



RELIANCE
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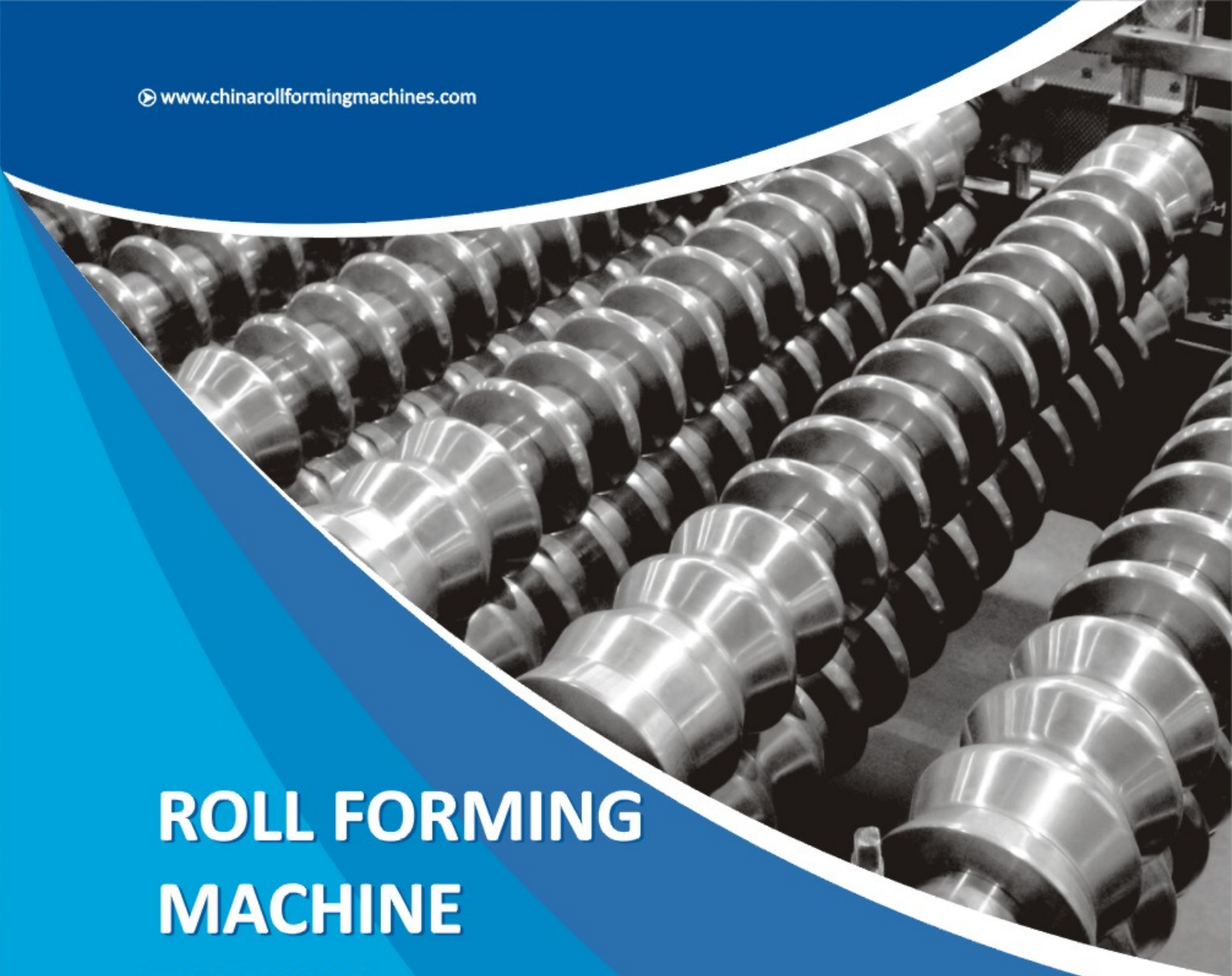
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ROLL FORMING MACHINE

TUBE MILL
SLITTING LINE
CUT TO LENGTH LINE



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**HANGZHOU RELIANCE
MACHINERY CO.,LTD.**



COMPANY PROFILE

Hangzhou Reliance Machinery Co., Ltd was established in 2011, we are a specialized supplier involved in roll forming machine, high frequency carbon steel tube mill line, steel slitting line, steel cut to length line, etc. With many years of experience in roll forming machine, steel tube mill, slitting line, cut to length line, Reliance plays an important role in this industry in China.

Reliance roll forming machines service a multitude of industries. Our strength is providing complete and continuous solution for door frame, shelving upright, box beam, cable tray, guardrail and post system, other special profiles with complicated holes, etc.

Reliance steel tube mill lines are widely applied for furniture, automotive industry, mechanical tube, structural tube, water/gas tube, API for oil and natural gas, etc.

Reliance slitting line and cut to length line are mainly destined for steel-work service centers as well as end-users such as the automotive and the household appliances industry. It's used to proceed wide range of material, from ferrous to non-ferrous such as steel, high resistance steel, stainless steel, painted steel and aluminium, etc.

Reliance Machinery's mission is to provide the highest quality products as a competitive price, good in Quality, On-Time Deliveries, and Superlative Customer Support.

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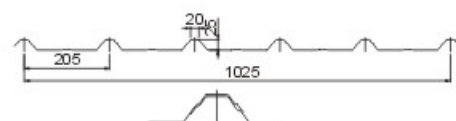
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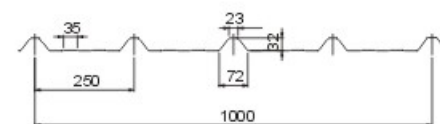
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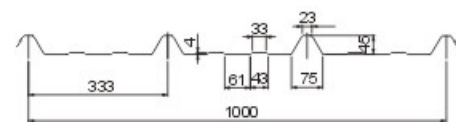
Trapezoidal Roof Roll Forming Machine



Model	Cover width(m)	Coil width(mm)	Thickness
RE-205B	820(1025)	1000(1200)	0.4 0.6 0.8



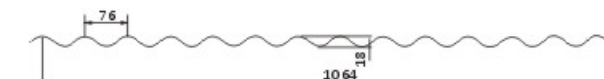
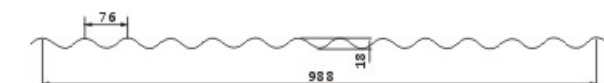
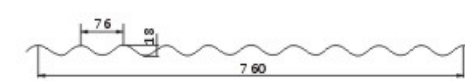
Model	Cover width(m)	Coil width(mm)	Thickness
RE-205I	1000	1220	0.4 0.6



Model	Cover width(m)	Coil width(mm)	Thickness
RE-333B	1000	1250	0.4 0.7



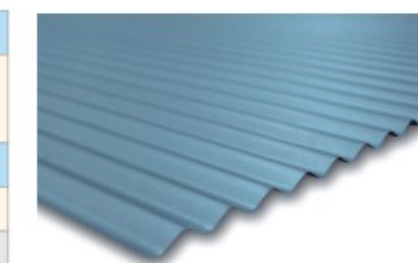
Corrugated Roof Roll Forming Machine



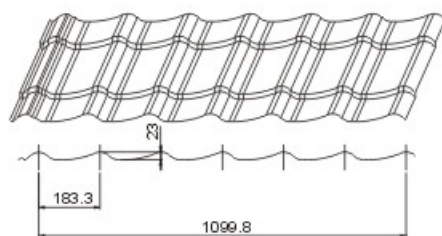
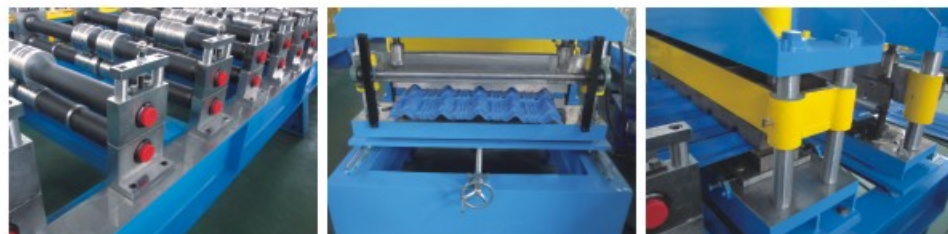
Application		
Metal trapezoidal roof is widely used for commercial metal buildings, associated with residential and commercial. Trapezoidal roof roll forming machine is special designed for its production.		
Technical Parameters		
1	Suitable Material	PPGI Steel Coil / Galvalume Steel Coil / Embossed Aluminum Coil
2	Material Width	914 / 1000 / 1200 / 1220 / 1250 mm
3	Material Thickness	0.3-0.8 mm
4	Roll Forming Speed	10-20 m/min (Exclude Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Rollformer with tooling	1 set
3	Hydraulic cut-off machine	1 set
4	Run out table or automatic stacking device	1 set
5	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set



