



沧州中拓成型设备制造有限公司

CANGZHOU ZHONGTUO ROLL FORMING MACHINERY CO.,LTD

Introduction for carbon steel Pipe forming machine

Description of Goods	Delivery Time	Package
carbon steel Pipe forming machine	75 working days	2*40 Container(nude packaging)

The mill is intended for manufacturing of round pipe(square pipe,rectangular pipe) of $\Phi 20-50\text{mm}$ with thickness of $0.5-3.0\text{mm}$. It supports many kinds of material like carbon steel, GI and others. Finished product will be of round, square or rectangular pipe.

III. Basic conditions

a) Steel Pipe Specification(to your request)

1. Pipe Length: 6-9m (can be set on PLC)
2. Length Tolerance: 0-3mm

b) Steel Tape Specification

1. Material: Low Carbon steel
2. Steel Tape: Inner diameter: $\Phi 580-\Phi 610\text{mm}$
Outer diameter: $\Phi 900-1500\text{mm}$
Strip steel width: 60mm-200mm
Strip steel thickness: 0.5mm-2.5mm

c) Electricity

1. Dynamic power: AC380V $\pm 10\%$, 3phases, 50Hz $\pm 1.0\%$
2. Control Power: AC220V $\pm 10\%$, one phase, 50Hz $\pm 1.0\%$

d) Electric installed capacity: (to the final design)

e) Cooling water

1. Reservoir for High Frequency equipment: 15 m³, one set
2. Reservoir for circulating cooling water: 15 m³, one set

f) Compressed air: 1. Pressure: 0.4Mpa 2. Flow: 0.5m³/h

g) Line speed: 50m/min





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Sr.	configurations	parameters	photos	FOB Tianjin (USD)
1	Hydraulic Double head Uncoiler	1.1. Rotary type to change coils easily, with a pneumatic brake 1.2. Mandrel expansion by Hydraulic 1.3. Mandrel position rotation shall be manual 1.4. Pneumatic brake 1.5 parameters Coil width:max.160mm Coil OD:max. \varnothing 1500mm Coil ID: \varnothing 470- \varnothing 510mm Coil weight:max. 3.0 tons		
2	Shearing & butt welding machine	Function: It is used to cut the irregular ends of the strips and then connect the strips by welding. Strip width: 60-240mm Welding thickness : 0.6-3.0mm Cutting Type : Hydraulic Welding Mode: Automatic		

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3	Spiral Accumulator	<p>This part is used for storage of coils to keep Continuous feeding.</p> <p>3.1 Feeding speed: 200m/min 3.2 Pinch roll drive: 7.5 KW AC motor with gear box 3.3 Pinch roll Dia.: 150mm 3.4 Storage: 300-400m</p>		
4	Forming and sizing mill	<p>4.1 Forming mill gearbox, universal joint 4.1.1 Mill entry flattener by five roll passive levelling, one pair of sending roll, two pairs of vertical roll 4.1.2 Forming mill consists of : Driven stand: 7 sets (Horizontal) Driven stand shaft: Ø55mm Material of shaft: 40Cr Side roll stand: 8 sets (Vertical) Side roll stand shaft: Ø30mm Material of shaft: 40Cr Gear box & universal joint: 7 sets Material of gear: 20CrMnTi 4.2 Sizing mill gear box, universal joint 4.2.1 Sizing mill consist of: Driven stand: 5 sets (Horizontal) Driven stand shaft: Ø55mm Material of shaft: 40Cr Side roll stand: 5 sets (Vertical) Side roll stand shaft: Ø30mm Material of shaft: 40Cr Gear box & universal joint: 5 sets</p>	  	

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		<p>Material of gear: 20CrMnTi</p> <p>2 set double head Turk's head, with 4 rollers* 2sets</p> <p>One speed testing roller with air cylinder for CNC flying saw</p>		
5	<p>solid state H.F. welder + 1 sets Electric Control System</p>	<p>5.1 Welding section consist of:</p> <p>Seam guide unit: 1 set</p> <p>Squeeze stand: 2 rollers(\varnothing35mm)</p> <p>Deburr frame: 1 set (2 heads)</p> <p>Horizontal unit for seam ironing: 2 rollers</p> <p>5.2 Cooling section</p> <p>Cooling trough: 1 set</p> <p>Cooling trough length: 2.0 m</p> <p>5.3 Solid state High frequency welder(GGP100KW) (to the final design)</p> <p>Nominal power: 100kW</p> <p>Rated DC power: Pd=120kW</p> <p>Rated DC voltage: UdN=450V</p> <p>Rated DC current: IdN=270A</p> <p>The whole efficiency: $\eta \geq 85\%$</p> <p>Output power: Pout > 100kW</p> <p>Designed frequency: f=450~500kHz</p> <p>MOSFET inverter: 60kW×2</p> <p>Tank circuit output mode: no welding transformer output, secondary resonance</p>	 	

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6	CNC flying friction saw	<p>6.1 Flying cutoff, mechanical section consist of:</p> <p>Saw disk: OD500mm×ID70mm×2.8mm</p> <p>Line speed: ≤90m/min</p> <p>Saw waver: Pneumatic</p> <p>Pipe clamp: Pneumatic</p> <p>Saw carriage travel: Rack and pinion with gear lath</p> <p>Motor for travel: DC 11KW</p> <p>Motor for sawing: AC 11KW</p> <p>Length Tolerance: 0-6mm</p>		
7	Run-out Table(12m)	<p>Roller conveyer 12 meter (including packing box)</p> <p>Reversed and pushed pneumatically</p>		
	Rollers We need to know the detail roller size then we can give you the detail price.	<p>9.1 Forming and sizing Rollers material</p> <p>Material: Cr12 Mov (or Cr 12)</p> <p>Hardness: 60 HRC +/-2</p> <p>9.2 Welding rollers material</p> <p>Material: H13</p> <p>Hardness: 50 HRC +/-3</p>		

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About us

Engineers and technicians of Zhongtuo are rich in experience of designing, developing, and manufacturing of machines. We pay close attention to and keep up with the new trend of technologies and adopt new technologies in the manufacturing of our products.

We produce steel plate processing machines suitable for developing countries. As far as price and automation are concerned, we save time and funds for our customers.

website: <http://www.steelpipemachines.com>

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