

STEEL STRUCTURE PRODUCTION LINE

H-BEAM ASSEMBLING, WELDING AND STRAIGHTENING INTEGRAL MACHINE

INTRODUCTION

This is a special machine for H beam assembling, welding and straightening, it combines the three processes into one machine, thus improves productivity, reduces cost, and saves the installation space. It can produce H beam and T beam with high efficiency



PERFORMANCE AND CHARACTERISTIC

1. the main assembling machine adopts heavy duty assembling structure which has applied invention patent, web plate and flange plate centering and positioning automatically, to make the assembling precision and efficiency greatly improved.
2. Firm welding torch fix mechanism is set up separately, it not only can adjust height and horizontal moving position, also can adjust the angle of welding torch on two directions, it guarantees the nice seam form.
3. assistant straightening machine has special designed structure, the two straightening rollers can straighten workpiece automatically under the pushing of oil cylinder, straightening mechanism will not block the line of sight on seam, it is convenient to see the adjustment of welding torch and seam quality.
4. Assembling machine and assistant straightening machine can be discharged and work separately.
5. Assistant straightening machine can work as small straightening machine after refit.



TECHNICAL PARAMETER

Web plate height	Web plate thickness	Straightening speed	flange plate width	flange plate thickness	main machine power
200-1500mm	6-14mm	0.35-3m/min	200-800mm	6-20mm	17.5KW

H-BEAM HORIZONTAL PRODUCTION LINE

INTRODUCTION

1. Adopting horizontal assembling made h-beam can be a shape to improve assembling efficiency.
2. Adopting horizontal welding to reduce welding deformation.
3. Adopting single arc double wires method to improve welding speed.



INTRODUCTION

H-beam steel Horizontal production line consists of assembling machine, auto welding machine, overturning machine and input/output conveyor. It is suitable for H-beam (light duty) volume-produce. The production efficiency is 1.5 times that of the ordinary steel.



TECHNICAL PARAMETER

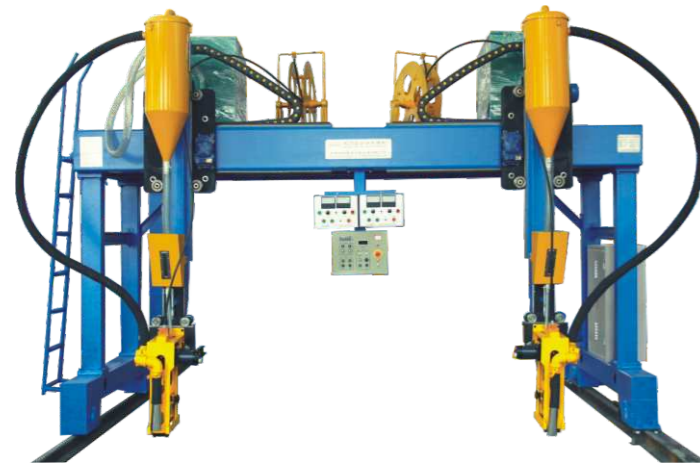
Web height	Web thickness	Welding speed	Flange width	Flange thickness
300-1500mm	4-16mm	0.3-1.9m/min	150-500mm	5-20mm

STEEL STRUCTURE PRODUCTION LINE

H-BEAM AUTO-WELDING MACHINE

PERFORMANCE AND CHARACTERISTIC

The auto-welding machine for H beam accepts the AC frequency converter to control speed with the merits of stable and reliable running and quick returning. It uses the auto-arc tracing & centering device to ensure the welding gun being auto and correct centering to the target workpiece. Meanwhile, it is equipped with the auto welding flux feeder and recovery system, easy operating and high efficiency. And the column-beam welding machine can increase the height of web according to the need of users.



LMH-4000



SXBH20

TECHNICAL PERFORMANCE

Model	Height of web	Width of flange	Model of welder	Mode welding	Welding speed	Returning speed	Rails span	Overall Power
LMH-4000	200-1500mm	200-800mm	Two sets of model MZ-1-1000 auto submerged-arc welders	boat-type welding	0.15-1.0m/min	3m/min	4000mm	9.6kw
SXBH20	200-2000mm	200-800mm	Two sets of model MZ-1-1000 auto submerged-arc welders	boat-type welding	0.15-1.0m/min	3m/min	2000mm	10kw



H-BEAM FLANGE STRAIGHTENING MACHINE

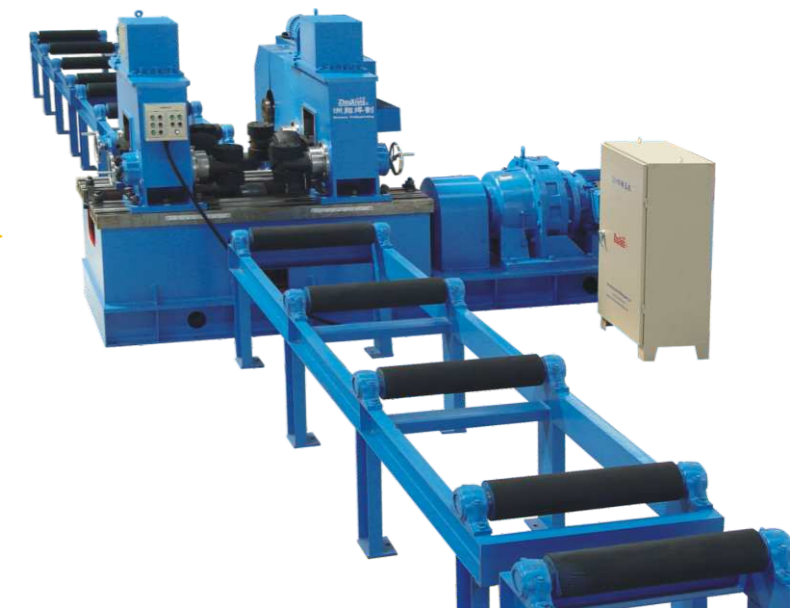
TECHNICAL PERFORMANCE

This machine is a special equipment for leveling the H-beam flange whose figure was deformed when it being welding. It has the feature of easy operating, high efficiency, reliable working etc.

