



张家港市张运机械制造有限公司

Zhangjiagang City Zhangyun Machinery Manufacturing Co.,Ltd.

Technical parameters of 40 welded stainless steel production line

I. Production line name and technical parameters

No.	Item name	Technical parameters
1	Parameters	
1.1	Pipe dia. range	$\varnothing 9.5 \sim \varnothing 50.8\text{mm}$
1.2	Pipe thickness	0.2~2mm
1.3	Cut-to-length	2.5m~6m
1.4	Length tolerance	2mm
1.5	Outer dia. tolerance	$\varnothing 9.5 \sim \varnothing 50.8\text{mm}$
1.6	Pipe straightness	$\varnothing 9.5 \sim \varnothing 50.8\text{mm}$
2	Production formation	
2.1	Decoiler	Uni-axial cantilever type. Inner dia. Of steel coil: $\varnothing 300 \sim \varnothing 500$; the maximum bearing weight <3000kg
2.2	Steel printing device	Printing moulage not included herein
2.3	Feeding device	1 unit, used to localized and press flat the steel strips
2.4	Forming machine train	Vertical stand adopted

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	Vertical stand	Casting piece
	Horizontal stand	Casting piece
	Horizontal axle material, axle dia.	Material: 40Cr, axle dia. ϕ 40mm; key A8
	Vertical axle material, axle dia.	Material: 40#; axle dia. Φ 25mm
2.5	Welding forming machine train	Single-gun TIG welding, (welding machine not included)
2.6	Sizing	2 sets of turkey-head forming
2.7	Transmission part	1 set, electromagnetic speed governing
		1 set, 2020 vehicle four-speed gearbox
		Worm gear worm wheel drive, WSD80(20:1)m=4
2.8	Electrics	Zhengtai group brand adopted(circuit stability)
2.9	Arrangement of machines	<u>VVHVHVHVVVHVHVHVHVHVHV</u> _ <u>HVH VHVHV HV</u> V-vertical stand; H-horizontal stand; polishing excluded

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2.10	Foundation	Panel 20mm, side plate: 5mm
	Automatic cutting machine	1 set, automatic cut-to-length cutting
	Discharging storage stand	1 unit, automatic discharging realized by air cylinder is used to discharge the finished products and store them.

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