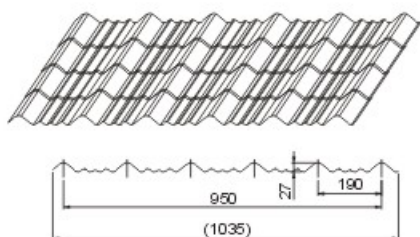
Application		
Metal corrugated roof is widely used for commercial metal buildings, associated with residential and commercial. Corrugated roof roll forming machine is special designed for its production.		
Technical Parameters		
1	Suitable Material	PPGI Steel Coil / Galvanized Steel Coil / Galvalume Steel Coil
2	Material Width	914 / 1000 / 1200 / 1220 mm
3	Material Thickness	0.3-0.8 mm / 0.15-0.25 mm SUPER THIN FULL HARD G550
4	Roll Forming Speed	10-20 m/min (Exclude Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Rollformer with tooling	1 set
3	Hydraulic cut-off machine	1 set
4	Run out table or automatic stacking device	1 set
5	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set



Roof Tile Roll Forming Machine

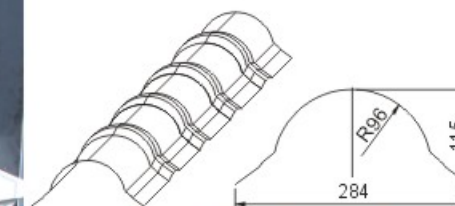
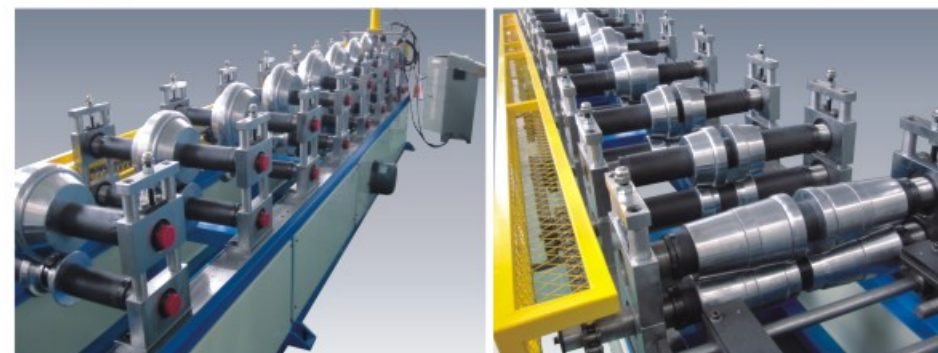


Model	Cover width(mm)	Col width(mm)	Thickness
RE-183	1099.8	1250	0.5 0.6

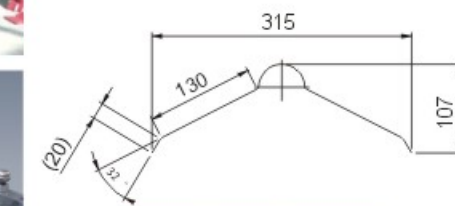


Model	Cover width(mm)	Col width(mm)	Thickness
RE-190B	950	1200	0.4 0.6

Ridge Cap Roll Forming Machine

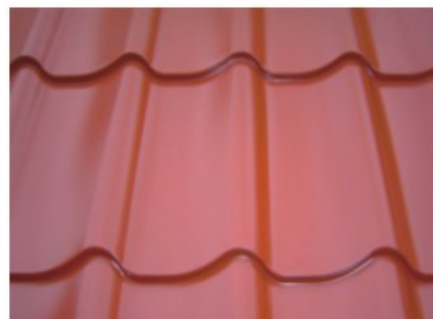


Model	Col width(mm)	Usage
RE-300	385	Curve ridge cap



Model	Col width(mm)	Usage
RE-130	396	Curve ridge cap

Application		
Metal roof tile/step tile roof is widely used for commercial metal buildings, associated with industrial parks and retail developments. Roof tile/Step tile roll forming machine is the essential for its production.		
Technical Parameters		
1	Suitable Material	PPGI Steel Coil
2	Material Width	914 / 1000 / 1220 / 1250 mm
3	Material Thickness	0.3-0.8 mm
4	Roll Forming Speed	10-15 m/min (Exclude Pressing & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Rollformer with tooling	1 set
3	Hydraulic step pressing device	1 set
4	Hydraulic cut-off machine	1 set
5	Run out table or automatic stacking device	1 set
6	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set



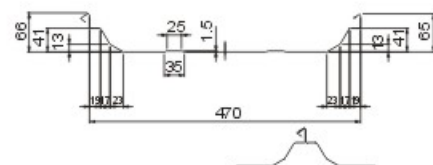
Application		
Metal ridge cap is recommended to prevent water, rain or snow leakage, for industrial and residential applications, enjoying simple installation. Ridge-stepping on cap is making match with step tile. Metal ridge cap roll forming machine is the essential for its production.		
Technical Parameters		
1	Suitable Material	PPGI Steel Coil
2	Material Width	According to profile drawing
3	Material Thickness	0.3-0.6 mm
4	Roll Forming Speed	10-15 m/min (Exclude Pressing & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Rollformer with tooling	1 set
3	Hydraulic step pressing device (Option)	1 set
4	Hydraulic cut-off machine	1 set
5	Run out table or automatic stacking device	1 set
6	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set



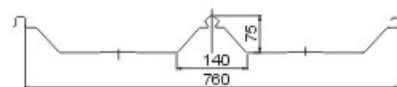
Standing Seam Roof Roll Forming Machine



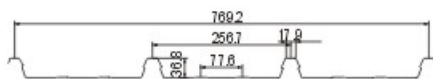
Application		
Standing seam roof is an economical, snap-together roofing system, for commercial and residential applications. Standing seam roof roll forming machine is special designed for its production.		
Technical Parameters		
1	Suitable Material	PPGI Steel Coil / Galvalume Steel Coil / Aluminium Coil / Galvanized Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.4-0.8 mm PPGI Steel Coil / 0.7-1.2 mm Aluminium Coil
4	Roll Forming Speed	10-20 m/min (Exclude Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Rollformer with tooling	1 set
3	Hydraulic cut-off machine	1 set
4	Run out table	1 set
5	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set
6	Automatic Seamer	1 set