Mode	JZJ-600	JZJ-800
Width of flange	150-600	200-800
Thickness of flange	≤20mm	≤40mm
Min height of web	160mm	350mm
Materia	Q235-A	Q235-A
Straightening speed	8.5m/min	9m/min
Power of over all machine	6.6kw	13.2kw



JZJ-800



YJZ60D HYDRAULIC STRAIGHTENING MACHINE

TECHNICAL FUNCTION

This machine is different with YJZ-60B hydraulic straightening machine, and uses the structure of JZJ-800 mechanical one, the two upper rollers press down. But it uses oil cylinder, instead of reducer, to drive the rollers. This machine has the following features:

- Both sides of flange can be straightened separately to gain better effect.
- Conveying Roller doesn't elevate, thus save cost and operate easily.

Thickness of plate	6-60mm (6-40mm for Q345)
Width of flange	200-800mm
Height of web	≥160mm
Material	Q235-A
Straightening speed	9.8m/min
Main transmission motor power	15kw
Hydraulic pump power	5.5kw
Working pressure	25Mpa



Flange width and thickness should be in accordance with the following list

Thickness	6-20	20-30	30-40	40-50	50-60
Width	200-800	350-800	500-800	650-800	750-800

STEEL STRUCTURE PRODUCTION LINE

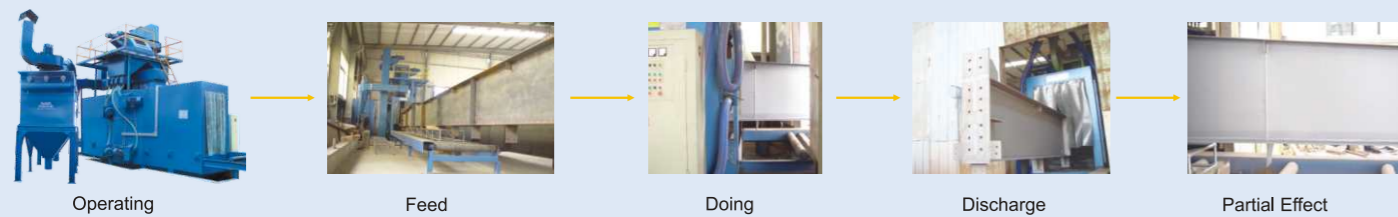
H-BEAM SHOT-BLASTING AND CLEANING MACHINE

TECHNICAL PERFORMANCE

H-beam shot-blasting and cleaning machine with HGP continuous rolling series is researched and developed in accordance with the features of the steel structure. The machine is adopted with computer 3-dimension dynamic simulating design to locate the position of the shot-blasting machine. The machine is equipped with a highly efficient filter-barrel pulse back-blowing dust removal.



FILTER CYLINDER DUST REMOVAL



MAIN TECHNICAL PARAMETER:

Type		HGP0816	HGP1018	HGP1220
Size of the work-piece	Section(width × height)	800 × 1600mm	1000 × 1800mm	1200 × 2000mm
	Length of the work-piece	3000 × 12000mm	3000 × 15000mm	3000 × 15000mm
Quality Standard	Cleanness of the surface	A-B Sa2-Sa2 1/2	A-B Sa2-A-B Sa2 1/2	A-B Sa2-A-B Sa2 1/2
	Roughness of the surface	15-50 μm	15-50 μm	15-50 μm
Shot-blaster	Qty	8	8	8
	Quan of shot-blasting	8 × 200kg/min	8 × 200kg/min	8 × 200kg/min
	Power	8 × 11KW	8 × 11KW	8 × 11KW
Inlet and outlet conveyor	Allowable load	1000kg/m	1000kg/m	1000kg/m
	Conveying speed	0.5-5m/min	0.5-5m/min	0.5-5m/min
Ventilation capacity		12000m ³ /h	12000m ³ /h	12000m ³ /h
Circulating quan of the shots		120T/h	120T/h	120T/h
Nominal Size(L × W × H)		6770 × 2100 × 2900mm	7200 × 2300 × 3250mm	7200 × 2520 × 3650mm
Depth of the pit		1950mm	1950mm	1820mm
Total power		140KW	140KW	140KW

SHEET SHOT BLASTING MACHINE

TECHNICAL PERFORMANCE

BP/HGP steel sheet shot blasting machine is mainly used to clean the surface of steel sheet and small profile beams. After clean by steel shots, the rust, dust, oxidated skin can be removed, the materials anti-wear strength is improved, the surface and inside quality is promoted. This equipment is widely used for chemical, ship yard, metal structures, steel products, rail vehicles, engineering machinery and bridge industry.



MAIN TECHNICAL PARAMETER:

