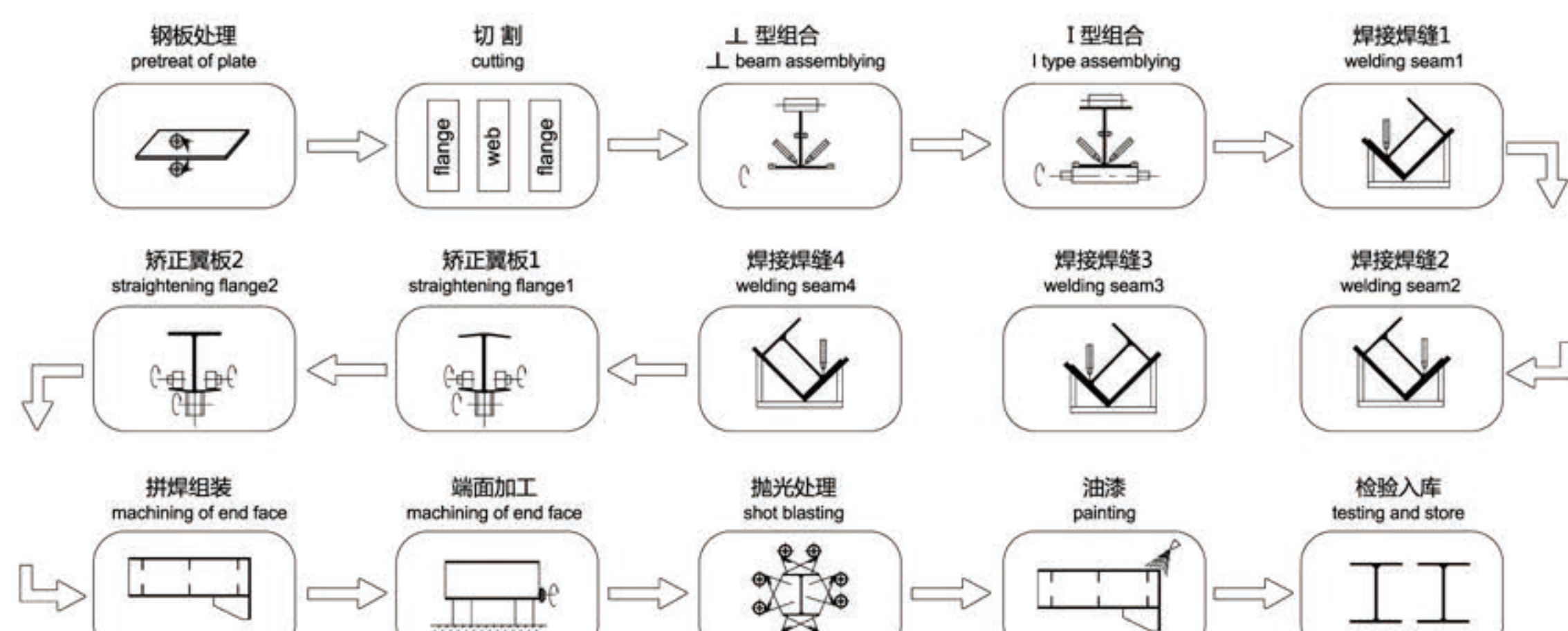
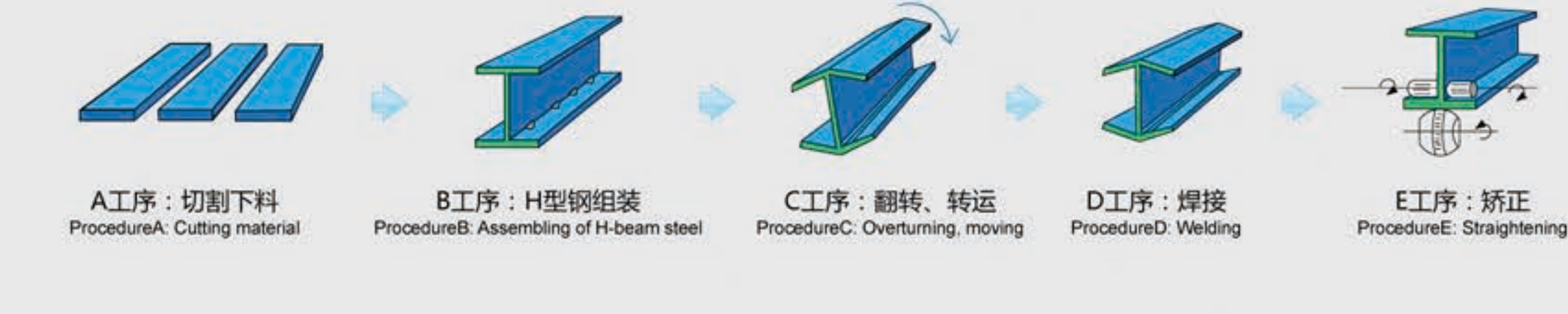


