

百锋机械有限公司坐落于江苏省，南京市，溧水区，明觉工业园内，公司成立于 1996 年。

我们专业生产智能化的通风设备：矩形风管生产线 1-5 线，并配套生产 TDF 法兰机，咬口机，共板 & 直板折边机，剪板机，冲床，风管合缝机，圆风管机，虾米弯头机及其他相关设备。

公司自 2008 年起引进圆风管机生产技术，并与当地最大的一家生产型企业合作，大力研发并生产圆风管通风设备。

如今，我们不仅是一家生产型的工厂，还成立了经验丰富的研发设计团队，建立了多方位的成熟的销售渠道。并通过阿里巴巴，中国制造，谷歌和 youtube 平台将我们的产品带到了全世界各个国家。

我们真诚的期待和您一起共同成长，并且欢迎您的及时反馈，好与不好都对我们非常重要，那将是我们公司发张壮大的动力。

期待您的光临，我们将竭诚为您服务。

BYFOCNC Machinery Co., Ltd, which was established in 1996, located in Mingjue industry area, Shiqiu Town, Lishui district, Nanjing City, Jiangsu Province, China. We professional produce HVAC Intelligent duct equipment, such as rectangular V, duct auto line V, auto line IV, auto line III, auto line II and Auto line I, spiral duct machine. And we also can make TDF flange forming machine, Pittsburgh lock forming machine, TDF & flat folding machine, shearing machine, punching machine, duct seam closing machine, round elbow machine and other related equipments.

In 2008, we started to produce spiral duct forming machine from imported technology, we now have worked together with a local largest manufacturing company for better development. Nowadays, we are not only a single manufacturing company, but also established an fully experienced design team and multi-directional sales channels, with the help of Alibaba, Made-in-China, Google and Youtube and other useful platforms to expand our business to all over the world.

We are sincerely looking forward to cooperating, growing and developing with you. we believe your not only positive feedback but also negative feedback is the most important for us to grow. From such precious feedback, we know how we have been doing and how we can improve in the future.

Looking forward to your inquiry, we will reply you immediately



# CONTENTS

## 目录

风管实例 ..... 01	椭圆风管机 ..... 28
Duct Making	Oval-shape duct machine
U 型风管生产五线 ..... 05	虾米弯头机 ..... 29
U shape auto duct line5	Elbow making machine
风管生产五线 ..... 07	液压虾米弯头机 ..... 30
Duct manufacture auto line 5	Hydraulic elbow making machine
风管生产四线 ..... 09	电动 / 液压角铁卷圆机 ..... 31
U shape auto duct line 4	Electric/Hydraulic angle rolling machine
风管生产三线 ..... 11	角铁卷圆打孔机 ..... 32
Super auto duct line 3	Angle rolling and punching machine
风管生产二线 ..... 13	液压立式合缝机 ..... 33
Super auto duct line 2	Hydraulic vertical seam closer
风管生产一线 ..... 15	气动合缝机 ..... 33
Super auto duct line 1	Pneumatic seam closer
方管简易搭配生产线 ..... 16	辘合骨机 ..... 34
Duct forming production line-Upgrades	Duct seam closer
数控等离子切割机 ..... 17	手持电动 / 气动合缝枪 ..... 35
CNC plasma cutting machine	Hand operated electric/pneumatic seam closer
数控角钢法兰生产线 ..... 19	圆管合缝机 ..... 36
CNC angle flange production line	Round duct seam duct
咬口机 ..... 20	气动缝焊机 ..... 37
Pittsburgh lock machine	Pneumatic welding machine
暗扣咬口机 / S 咬口机 ..... 21	风管直缝焊机 ..... 38
Snap lock machine/S lock machine	Stitchwelder
立式 S 咬口机 ..... 22	气动角码安装机 / 压筋机 ..... 39
Standing S lock machine	Pneumatic corner mouting machine/Beading machine
共板法兰机 ..... 23	电动剪板机 / 电动卷板机 ..... 40
TDF flange forming machine	Electric shearing machine/Rolling machine
双机联动共板法兰机 ..... 24	折边机 ..... 41
Double TDF flange machine	Folding machine
TDC 法兰机 ..... 25	辘线机 / 铆钉机 ..... 43
TDC flange machine	Rotary machine/Hydraulic riveting machine
BYL-1500 螺旋风管机 ..... 26	牛头剪 / 剪角机 ..... 44
BYL-1500 spiral duct machine	Reel shearing beading machine/Angle notching machine
BYL-1602 螺旋风管机 ..... 27	
BYL-1602 spiral duct machine	

# 矩形风管实例 Square Duct

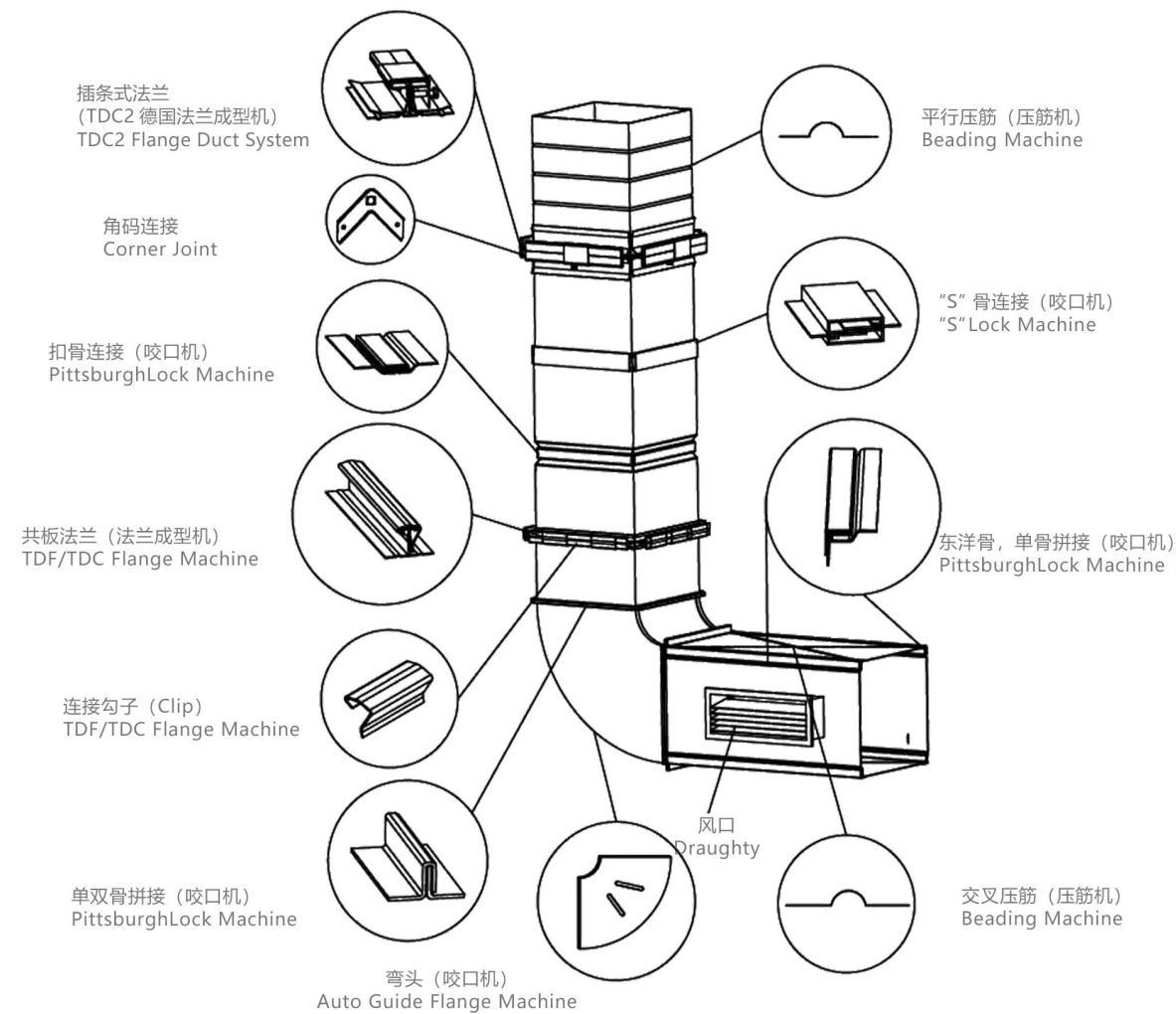


表3.2.1-1 钢板矩形风管板材厚度 (mm)

风管边长b	一般用途风管		除尘系统风管
	中、低压系统	高压系统	
b ≤ 320	0.5	0.75	1.5
320 < b ≤ 450	0.6	0.75	1.5
450 < b ≤ 630	0.6	0.75	2.0
630 < b ≤ 1000	0.75	1.0	2.0

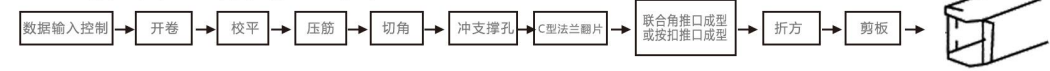
表2.0.10-1 矩形风管常用规格 (mm)

风管边长				
120	320	800	2000	4000
160	400	1000	2500	—
200	500	1250	3000	—
250	630	1600	3500	—

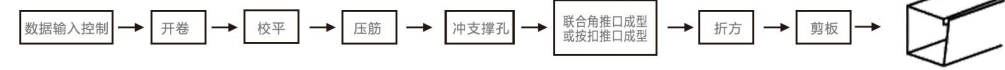
## 1. 角钢法兰直管制作工艺



## 2. C.S插条法兰直管制作工艺



## 3. TDC2法兰直管制作工艺



注：角钢法兰，C.S插条法兰，TDC2法兰风管加工工序采用经济型半条流水线就可以完成。

## 4. TDC1法兰直管制作工艺

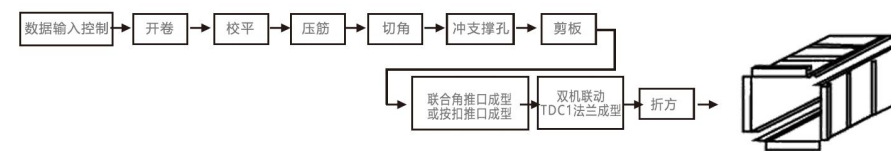


表3.1.5-1 金属矩形风管连接形式及适用风管边长

连接形式	附件规格 (mm)	适用风管边长 (mm)		
		低压风管	中压风管	高压风管
角兰	M6螺栓	L25X3	≤1250	≤1000
	M8螺栓	L30X3	≤2000	≤2000
	M8螺栓	L40X3	≤2500	≤1600
	M8螺栓	L50X3	≤4000	≤2500
薄钢板法兰	弹簧夹式	h=25, δ <sub>1</sub> =0.6	≤630	≤630
	插接式	h=25, δ <sub>1</sub> =0.75	≤1000	≤1000
	顶丝卡式	h=25, δ <sub>1</sub> =1.0	≤2000	≤2000
	组合式	h=25, δ <sub>1</sub> =1.2	≤2000	≤2000
S 插形条	平插条	大于风管壁厚且大于或等于0.75mm	≤630	—
	立插条	大于风管壁厚且大于或等于0.75mm, h ≥ 25mm	≤1000	—
C 插形条	平插条	大于风管壁厚且大于或等于0.75mm	≤630	≤450
	立插条	大于风管壁厚且大于或等于0.75mm, h ≥ 25mm	≤1000	≤630
	直角插条	等于风管壁厚且大于或等于0.75mm	≤630	—
立联合角形插条	等于风管壁厚且大于或等于0.75mm, h ≥ 25mm	≤1250	—	—
立咬口	咬口包边板厚度等于风管臂厚度, h ≥ 25mm	≤1000	≤630	—

表3.2.1-3 矩形风管连接允许最大间距 (mm)

刚度等级	风管边长b									
	≤500	630	800	1000	1250	1600	2000	2500	3000	
低压风管	F 1	允许最大间距								
	F 2	1000								
	F 3	2000	1600	1250	不使用					
	F 4	2000	1600	1250	1000	800	800			
	F 5	2000	1600	1250	1000	800	800	800		
	F 6	2000	1600	1250	1000	800	800	800	800	
中压风管	F 2	1250								
	F 3	1600	1250	1000	不使用					
	F 4	1600	1250	1000	800	800				
	F 5	1600	1250	1000	800	800	800	625		
	F 6	2000	1600	1000	800	800	800	800	625	
	高压风管	F 3	1250							
F 4		1250	1000	800	625	不使用				
F 5		1250	1000	800	625	625				
F 6		1250	1000	800	625	625	625	500	400	

表3.2.1-4 薄钢板法兰矩形风管连接允许最大间距 (mm)