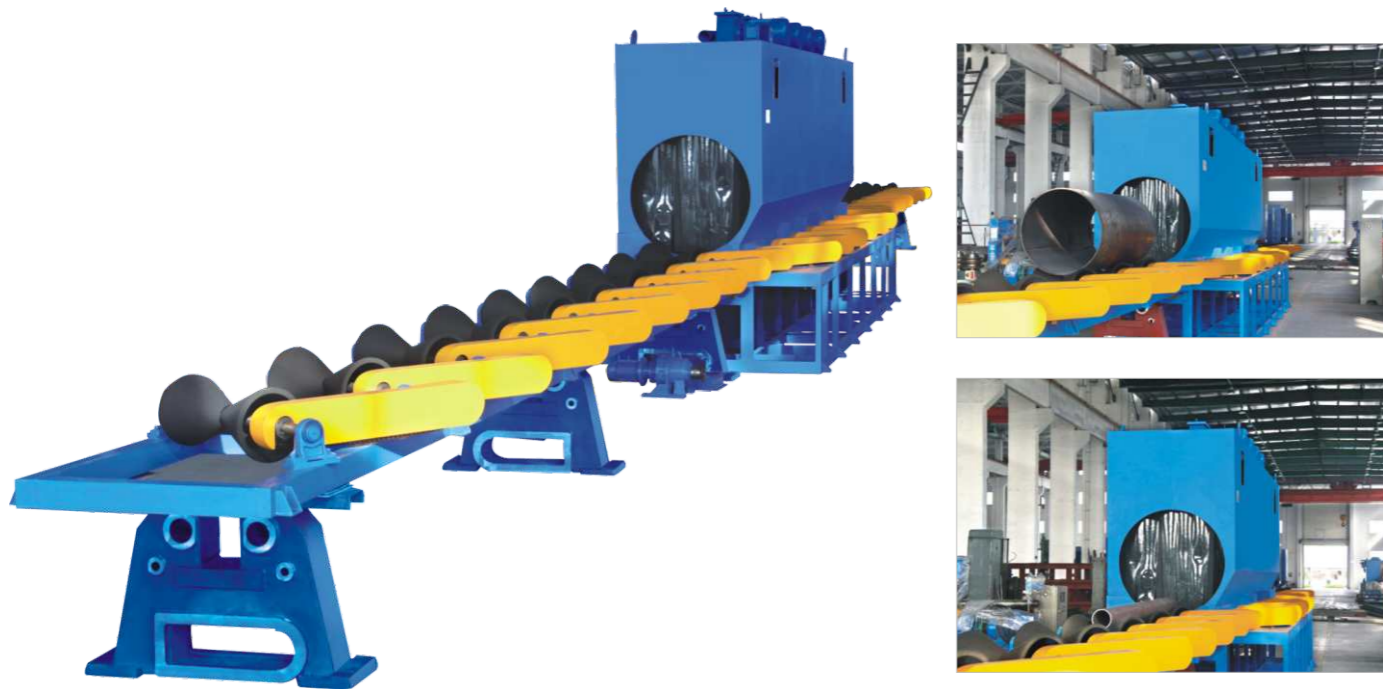
		Model	BP2500-6	HGP2224-12	BP-3500-12
Size of work piece	Section(W×H×L)		2500×400×15000mm	2200×2400×15000mm	2500×1200×1500
	Speed		0.5~5m/min	0.5~5m/min	0.5-5m/min
conveyor	Power		3×3kw	3×5.5kw	3-5.5kw
	Moder		Q034 II	Q034 II	Q034 II
Shot blaster	Shot blasting speed		65~70m/s	65~70m/s	65-70m/s
	No xunit power		6×18.5kw	12×18.5kw	12×18.5kw
Lifter	Power		7.5kw	11kw	11kw
Longnitudinal conveyor	Conveying capacity		120T/h	180T/h	180T/h
	Power		5.5kw	7.5kw	7.5kw
Feeding conveyor	Conveying capacity		120T/h	180T/h	180T/h
	Power		2×4kw	4kw+5.5kw	4kw / 5.5kw
Dust collection system	Model		LMC-18	LMF- II	LMC-24
	Ventilation capacity		12000m ³ /h	24000m ³ /h	2000m ³ /h
Centrifugal ventilator	Moder		4-72-5A	4-72-8C	4-72-8C
	Power		15kw	22kw	22kw
Cleaning system	Ventilation capacity		6762m ³ /h	5000m ³ /h	6762m ³ /h
	Power		18.5kw	15kw	18.5kw
Overall power			154kw	214kw	270kw
Overall dimension			7900×3100×3300mm	9750×3600×4580mm	7900×4100×4300
Height overground+underground of main machine			6600mm+2400mm	8250mm+2350mm	8500mm+2560mm

STEEL STRUCTURE PRODUCTION LINE

GGP1050 PIPE SHOT-BLASTING MACHINE

FUNCTION DESCRIPTIONS

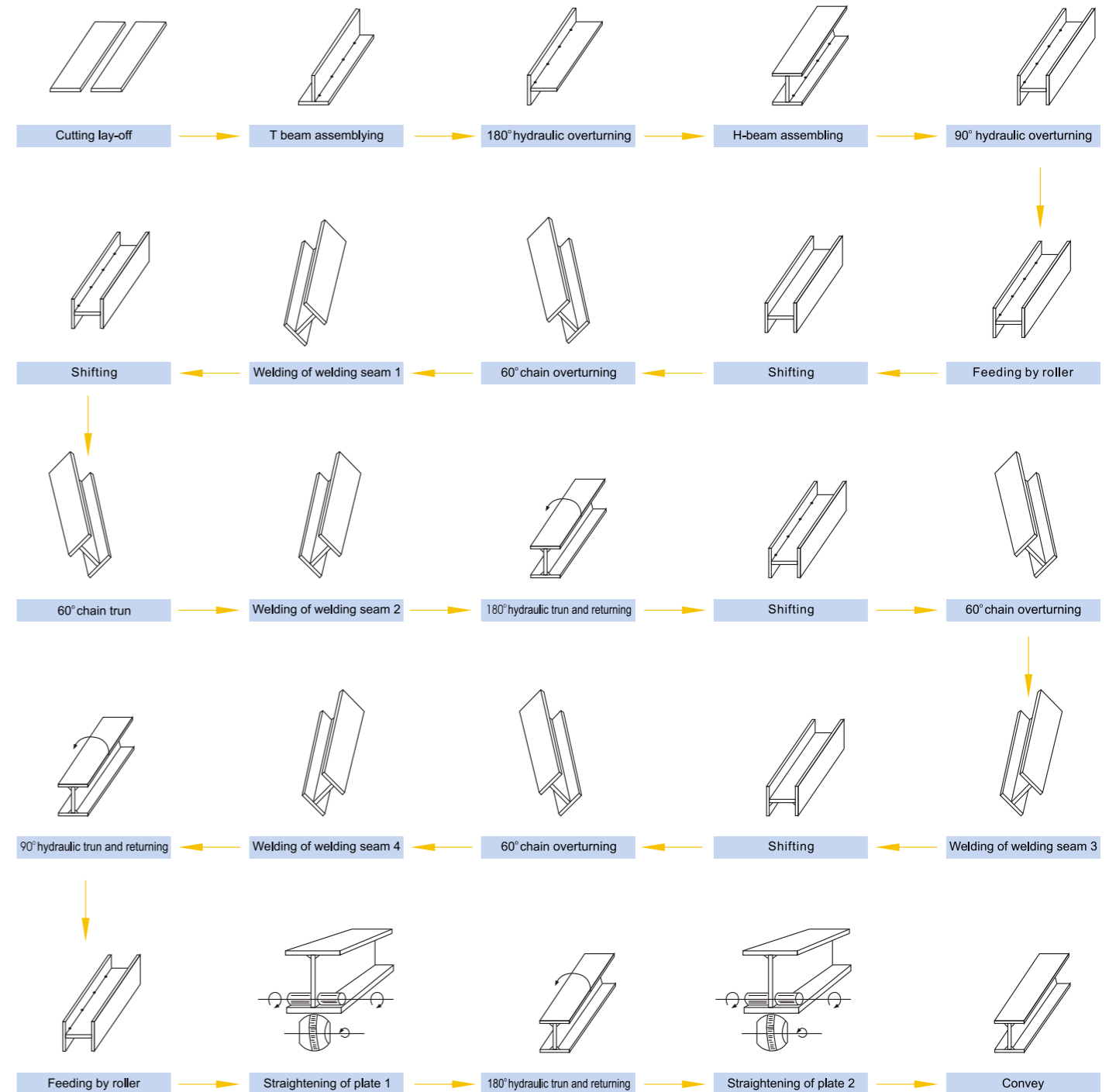
Pipe shot-blasting machine is widely used to clean the small and medium size pipes. The work-piece rotate and run automatically on the convey roller which has a 'V' type roller, the rust, oxidized skin can be removed. The running speed of the work-piece can be adjusted according to the requirements of the surface quality.