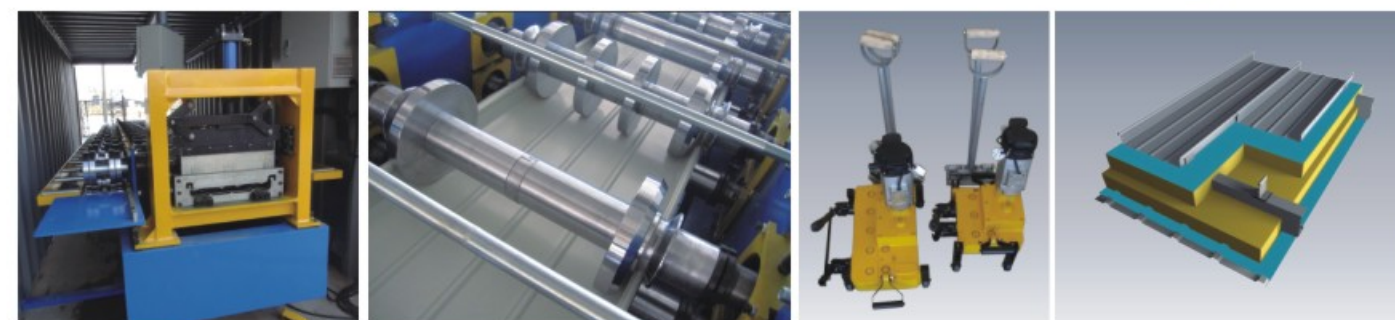
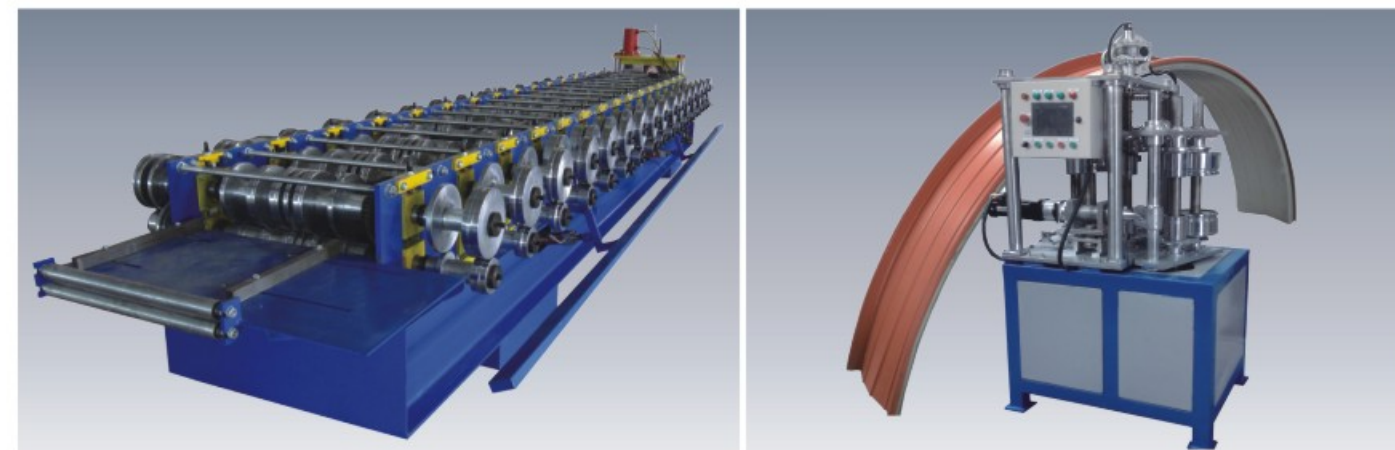
Model	Cover width(mm)	Coil width(mm)	Thickness
RE-470C	470	600	0.4 0.6



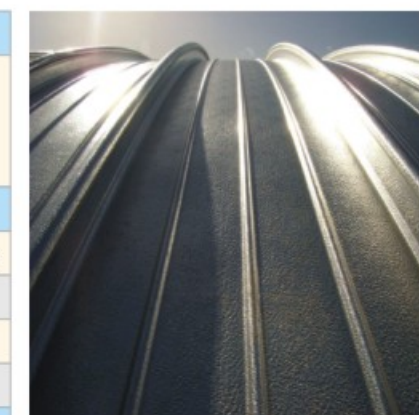
Model	Cover width(mm)	Coil width(mm)	Thickness
RE-380	760	1000	0.5 0.6 0.8



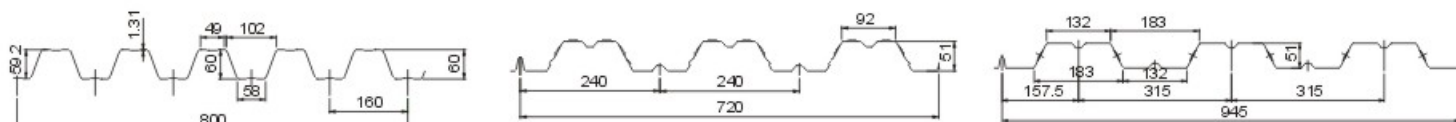
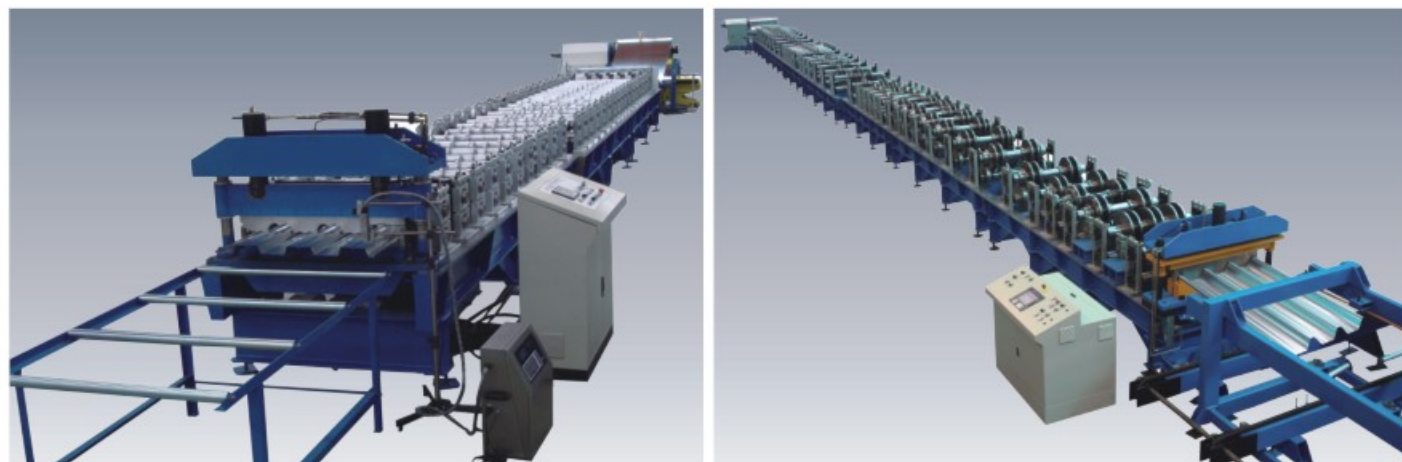
Bemo Roof Roll Forming Machine



Application		
Bemo-Roof system provides the most advanced and versatile structural standing seam roofing system available in today's architecturally demanding market. It's a secret fix standing seam roofing solution which has no external fasteners on the outer weathering skin. We provide complete solution for straight standing seam roof, tapered roof, curved roof production.		
Technical Parameters		
1	Suitable Material	PPGI Steel Coil / Galvalume Steel Coil / Aluminium Coil / Galvanized Steel Coil
2	Material Width	Max.680 mm, According to Profile Drawing
3	Material Thickness	0.4-0.8 mm PPGI Steel Coil / 0.7-1.2 mm Aluminium Coil
4	Roll Forming Speed	10-20 m/min (Exclude Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Rollformer with tooling, can make both straight standing seam roof and tapered roof	1 set
3	Hydraulic cut-off machine	1 set
4	Run out table	1 set
5	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set
6	Curving machine, Convex, Concave or "S" curving	1 set
7	Automatic Seamer	1 set