H型钢制作工艺
H-beam Manufacture Process Flow

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型钢焊接机、H型钢矫正机组成。

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



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	切割高度行程 (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) Depend on the type of plasma power source	6000	150
CNC-CG-3500	单边 Single side	3500	2700			6000	150
CNC-CG-4000	单边 Single side	4000	3200			6000	150
CNC-CG-5000	单边 Single side	5000	4200			6000	150
CNC-CG-6000	双边 Double side	6000	5200			6000	150
CNC-CG-7000	双边 Double side	7000	6200			6000	150
CNC-CG-8000	双边 Double side	8000	7200			6000	150
CNC-CG-9000	双边 Double side	9000	8200			6000	150
CNC-CG-10000	双边 Double side	10000	9200			6000	150
CNC-CG-11000	双边 Double side	11000	10200			6000	150
CNC-CG-12000	双边 Double side	12000	11200			6000	150
CNC-CG-13000	双边 Double side	13000	12200			6000	150

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

LHA龙门式自动焊接机
LHA Gantry Auto-welding Machine



主要功能及特点 Main functions and features

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

H-type steel automatic welding machine uses frequency converter gear for speed regulation, ensuring the stable operation. When returning, with automatic tracking equipment of centering, it ensures the welding gun automatically and precisely to locate centering. The main engine and welding carry out gang control equipped with flux automatic transmission and recovery system, which can be operated easily and with high efficiency.



集中控制的龙门焊
Centrally-controlled gantry Welding

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



悬臂式焊接机
Cantilever Type Welding Machine



LHC悬臂式焊接机
LHC Cantilever Type Welding Machine



龙门式自动焊接机
Gantry Auto-welding Machine

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。有机械矫正和液压矫正两种。

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	HYJ-600	HYJ-800	YJB-608
翼缘宽度 (mm) Flange width(mm)	150-600	200-800	200-800
翼缘厚度 (mm) Flange Thickness (mm)	≤20	≤40	≤60
腹板最小高度 (mm) Min web height (mm)	160	350	350
材质 Material	Q235A	Q235A	Q345A
矫正速度 (m/min) Leveling speed (m/min)	8.5	18	37
整机功率 (KW) Motor power (kw)	9	25	63
矫正方式 Leveling Type	机械式 Mechanical Type		液压式 Hydraulic Type

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割炬数量，沿纵向和横向进行切割，一次同时切割加工多块条板；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；长期使用不显变形；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 machines are a kind of high-efficient 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型钢自动组立机
H-beam auto-assembling machine



U型组立机
U-type Assembling Machine

H型钢自动组立机 (重型)
H-beam Auto-assembling Machine(heavy-duty)

主要功能及特点 Main functions and features

该机可采用 PLC 可编程序控制器，对H型钢的夹头、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 pressurizer 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