MAIN TECHNICAL PARAMETER:

Model	GGP1050	
Specification	≤ Φ1050	
Length	3000~12000mm	
Convey roller	Cone-shape rotating speed	1.2~12rpm
	Power	3KW
	Roller frame	2×11000 mm
Shot- blaster(4sets)	Shot blasting speed	65~70m/s
	Power	4×11Kw
Elevating machine	Power	5.5Kw
	Conveying capacity	50t/h
Lengthways screw conveyer	Power	4Kw
	Ventilation capacity	8000 m3/h
Dust collection system	Dust removal fan model	4-72-4.5A
	Power	5.5Kw
	Total power	68Kw
Standard of dust removal	Sa2-2.5 GB8923-88	
Overall dimension(L×W×H)	7500×2000×3120mm	

TECHNICAL PROCESS OF H-BEAM(HEAVY STEEL) AUTOMATIC WELDING PRODUCTION LINE



STEEL STRUCTURE PRODUCTION LINE



VERTICAL ASSEMBLY FOR HEAVY DUTY



TECHNICAL PERFORMANCE

The vertical assembly machine which the flange,web fastening and calibrating, positioning,and auto spot welding equipped, all of which accept the Japanese Mitsubishi programmable controller and the Ac frequency converter so as to increase the productivity one times above comparing with common products, with the features of stable and reliable working state and the welding gun is equipped with the arc-tracing device to ensure the quality of spot welding.

Web of Size	Height	200-2000mm
	Thickness	6-32mm
	Length	6000-15000mm
Size of Flange	Width	200-800mm
	Thickness	6-40mm
	Length	6000-15000mm
Assembling speed	0.5-6m/min	
Machine power	16.5KW (Two welding machines are excluded)	

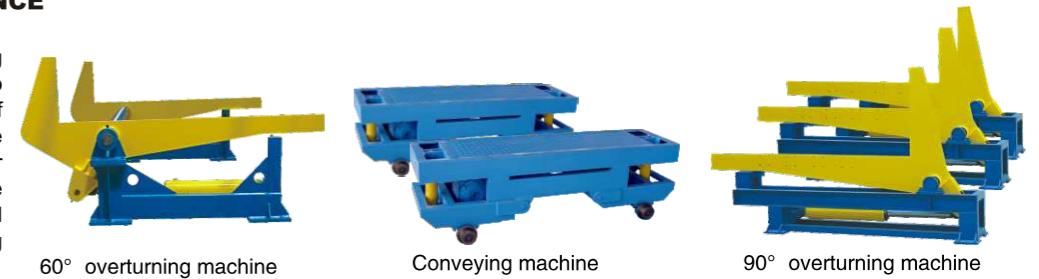


TURNING AND CONVEYING MACHINE



TECHNICAL PERFORMANCE

In order to improve manipulating and conveying efficiency and to reduce the usage frequency of moving the machine,we provide the chain manipulator,the conveyer for steel,overturning support to realize automatic conveying and manipulating for the whole welding and straightening course.



60° overturning machine

Conveying machine

90° overturning machine

180° HYDRAULIC OVERTURNING MACHINE

TECHNICAL PERFORMANCE

Moving type 180° overturning machine is composed of main machine, hydraulic system and electrical control system. Main machine is composed of 90° overturning arm, base frame, moving wheel group, moving motor gearbox box and rail.

When working away from roller conveyor, gear motor driving two groups overturning frame moving simultaneously, to make workpiece moving to the side of roller conveyor, and finally oil cylinder push arm to turning workpiece 180°, and then moving to roller conveyor and conveying, cable oil pipe adopts drag link packing, safety and beauty, reliable, the total machine structure is compact and operation is simple.



180° hydraulic overturning machine

Suitable work-piece weight	≤15T
Max section dimension of overturning work-piece	800 x 1500mm
Moving motor power	2 x 1.5KW
Moving speed	6m/min
Overturning cylinder diameter	φ 140mm
Max pressure of hydraulic system	20Mpa
Power of the machine	18.5KW



STEEL STRUCTURE PRODUCTION LINE

CANTILEVER WELDING MACHINE

TECHNICAL PERFORMANCE

XBH type column-beam welding machine adopts the imported AC transducer. The equipment is stable and reliable in operation, and has the quick move-back function. The tracking arc-guide mechanism is three-spindle tracking system to guarantee the alignment and not bias are on the weld. The main frame and the welding machine are performed integrated interlocking and the equipment is provided with flux auto-recovering system and it is easy controlled, and highly efficient.



Type	XBH
Height of web(mm)	200-2000mm
Width of flange(mm)	200-800mm
Length of H-beam	4000-15000mm
Welding machines	MZ-1-1000Auto-submerged two sets of model MZ-1-1000 auto union melt welder
Welding mode	Ship-welding
Welding velocity	0.3-1.5m/min
Reverse velocity	3m/min
Track distance	1150mm
Power of the assembling machine	4.75kw (Welding machine is excluded)

HORIZONTAL TYPE H-BEAM STRAIGHTENING MACHINE

TECHNICAL PERFORMANCE

Horizontal straightening machine can achieve both sides straightening of the H-beam flange at the same time, improve the efficiency of straightening. And can work with H-beam horizontal production line, can achieve the whole process from H-beam assembling, welding to straightening.