Floor Deck Roll Forming Machine



Model	Cover width(mm)	Col width(mm)	Thickness
RE-160	800	1250	0.8 1.0

Model	Cover width(mm)	Col width(mm)	Thickness
RE-240	720	1000	0.8 1.0 1.2

Model	Cover width(mm)	Col width(mm)	Thickness
RE-315A	945	1219	0.7 1.1

Application		
The metal floor deck produced by floor deck forming machine has high strength with high wave. It adheres well to concrete, used on industrial building. Metal floor deck roll forming machine is the essential for its production.		
Technical Parameters		
1	Suitable Material	Galvanized Steel Coil
2	Material Width	914 / 1000 / 1200 / 1220 / 1250mm
3	Material Thickness	0.8-1.2 mm
4	Roll Forming Speed	10-15 m/min (Exclude Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Loading Coil Car(Optional)	1 set
3	Pre-Shearing Device	1 set
4	Lubricating Device(Optional)	1 set
5	Rollformer with tooling	1 set
6	Hydraulic cut-off machine	1 set
7	Run out table or automatic stacking device	1 set
8	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set



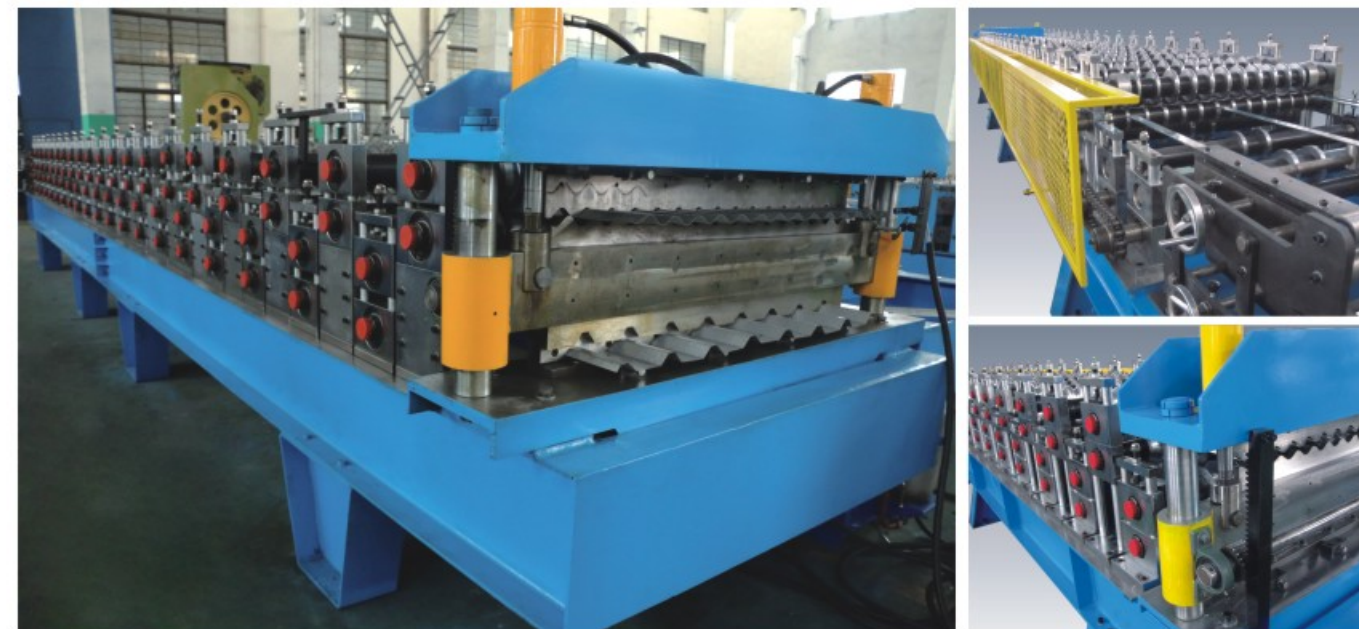
Cassette (Rafted) Type Roll Forming Machine



The Rafted Roll forming Machine consists of a base chassis unit fitted with hardened tapered locating pins for self alignment of tooling raft sections.

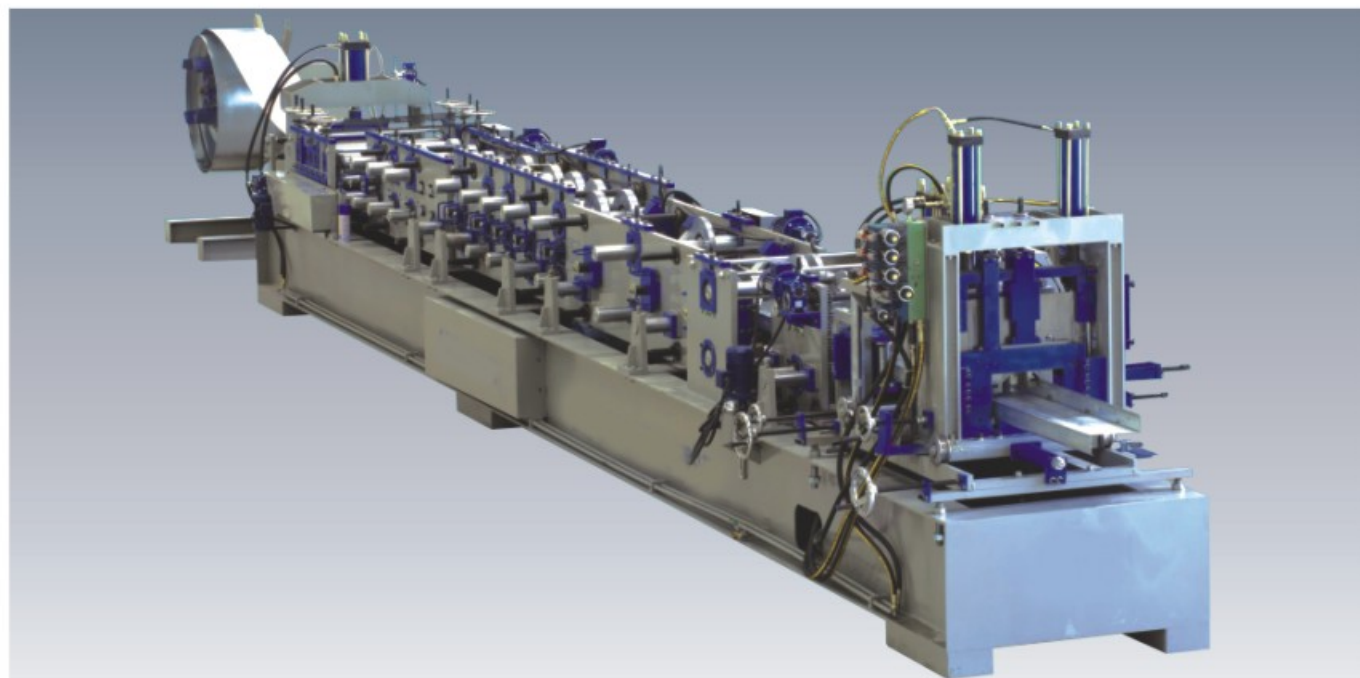
Tooling Rafts are manufactured in sections with balance point lifting lugs that enables easy handling with factory lifting equipment. Raft tooling sections are complete with dedicated tooling to produce a specific profile.

