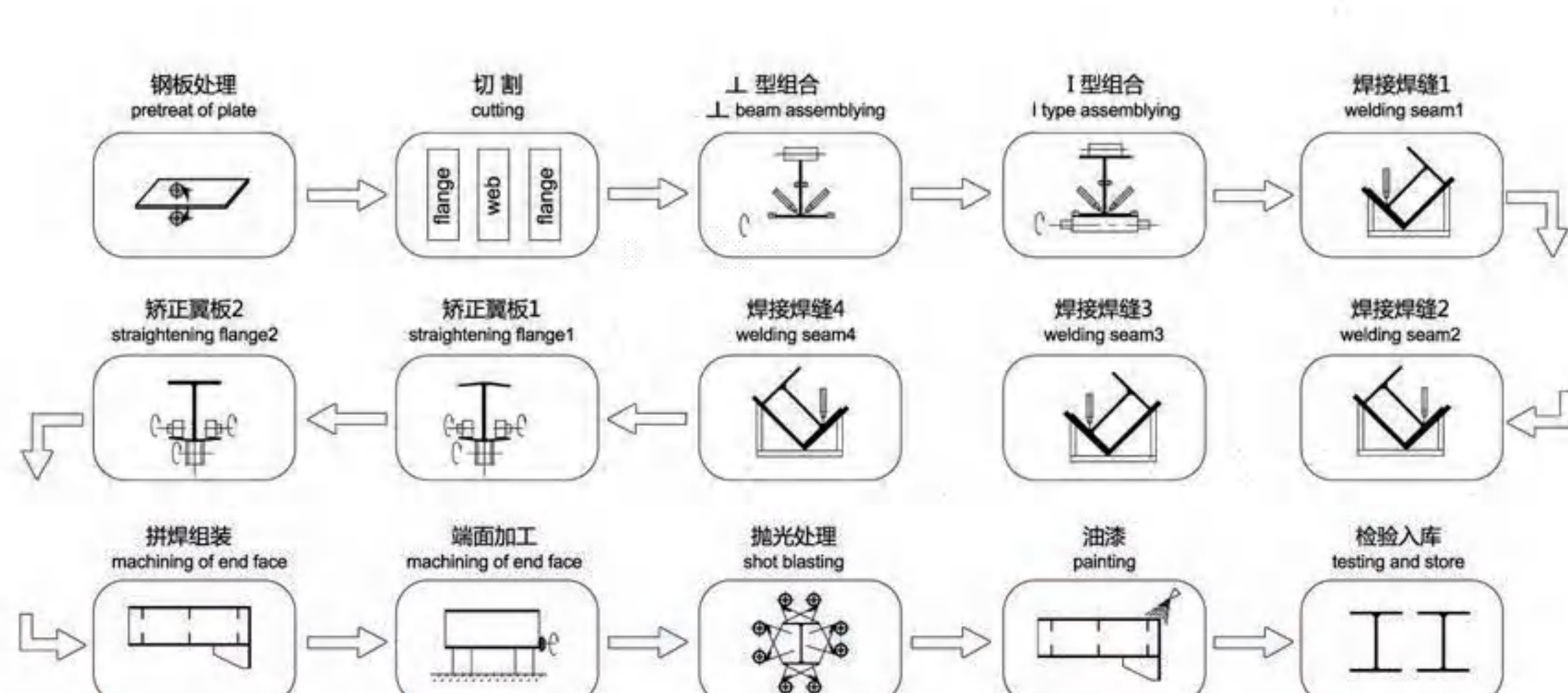


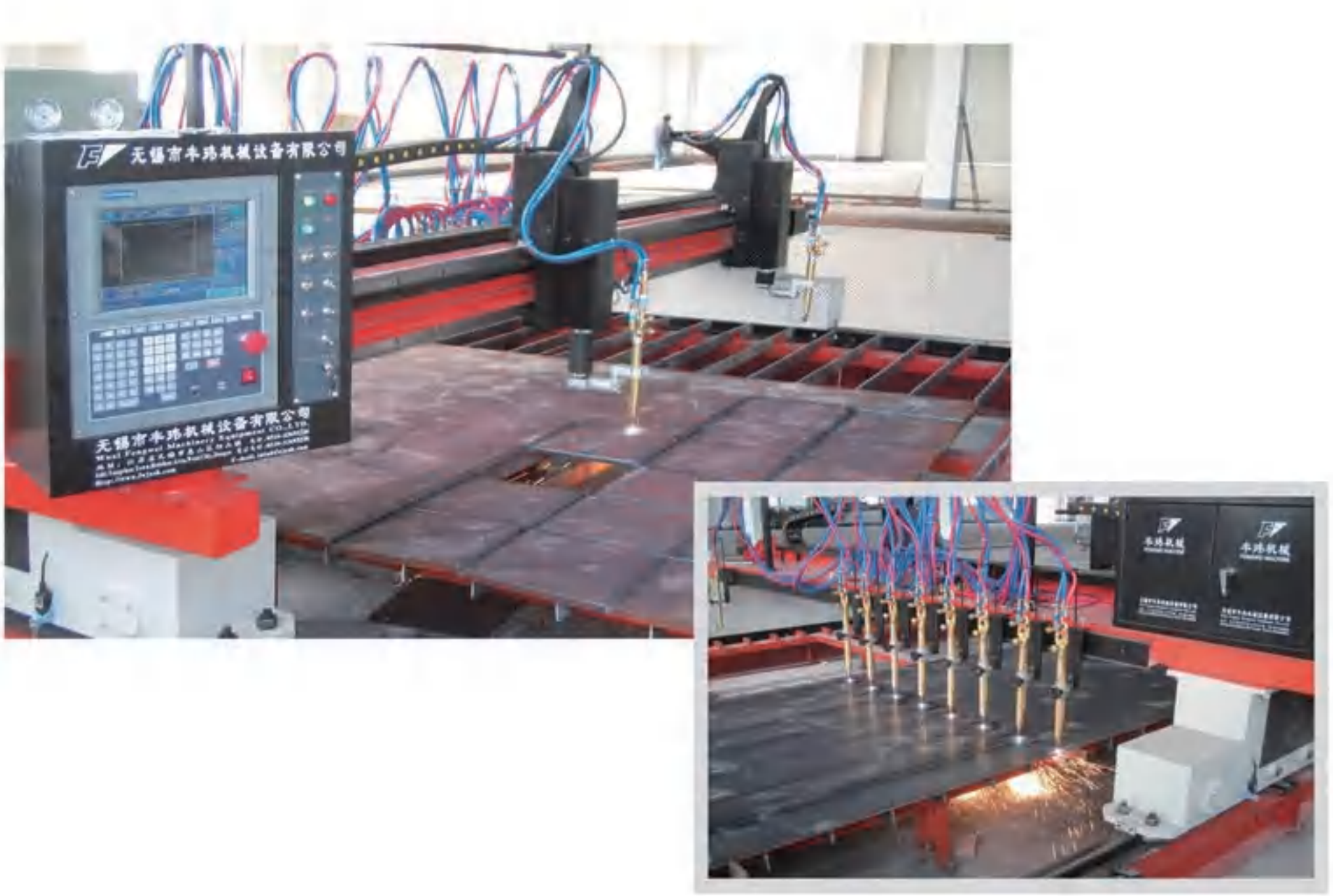
H型钢制作工艺  
H-beam Manufacture Process Flow

本公司生产的自动H型钢生产线主要有多头直条切割机（数控直条切割机）、H型钢组立机、翻转机、H型钢焊机、H型钢矫正机等组成。

The automatic H-beam product line of us is mainly composed of multi-burner straight cutter (digital-controlled straight cutter), tapper, H-beam welding machine, H-beam straightener.



数控火焰/直条切割机  
Numerical control flame / strip cutting machine



主要功能及特点 Main functions and features

该切割机是一种高效率的、氧燃气切割设备，可根据用户需要配置切割数量，沿纵向和横向进行切割，一次同时切割加工多块余板；也可在直条的基础上增加实用的数控系统，既可用于批量切割直条板，又可切割异形件；切割机采用门架式结构，机架整体经退火处理消除应力，结构稳定、强度高、刚性好；长期使用不易变形；驱动采用日本松下全数字交流伺服系统，运行平稳可靠，切割精度高。

This cutting machine is a kind of high efficiency oxygen gas-burning cutting device, which can deploy number of cutting torches according to the demands of users, and process cutting vertically and horizontally with several slats cut at the same time, it can also add practical numerical control system on the basis of strips, which can be used to cut not only strips with large quantities, but also shaped pieces, the cutting machine adopts portal framed structure with annealing treatment to get rid of stress and with