Horizontal straightening machine mainly consists of fixed end straightening unit, moving end straightening unit, conveyor roller, hydraulic system, electric control system.

Model	WJ40B	WJ60B
Web height	300-1000mm	350-2000mm
Web thickness	6-30mm	6-40mm
Flange width	120-500mm	350-900mm
Flange thickness	6-40mm	6-60mm
Workpiece length	4000-15000mm	4000-20000mm
Material	Q345B	Q345B
Straightening speed	6.2m/min	7.4m/min



YJZ60C HYDRAULIC STRAIGHTENING MACHINE

TECHNICAL PERFORMANCE

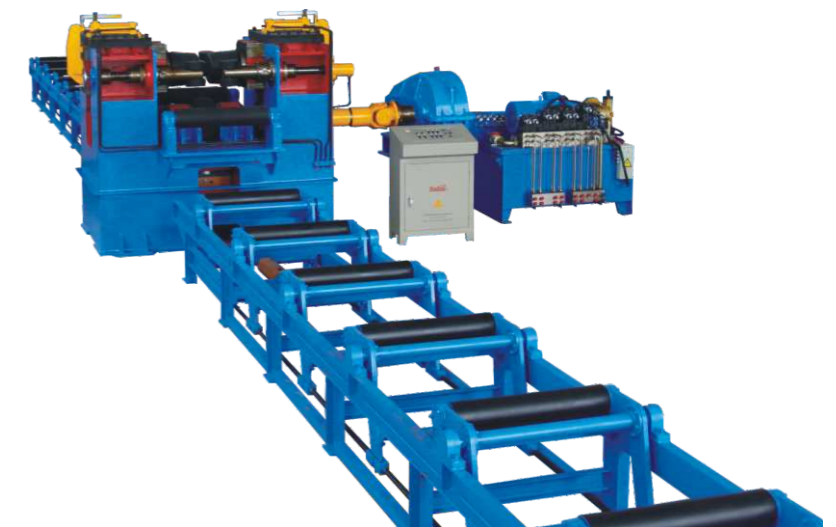
YJZ60C hydraulic straightening machine is oil cylinder down press type straightening machine, its straightening capacity is the same as YJZ-60B, but straightening range is wider than YJZ-60B (flange plate can be 1000mm), and two upper press cylinder can do straightening work separately to straightening asymmetry deformation. The producing cost of down press type straightening is lower than up-lift type, no need elevating roller conveyor and universal joint.



YJZ60B/YJZ80B HYDRAULIC STRAIGHTENING MACHINE

TECHNICAL PERFORMANCE

This machine is the special equipment used to straighten the deformed H-beam flange. The hydraulic straightening machine (YJZ60B, YJZ80B) oil cylinder up-lift type straightening machine. has capacity of correction, wide range, and high automation.

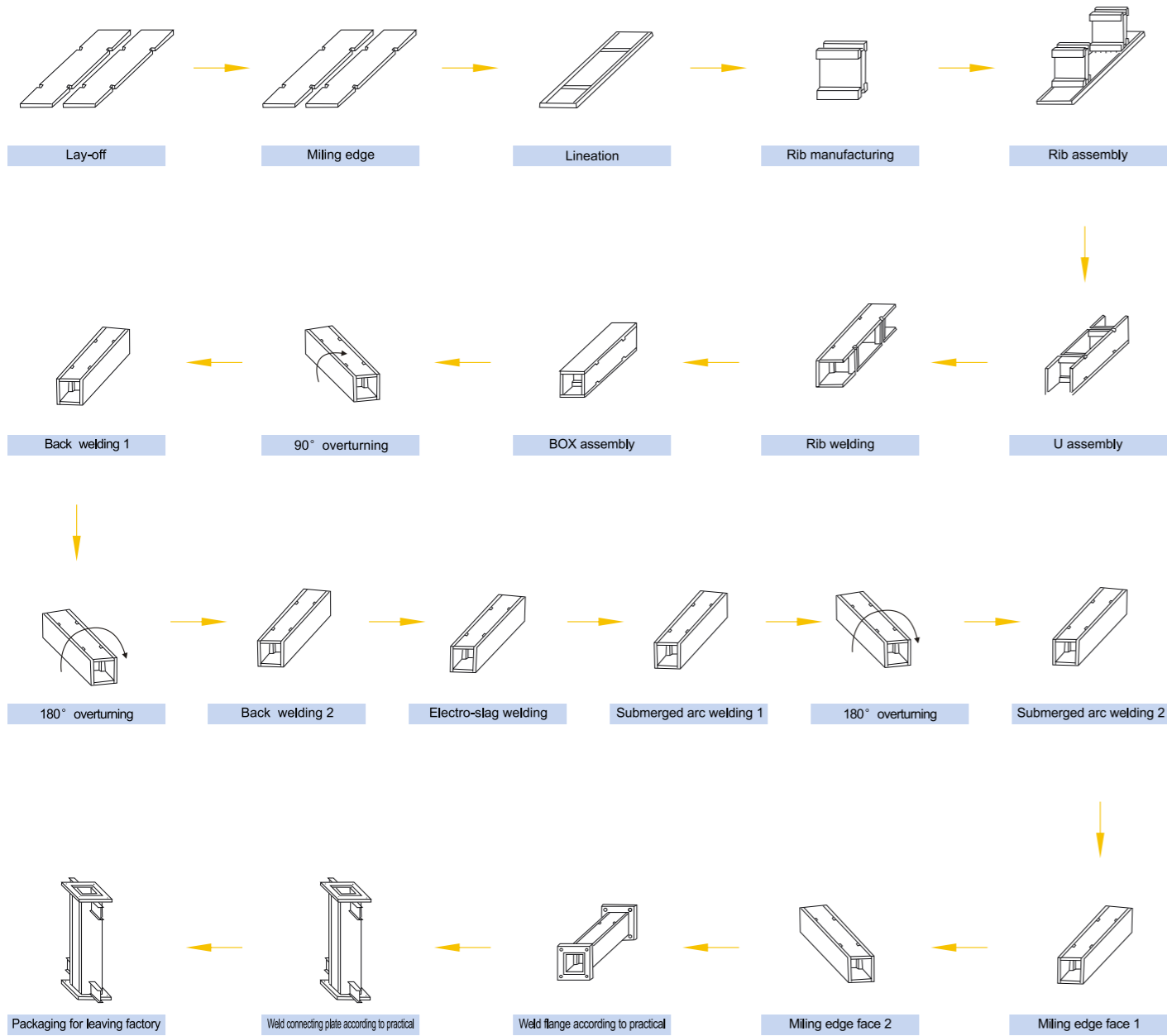


Descriptions	YJZ60B	YJZ80B	YJZ60C
With of flange	180-800mm	200-1000mm	200-1000mm
Thickness of flange	≤60mm	≤80mm	≤60mm
Min height of web	350mm	350mm	350mm
Material	Q345(16Mn)	Q345(16Mn)	Q345(16Mn)
Straightening speed	6.15m/min	6.56m/min	6.15m/min
Total Power	37kw	28kw	27.5kw

