

工艺流程 PROCESS FLOW



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|--|---|
| 1/ 放料架
Uncoiler | 4/ 带导向动力纵剪机
Guided power slitter |
| 2/ 开口移动横剪机
Open type lateral shears | 5/ 带编码器矫平机
Flattener with coders |
| 3/ 液压夹辊送料机
Hydraulic roller type feeder | 6/ 带压脚双立柱横剪机
Double column-type lateral shears with spring press |

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anber machine

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STEEL GRID WELDING MACHINE
钢格板压焊机



全自动钢格板压焊机

STEEL GRID WELDING MACHINE



焊接电源采用三相交流电源输入，经逆变控制器逆变为单相交流电源输出且通过单相焊接变压器降压后提供焊接电流，解决了交流压焊机的单相供电问题，避免了电网不平衡现象。

高效节能，效率可达到80%-90%，比传统压焊机节电1/3以上。

由于焊接主回路采用了逆变工作方式，有效的提高了设备的功率因素，即使不配置专用功率因素补偿装置，也可使供电的功率因素大于0.9。

逆变电路采用嵌入式单片机控制，简单可靠，抗干扰性能好。

整个逆变电源采用模块化结构，每个模块单元输出功率为115KVA，可通过不同数量的模块单元组合成630、800、1000型钢格板压焊机。

Welding power is input from A.C. 3-phase power supply and then reverse changes to A.C. single phase power supply output through a reverse-controller, and finally goes through a single phase step-down transformer for welding current output. In this way the problem of single power supply for A.C. steel grid welding machine is solved, preventing a power grid from unbalance.

High efficiency and energy preservation. The efficiency can reach up 80%--90%, preserving energy 1/3 more than traditional electroforge-welding machines.

The reverse method is used in welding main circuit so as to efficiently increase the power factor of the welding equipment. The power factor for electric power supply can be over 0.9 even without a dedicated power factor compensation device.

The reverse circuit is controlled with an embedded computer, being simple in structure, reliable in operation, and excellent in anti-interference.

Modularized structures are utilized in the whole reverse power supply. Each modular unit generates power output 115KVA. Different numbers of modular units can be assembled to form such sizes of products as 630, 800 and 1000 steel grid welding machine for steel bar gratings.

设备参数

项目	ABE-GY-1000-2A-2	ABE-GY-800-2A-2	ABE-GY-630-2A-2	
生产钢格板规格	长	6000mm(可定制)		
	宽	1000mm(可定制)		
	负载扁钢间距	3040mm(可定制)		
	横杆间距	50100mm(可定制)		
每根横杆与负载扁钢最大接触截面	800mm ²	1000mm ²	1250mm ²	
	高度	20-60mm	20-60mm	20-60mm
负载扁钢规格	厚度	2-4mm	2-5mm	2-6mm
	横杆规格X2	5mmx5mm,6mmx6mm		
工作循环X3	≤8秒			
设备功能	每次焊接横杆数	2根		
	压焊主机压力	75T	75T	100T
	负载扁钢送进方	手动定位手动送料	手动定位自动送料	
	横杆进方式	手动排齐自动送进	自动排齐自动送进	
焊接钢格板步进	往复定距方式		直线拉网方式	

1. 适用负载扁钢厚度与负载扁钢间距及负载扁钢根数及横杆规格有关，即每根横杆与负载扁钢的接触截面，表中负载扁钢的间距以30mm、负载扁钢根数为34根、横杆以6mmx6mm为例，即焊接钢格板宽度为994（995）（996）；
2. 相同截面的圆钢也可使用；
3. 表中所列生产工作节拍是按焊接G254/30/100型钢格板为例；

PARAMETER

ITEM	ABE-GY-1000-2A-2	ABE-GY-800-2A-2	ABE-GY-630-2A-2	
Steel bar Grating size	Length	6000mm (It can be customized)		
	Width	1000mm (It can be customized)		
	Bearing bar	3040mm (It can be customized)		
	Cross bar	50100mm (It can be customized)		
Max.contact area of a cross bar with bearing bars	800mm ²	1000mm ²	1250mm ²	
	Height	20-60mm	20-60mm	20-60mm
Bearing bar size	Thickness	2-4mm	2-5mm	2-6mm
	Cross bar size x2	5mmx5mm,6mmx6mm		
Working cycleX3	≤8秒			
Function	Qty of cross	2 Pieces		
	Pressure	75T	75T	100T
	Method of feeding bearing bars	Manually positioned & fed	Manually positioned & automatically fed	
	Method of feeding cross bars	automatically fed	Automatically laid & fed	
Method of step-moving for welding	Reciprocating constant distance	Linear dragging steel bar grating		