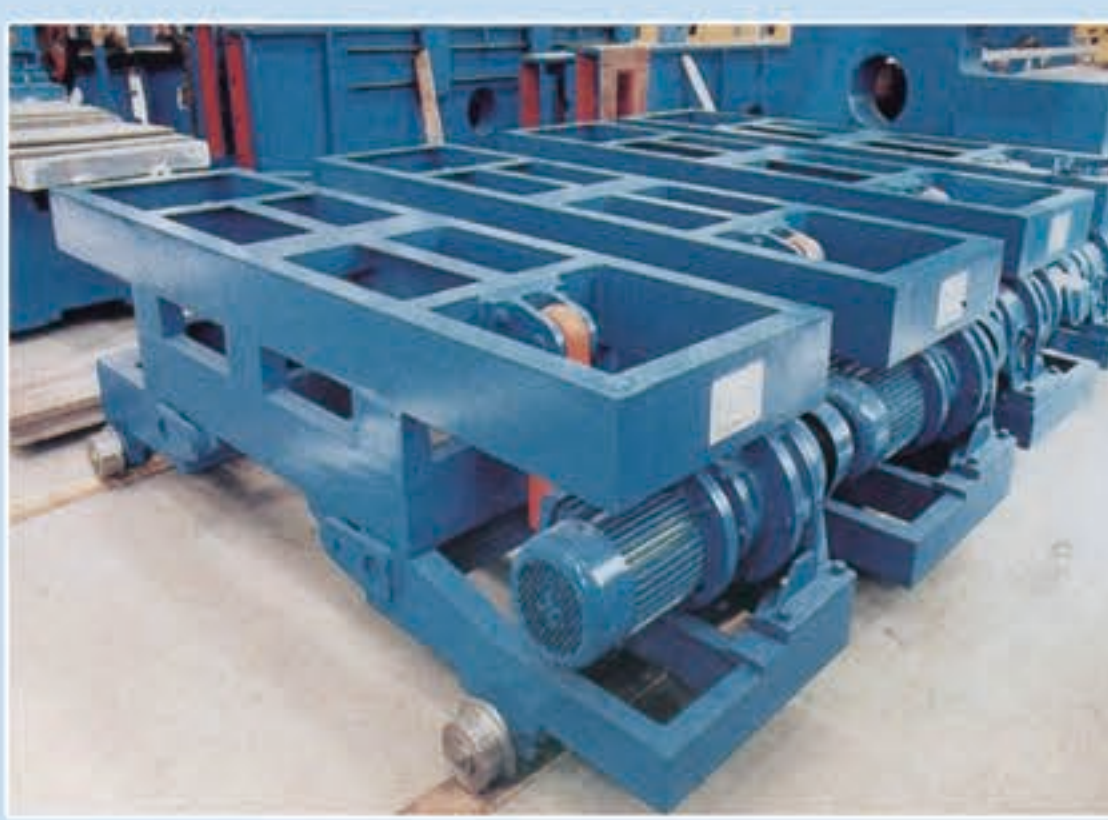
规格型号 Type	Type	Z15	Z18
高 (mm) Height		200-1500	200-1800
幅板尺寸 Web size	厚 (mm) Thickness	6-32	6-32
	长 (mm) Length	2000-15000	2000-15000
	宽 (mm) Width	200-800	200-800
翼板尺寸 Flange plate size	厚 (mm) Thickness	6-40	6-40
	长 (mm) Length	4000-15000	4000-15000
组立速度 Assembling standing speed	(m/min)	0.6-6	0.5-6

主要技术参数 Main technical parameters

规格型号	Type	LHA
腹板高度 (mm)	Web Height (mm)	200-1500
翼板宽度 (mm)	Flange Plate Width (mm)	200-800
焊机型号	The type of welding machine	MZ-1000(自动埋弧焊机) 2台 2 MZ-100 automatic submerged arc
焊接形式	The form of welding	埋弧焊 Bose Welding
焊接速度 (m/min)	The welding speed	0.15-1.5
回程速度 (m/min)	The returning speed	1.5
轨距 (mm)	Rack distance	4000
气源压力 (Mpa)	The pressure of air supply	0.2-0.8
整机功率 (KW)	The power of complete machine	10 (不含焊机) without welding machine



链条翻转机
Chain Manipulator



移钢机
Steel Conveyor



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



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



腹板H型钢的焊接
Welding of the Rib of the H-beam

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



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