BOX BEAM PRODUCTION LINE SERIES EQUIPMENT



TECHNICAL PROCESS OF WELDING BOX BEAM



BOX BEAM PRODUCTION LINE SERIES EQUIPMENT



TECHNICAL PERFORMANCE

This production line is mainly made up by CNC/Multi-head Strip Cutting Machine, U type /Box type integral assembling machine, cantilever back machine, Cantilever Electric slag-welder, Cantilever submerged arc-welding Machine, Terminal Surface Mill, Edge Miller, Baffle Assembling Machine, Roll Table and other complements.

Length	4000~15000mm
Sectional size	300×300mm ² ~1200×1200mm ²
Trickness	20~80mm



U TYPE AND BOX TYPE ASSEMBLY MACHINE MODEL UBZJ12

TECHNICAL PERFORMANCE

This is the special machine for assembling the U type and box type beam, it is composed of main machine, roller conveyor, centering device, positioning device, hydraulic system and electrical control system. This machine adopt workpiece fixed, but machine moving type, hold down workpiece with some pieces and manual welding the workpiece after holding.

The characteristic of this machine: finish U type assembling and box type assembling on the same machine, it reduces the cost and saves layout space.



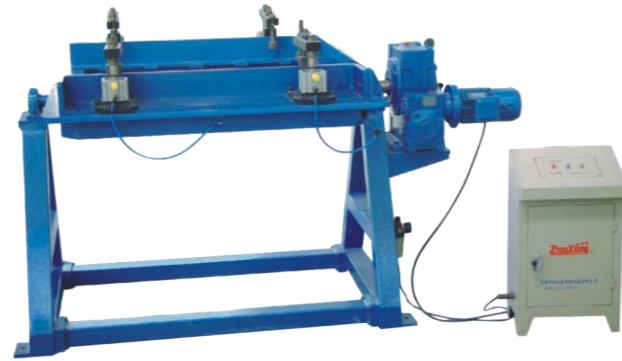
BOX BEAM PRODUCTION LINE SERIES EQUIPMENT



VERTICAL DIAPHRAGM ASSEMBLY MACHINE MODEL NO.GZ15

TECHNICAL PERFORMANCE

This machine is the special equipment to assemble and weld the middle clapboards in BOX type beam. When assembling, adopt the cylinder compacting to determine the position, then weld them by spot. After finish to weld one face, then turn over the rotation work table for 180 degree through motor. After weld the another face, Turn the work table to the level, loose the Cylinder and unload forworing.