刚度等级	风管边长b									
	≤500	630	800	1000	1250	1600	2000	2500	3000	
低压风管	Fb1	1600	1250	625	500					
	Fb2	2000	1600	1250	650	500	400			
	Fb3	2000	1600	1250	1000	800	600	不使用		
	Fb4	2000	1600	1250	1000	800	800			
中压风管	Fb1	1250	650	500						
	Fb2	1250	1250	650	500	400	400			
	Fb3	1600	1250	1000	800	650	500	不使用		
	Fb4	1800	1250	1000	800	800	800			

# 圆形风管实例 Round Duct

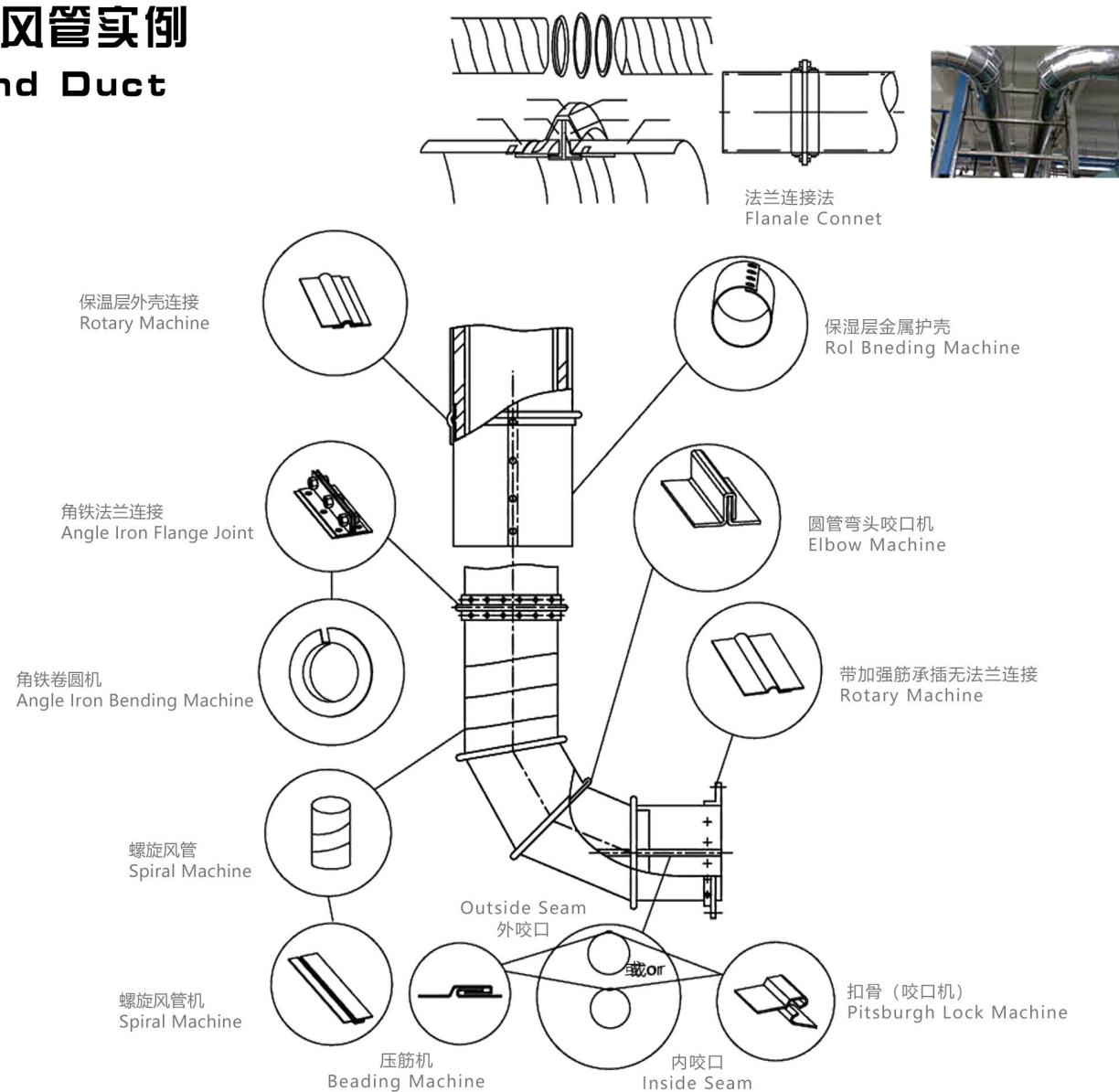


表3.1.5-2 金属圆形风管连接形式及适用范围

连接形式	附件规格 (mm)	连接要求	适用范围
角钢法兰连接	L25x3 L30x3 L40x4	法兰与房改连接采用铆接或焊接	低、中、高压风管
承插连接	普通	—	插入深度大于或等于30mm, 应有密封措施
	角钢加固	L25x3 L30x4	插入深度大于或等于20mm, 应有密封措施
	压加强筋	—	插入深度大于或等于20mm, 应有密封措施
芯管连接	芯管板厚度大于或等于风管壁厚	插入深度大于或等于20mm, 应有密封措施	低、中、高压风管
立筋抱箍连接	抱箍板厚度大于或等于风管壁厚	风管翻边与抱箍匹配, 结合坚固严密	低、中、高压风管
抱箍连接	抱箍板厚度大于或等于风管壁厚	管端应对正, 抱箍应居中	低、中压风管 抱箍宽度大于或等于10m

表3.1.8 风管及法兰制作的允许偏差 (mm)

风管边长b或直径D	允许偏差				
	允许偏差	允许偏差	允许偏差	允许偏差	允许偏差
金属风管	b(D) ≤ 320	≤ 2	≤ 10	≤ 10	≤ 2
	b(D) > 320	≤ 3	—	—	≤ 2
非金属风管	b(D) ≤ 320	≤ 2	≤ 3	≤ 3	≤ 2
	320 < b(D) ≤ 2000	≤ 3	≤ 5	≤ 5	≤ 4

表3.2.6-2 芯管长度、螺钉数量及直径允许偏差 (mm)

风管直径D	低压风管		中压风管		中压风管	
	螺旋缝	直缝	螺旋缝	直缝	螺旋缝	直缝
D ≤ 320	0.50		0.50		0.50	
320 < D ≤ 450	0.50	0.60	0.50	0.75	0.60	0.75
320 < D ≤ 450	0.60	0.75	0.60	0.75	0.60	0.75
320 < D ≤ 450	0.75	1.00	0.75	1.00	1.00	
320 < D ≤ 450	1.00	1.20	1.20		1.520	
320 < D ≤ 450	1.20	按设计				

表3.2.6-2 芯管长度、螺钉数量及直径允许偏差 (mm)

风管直径D	芯管长度 (mm)	芯管每端口自攻螺钉或铆钉数量 (个)	芯管直径允许偏差 (mm)
120	120	3	-3-4
120	160	4	

表3.1.4 金属风管板材连接形式及使用范围

名称	连接方式	适用范围
单咬口	内平咬口	低、中、高压系统
	外平咬口	低、中、高压系统
联合角咬口		低、中、高压系统 矩形风管及配件四角咬口
转角咬口		低、中、高压系统 矩形风管及配件四角咬口
按扣式咬口		低、中、高压系统 及配件四角咬接低压圆形风管
立咬口		圆、矩形风管横向连接或纵向接缝 圆形弯头制作不加铆钉
焊接	见图3.21	低、中、高压系统

表3.4.1 铝板风管板材厚度 (mm)

风管边长b或直径D	铝板厚度	风管边长b或直径D	不锈钢厚度
100 < b(D) ≤ 320	1.0	100 < b(D) ≤ 500	0.5
320 < b(D) ≤ 630	1.5	500 < b(D) ≤ 1120	0.75
630 < b(D) ≤ 2000	2.0	1120 < b(D) ≤ 2000	1.0
2000 < b(D) ≤ 4000	按设计	2000 < b(D) ≤ 4000	1.2

表3.3.1 不锈钢板风管和配件的板材厚度

表3.2.6-2 芯管长度、螺钉数量及直径允许偏差

风管直径D	法兰材料规格		螺栓规格
	扁钢	角钢	
D ≤ 140	20x4	—	M6
140 < D ≤ 280	25x4	—	
280 < D ≤ 630	—	25x3	M8
630 < D ≤ 1250	—	30x3	
1250 < D ≤ 2000	—	40x4	

表2.0.10-2 圆形风管规格 (mm)

风管直径	基本系列													
	100	120	140	160	180	200	220	250	280	320	360	400	450	
	80	90	110	130	150	170	190	210	240	260	300	340	380	420
	50	560	630	700	80	90	100	1120	1250	1400	1600	180	2000	
辅助系列														
	480	530	600	670	750	850	950	1060	1180	1320	1500	1700	1900	

表3.2.6-1 圆形风管板材厚度 (m)

风管直径D	低压风管		中压风管		高压风管	
	螺旋缝	直缝	螺旋缝	直缝	螺旋缝	直缝
D ≤ 320	0.50		0.50		0.50	
320 < D ≤ 450	0.50	0.60	0.50	0.75	0.60	0.75
450 < D ≤ 1000	0.60	0.75	0.60	0.75	0.60	0.75
1000 < D ≤ 1250	0.75	1.00	0.75	1.00	1.00	
1250 < D ≤ 2000	1.00	1.20	1.20		1.20	
D < 2000	1.20	按设计				



# U型风管生产5线

## U shape auto duct line V

### 功能 Function

主要完成共板法兰/角钢法兰或“C”型法兰成型，日加工能力1500-2000平米，风管只要输入尺寸，生产线自动完成开卷、校平、压筋、冲角、剪切、联合咬口、共板法兰/角钢法兰成型或“C”型法兰成型，折方成型。

It's mainly used for TDF/angle steel/C-shaped flange making, the daily capability is 1500-2000 square meters. Only input duct sizes into controller, then the production line can automatically complete uncoiling, leveling, beading, punching, shearing, duplex locking, forming TDF/angle steel/C-shaped flange and folding.

## 20-25秒完成一节L片

One piece of L film is completed in 20-25 seconds



### 性能特点 Performance Features

1. U型结构，占地小，组装简单，适合中小厂房使用
2. 伺服气动机械手驱动送料，保证平稳，定位精准，速度更快
3. 超高效率，超省人工，每片L片只需20-25秒，效率较直线型提高一倍
4. 固定式咬口机，省去来回移动时间，提高工作效率
5. 所有轧辊全部采用轴承钢材质，使用寿命提高5倍以上
6. 数控系统增加省料模式，每卷料只有一小块小于20mm的废料
7. 带生产记忆功能，具有生产订单可查询功能

1. Honest strengthens the basis in the pursuit of customer satisfaction and Constant innovation helps customer to achieve their goals.
2. Driving feeding mechanism with pneumatic servo manipulator helps to ensure stability and speed of the machine, and the accuracy of its locating system.
3. It only takes 20-25 seconds to make one L-shaped workpiece and the efficiency will double comparing with the linear type.
4. Without moving back and forth the fixed locking machine is able to improve the efficiency.
5. All the rolling reels are made of bearing steel so that the lifetime prolongs by more than 5 times.
6. Under the material-saving mode of CNC system, waste is less than 20mm per roll.
7. With production memory functions, the production orders can be tracked and checked.