a stable structure, high strength, strong rigidity, it features good complete resistance with long term usage. Its driver adopts full digital AC servo drive system made by Panasonic of Japan, with stable operation and high cutting precision.

H型钢生产线系列  
H-beam Production Line series



主要技术参数 Main technical parameters

规格型号 Type	驱动形式 Driving form	轨距 (mm) Track distance	有效切割宽度 (mm) Effective cutting width	切割厚度 (mm) Cutting thickness	切割速度 (mm/min) Cutting speed	最高速度 (mm/min) Max speed	割炬高度行程 (mm) Vertical range of the cutting torch
CNC-CG-3000	单边 Single side	3000	2200	6-200(具体值可参考割炬性能表) Refer to the performance of the cutting head	100-750(具体值可参考割炬性能表) Dependent on the type of plasma power source	6000	150
CNC-CG-3500	单边 Single side	3500	2700				
CNC-CG-4000	单边 Single side	4000	3200				
CNC-CG-5000	单边 Single side	5000	4200				
CNC-CG-6000	双边 Double side	6000	5200				
CNC-CG-7000	双边 Double side	7000	6200				
CNC-CG-8000	双边 Double side	8000	7200				
CNC-CG-9000	双边 Double side	9000	8200				
CNC-CG-10000	双边 Double side	10000	9200				
CNC-CG-11000	双边 Double side	11000	10200				
CNC-CG-12000	双边 Double side	12000	11200				
CNC-CG-13000	双边 Double side	13000	12200				