BOX BEAM OVERTURNING MACHINE



➤ Moving type 90 degree hydraulic overturning machine

➤ Moving type 180 degree hydraulic overturning machine

VERTICAL ASSEMBLY MACHINE MODEL NO.UZJ12

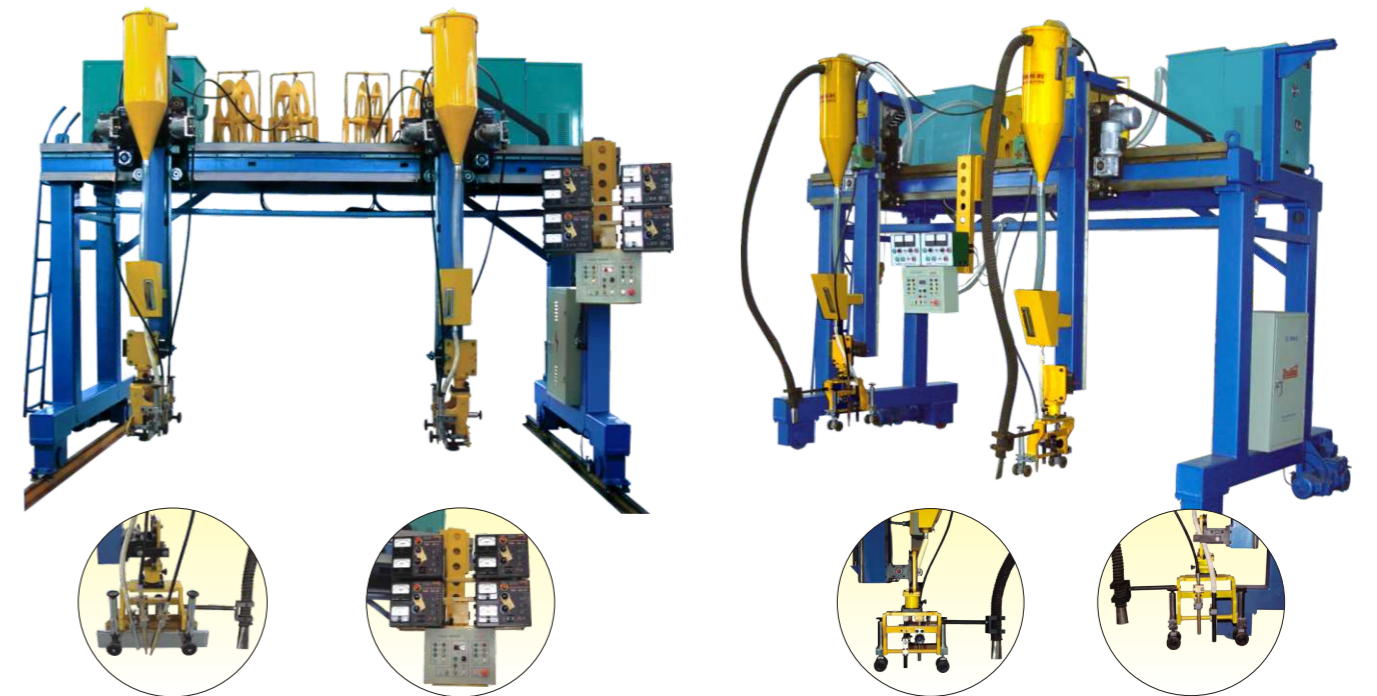


GANTRY TYPE BOX BEAM WELDING MACHINE MODEL NO.LMHA-4000



TECHNICAL PERFORMANCE

It is the welding supplementary machine for special use that design for box-beam welding(flat angle welding seam). The machine use gantry style main struture, driving in double-sides, controlled the speed steplessly by converter; Tracing of welding seam uses the type of mechanic guiding roller; The up-down and right-left operation is controlled by pneumatic technology; In order to improve the effcndcy of big fillet welding,it is equipped with big electric current and double machine head(single welding seam)to process double arcs and double wires weldings, installation of the machine head is separated from arc-guiding mechanism; The device which is used to protect solder, avoiding too much solder drop down;lay-up of workpiece can use fixed frame and it can also be transmitted by roller, so it can from an assembly line with other sets of machines



Box-beam arc guiding rack

Box-beam control system

H beam steel arc guiding rack

Width of applicable box-beam	Height of applicable box-beam	Welding speed	Returning speed	Welding position	Total power
300~1200mm	300~1200mm	0.17~3.4m/min	6.8m/min	Horizontal welding	9KW



Triple wires with triple arc (2DC+AC)

Twin wires with twin arc (DC+AC)

Gate double thread gas shield welding padding machine

BOX BEAM PRODUCTION LINE SERIES EQUIPMENT



CANTILEVER TYPE(NOZZLE MELT) ELECTRO-SLAG WELDING MACHINE MODEL XDZ-12



CANTILEVER TYPE(WIRE MELT) ELECTRO-SLAG WELDING MACHINE MODEL XDZ-12



▶ TECHNICAL PERFORMANCE

XDZ-12/12S series box beam slag welder is a special equipment for box beam baffle welding, which adopts baffle and surround steel plate welding hard in vertical slag welding way.

According to customers' different requirement, these are two ways of box beam slag welding: wire melt and nozzle melt. Welding speed of wire melt slag welding is faster and lower welding cost, but higher equipment cost and more complicate control system; nozzle melt slag welding is lower equipment cost and simple operation, but the welding efficiency is lower than wire melt slag welding.

Wire melt slag welding is suitable for big quantity box beam production, while nozzle melt slag welding is suitable for small quantity.

Trolley gauge	1000 mm
Trolley travelling speed	6 m/min
travelling motor power	0.55 KW
suitable workpiece size	300~1200 mm

XXBC-12 MODLE CANTIEVER TYPE BACK WELDING MACHINE

▶ STRUCTURE AND PERFORMANCE

Cantilever type back welding machine is usually used before SAW welding in box-beam manufacturing process, this machine can prevent the workpieces welding seam to be burned through, and it is composed of travelling cart, welding arm, welding gun tracking device, pneumatic system, electrical control system, flux recovery system, CO₂ welding power and so on.

For box-beam back welding, it usually adopts single arc single wire, also can use double arc double wire. The welding power is Panasonic YD-600KH.

Width of applicable box-beam	300~1200mm
Length of applicable box-beam	4000~15000mm
Welding speed	0.3~1.5m/min
Returning speed	3m/min
Welding position	Horizontal welding



▶ SUBMERGED ARC WELDER



▶ Lincoln AC-1200 submerged Arc welder



▶ Lincoln DC-1000 SAW welder



▶ MZ-1250 IGBT inverter Arc Welder

BOX BEAM PRODUCTION LINE SERIES EQUIPMENT

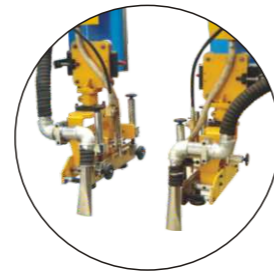
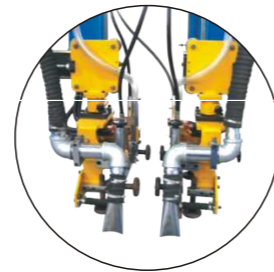
XXBH-12 CANTILEVER TYPE SUBMERGED ARC WELDER(SINGLE ARC SINGLE WIRE)

STRUCTURE AND PERFORMANCE

This machine is composed of traveling cart, welding arm, welding gun mechanical tracking device, pneumatic system, electrical control system, flux feeding and recovery machine and submerged arc welding power. It is mainly used for welding the box beam.

There are two kinds of welding method for box-beam SAW welding, single arc single wire and double arc double wire. For single arc single wire welding, the welding power can be domestic-made or foreign-imported; while for double arc double wire welding, usually equipped with welding power American Lincoln DC-100, AC-1200 to improve work efficiency.

Suitable workpiece size	300~1200mm
Welding speed	0.3~1.5 m/min
Return speed	3 m/min
Cart gauge	1400 mm
Gas power pressure	0.4~0.8 Mpa



CNC/DX1215 CNC FACE MILLING MACHINE

STRUCTURE AND PERFORMANCE

CNC face milling machine is made up of milling head, elevation column, work table, bed, mechanical feeding system, electric control system, CNC system, guideway protective device and miller. It is used for two ends of h-beam and box column welding and rolling face milling and processing. The Max. workpiece milling face size is 1200×1500mm; min. workpiece face is 300×200mm, also it can mill the side face of H-beam steel and box column. It is convenient operation, simple structure and fast adjustment, which is necessary equipment for profile steel professional manufacturer. The slide feeding and milling head elevation of this machine adopt Guangzhou CNC DA98A drive servo motor, DA98A AC servo system is the first domestic-made all digital AC servo system, adopting American IT company latest digital signal processing (DSP(TMS320F 2407A)) large-scale programmable door array(CPLD)and MITSUBISHI intelligent power module(IPM), high integration, small volume, complete protection and good reliability, adopting good PID accumulation to finish PWM control and the performance meeting product's international level.



FACE MILLING MACHINE MODEL NO.DX1215



DX1215 Face Milling Machine



Finish Box Beams

STRUCTURE AND PERFORMANCE

The face miller consists of milling and cutting head, lifting upright column, work table, machine body, mechanical feeding system, electrical control system, rail protection device, tools, etc.