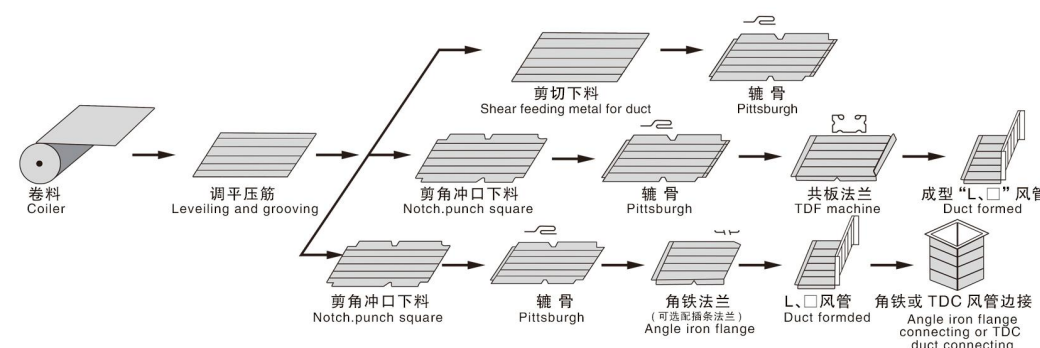
### 主要进口配置 Main Import Configuration

1. 北京华德+台湾液压系
  2. 日本欧姆龙 (OMRON) 专用编码器
  3. 台湾上银 (HIWIN) 直线导轨
  4. 三菱电气系统
- Beijing Huade plus hydraulic system from Taiwan
  - Japan Omron encoder
  - Taiwan Hiwin linear guideways
  - Mitsubishi electrical system

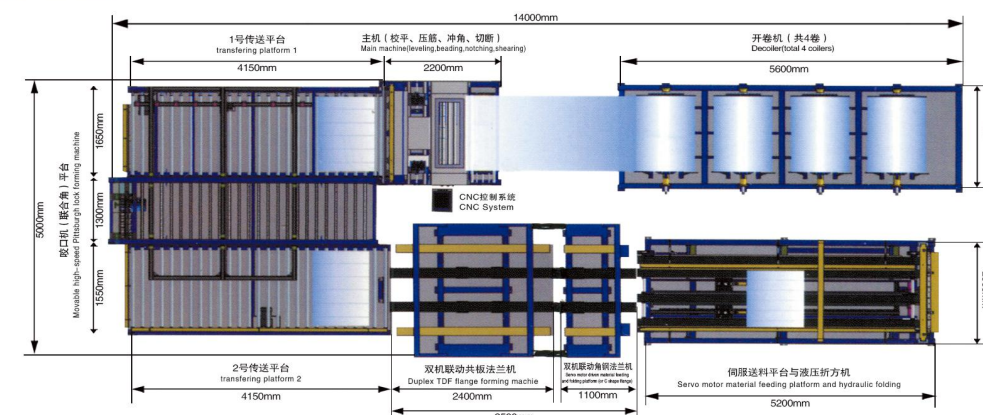
### 基本配置 Basic Configuration

1. 电动卷料架两台，料盘4个 (每卷5-7吨)
  2. 托料架一个
  3. 主机一台 (二线主机)
  4. 不锈钢滚筒式传送平台两个
  5. 固定式联合咬口机一台
  6. 双机联动共板法兰机一台
  7. 双机联动角钢法兰机一台
  8. 伺服送料平台一个
  9. 液压折方机一台
  10. 电脑控制系统一套
- Two electric coil cradles, 4 material trays (5-7teach roll)
  - One rack
  - One host (line 2 host)
  - Two stainless steel roller conveyer platforms
  - One fixed joint locking machine
  - One duplex TDF flange forming machine
  - One duplex angle steel flange forming machine
  - One servo feeding platform
  - One hydraulic folding machine
  - One set of computer controlling system

### 工作示意图 Working Schematic Diagram



### 功能流程图 Work Flow



### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	最大加工板宽 Max width (mm)	最大进料速度 Max working speed (m/min)	卷料最大重量 Coiler max weight (T)	外形尺寸 Dimensions (mm)			总功率 Power (kw)	重量 Weight (T)
					长 (L)	宽 (W)	高 (H)		
BYL-U-V-1250	0.5-1.2	1250	15	7	14000	5000	1500	30	13
BYL-U-V-1500	0.5-1.2	1500	15	7	14000	5400	1500	30	14

# 风管生产 5 线

## Auto duct line V

### 性能特点 Performance Features

1. 直线型结构、生产流畅、占地小
2. 所有轧轴全部采用轴承钢材质，使用寿命提高5倍以上
3. 数控系统增加省料模式，每卷料只有一块小于20mm的废料
4. 折方伺服送料，定位精确，尤其是在加工“口”字型管道时，优势明显
5. 采用10寸液晶触摸屏输入，并可选配键盘双模式，保证操作的稳定性
6. 至少需要1人操作，班产量可达600-2000
7. 带生产记忆功能，具有生产订单可查询功能

1. The linear structure of machine makes processing smoothly and occupies a small Space.
2. All the rolling reels are made of bearing steel so that the lifetime prolongs by more than 5 times.
3. Under the material-saving mode of CNC system, the waste is less than 20mm per roll.
4. The locating system is very accurate with servo feeding system, especially when making square-shaped pipes.
5. It's equipped with 10 inch LCD touch screen and optional dual keyboard mode to keep operation stable.
6. It requires at least one person to operate and each shift can output 600-2000.
7. With production memory functions, the production orders can be tracked and checked.



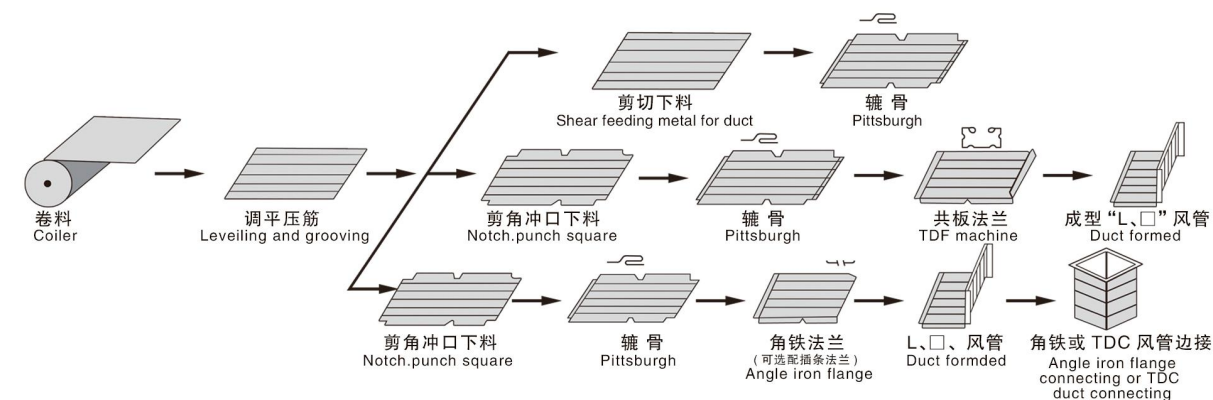
### 功能 Function

主要完成共板法兰/角钢法兰或“C”型法兰成型，日加工能力1000-1500平米，风管只要输入尺寸，生产线自动完成开卷，校平，压筋，冲角，剪切，联合咬口，共板法兰/角钢法兰或“C”型法兰成型，折方成型。

It's mainly for TDFR/angle steel/C-shaped flange forming with daily processing capability of 1000-1500 square meters. Only with inputting dimensions in duct, production line can automatically complete uncoiling, leveling, beading, punching, shearing, locking, forming TDF/angle steel/C-shaped flange and folding.



### 工作示意图 Working Schematic Diagram



### 主要进口配置 Main Import Configuration

1. 德国费斯托 (FESTO) 原装进口气缸
2. 北京华德+台湾液压系统
3. 日本欧姆龙 (OMRON) 专用编码器
4. 台湾上银 (HIWIN) 直线导轨
5. 三菱电气系统

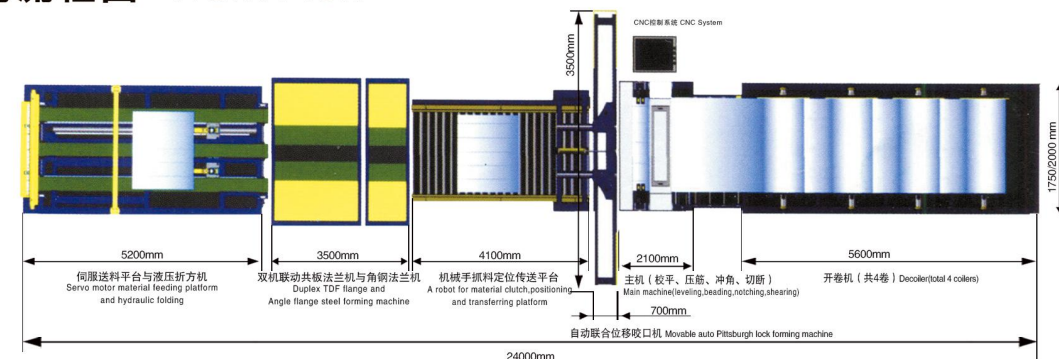
- Cylinder imported from Germany Festo
- Beijing Huade plus hydraulic system from Taiwan
- Japan Omron encoder
- Taiwan Hiwin linear guideways
- Mitsubishi electrical system

### 基本配置 Basic Configuration

1. 电动卷料架两台，料盘4个 (每卷5-7吨)
2. 托料架一个
3. 主机一台 (二线主机)
4. 机械手抓料定位传送平台一个
5. 位移式联合咬口机一台
6. 双机联动共板法兰机一台
7. 双机联动角钢法兰机一台
8. 伺服送料平台一个
9. 液压折方机一台
10. 电脑控制系统一套

- Two electric coil cradles, 4 material trays (5-7teach roll)
- One rack
- One host (line 2 host)
- One mechanical arm clutching, locating and transferring platform
- One displacement type locking machine
- One duplex TDF flange forming machine
- One duplex angle steel flange forming machine
- One servo feeding platform
- One hydraulic folding machine
- One set of computer controlling system

### 功能流程图 Work Flow



### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	最大加工板宽 Max width (mm)	最大进料速度 Max working speed (m/min)	卷料最大重量 Coiler max weight (T)	外形尺寸 Dimensions (mm)			总功率 Power (kw)	重量 Weight (T)
					长 (L)	宽 (W)	高 (H)		
BYL-V-1250	0.5-1.2	1250	15	7	24000	3500	1500	30	12
BYL-V-1500	0.5-1.2	1500	15	7	24000	4000	1500	30	13

# 风管生产4线

## Auto duct line IV

### 功能 Function

主要完成卷料的开卷，校平，压筋，冲角，联合口单双口，双边角钢法兰或共板法兰的加工，该生产线占地小，组合方便，现场施工便捷，有小五线的名称。

It's mainly for uncoiling, leveling, beading, punching, locking, Duplex angle steel or TDF flange forming. Because of its small space requirement and easy to install and operate, people also call it "mini-line 5".

### 主要进口配置 Main Import Configuration

1. 德国费斯托 (FESTO) 原装进口气缸
2. 北京华德或台湾液压系统
3. 日本欧姆龙 (OMRON) 专用编码器
4. 台湾上银 (HIWIN) 直线导轨
5. 三菱电气系统

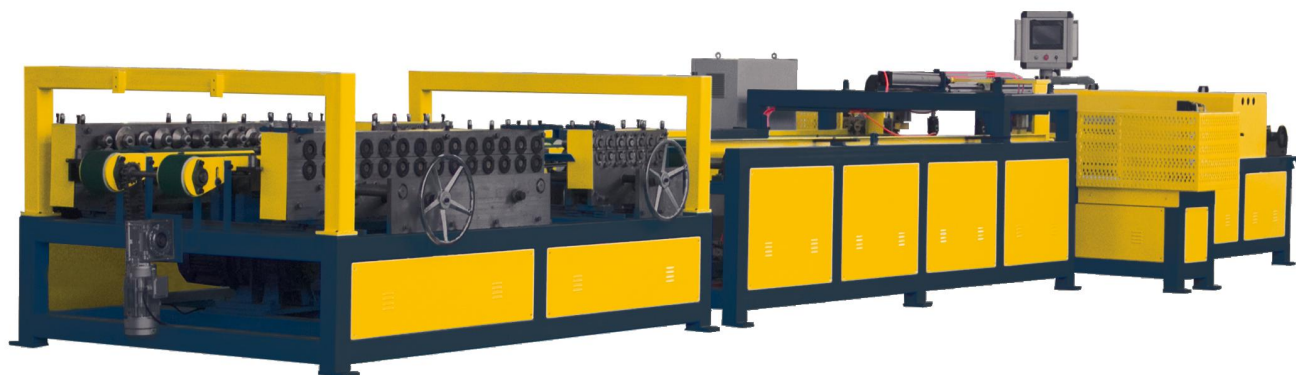
### 性能特点 Performance Features

1. 所有轧辊全部采用轴承钢材质，使用寿命提高5倍以上
  2. 数控系统增加省料模式，每次任务实现自动退料
  3. 带生产记忆功能，具有生产订单可查询功能
- All the rolling reels are made of bearing steel so that the lifetime prolongs by more than 5 Times.
  - Under the material-saving mode of CNC system, machine can withdraw material automatically after finishing tasks.
  - With production memory functions, the production orders can be tracked and checked.