Double Layer Roll Forming Machine

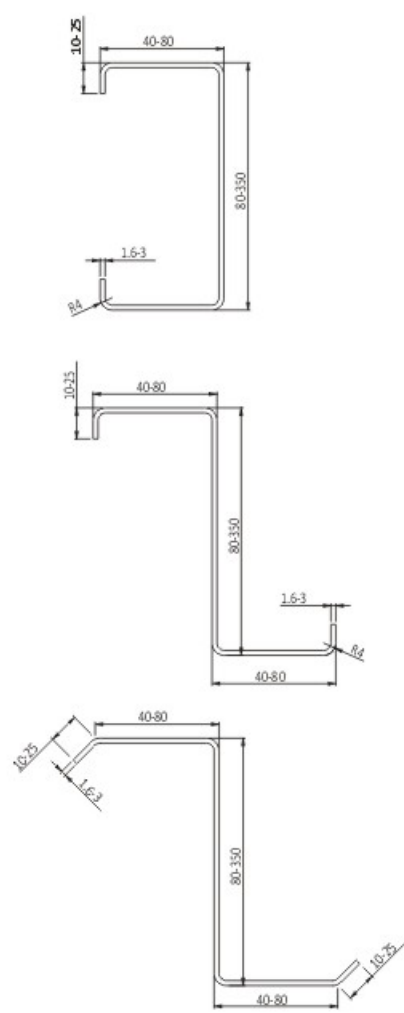


It's based on the same principal as the Single Level machine, but has two levels of dedicated tooling to produce two specific profiles from similar coil widths. This enables the production of two profiles within the floor space of a single level machine.

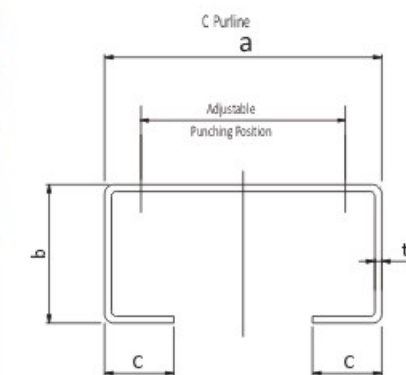
C/Z Purline Quick Changeable Roll Forming Machine



Features		
1	Quick C Or Z Change	Infinite varieties of C and Z purline size, without removing tooling or spacers.
2	Quick C to Z Change	Simply rotate the adjustable tooling 180 degrees.
Work Flow		
Option 1: De-coiling→Entry Guide→Leveling→Pre-Punching→Pre-Cutting→Adjustable Rollformer→Straightening→Run Out Table		
Option 2: De-coiling→Entry Guide→Leveling→Adjustable Rollformer→Straightening→Hydraulic Universal Punching & Cutting→Run Out Table		
Technical Parameters		
1	Suitable Material	Galvanized Steel Coil / Hot Rolled Steel / Cold Rolled Steel
2	Material Width	According to Profile Drawing
3	Material Thickness	1.0-3.0 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Entry Guide + Five(5)-Roll Leveler	1 set
3	Hydraulic Pre-Punching Device	1 set
4	Hydraulic Pre-Cutting Device	1 set
5	Adjustable Roll Former (18 Roll Stations) with tooling	1 set
6	Strengthening Device	1 set
7	Run out table	1 set
8	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set



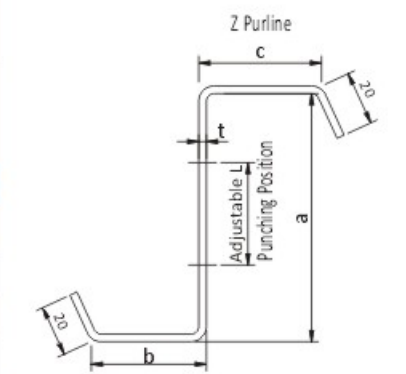
C/U/M/Z Purline Roll Forming Machine



NO	a	b	c	t	L	Coil Width	Remark
1	80	40	25	3.0	172	222	○
	100	40	25	3.0	40	262	✓
2	100	50	30	3.0	40	222	✓
	120	60	30	3.0	40	242	✓
3	120	50	30	3.0	50	242	✓
	120	60	30	3.0	50	262	✓
4	140	50	30	3.0	60	262	✓
	140	60	30	3.0	60	282	✓
5	160	60	30	3.0	80	302	✓
	160	70	30	3.0	80	322	✓
6	180	60	30	3.0	100	322	✓
	180	70	30	3.0	100	342	✓
7	200	60	30	3.0	120	342	✓
	200	70	30	3.0	120	362	✓
8	220	70	30	3.0	120	382	✓
	220	80	30	3.0	120	402	✓
9	240	70	30	3.0	120	402	✓
	240	80	30	3.0	120	422	○
10	250	80	30	3.0	120	422	○

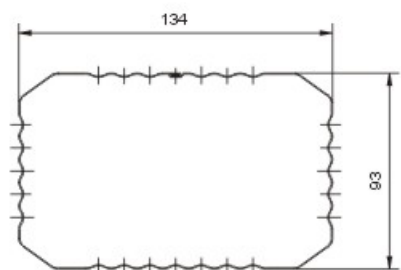
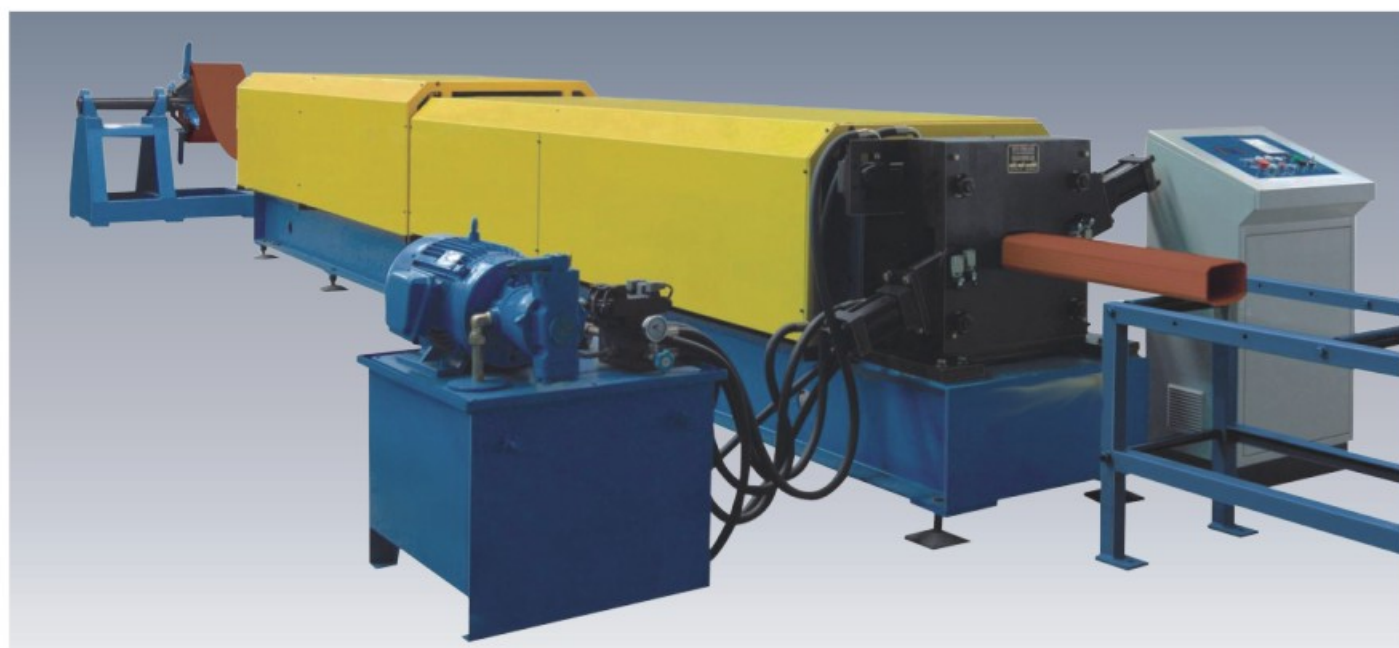
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Note: 1.The size with "○" is company's standard size