H型钢自动组立机  
H-beam auto-assembling machine



主要功能及特点 Main functions and features

该机可采用 PLC 可编程控制器，对H型钢的夹装、对中定位、点焊的全过程实行自动控制，速度快、效率高。该机还设有保压装置，可对变截面的H型钢实行自动拼装点焊，焊枪为机（液）跟踪，操作方便，质量可靠。

The machine can apply PLC programmable controller to make automatic control to the whole process of clamping H-type steel, centering location and welding with a high speed and efficiency. This machine is equipped with pressor to make automatic assembly and welding to the varying sections of H-type steel. The welding gun is machine (or liquid) tracking, which can be operated easily with reliable quality.

主要技术参数 Main technical parameters

规格型号 Type	Type	Z15	Z18
幅板尺寸 Web size	高 (mm) Height	200-1500	200-1800
	厚 (mm) Thickness	6-32	6-32
翼板尺寸 Flange plate size	长 (mm) Length	2000-15000	2000-15000
	宽 (mm) Width	200-800	200-800
组立速度 Assembling standing speed	厚 (mm) Thickness	6-40	6-40
	长 (mm) Length	4000-15000	4000-15000
	(m/min)	0.6-6	0.5-6

H型钢生产线系列  
H-beam Production Line series

LHA龙门式自动焊机  
LHA Gantry Auto-welding Machine



主要功能及特点 Main functions and features

H型钢自动焊机采用交流变频器调速控制，具有运动平稳可靠，返程还具有自动跟踪寻对中机构，能确保焊枪自动、准确对中。主机与焊接实行联动控制，并配备焊剂自动输送回收系统，操作方便，效率高。



集中控制的龙门焊  
Centrally controlled gantry welding

主要技术参数 Main technical parameters

规格型号 Type	Type	LHA
幅板高度 (mm) Web height (mm)	Web height (mm)	200-1500
翼板高度 (mm) Flange plate height (mm)	Flange plate height (mm)	200-800
焊机型号 The type of welding machine	The type of welding machine	MC-1000(自动埋弧焊) 1台 2 MC-100 automatic submerged arc
焊接形式 The form of welding	The form of welding	埋弧焊 Submerged arc welding
焊接速度 (m/min) The welding speed	The welding speed	0.15-1.5
回程速度 (m/min) The returning speed	The returning speed	1.5
轨距 (mm) Track distance	Track distance	4000
气源压力 (Mpa) The pressure of air supply	The pressure of air supply	0.2-0.8
整机功率 (KW) The power of complete machine	The power of complete machine	10 (不含焊机) Without welding machine



H型钢生产线系列  
H-beam Production Line series



悬臂式焊机  
Cantilever Type Welding Machine



链条翻转机  
Chain Manipulator

移钢机  
Steel Conveyor



变截面H型钢焊机  
Variable Section H-beam Steel Welding Machine



变截面H型钢的焊接  
Welding of the Variable Section Beam



固定截面H型钢的焊接  
Welding of the Fixed-section Beam

H型钢生产线系列  
H-beam Production Line series

H型钢翼缘矫正机  
H-beam flange straightening machine



主要功能及特点 Main functions and features

该机为矫正焊接后H型钢翼缘变形的专用设备，具有结构简单，操作方便，速度快，效率高，工作可靠等特点。有机械矫正和液压两种。

The machine is the special equipment for the shaping of H-type steel flange plates after correct welding, featuring with simple structure, convenient operation, fast speed, high efficiency and reliable working. There are 2 kinds as mechanical and hydraulic type available for choice.

主要技术参数 Main technical parameters

规格型号 Type	Type	HYJ-600	HYJ-800	YJB-608
翼缘厚度 (mm) Flange thickness (mm)	Flange thickness (mm)	150-600	200-800	200-800
翼缘最小高度 (mm) Min web height (mm)	Min web height (mm)	≤20	≤40	≤60
材质 Material	Material	Q235A	Q235A	Q345A
矫正速度 (m/min) Leveling speed (m/min)	Leveling speed (m/min)	8.5	18	6.37
整机功率 (KW) Motor power (KW)	Motor power (KW)	9	25	37
矫正方式 Leveling type	Leveling type	机械式 Mechanical type		液压式 Hydraulic type



HYJ-800 H型钢翼缘矫正机  
HYJ-800 H-beam Flange Straightening Machine



YJB-608液压矫正机  
YJB-608 Hydraulic Straightening Machine



HYJ-600 H型钢翼缘矫正机  
HYJ-600 H-beam Flange Straightening Machine