### 基本配置 Basic Configuration

1. 电动卷料架两台，料盘4个 (每卷5-7吨)
2. 托料架一个
3. 主机一台 (三线主机)
4. 机械手抓料定位传送平台一个
5. 位移式咬口机一台
6. 双机联动共板法兰机一台
7. 双机联动角钢法兰机一台
8. 电脑控制系统一套

- Two electric coil cradles, 4 material trays (5-7t each roll)
- One rack
- One host (line 3 host)
- One mechanical arm clutching, locating and transferring platform
- One displacement type locking machine
- One duplex TDF flange forming machine
- One duplex angle steel flange forming machine
- One set of computer controlling system

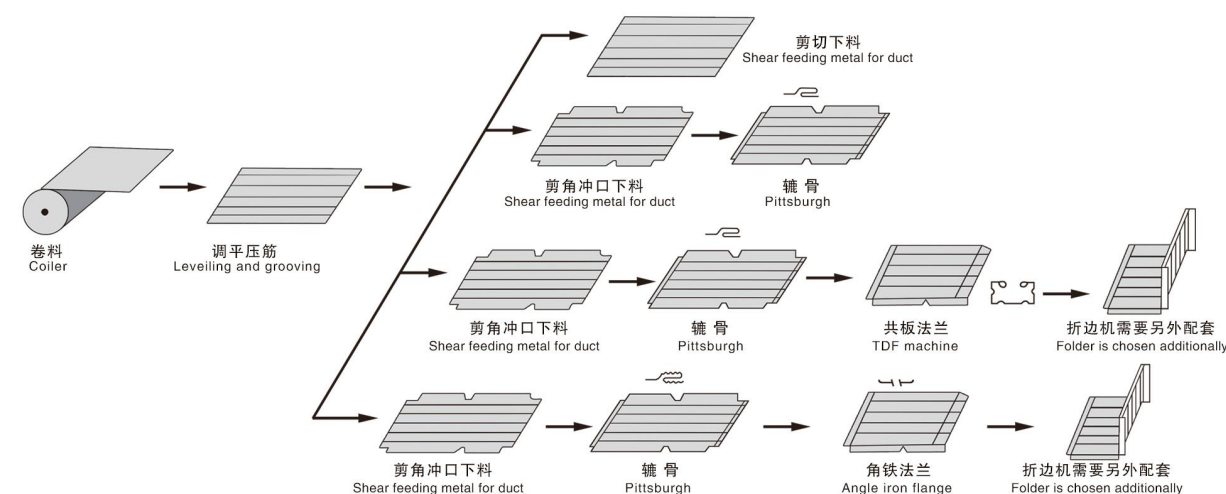


### 产品优势 Advantages of products

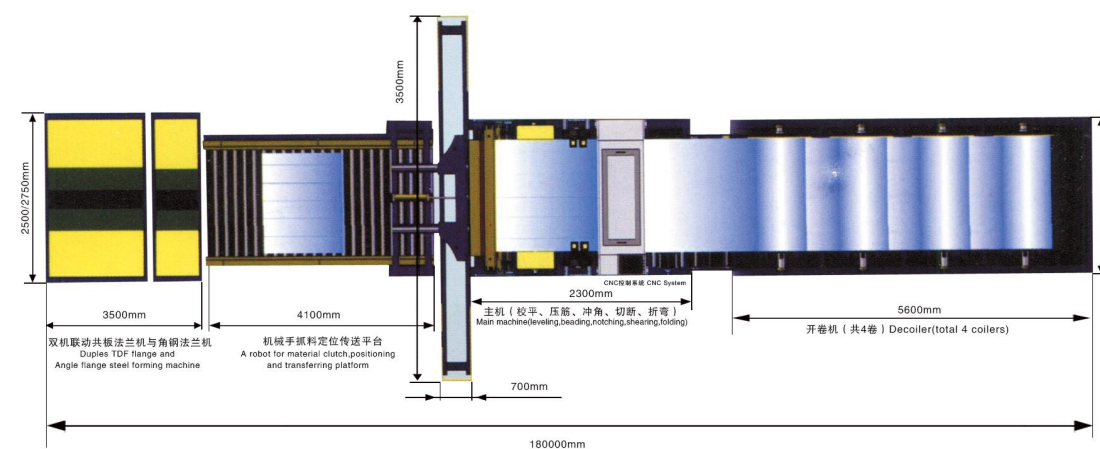
1. 采用最新设计有效解决滚剪式位移咬口机容易卡料，维修多的问题。
2. 利用三线折弯功能将小边直接折好，可稳定加工板厚0.5-1.2mm镀锌板，避免浪费。

- The latest design can resolve the problems like getting stuck, too many repairs from roll-shearing displacement lock machine.
- The three-line bending function can crimp narrow edges and stably process 0.5-1.2mm galvanized sheet to avoid wasting.

### 工作示意图 Working Schematic Diagram



### 功能流程图 Work Flow



### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	最大加工板宽 Max width (mm)	最大进料速度 Max working speed (m/min)	卷料最大重量 Coiler max weight (T)	外形尺寸 Dimensions (mm)			总功率 Power (kw)	重量 Weight (T)
					长 (L)	宽 (W)	高 (H)		
BYL-IV-1250	0.5-1.2	1250	15	7	18000	3500	1500	26	9
BYL-IV-1500	0.5-1.2	1500	15	7	18000	4000	1500	26	10

# 风管生产 3 线

## Auto duct line III

### 功能 Function

风管生产三线可以满足风管板料下料，同时也非常适用于TDF共板法兰，角钢法兰及插接式法兰机的多元化生产，角钢法兰及插接式法兰可以自动折方成方管。

Duct production line 3 can do blanking for duct. Mean-time, it's very suitable for multi-production like TD-F/angle steel/TDC angle steel flange and TDC flange can be bent to square-shaped duct automatically.

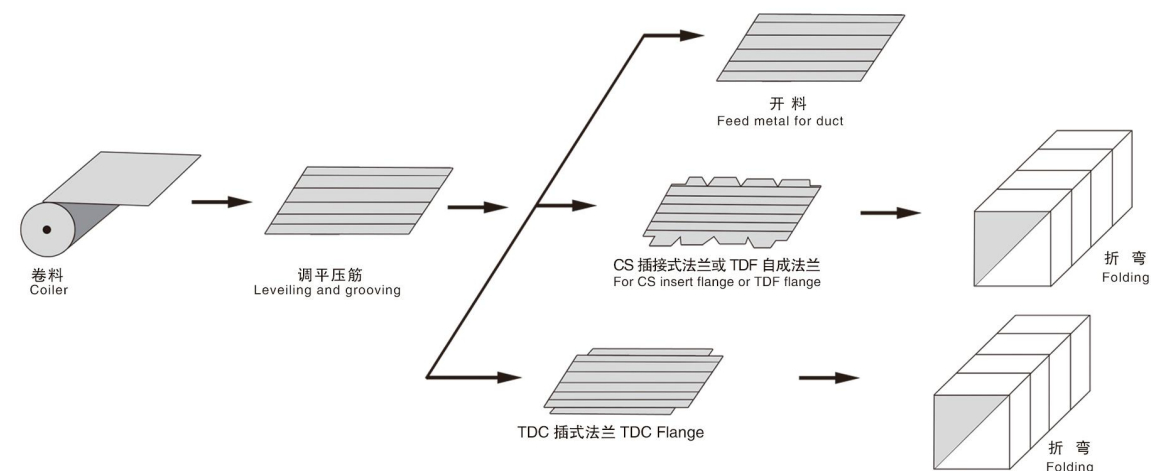


### 性能特点 Performance Features

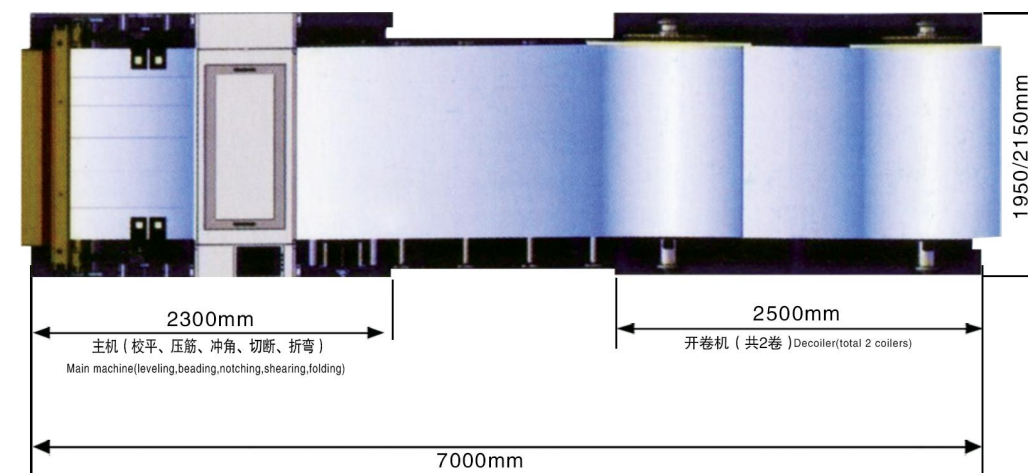
1. 采用铝合金悬挂臂操作便捷
  2. 内置式控制柜整体结构移动方便减少接线
  3. 全进口配置性能稳定操作方便
- Aluminium alloy suspension arm makes the machine easy to operate.
  - The build-in control cabinet reduces wiring as a whole structure and makes it easy to move.
  - The imported configuration is very stable and comfortable to use.



### 工作示意图 Working Schematic Diagram



### 功能流程图 Work Flow



### 主要进口配置 Main Import Configuration

1. 三菱电气系统
  2. 北京华德或台湾液压系统
  3. 日本欧姆龙 (OMRON) 专用编码器
- Mitsubishi electrical system
  - Beijing Huade or hydraulic system from Taiwa
  - Japan Omron encoder

### 基本配置 Basic Configuration

1. 电动卷料架一台 (料盘二个)
  2. 校平压筋装置一套
  3. 液压剪角机四连套模具
  4. 液压剪板机液压折弯机液压压料机
  5. 全数控电脑控制系统及生产软件一套
- One electric coll cradle(two material trays)
  - One set of levelling and beading equipment
  - Hydraulic angle-shearing machine with four sets of die
  - Hydraulic shet-sheariy machine,hydraulic press machine,hydraulic press machine
  - A set of CNC computer control system and production software

### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	最大加工板宽 Max width (mm)	最大进料速度 Max working speed (m/min)	卷料最大重量 Coiler max weight (T)	外形尺寸 Dimensions(mm)			总功率 Power (kw)	重量 Weight (T)
					长 (L)	宽 (W)	高 (H)		
BYL-III-1250	0.5-1.2	1250	15	7	2200	1950	1300	7	3.5
					2500	1950	1600	7	3.5
BYL-III-1500	0.5-1.2	1500	15	7	2200	2150	1300	8.5	4
					2500	1950	1600	8.5	4

# 风管生产2线

## Auto duct line II

### 功能 Function

风管生产二线可以满足风管板料下料，同时也非常适用于TDF共板法兰下料工作，与共板法兰机，辊骨机，折边机配套，加上相应的角码就能生产高质量的风管。

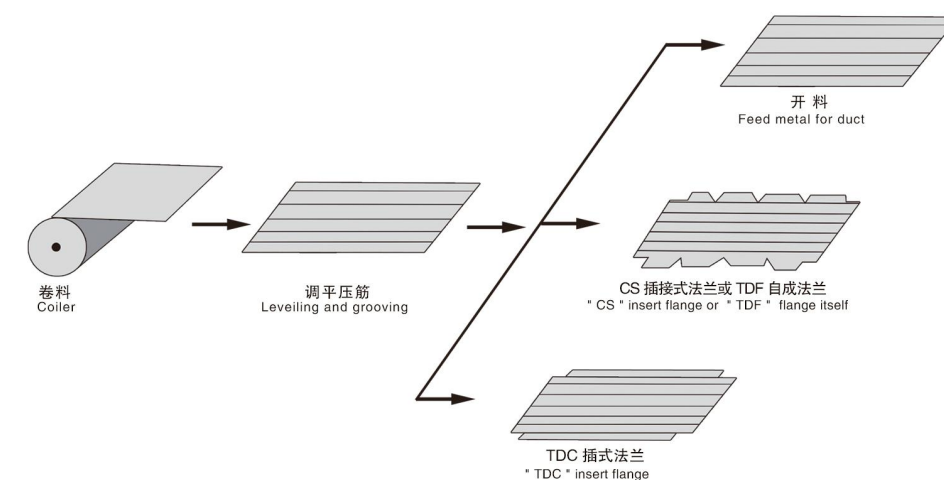
Duct production line 2 can do blanking for duct, and also suitable for TDF flange forming machine. Working together with TDF flange forming machine, rolling reel machine, folding machine and corner accordingly can make high quality ducts.