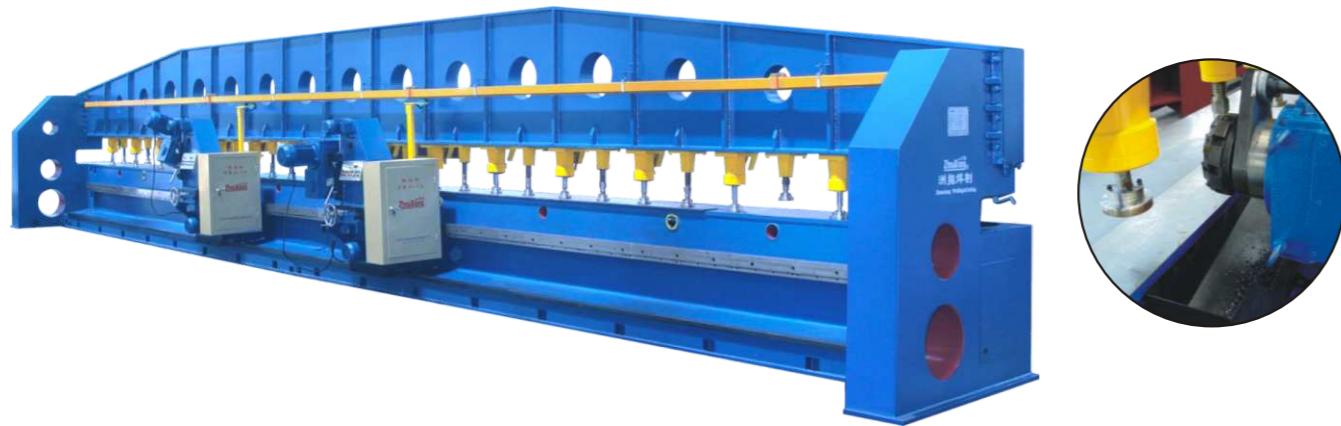
This machine is used to weld or roll the shaped H type steel or mill two end faces of BOX type steel. Themax. Milling end face is 1,200x1,500 mm, the min. Workpiece end face is 300x200 mmshaped steell, it is also used to mill the H type steel or the side face of BOX type steel, it features easy operation, simple structure, quick adjustment and so on as one of necessary equipments of welding shaped steel professional manufacturer.

BOX BEAM PRODUCTION LINE SERIES EQUIPMENT



EDGE MILLING MACHINE

▶ 12M DOUBLE HEAD MILLING MACHINE



Material supporter

16m double head milling machine

▶ STRUCTURE AND PERFORMANCE

Compared with the traditional edge milling machines, this machine series is dismantlable in their tracks, more rational in structure by heat-treatment of the bench, more reliable and stable in the milling & turning heads running. The feed and feed-back systems are fully independent respectively. The feed-back is quick and is highly efficient. The angle of the milling tools tray is convenient in adjustment, and the custom-built tool rest and the normal tool rest can be inter-converted. They are the updated products of the traditional edge milling machine.

▶ MAIN TECHNICAL PARAMETER

Type	XBJ-6	XBJ-9	XBJ-12
The angle milling		0-45°	
The thickness of being processed steel plate (mm)		6-50	
The traveling speed of crosswise milling (m/min)		0.1-1m/min	
Back stroke milling speed (m/min)		2m/min	
The rev. speed of milling spindle (m/min)		80-400	
The working pressure of hydraulic pressure system (mpa)		≤3.5	
The numbers of the cylinders	8	11	15
The height between the platform and the ground (mm)		900	
The power of driving motor (kw)		1.5kw	
The power of milling motor (kw)		5.5kw	
The power of oil pump motor (kw)	5.5	5.5	5.5
The overall size of the machine(a×b×h) (mm)	8680×2600×2100	11680×2600×2300	14200×2600×2400



Taiwan driving head



In milling process

▶ 18M PRESSURE BEAM MOVING TYPE MILLING MACHINE



▶ STRUCTURE AND PERFORMANCE

This equipment is a large milling machine, and both sides can also edge milling. It has only four power installation head on the tool body to improve processing efficiency. The pressure beam machine adopts moving type. In the process it is convenient for users to feed materials, and after processing easy to laying-off so that improve working efficiency. Comparing with traditional milling machine it is more flexible and high efficiency.



▶ MAIN TECHNICAL PARAMETER

Model	YXBJ-18
Workpiece thickness	10-160mm
Workpiece width	300-1100mm
Workpiece length	≤18000mm
The traveling speed of milling	130-1200mm/min
Back stroke milling speed	1500mm/min
Working pressure of hydraulic pressure system	0.5-3.5 Mpa
Moving distance	1000mm
Power of driving motor	1.5kw
Power of milling motor	7.5kw
Pressure beam moving motor power	2 X 1.5 kw
Pressure beam Press foot number	19

BOX BEAM PRODUCTION LINE SERIES EQUIPMENT

CNC DRILLING MACHINE

ZPZ 400 CNC DRILLING MACHINE



ZPZ 200 CNC DRILLING MACHINE



STRUCTURE AND PERFORMANCE

ZPZ160A digital control driller employs AC servo motor to drive the X axis and Y axis, while its Z axis is positioned by high accuracy raster. By using semi-closed closure digital control system, the machine has reliable performance. The operation of the machine can either be automatic or manual. This machine is widely used in steel frame construction.

MAIN TECHNICAL PARAMETER

Item	ZPZ160	ZPZ200	ZPZ400
Drilling diameter	φ50	φ60	φ60
Max. dimension of workpiece	1600 × 1000 × 80	2000 × 1500 × 80	2000 × 1500 × 80
Rotary speed of main shaft	130–400 r/min, Step less and adjustable	130–400 r/min, Step less and adjustable	130–400 r/min, Step less and adjustable
Feeding type of main shaft	Hydraulic	lead screw	lead screw
Quantity of moveable working platform	2	2	2
Workpieces can be toolled for once	4pcs	4pcs	4pcs
Clamping type	Hydraulic	Hydraulic	Hydraulic
X and Y axis fast moving speed	12m/min	12m/min	12m/min

- A. hydraulic clamp hold and loose.
- b. driving feed movement of main shaft.
- c. locked gantry frame, guarantee drilling position and size precision