Application	
In all metal or mixed building roof systems, purline members are frequently constructed from cold-formed steel C or U or M or Z sections. Purline roll forming machine is special designed for its production.	
Work Flow	
Option 1: De-coiling→Entry Guide→Leveling→Pre-Punching→Pre-Cutting→Rollformer→Straightening→Run Out Table	
Option 2: De-coiling→Entry Guide→Leveling→Rollformer→Straightening→Hydraulic Post-Punching & Cutting→Run Out Table	
Technical Parameters	
1	Suitable Material Galvanized Steel Coil / Hot Rolled Steel / Cold Rolled Steel
2	Material Width According to Profile Drawing
3	Material Thickness 1.0-3.0 mm
4	Roll Forming Speed 10-15 m/min (Exclude Punching & Cutting Time)
Equipment List	
1	Hydraulic Decoiler with Breaking device is equipped for coil processing 1 set
2	Entry Guide + Five(5)-Roll Leveler 1 set
3	Hydraulic Pre-Punching Device 1 set
4	Hydraulic Pre-Cutting Device 1 set
5	Rollformer with tooling 1 set
6	Run out table 1 set
7	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting 1 set

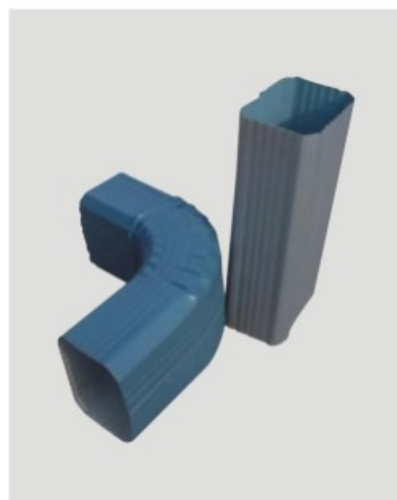


NO	a	b	c	t	L	Coil Width
1	100	54	50	2.0-3.0	40	234
2	120	64	60	2.0-3.0	Adjustable	274
3	140	64	60	2.0-3.0	Adjustable	294
4	160	74	70	2.0-3.0	Adjustable	334
5	180	74	70	2.0-3.0	Adjustable	354
6	200	74	70	2.0-3.0	Adjustable	374
7	220	84	80	2.0-3.0	Adjustable	414
8	240	84	80	2.0-3.0	Adjustable	434

Down Spout Roll Forming Machine



Model	Coil Width(mm)	Thickness	Usage
RE-134	437	0.5 0.6	Waterfalling tube



Application

A down spout is a rectangle or round shape, forming the component of a roof system which collects and diverts rainwater shed by the roof. Down spout roll forming machine is the essential for its production.

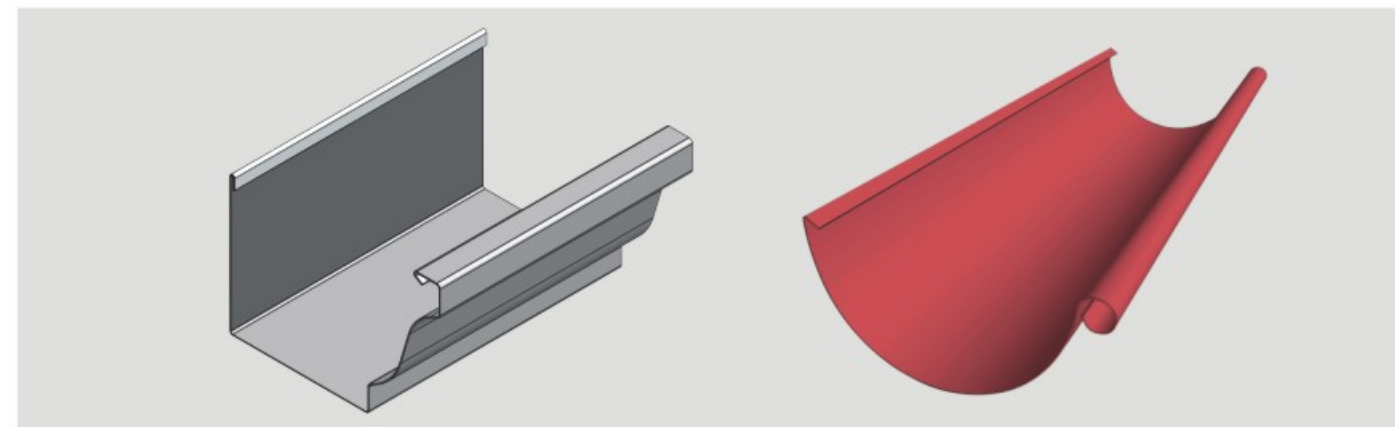
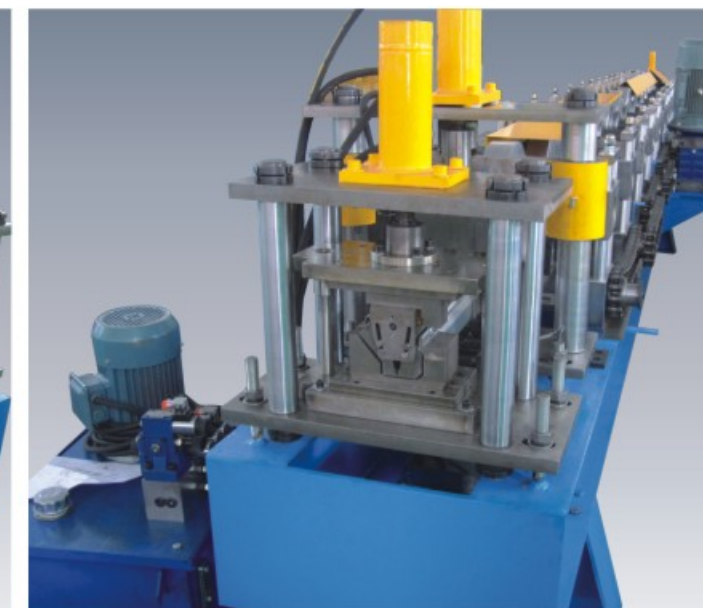
Technical Parameters

1	Suitable Material	PPGI Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.5-0.6 mm
4	Roll Forming Speed	10-12 m/min (Exclude Cutting Time)

Equipment List

1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Rollformer with tooling	1 set
3	Hydraulic cut-off machine	1 set
4	Run out table	1 set
5	Pipe Curving Machine	1 set
6	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set

Rainwater Gutter Roll Forming Machine



Application

A rain gutter is a narrow channel, or trough, forming the component of a roof system which collects and diverts rainwater shed by the roof. Rainwater roll forming machine is the essential for its production.