### 性能特点 Performance Features

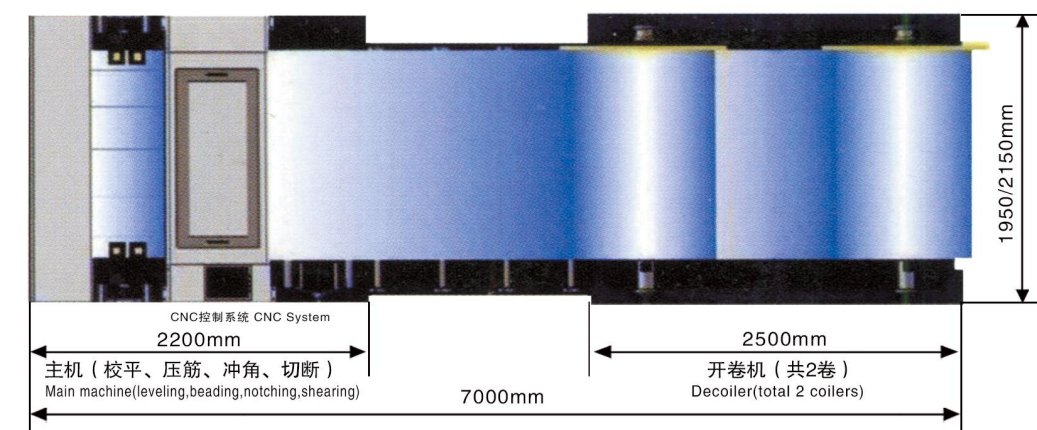
1. 采用铝合金悬挂臂操作便捷
  2. 内置式控制柜整体结构移动方便减少接线
  3. 全进口配置性能稳定操作方便
- Aluminium alloy suspension arm makes the machine easy to operate.
  - The build-in control cabinet reduces wiring as a whole structure and makes it easy to move.
  - The imported configuration is very stable and comfortable to use.



### 工作示意图 Working Schematic Diagram



### 功能流程图 Work Flow



### 主要进口配置 Main Import Configuration

1. 三菱电气系统
  2. 北京华德或台湾液压系统
  3. 日本欧姆龙 ( OMRON ) 专用编码器
- Mitsubishi electrical system
  - Beijing Huade or hydraulic system from Taiwa
  - Japan Omron encoder

### 基本配置 Basic Configuration

1. 电动卷料架一台 (料盘二个)
  2. 校平压筋装置一套
  3. 液压剪角机四连套模具
  4. 液压剪板机
  5. 全数控电脑控制系统及生产软件一套
- One electric coil cradle(two material trays)
  - One set of leveling and beading equipment
  - Hydraulic angle-shearing machine with four sets of die
  - Hydraulic sheet-shearing machine
  - A set of CNC computer control system and production software

### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	最大加工板宽 Max width (mm)	最大进料速度 Max working speed (m/min)	卷料最大重量 Coiler max weight (T)	外形尺寸 Dimensions(mm)			总功率 Power (kw)	重量 Weight (T)
					长 (L)	宽 (W)	高 (H)		
BYL-II-1250	0.5-1.2	1250	15	7	1900	1950	1500	7	3.2
					2500	1950	1600		
BYL-II-1500	0.5-1.2	1500	15	7	1900	2150	1500	8.5	3.7
					2500	2150	1600		



## 风管生产 1 线 Auto duct line I

### 功能 Function

经济型生产线是由上料架、校平机或电动剪板机组成。控制部分采用全电脑控制。该生产线最大工作速度为20米/分，精度为：长度误差±0.5MM，对角线误差为±0.8MM，上料架可以根据客户要求配套。经济I线也可以为开卷生产，只要增加相应装置即可以，加工生产普通板厚2.5MM，不锈钢1.5MM卷生产。

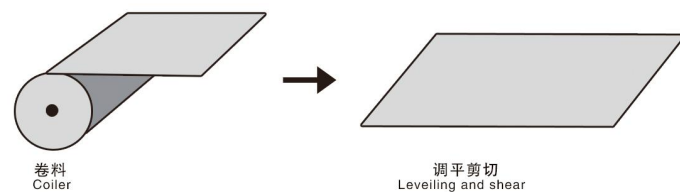
Line 1 consists of a decoiler, leveller and electrical shearing machine. it is full controlled by computer. The maximum working speed is 20m/min. The length tolerance is ±0.5mm. diagonal tolerance is ±0.8mm. The decoiler can be produced as per customer's requirement.

### 基本配置 Basic Configuration

1. 电动送料架一台（料盘二个）  
One power metal feeding frame
2. 压筋调平剪板机一套  
Leveier grooving roll & cutting machine
3. 电脑控制器及生产软件一套  
Industrial computer and specific software



### 工作示意图 Working Schematic Diagram



### 工作原理 The work flow

卷料 — 上料 — 校平 — 剪切  
Coiler — material feel — leveler — shear

### 主要技术参数 Main Technical Parameters

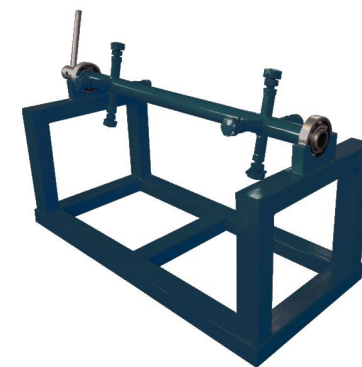
型号 Model	加工板厚 Sheet thicknes (mm)	最大加工板宽 Max width (mm)	最大进料速度 Max working speed (m/min)	卷料最大重量 Coiler max weight (T)	外形尺寸 Dimensions(mm)			总功率 Power (kw)	重量 Weight (T)
					长 (L)	宽 (W)	高 (H)		
BYL- I	镀锌板0.5-1.2	1300	16	7	1300	1700	1200	7	3.4
					3200	1800	1500		
BYL- I	不锈钢板0.5-1.2	1500	16	7	1300	1700	1200	7	3.4
					3200	1800	1500		

## 方管简易搭配生产线 Square Tube Simple Collection Production line

### 基本配置 Basic Configuration

以下6台设备可组成一条简易的方管生产线，是目前风管市场应用最为广泛且性价比最高的设备组合线，机器移动灵活，操作方便，是工地作业的第一选择。

The following 6 equipments can be used as a simple rectangular duct line. It is a widest combinational line for HVAC industry at market, It is the top option for Site operations.



料架



五线压筋机



电动剪板机



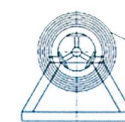
多功能咬口机



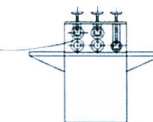
共板法兰机



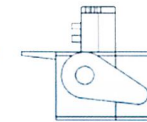
共板折边机



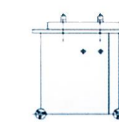
Run-Out Table



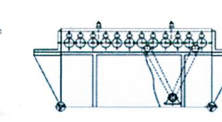
Five grooving machine



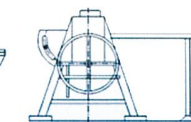
Motor Driver Shear



Lock Forming Machine



TDF Flange Forming Machine



Hand Folder

# 数控等离子切割机

## CNC Plasma Cutting Machine

### 功能 Function

全自动数控等离子切割机主要完成异形弯头部件的自动化放样与切割，在新版CAM-DUCT的立体图库中选择适合您的图形并输入尺寸，选择连接方式，软件可根据您的需求，实现自动计算，排版，套料，切割。

It's mainly used for automatically lofting and cutting the deformed workpiece. You can select a drawing from the new version of CAM-DUCT and input dimensions and choose a way of connection, then the software will start calculating, composing, jacking and cutting automatically according to your requirements.

### 性能特点 Performance Features

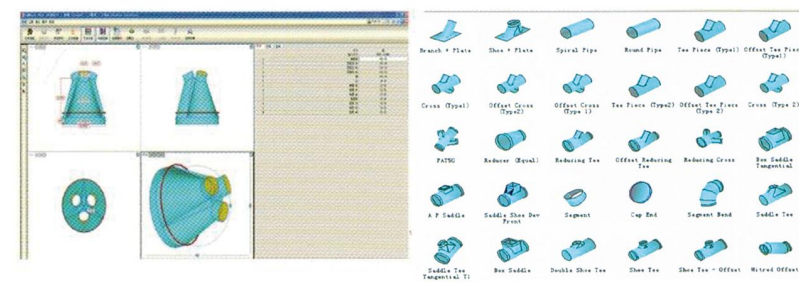
1. 采用立式控制柜10寸触摸屏（可选配15寸大屏幕一体机）
2. 美国AUTODESK公司CAM-DUCT新版风管套料软件 加密使用（简体中文版）
3. 美国海宝（HYPER THERM）原装发生器或国产华远牌发生器（经济型）

- Vertical control panel is 10 inch touch screen(15 inch screen is optional)
- New version of CAM-DUCT software from Hypertherm of United states and encrypting Chinese version
- Original generator of Hypertherm of United States or made in China generator of Huayuan(economy version)

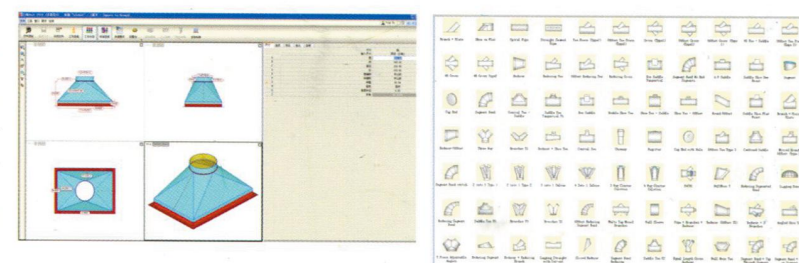


### 软件 Software

采用美国AUTO DESK公司CAM-DUCT新版风管套料软件，该风管软件使用预设计标准风管图形及参数设定来达到风管部件切割需求，集科技，数据程序，管理于一体。软件程序操作简单易学，只需输入加工尺寸即可自动生成异形风管展开图。



The machine adopts the latest CAM-DUCT software from Auto Desk company and the software combines technology, data procedure with management and meets cutting requirements of duct workpiece by using pre-designed standard duct drawing and parameter settings. The software is easy to learn and operate because it only requires machining dimensions to develop an unfolded view of deformed duct automatically.



### 样例展示 Sample show



### 主要技术参数 Main Technical Parameters

型号 Model	加工范围 Working range (mm)	加工板厚 Sheet thicknes (mm)	功率 Power (kw)	外形尺寸 Dimensions(LxWxH)	重量 Weight (T)
BY-1340	1250x4000	0.4-3	10	4600x1900x1500	1200
BY-1540	1500x4000	0.4-3	10	4600x2200x1500	1300

## 数控角钢法兰生产线

### CNC Angle Steel Flange Production Line

#### 功能 Function

全自动数控角钢法兰生产线，又名数控角铁生产线，主要完成风管角钢法兰（30-50角铁）的大小孔的冲孔及切断功能，实现自动送料，打孔，切断全自动数控控制要求，节约人工，提高效率，具有速度快，尺寸准确，自动化程度高等特点。

Fully automatic angle steel flange production line, or CNC angle steel flange production line, is mainly for punching and cutting duct angle steel flange. The machine are designed to feed, punch, cut automatically in order to save labor and improve efficiency. It's very fast, accurate and highly automatic.

#### 性能特点 Performance Features

1. 全新设计，可实现角钢末端尾料350mm以内
2. 采用伺服电机控制，送料尺寸精准
3. 编制程序时只需输入工件尺寸，大小孔距，打孔数量即可，操作简单
4. 带生产记忆功能，具有生产订单可查询功能
5. 全新设计模具，5秒之内完成角钢切换，冲头经久耐用。

- It's a brand new design which can keep angle steel tailing less than 350mm.
- It's controlled by servo motor and its feeding dimensions are accurate.
- It only requires to input the size of workpiece, distance between holed and how many holes to punch when programming, which is very easy to operate.
- With production memory functions, the production orders can be tracked and checked.
- The new design mold can complete the angle steel switching within 5 seconds, with the durable punch.

#### 主要进口配置

##### Main Import Configuration

1. 北京华德或台湾液压系统
  2. 切断刀具及冲孔模具均采用日本SKH51材质
  3. 全伺服电机驱动送料系统
- Beijing Huade or hydraulic system from Taiwan
  - Cutter and punching die which are both made of Japan SKH51
  - Servo motor-driven feeding system



#### 主要技术参数 Main Technical Parameters

1. 加工角钢范围(mm): 3-5号角钢
2. 常用冲孔大小(mm): 大孔9.5x13mm 小孔4.2/5.2mm
3. 可同时安装冲头数目(个): 2个
4. 常用角钢长度: 6000mm
5. 加工精度: ≤0.5mm
6. 角钢送进速度: 15-20m/min

- Scale of angle steel to process: #3-#5 angle steel
- Common punching sizes: big-sized 9.5x13mm small-sized 4.2/5.2mm
- The number of punches which can be installed simultaneously: 2
- Common length of angle steel: 6000mm
- Machining accuracy not more than: 0.5mm
- Feeding speed of angle steel: 15-20m/min

型号 Model	加工范围 Working range	功率 Power(KW)	重量 Weight(Kg)	外形尺寸(mm) Dimensions(LxWxH)
XT-1050	30/40/50角钢	7.5	900	3000x900x1300

## 咬口机

### Pittsburgh Lock Machine

#### 性能特点 Performance Features

咬口机是风管制作行业的必选设备，可以加工出各种不同的骨型已达到板材拼接需要，标准机型可加工0.5-1.5mm的镀锌板，本公司特别推出GCr15材质的高强度轧辊，使用寿命较普通材质提高5倍以上，大大提高工作效率。

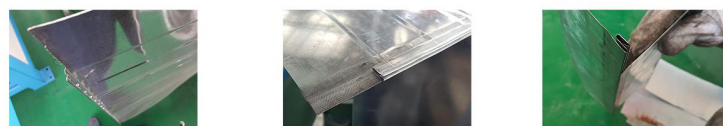
Pittsburgh lock machine is necessary equipment for duct industry, because it can produce all kinds of seam locks for all requirements. Standard model can do 0.5-1.5mm galvanized sheet, and our company would specially introduce high-strength rolling reels made of GCr15, a kind of steel which prolongs the machine life by more than 5 times and improve the efficiency dramatically.



#### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	成型形状 Shape	功率 Power (kw)	重量 Weight (T)	外型尺寸(mm) Dimensions(LxWxH)
SA-12HB	0.5-1.2		1.5	220	1050x570x1020mm
SA-15HB	0.8-1.5		2.2	280	1150x600x1100mm
SA-12B	0.5-1.2		1.5	215	1050x570x1020mm
SA-12	0.5-1.2		1.5	200	1050x570x870mm
SA-12C	0.5-1.2		1.5	200	1050x570x870mm

## 暗扣式咬口机 Snap Lock Machine



### 功能 Function

暗扣式咬口机具有两个咬口工位，两个咬口配合使用，可为风管合缝。可加工板材厚度0.4-1.0mm，该机器为九排成型辊轮，生产速度可达18米/分，是传统制作的数倍以上。

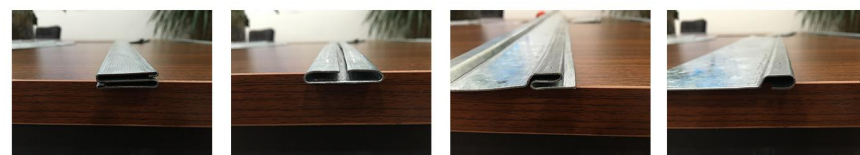
Snap lock machine is station with two seams, two bite used for wind pipe linking. Machinable plate thickness 0.4-1.0mm, the machine is nine rows of molding roller, production speed up to 18 meters / points, the traditional production of more than a few times.



### 主要技术参数 Main Technical Parameters

型号 Model	形状 Shape	加工厚度(mm) Thickness	功率 (Kw) Power	重量 (Kg) Weight	外型尺寸 (mm) Dimension
SNAP		0.4-1.0	2.2	250	1450*570*1000

## S 咬口机 S Lock Machine



### 功能 Function

S咬口机是通风管制作行业风管法兰的两种连接方式，该产品配有高质量精加工辊轮，优质的马达，高精度轴承，重型底盘；箱体坚固，轴经过磨圆，焊接的钢结构支架，保证机器的高效和长寿命，为您节约成本。

S lock machine is made of two kinds of ventilation pipe connection flange of the wind industry, the products with high quality finishing roller, high quality motor, high precision bearings, heavy-duty chassis; sturdy, shaft after grinding, welding steel structure bracket, ensure the machine efficiency and long life, cost saving you.



### 主要技术参数 Main Technical Parameters

型号 Model	形状 Shape	加工厚度(mm) Thickness	功率 (Kw) Power	重量 (Kg) Weight	外型尺寸 (mm) Dimension
SA-S		0.4-1.0	2.2	350	1450*700*1100

## 立式 S 咬口机 Standing S Lock Machine

### 性能特点 Performance Features

立式S骨是两个风管连接的另一种方式，它替代了传统扁平式S骨的地位，因为立式S骨在风管连接面是双重叠的。虽然扁平式S骨在风管连接后可以保证统一的外观，但它无法应用在大面积的风管方面，但立式S骨则解决了这个问题，因为它含有一个25mm高的法兰边用以提高其刚性，从而扩大了立式S骨的应用范围。

Standing S lock machine is another way of connecting two wind pipes. It replaces the status of the traditional flat S bone, because the vertical S bone is duplex in the connection surface of the wind pipe. Although the flat type S bone in the wind pipe connection can ensure uniform appearance, but it can not be applied in a large area of the duct, but the vertical bone S is to solve this problem, because it contains a high 25mm flange to enhance its rigidity, thus expanding the scope of application of vertical bone S.



### 主要技术参数 Main Technical Parameters

型号 Model	形状 Shape	加工厚度(mm) Thickness	功率 (Kw) Power	重量 (Kg) Weight	外型尺寸 (mm) Dimension
SA-LS		0.5-0.8	2.2	1200	4700*700*1100

## TDF 共板法兰机

### TDF Flange Machine



### 性能特点 Performance Features

共板法兰机按工作要求可分为三种型号：单机型T-12，T-15，双机联动共板法兰2-T-12：单机一侧成型法兰边，另一侧成型勾码边；双机联动法兰机两侧同时成型法兰边，提高工作效率，节约时间，另可根据客户需求在双机两外侧增加单法兰或勾码，做到一机两用。本公司特别推出GCr15材质高强度轧轴，使用寿命较普通45钢材质提高5倍以上，并可生产不锈钢共板法兰。

TDF flange machine can be divided into three types according to the working requirements: single type T-12 and T-15, duplex type 2-T-12. Single type machine like T-12 and T-15 can form flange edge at one side and crimping edge at the other side; duplex type like 2-T-12 can form flange edge at both sides simultaneously to improve efficiency and save time. Additionally, duplex type can add flange edge or crimping edge outside at either side. Our company would specially introduce high-strength rolling reels made of GCr 15, a kind of steel which prolongs the machine life by more than 5 times and outputs stainless steel TDF flange.



### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	加工形状 Shape	功率 Power (kw)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
T-12	0.5-1.2		3	840	2700x700x1110mm
T-15	0.8-1.5		4	950	2800x700x1110mm

## 双机联动共板法兰机

### Double TDF Flange Machine



### 性能特点 Performance Features

双机联动共板法兰机可一次完成风管两端的法兰边成型；双边驱动，采用台湾上银（HIWIN）直线导轨，达到高负载，高精度移动要求，另可根据客户需求在双机两外侧增加单法兰或勾码，做到一机两用。和单机相比，提高加工效率。缩短交货期，大大节约人工成本。本公司特别推出GCr15材质高强度轧轴，使用寿命较普通45钢材质提高5倍以上，并可生产不锈钢共板法兰。

Duplex TDF flange forming machine can form flange at two sides of duct simultaneously. It's double-sided driven and able to meet mobile requirements of high load and high accuracy with linear guideways of Taiwan Hiwin. Comparing with single type, duplex type help us improve efficiency, reduce delivery duration and save up labor. Our company would specially introduce high-strength rolling reels made of GCr15, a kind of steel which prolongs the machine life by more than 5 times and outputs stainless steel TDF flange.



### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	加工形状 Shape	功率 Power (kw)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
S-T-12	0.5-1.2		5.5	2100	2800x2800x1100mm
S-T-15	0.8-1.5		7.5	2300	2800x2800x1100mm

## TDC 法兰机

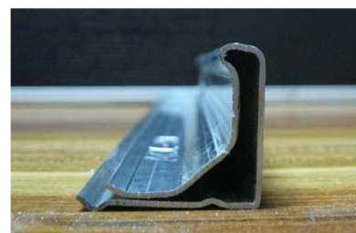
### TDC Flange Machine



### 性能特点 Performance Features

TDC法兰是目前国际上应用最广泛的风管法兰之一。它具有省时、省料、工作效率高、密封好、坚固耐用和驳接坚固等特点。它特别适用于通风管道截面面积较大的风管。TDC法兰机主要由送料架、冷轧成型主机和切割部分组成。配置了高速钢圆锯片不停机切割系统。可定尺切断。切断毛刺小，可实现全自动化生产。其工作速度为6米/分钟。按其工作性能和法兰强度及密封等级可以分为五种型号：T-20、T-25、T-30、T-35、T-40，其对应连接角码为

TDC flange is one of the most widely used air pipe flanges in the world. It has the characteristics of time saving, material saving, high efficiency, good seal, strong durability and strong refutation. It is especially suitable for the wind pipe with large section area of the ventilation pipe. TDC flange machine is mainly composed of feeding frame, cold rolling molding machine and cutting part. The high speed steel circular saw blade cutting system is configured. The ruler can be cut off. Cutting off the burr is small, and it can be fully automated. It works at a speed of 6 meters per minute. According to the working performance and strength of flange and seal level can be divided into five types: T-20, T-25, T-30, T-35, T-40, the corresponding connection corner is T-20DC, T-25DC, T-30DC, T-30DC and T-40DC.



### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	电机功率 Power(Kw)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
T-20	1.0	3	1520	5600*850*1500
T-25	1.0	4	1530	5600*850*1500
T-30	0.8	4	1550	5600*850*1500
T-35	1.0-1.2	4	1780	5600*850*1500
T-40	1.0-1.2	4	1800	5600*850*1500

## BYL-1500 螺旋风管机

### BYL-1500 Spiral machine



### 主要技术参数 Main Technical Parameters

型号 Model	BYL-1500
卷管直径 Tube diameter	80-1500mm
卷管长度 Tube length	120-8000mm
适材 Suitable material	镀锌板、不锈钢，铝 Galvanizde steel、Stainless steel、Aluminum
加工板厚 Thickness of strip	0.4-1.2mm
加工板宽 Width of strip	137-140mm
加工速度 Strip speed	1-45m/min
咬口 Lock seam	外圆管，可按照要求在内部咬口 Outside tube,on the inside on request
电控系统 Controlling system	电脑PLC控制。变频调速 PLC automatic control
主机功率 Main motor power	5.5KW
切割电机功率 Cutting motor power	4KW
切割方式 Cutting system	锯片切割 Sawing cutting
重量 Weight	约2200KG
包装尺寸 Packing dimension	2700*1700*2300mm

## BYL-1602 螺旋风管机

BYL-1602 Spiral Machine



### 性能特点 Performance Features

模块技术使客户有可能在多个选项之间进行选择，允许他创建一台机器，选择许多选项，允许他为自己的特定需求创建一台机器。频率控制主驱动器确保平稳加速和几乎无噪音的操作。优秀专利飞切割管无噪声或热火花已知从锯长度提供平滑的管端无毛刺。该设计和选择满足暖通空调生产在低碳钢，镀锌钢，不锈钢或铝的波纹单元允许降低材料成本，使更大直径管更严格的需要。

The module technique gives the customer the possibility to choose between a number of options, allowing him to create a machine a number of options, allowing him to create a machine for his specific needs. The frequency controlled main drive ensures a smooth acceleration and an almost noiseless operation. The outstanding patented flying slitter cuts the tubes to length without noise or hot sparks as known from the saws and provides smooth tube ends without deburring. The design and options fulfill the needs in HVAC to produce in mild steel, galvanized steel, stainless steel or aluminum. The corrugation unit allows a reduction in material costs and makes the bigger diameter tubes more rigid.

### 主要技术参数 Main Technical Parameters

型号 Model	BYL-1602
卷管直径 Tube diameter	80-1600mm
卷管长度 Tube length	120-8000mm
适材 Suitable material	镀锌板、不锈钢，铝 Galvanized steel, Stainless steel, Aluminum
加工板厚 Thickness of strip	0.4-1.3mm
加工板宽 Width of strip	137-140mm
加工速度 Strip speed	1-80m/min
咬口 Lock seam	外圆管 Outside tube, on the inside on request
电控系统 Controlling system	电脑PLC控制。变频调速 PLC automatic control
主机功率 Main motor power	5.5KW
模具 Mold	固定模具 Fixed Mold
切割方式 Cutting system	滚剪切割 Flying slitter cutting
重量 Weight	约3200KG
包装尺寸 Packing dimension	3400mm*2150mm*1600mm

## 椭圆风管机

Oval-shaped Duct Machine



### 性能特点 Performance Features

椭圆风管机能够将螺旋管制作成平直或椭圆的管道。PLC控制，LCD操作面板，储存了所有参数以便在实际操作过程中能被快速使用。

Oval-shaped duct machine can make a spiral pipe into a straight or elliptical pipe. The PLC control, the LCD operation panel, stores all the parameters so that it can be used quickly during the actual operation.