1. Bearing bar centers, quantity of bearing bars and cross bar size should be comprehensively put into consideration when selecting suitable thickness of bearing bar, being subject to the contact area of a cross bar with bearing bars. In addition, the width of grating panel is related to several factors, we take bearing bar centers 30mm, 34 pieces of bearing bars, and cross bar 6mmx6mm for example, its width will be 994 (995) (996);
2. Round bar of same diameter can also be used as cross bar;
3. The tabulated working cycle is based on welding of G254/30/100 steel bar grating.

半自动钢格板焊接机

STEEL GRID WELDING MACHINE



钢条厚度：2.5-5mm
钢条宽度：25mm-60mm
扭花直条：5-8mm
焊接板宽度：1M
焊接板长度：6M
产量：70-100平方米/架(8小时)
间距：25,30,40,50,60mm
横向间距：30mm,50mm,100mm,160mm
输入功率：3phase,380V/50Hz
变压器：200 kva
外形尺寸：16*2.5*1.5M
重量：4000kg

The machine adopts hydraulic device to control welding electrode;
bar range : 2.5-5mm
Bar width: 25mm-60mm
Cross bar range: 5-8mm(twisted square steel)
Welding panel width: 1M; length:6M
Production capacity : 70-100M2/shift(8hours), one panel per two hours
Pitch of flat bar: 25,30,40,50,60mm
Pitch of cross bar: 30,50,100,160mmmm
Input power: 3phase,380V/50Hz
Welding transformer: 200 kva
Overall size: 16*2.5*1.5M
Weight : 4000kg

钢格板横切锯机

LATERAL SAW OF STEEL GRID

ABE-GHJ-1050钢格板横切锯是对钢格板生产实现定尺，锯切各种钢格板的专用设备。锯切电机采用降压启动；锯片运行电机采用交流变频调速，链轮链条传动传动；锯切小车轨道采用四方向等载荷型滚动直线圆柱导轨，摩擦力小，导轨经热处理和磨削而成，保证导轨的耐磨性及运行精度。

Model ABE-GHJ-1050 Lateral Saw of Steel Grating is a kind of dedicated equipment, which is used to cut various kind of steel grating into sized ones. The cutting motor is started up with step-down voltage. The saw disc running is driven with chain drive by an A.C. Variable motor with frequency conversion. Rails for saw disc running are heat-treated and grinded possessing low friction resistance, high wearability and running precision.



扁钢分剪矮平定尺机组

SLITTING SHEARS FOR STEEL GRID WELDING MACHINE

该设备是宽带卷钢带进行分条生产各种规格的定尺扁钢的自动生产线。The Slitting shears are used to longitudinally cut a wide coil strip into sized flat steels.

钢格板横杆拉制机组

BAR DRAWING-TWISTING MACHINE

用于圆钢端头轧尖、圆钢拉拔成扭绞方钢、扭绞方钢的校直并定尺切断。The machine includes three units, which are respectively used to mill end of round bar into tip, draw round bar into twisted bar, straighten twisted bar & cut it into sized lengths.

基本技术参数
原料卷板厚：2-6mm
原料卷板宽：200-500mm
原料卷材质：热轧普碳钢
夹送速度：20m/min
矫平速度：0-15m/min
纵剪最窄条宽：20mm
最多条数：20条
设备布置：由右至左<操作台面向机组>（客户可定）
本机组长度约8m（安装长度20m左右），宽度3m，高度1.5m。

Basic Parameters
Raw stock (coil strip) thickness:2-6mm
Raw stock (coil strip) width: 200-500mm
Raw material: Q235A、B hot-milled plain carbon steel
Feeding speed: 20m/min
Flattening speed: 0-15m/min
Min. width of sized flat steel: 20mm
Max. Pieces of sized flat steel: 20 pieces
Equipment layout: From right to left (Operating console faces to the equipment itself) (It may be specified by a customer)

成品

FINISHED PROUDCTS