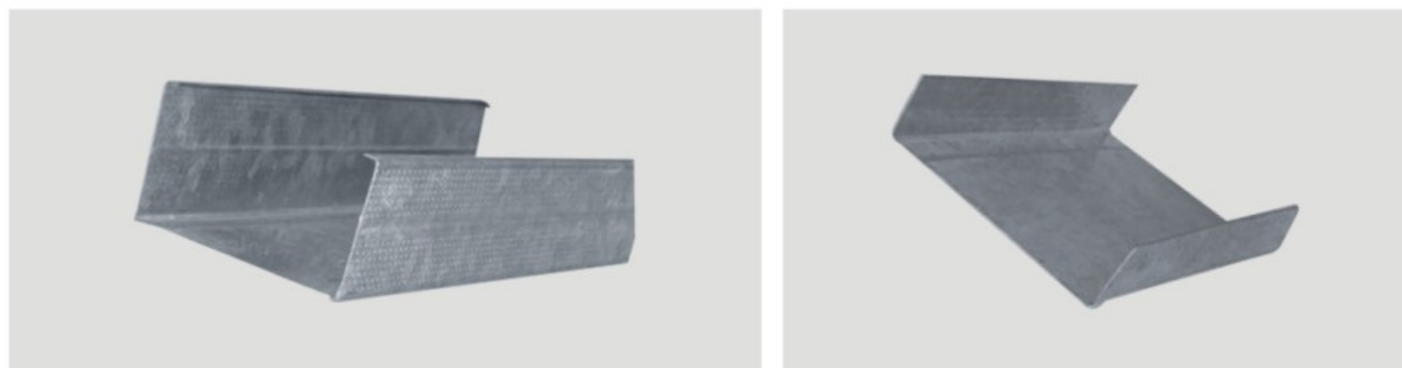
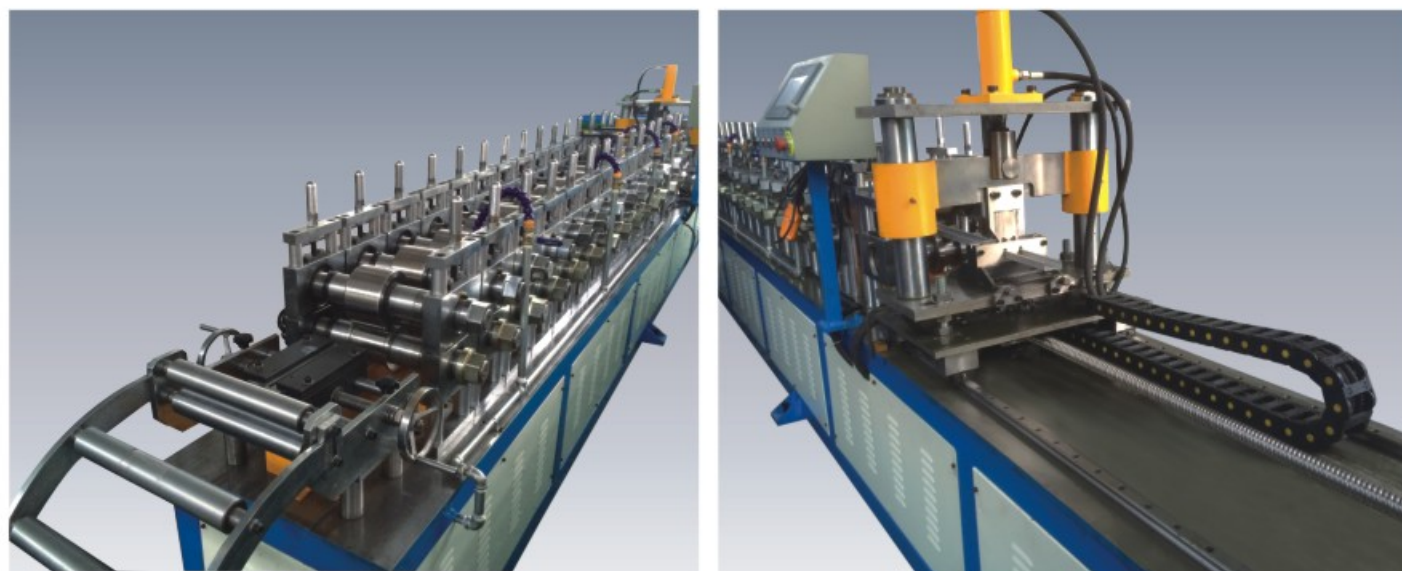
Technical Parameters

1	Suitable Material	PPGI Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.5-0.6 mm
4	Roll Forming Speed	10-15 m/min (Exclude Cutting Time)

Equipment List

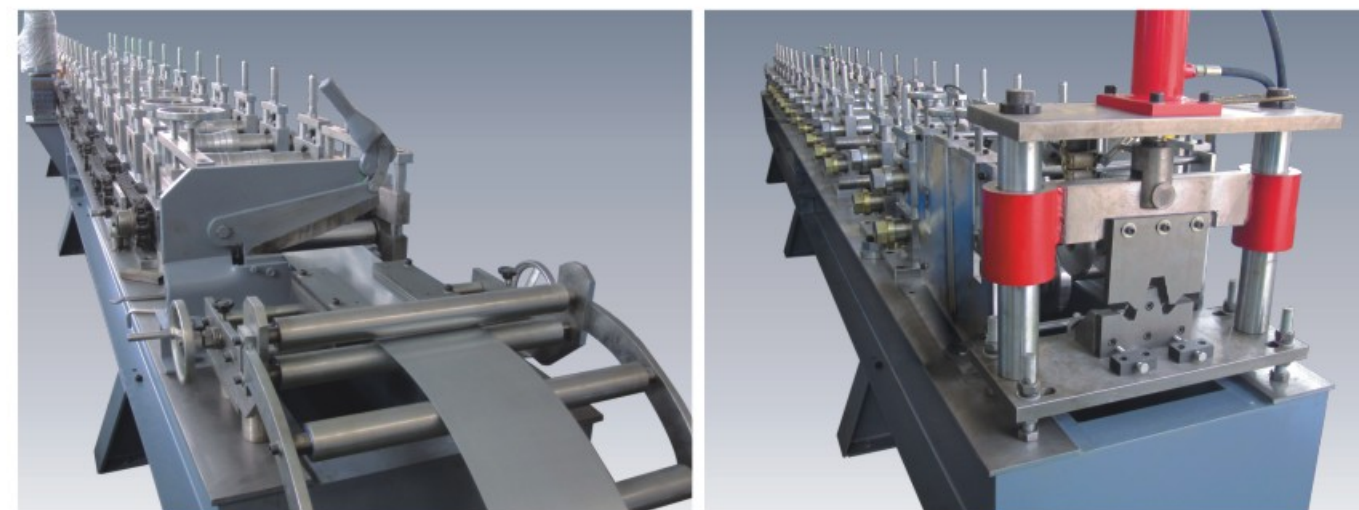
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Rollformer with tooling	1 set
3	Hydraulic cut-off machine	1 set
4	Run out table	1 set
5	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set

Drywall Stud/Track Roll Forming Machine

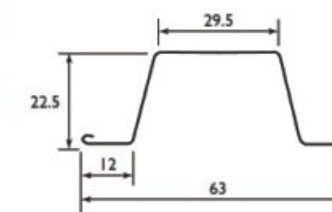
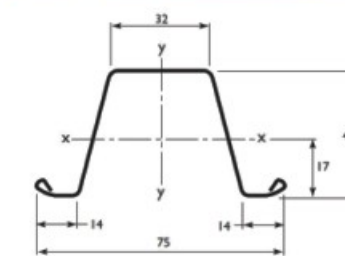


Application		
Drywall stud/track is a vertical member in the light frame construction techniques called balloon framing and platform framing of a building's wall. Drywall stud/track roll forming machine is the essential for its production.		
Technical Parameters		
1	Suitable Material	Galvanized Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.5-1.0 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Hydraulic Pre-Punching Device	1 set
3	Rollformer with tooling	1 set
4	Hydraulic cut-off machine (Option: Flying Shear)	1 set
5	Run out table or automatic stacking device	1 set
6	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set