### 主要技术参数 Main Technical Parameters

加工板厚 Thickness range	0.4 -1.2mm
最大管长 Maximum duct length	3100mm
臂章范围 Arm range	最小圆管直径 Minimum diameter 330mm
模具规格 Die specification	φ 150、φ 200、φ 250、φ 300、φ 350、φ 400、φ 450、φ 500
托架规格 Tray specification	50、100、200、300、400、500、600mm
功率 Motor power	18.5Kw
重量 Weight	2720kg
外形尺寸 Dimension	5630 mm × 1250 mm × 1130mm

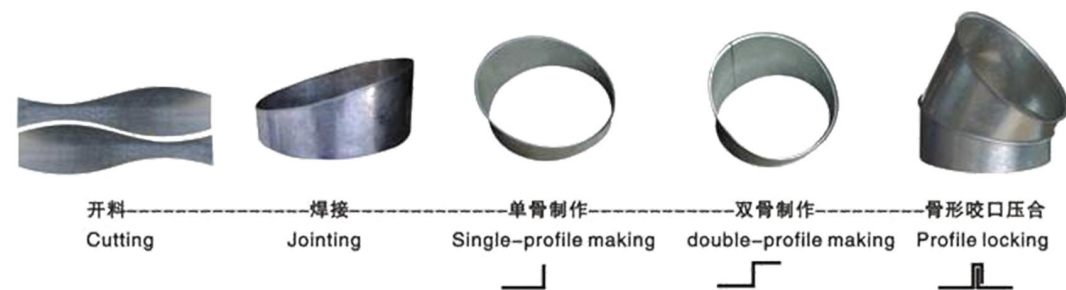
## 虾米弯头机

Electric Elbow Making Machine

### 性能特点 Performance Features

用于虾米弯头圆管的单口，双口骨型的制作及合缝。

It's also used for interface modeling and commissure of shrimp elbow tube.

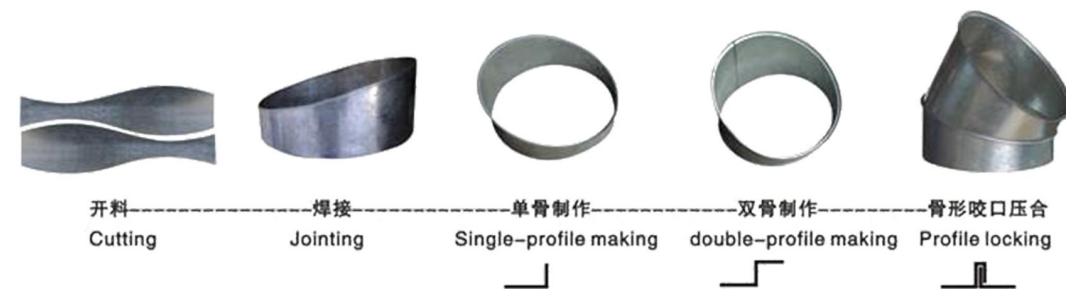


### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thicknes (mm)	加工直径 Sheet diameter (mm)	功率 Power (kw)	重量 Weight (T)	外形尺寸 Dimensions(LxWxH)
BY-1.2x1000	1.2	Φ120-1000	3	460	2220x920x1050mm

## 液压虾米弯头机

Hydraulic Elbow Making Machine



### 主要技术参数 Main Technical Parameters

电压 Voltage	380V/50Hz/3Ph or Customizable voltage
总功率 Power	5KW
液压油 Hydraulic Oil	55L
压缩气消耗 Compressed gas consumption	75L/hour 6har
最大成型速度 MAX Speed	120m/min
直径范围 Diameter range	137-140mm
重量 Weight	750Kg
镀锌板 Galvanizde steel	0.4-1.2mm
不锈钢 Stainless steel	0.4-0.8mm
铝板 Aluminum	0.4-1.2mm



## 角铁卷圆机

Electric Angle Rolling Machine



### 性能特点 Performance Features

用于角钢法兰的卷圆，选用40Cr材质，经整体热处理，经久耐用。

It's used for rolling angle steel flange and 40Cr steel with overall heat treatment makes the machine more durable.

### 主要技术参数 Main Technical Parameters

型号 Model	屈服极限 Yield limit	最小直径 Minimum diameter (mm)	最大加工能力 Maximum working capacity	功率 Power (kw)	重量 Weight (T)	外形尺寸 Dimensions(LxWxH)
J24Y-50	≤245	400mm	L 50x5	2.2kw	350kg	770x900x1180

## JY50/63 液压角铁卷圆机

JY50/63 Hydraulic Angle Rolling Machine



### 主要技术参数 Main Technical Parameters

项目	型号	JY-50	JY-63
屈服系数 Yield limit		≤245	≤245
最小卷圆直径 Minimum beading dimensions		300	300
角铁 Angle		L 50*5	L 63*6
机械外形 Model size(mm)	L	760	980
	W	660	860
	H	1020	1020
重量 Weight(kg)		350	430
主电机 Main motor(kw)		3	4

## 角铁卷圆打孔机

Angle Rolling And Punching Machine

### 性能特点 Performance Features

采用卷料直接滚压成形为角铁法兰形状后，自动切断角铁法兰。成形美观，尺寸精准，是用于圆形风管、风机行业法兰连接的首选产品。

The machine employs coilers to form angle iron flange, and then cut off the processed workpieces with pleasant appearance and accurate dimensions. It is a perfect choice when connecting round ducts or blower fan flange.



角铁卷圆成形机  
Section Bending Machine



自动打孔机  
Auto Holes-punching Machine

## 液压立式合缝机

Hydraulic Vertical Seam Closer



### 性能特点 Performance Features

风管立式合缝机可以和风管生产线、T12法兰机和轱骨机配套使用。联合口和直角边是风管连接的理想接口，合缝机SL-12可以不用任何其他辅助的连接工具，就能准确高质量的结合联合口的缝隙，不仅美观大方，而且不损伤金属表面、噪声低，合缝严密、平整，效果良好。适用于不同的板厚，合缝快速安全。采用三菱PLC控制，长时间工作性能稳定、优良。立式布局，符合人体力学的设计，操作方便，大大的提高了风管生产效率。

You can use the vertical seam closer and production line of wind pipe, T12 flange machine and reel bone machine. With mouth and a right angle edge is an ideal interface for connecting wind pipe linking machine SL-12 without any other auxiliary connection tools, can be combined with the high quality of the mouth of the gap, not only beautiful, but also does not damage the metal surface, low noise, tight linking and smooth, good effect. Suitable for different plate thickness, fast and safe linking.

Using MITSUBISHI PLC control, long time work performance is stable and excellent. Vertical layout, in line with the design of human body mechanics, convenient.

### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Thickness	加工长度 Length	功率 Power	重量 Weight	外形尺寸 Dimension
SL-12	0.4-1.2	1000-1550	4	1060	1000*1000*2100

## 气动合缝机

Pneumatic Seam Closer

### 性能特点 Performance Features

用于1250mm以内的矩形风管联合咬口的合缝，气动操作，减少人工，提高效率。

It's used for locking rectangular duct within 1250mm and pneumatic operation can save labor and improve efficiency.



### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	流体压力 Fluid pressure (Mpa)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
HFJ-1250	1.0mm	0.6-0.8	650	3200x1000x1030

## 轱合骨机

Duct Seam Closer

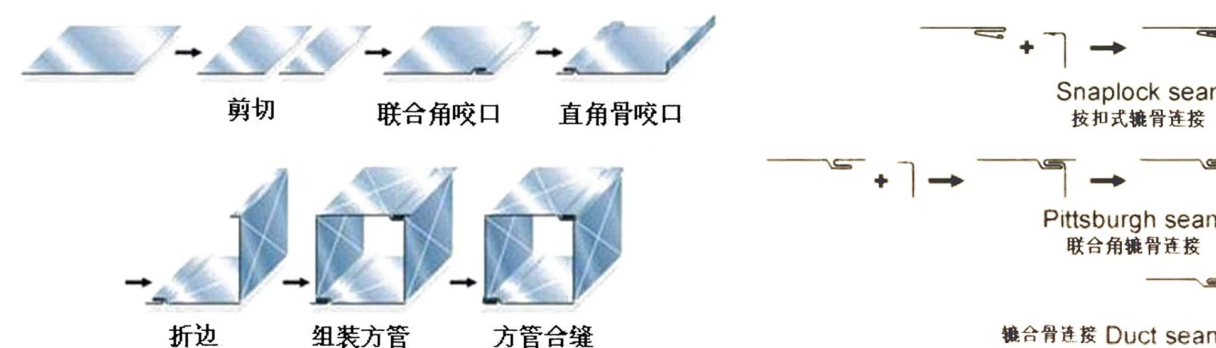


### 性能特点 Performance Features

传统的风管接合需经纵向轱骨，两端法兰成型后折弯咬合才能成型，轱合骨机将传统的风管接合“三步曲”合二为一，大大的节约了人工和生产成本。

The traditional wind pipe joint by vertical roller bending forming to both ends of bone, occlusal flange, reel bone machine will be the traditional wind pipe joint "three steps" to be made one, save labor and production costs.

### 主要技术参数 Main Technical Parameters



型号 Model	加工板厚 Sheet thickness (mm)	最小风管尺寸 Minimum duct size (mm)	支承高度 Support height (mm)	支承长度 Support length (mm)	支承臂数量 Number of supporting arms(pcs)	加工高度 Processing height (mm)
H-10	0.4-1.0	150*150	700	1550	2*3	800
H-08	0.4-0.8	100*100	700	1550	2*3	800

## 手持电动合缝枪

Hand Operated Electric Duct Closer



### 主要技术参数 Main Technical Parameters

电压 Power	220V
频率 Frequency	50/60Hz
材料强度400N/MM Material strength	0.75-1.25mm
工作速度 Work speed	4-7m/min
空转时的速度 Rotating speed	160/min
额定消耗功率 Rated power consumption	1400w
重量 Weight	6.6kg
内径 ID	≥300mm
外径 OD	≥400mm
保护绝缘 Protection of insulation	II级

## 圆管合缝机

Round Duct Seam Closer



## 手持气动合缝枪

Hand Operated Pneumatic Duct Closer



### 主要技术参数 Main Technical Parameters

型号 Model	250
板材厚度 Thickness	0.5-1.5mm
所需气压 Required pressure	7kg/cm <sup>2</sup>
打击次数 Percussion times	2200rpm
气缸行程 Cylinder stroked	90mm
耗气量 Air consumption	5scfm
进气螺丝 Intake screw	1/4"
风管内径 ID	3/8"
工作气压 Working pressure	0.63Mpa
净重 Weight	2.6kg

### 主要技术参数 Main Technical Parameters

型号 Model	BYHF-1.5*2000	BYHF-1.5*1500
最大加工长度 Max.length	2000mm	21500mm
最大加工厚度 Max.thickness	1.5mm	1.5mm
最小加工直径 Min.diameter	φ 100	φ 100
电机功率 Power	0.55KW	0.55KW
重量 Weight	455KG	455KG
外型尺寸 Dimension	2770*780*1370	2690*950*1600

# 气动缝焊机

Pneumatic Welding Machine



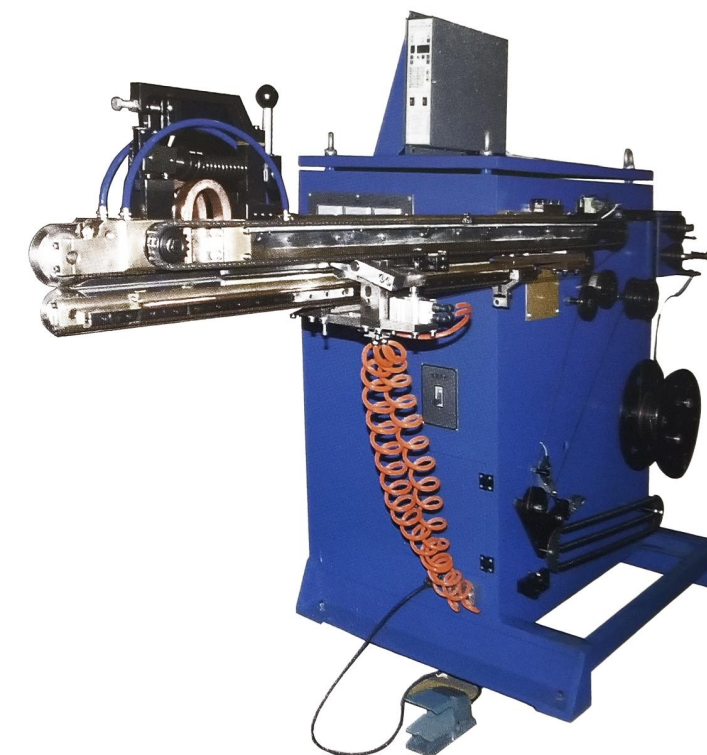
## 主要技术参数

Main Technical Parameters

型号	FN-35	FN-55	FN-75	FN-100
板厚	0.4-1.0mm	0.4-1.0mm	0.4-1.0mm	0.4-1.0mm
最大输入电容量	45KVA	55KVA	75KVA	100KVA
最大短路电流	6200A	11000A	16000A	26000A
最大电极压力	400KGF	600KGF	1000KGF	1000KGF
冷却水流量	6L/min	6L/min	6L/min	6L/min
臂伸长度	600mm	600mm	600mm	600mm
电极行程	80mm	80mm	80mm	80mm
焊接速度	0.5-3m/min	0.5-3m/min	0.5-3m/min	0.5-3m/min
重量	328kg	378kg	428kg	478kg
外型尺寸	1800*610*1930	1800*610*1930	1800*610*1930	1800*610*1930

# 风管直缝焊机

Stitchwelder



## 主要技术参数 Main Technical Parameters

焊接直径 Diameter	φ 100- φ 1000
焊接长度 Range length	50-1000mm
焊接搭接量 Overlap	6mm
焊板厚度 Thickness	0.4-1.2mm
焊接速度 Speed	2m/min
铜丝直径 Copper diameter	φ 2.0-2.2mm
最大功率 Max power	40Kw
重量 Weight	2500Kg
外型尺寸 Dimension	1000*2000*1700mm

## 气动角码安装机

Pneumatic Corner Mounting Machine



### 性能特点 Performance Features

主要用于矩形风管的角码自动安装，替代人工砸装角码，快速，省时，高效。

It's used for installing rectangular duct corner code automatically to replace workers, which is fast, time-saving and effective.

### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	流体压力 Fluid pressure (Mpa)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
CM-12	1.2mm	0.6-0.8	450	1500x800x1050

## 压筋机

Beading Machine



### 性能特点 Performance Features

五线，七线压筋机用于风管行业制作加强筋使用，可一次压出五条或七条加强筋，并可根据客户要求定制多线平行压筋机。

Line 5/line 7 beading machines are used to make reinforced ribs in the duct area, and it can output 5 or 7 reinforced ribs at one time. Customer can customize multiple-line beading machine according to different requirements.

### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	加工板宽 Max width (mm)	功率 Power (kw)	重量 Weight (T)	外形尺寸 Dimensions(LxWxH)
G1.2x1300	1.2	1300	1.5	460	1550x900x1060
G1.2x2000	1.5	2000	3	650	2300x900x1120

## 电动剪板机

Electric Shearing Machine

### 性能特点 Performance Features

本机采用全钢焊接结构，闸式下传动剪切原理，链条传动，电机自带刹车，不剪切不耗电，适合于3毫米以下的普通钢板剪切加工。

The machine is overall steel-welded and gate-type with chain drive. The motor has its own brake, which means no power consuming when not shearing. It's suitable for processing sheet metal less than 3mm in thickness.



### 主要技术参数 Main Technical Parameters

型号 Model	可剪板厚 Shear plate thickness (mm)	可剪板宽 Shear plate width (mm)	行程次数 Number of strokes (/min)	功率 Power (kw)	外型尺寸 (mm) Dimensions(LxWxH)
Q11-3x1300	3	1300	30	4.5	2000x900x1250
Q11-3x1600	3	1600	30	4.5	2300x900x1250
Q11-3x2000	3	2000	30	5.5	2700x900x1250
Q11-2x2500	2	2500	30	5.5	3200x900x1250

## 电动偏三星卷板机

Electric Three-Roller Beading Machine



### 性能特点 Performance Features

具有预弯功能，直边更小，最小可卷直径100mm的小型圆管，增加手动涡轮杆及偏心轮装置，可快速升降侧辊，提高工作效率。

It has Pre-bending function, make straight edges narrower, and it can even roll small round pipe with diameter of 100mm. with manual worm gear and eccentric wheel device so that the machine can quickly move side rollers up and down to improve efficiency.

### 主要技术参数 Main Technical Parameters

型号 Model	最大厚度 Maximum thickness (mm)	最大宽度 Max width (mm)	最小直径 Minimum diameter (mm)	功率 Power (kw)	重量 Weight (T)	外形尺寸 Dimensions(LxWxH)
W11G-2*1000	2	1000	100	1.5	240	1400*600*1100mm
W11G-1.5*1300	1.5	1300	100	1.5	260	1700*600*1100mm
W11G-1.5*1500	1.5	1500	100	1.5	280	1900*600*1100mm

## 手动折边机

### Manual Folding Machine



#### 性能特点 Performance Features

手动折边机是现代薄板钣金加工中的设备之一，专业用于薄板的折边弯加工，具有重量轻、操作简单、搬运方便，更适合短期临时工地现场折弯加工，可在任何环境中使用。长度可根据客户定做。

Manual folding machine is one of the modern sheet metal processing equipment, professional for thin plate bending process, has the advantages of light weight, simple operation, convenient transportation, more suitable for short-term temporary site bending processing, can be used in any environment. The length can be based on user customized.

#### 主要技术参数 Main Technical Parameters

型号 Model	最小折弯角度 Sheet thickness (mm)	重量 Weight (T)	外形尺寸 Dimensions(LxWxH)
WS-1.5x1300	60°	400	1950x650x1500
WS-1.5x1500	60°	440	2150x650x1500
WS-1.5x2000	60°	500	2650x650x1500
WS-1.5x2500	60°	600	3150x650x1500

## 手动共板折边机

### Manual TDF Folding Machine



#### 性能特点 Performance Features

本机可对已做好法兰的板材进行折弯加工，实现板材的三折，是共板法兰风管加工过程中实用必备的设备，同时又可以作为通用折边机使用。

This machine is able to bend the flange sheet metal to get three folds, and it's also considered as a general crimping machine.

#### 主要技术参数 Main Technical Parameters

型号 Model	最小折弯角度 Sheet thickness (mm)	重量 Weight (T)	外形尺寸 Dimensions(LxWxH)
TDF-1.5x1300	45°	450	1950x650x1550
TDF-1.5x2000	45°	600	2650x650x1550
TDF-1.5x2500	45°	700	3100x650x1550

## 气动折边机

### Pneumatic Folding Machine



#### 性能特点 Performance Features

采用四缸气动作为动力源，双缸压紧，双缸折弯，无需电源，操作平稳，是共板法兰风管折弯的高效理想设备，并可根据客户要求定制普通机型。

Taking 4-cylinder pneumatic system as power source, two cylinders are used for bending when the other two are used for pressing. Working stably without power makes the machine an efficient ideal equipment, and our company can customize general type according to the customer requirements.

#### 主要技术参数 Main Technical Parameters

型号 Model	最小折弯角度 Sheet thickness (mm)	重量 Weight (T)	外形尺寸 Dimensions(LxWxH)
QTDF-1.5x1300	60°	380	2000x800x1300
QTDF-1.5x2000	60°	500	2700x800x1300
QTDF-1.5x2500	60°	580	3200x800x1300

## 电动折边机

### Electric Folding Machine

#### 性能特点 Performance Features

本机械为全钢板焊接结构，经振动时效，保证强度高，变形量小，操作方便，机床能耗低，经久耐用。全液压设计，系统宁静，维修简易，压刀可分段，适合于盘盒类工件制作，开口高度200mm。

上压刀可自动调整高度，工作角度可快速调校，特别适合厨具、五金、家具等加工业。

This machine is completed welded by steel plates, Through vibratory treatment to ensure high strength and small deformation, operation simply and low energy, long time usage. Adopting completed hydro design, system silently, maintenance simple and bending tools could be segmented, open height up to 200mm, much suitable for panel and boxes fabrication.

Upper blades' height could be adjusted automatic, and the bending angle could be changed rapidly, much more suitable for kitchenware, hardware and furniture and other industry.



#### 主要技术参数 Main Technical Parameters

型号 Model	折板能力 The panels ability(mm)	最小折弯度 Aboard the degrees angle(°)	开距 Open from(mm)	主电机和副电机功率 The electrical and auxiliary power(kw)	重量 Weight(kg)	外形尺寸 Dimensions(LxWxH)
W625D1.5x1300	1.5x1300	55°	160	3/1.5	450	1950x650x1550
W625D1.5x2000	1.5x2000	55°	160	3/1.5	600	2650x650x1550
W625D1.5x2500	1.5x2500	55°	160	4/1.5	700	3100x650x1550

## 液压折边机

### Hydraulic Folding Machine

#### 性能特点 Performance Features

本机床广泛用于有色金属板，不锈钢板的折弯，翻边工作，是家用电器、不锈钢厨具、灯饰、五金家具、冷暖通风、空调设备等箱体、管道的成型加工设备。

This machine is widely used for bending and folding steel plate. Non-ferrous metal plate and stainless steel plate. It is the forming and fabricating equipment of boxes and pipes and especially suitable for machining household appliance, stainless kitchenware, lighting hardware and furniture, HVAC, air condition equipment.



#### 主要技术参数 Main Technical Parameters

项目	型号	W62Y-2x2500	W62Y-3x2500	W62Y-2x3100
折板宽度 Folding length(mm)		2500	2500	3100
折板厚度 Folding thickness(mm)		2.0	3.0	2.0
折边梁回转角度 Bending angle of the bending beam (°)		110°	110°	110°
上梁最大上升度 Max. lift of the upper beam(mm)		200	200	200
机械外形 Model size(mm)	L	3350	3350	3875
	W	1000	1000	1000
	H	1100	1100	1100
重量 Weight(kg)		2200	2200	2500
主电机 Main motor(kw)		4.5	5.0	5.5

## 辘线机

Rotary Machine

### 性能特点 Performance Features

辘线机分手动辘线机和电动辘线机，主要完成圆管压筋，连接等功能。

There are manual and electric type of reel machine and it's mainly used for beading round pipe and connection.



### 主要技术参数 Main Technical Parameters

型号 Model	形状 Shape	板厚 Sheet thickness (mm)	功率 Power (kw)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
LH-15		1.2	0.75	90	400x860x960mm
LH-10		1.0	无	50	560x310x970mm

## 铆钉机

Hydraulic Riveting Machine

### 性能特点 Performance Features

适用于角钢法兰与镀锌板材连接的铆接作业，操作方便，移动灵活。

It's widely used for riveting angle steel flange and galvanized sheet metal because the machine is easy to operate and move.



### 主要技术参数 Main Technical Parameters

型号 Model	压力 Pressure (mm)	铆钉 Rivet (mm)	功率 Power (kw)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
DMY-1	10-12	4x10/5x10	1.5	65	600x400x650mm

## 牛头剪

Reel Shearing Beading Machine

### 性能特点 Performance Features

辘剪压筋机，又名牛头剪，既可剪板，又可压筋，滚剪刀片，适用于薄板分条剪切。

Reel shear beading machine, or Ngau Tau scissors, is capable of shearing and beading, and it's also suitable for slitting.



### 主要技术参数 Main Technical Parameters

型号 Model	加工板厚 Sheet thickness (mm)	加工形状 Shape	功率 Power (kw)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
LQ-15	1.5		1.5	260	1600x600x1120

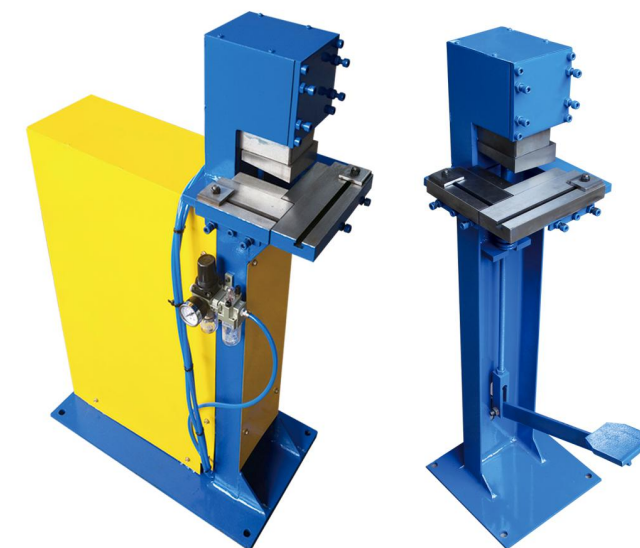
## 脚踏 / 气动剪角机

Reel Shearing Beading Machine

### 性能特点 Performance Features

剪角机分脚踏式和气动式两种，用于金属薄板的直角剪切。

There are two types: pedaled type and pneumatic type; and it's use for notching or cutting right angle on sheet metal.



### 主要技术参数 Main Technical Parameters

型号 Model	板厚 Sheet thickness (mm)	剪直角尺寸 Angle size (mm)	重量 Weight (Kg)	外形尺寸 Dimensions(LxWxH)
Q-1.2x80	1.2	80*80	50	420x290x950
QD-1.2x80	1.2	80*80	70	650x300x1000