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\text{20-50mm}\$** with thickness of **0.5-3.0mm**. 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: Φ580-Φ610mm

c) Electricity

Dynamic power: AC380V±10%, 3phases, 50Hz±1.0%
 Control Power: AC220V±10%, one phase, 50Hz±1.0%

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

e) Cooling water

Reservoir for High Frequency equipment: 15 m³, one set
 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



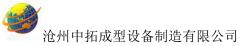
| Sr. | configurations | parameters | photos | FOB Tianjin (USD) |
|-----|-----------------------------------|---|--------|-------------------|
| 1 | Hydraulic Double head Uncoiler | 1.1. Rotary type to change coils easily, with a pneumatic brake 1.2. Mandrel expansion by Hydraulic 1.3. Mandrel position rotation shall be manual 1.4. Pneumatic brake 1.5 parameters Coil width:max.160mm Coil OD:max. Ø1500mm Coil ID:Ø 470- Ø 510mm Coil weight:max. 3.0 tons | | |
| 2 | Shearing & butt | 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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| | | This part is used for storage of coils to keep Continuous feeding. | | ils to keep Continuous feeding. | |
|---|-------------------------|--|------------------------|---|--|
| | Spiral 3 Accumulator | 3.1 Feeding speed: 200m | | m/min | |
| | | | | KW AC motor with gear box | |
| 3 | | 3.3 Pinch roll Dia.: 150r | | mm | |
| | | 3.4 Storage: | 300 | l-400m | |
| | | | ng mill gearbox, unive | | |
| | | 4.1.1 Mill entry flattener by five roll passive levelling, one pair of sending roll, two | | roll passive levelling, one pair of sending roll, two | |
| | | pairs of vertical roll | | | |
| | | | ing mill consists of : | | |
| | | | n stand: | 7 sets (Horizontal) | |
| | | | n stand shaft: | Ø55mm | |
| | | | rial of shaft: | 40Cr | |
| | | Side i | roll stand: | 8 sets(Vertical) | |
| | | | roll stand shaft: | Ø30mm | |
| | Forming and | | rial of shaft: | 40Cr | |
| 4 | sizing mill | Gear | box & universal joint: | 7 sets | |
| | _ | Mate | rial of gear: | 20CrMnTi | |
| | | 4.2 Sizing mill gear box, universal joint | | rsal joint | |
| | | 4.2.1 Sizir | ng mill consist of: | | |
| | | Drive | n stand: | 5 sets (Horizontal) | |
| | | Drive | n stand shaft: | Ø55mm | |
| | | Mate | rial of shaft: | 40Cr | |
| | | Side i | roll stand: | 5 sets(Vertical) | |
| | | Side | roll stand shaft: | Ø30mm | |
| | | Mate | rial of shaft: | 40Cr | |
| | | Gear | box & universal joint: | 5 sets | |

| | Material of gear: | 20CrMnTi | |
|---------------|---|---|--|
| | 2 set double head Tu | rk's head, with 4 rollers* 2sets | |
| | One speed testing ro | ller with air cylinder for CNC flying saw | |
| | 5.1 Welding section consist of | | |
| | Seam guide unit: | 1 set | |
| | Squeeze stand: | 2 rollers(Ø35mm) | |
| | Deburr frame: | 1 set (2 heads) | |
| | Horizontal unit for seam ironing: 2 rollers | | |
| | 5.2 Cooling section | | |
| | Cooling trough: | 1 set | |
| | Cooling trough leng | th: 2.0 m | I I |
| | 5.3 Solid state High frequency welder(GGP100KW) (to the final design) | | |
| lder + 1 sets | Nominal power: | 100kW | |
| ctric Control | Rated DC power: | Pd=120kW | |
| System | Rated DC voltage: | UdN=450V | |
| | Rated DC current: | IdN=270A | |
| | The whole efficiency: | η≥85% | |
| | Output power: | Pout > 100kW | |
| | Designed frequency: | f=450~500kHz | and the same of th |
| | MOSFET inverter: | 60kW×2 | |
| | Tank circuit output mode | onance | |



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

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.

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