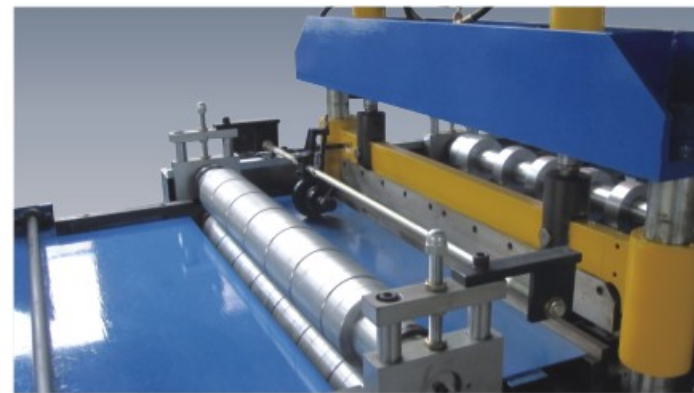
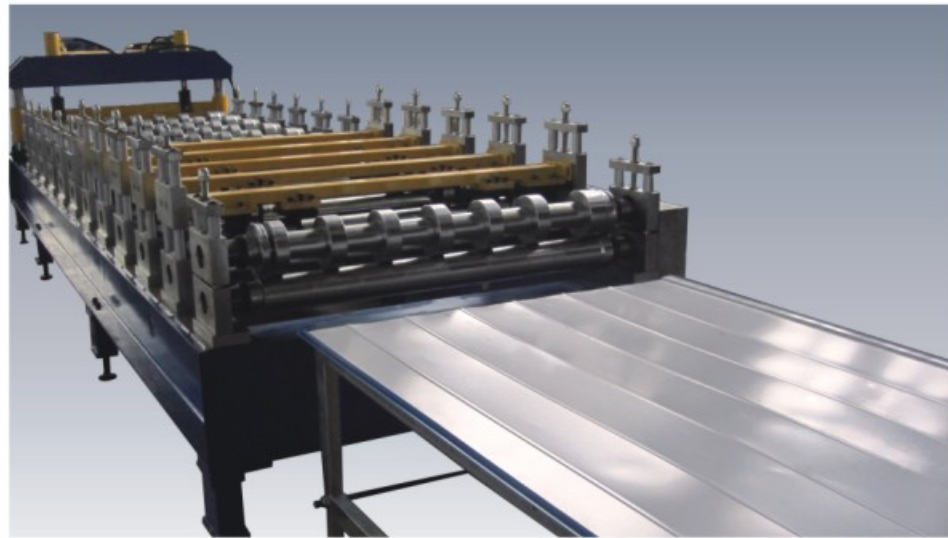
Batten Roll Forming Machine



Application		
Ceiling Batten and roof batten Steel Sections are light and strong and have several advantages over traditional battens. Ceiling and roof batten roll forming machine is special designed for its production.		
Technical Parameters		
1	Suitable Material	Galvanized Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.8-1.2 mm
4	Roll Forming Speed	10-15 m/min (Exclude Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Embossing device	1 set
3	Rollformer with tooling	1 set
4	Hydraulic cut-off machine	1 set
5	Run out table	1 set
6	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set



Cold Storage Panel (Refrigeration Panel) Roll Forming Machine



Application

Cold storage panels function as walls, ceilings and roofs for cooler, freezer and food processing buildings, in new and retrofit construction. Cold storage panel roll forming machine is special designed for its skin sheet production.

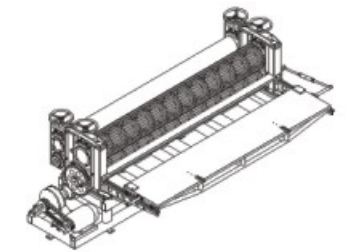
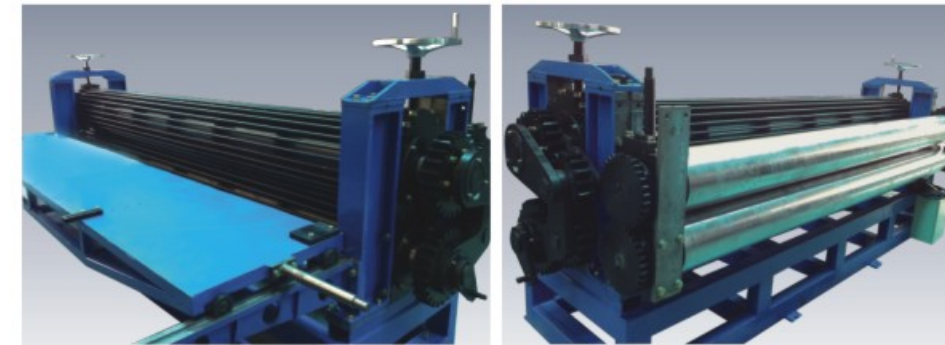
Technical Parameters

1	Suitable Material	PPGI Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.4-1.0 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)

Equipment List

1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Entry Guide + Five(5)-Roll Leveling device	1 set
3	Hydraulic Pre-Punching & Notching Device	1 set
4	Hydraulic Pre-Cutting Device	1 set
5	Edge Rollformer with tooling	1 set
6	Hydraulic L bending(Front & Rear)	1 set
7	Roller Conveyor(After bending)	1 set
8	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set

Barrel Corrugation Machine



Sheet Width: 1250mm
No. of Corrugations: 15

Sheet Width: 1000mm
No. of Corrugations: 12

Sheet Width: 914mm
No. of Corrugations: 11

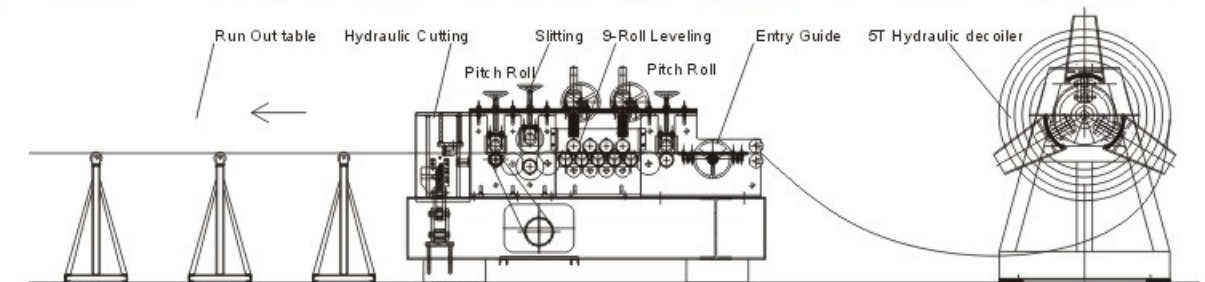
Sheet Width: 762mm
No. of Corrugations: 9

Profiles of Corrugation

Technical Parameters

Technical Parameters		Technical Parameters
1	Raw Material	Full Hard, Semi-Hard, Soft Galvanised Sheets
2	Material Thickness	0.15-0.45 mm
3	Sheet Length	Max. 2500 mm/3000 mm/3660 mm/4267 mm
4	Sheet Width	762 / 914 / 1000/1220 / 1250 mm
5	Drive	AC5.5kW
6	O.D. Of Corrugation Rolls	380 mm
7	O.D. Of Pinch Rolls	317 mm
8	Production Capacity	1.5-18 m/min

Simple Slitting & Cut To Length Machine



Technical Parameters

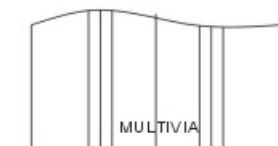
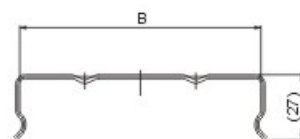
1	Raw Material	PPGI Steel Coil / Galvanized Steel Coil / Galvalume Steel Coil
2	Thickness(mm)	0.2-1.2 mm
3	Slitting Width(mm)	80 mm—1250 mm
4	Working Speed (m/min)	Adjustable up to 18 m/min
5	Slitting Blade	9 pcs
6	Total Power(kw)	9.2

Cable Tray Roll Forming Machine



Profile of HC-600
Yield strength of material: less than 235Mpa
Thickness of material: 1.0mm-1.5mm

110	×	414	464	564	664	764	864
85	×	364	414	514	614	714	814
60	×	264	314	464	564	664	764
35	×	214	264	314	414	514	614
100		150	200	300	400	500	600



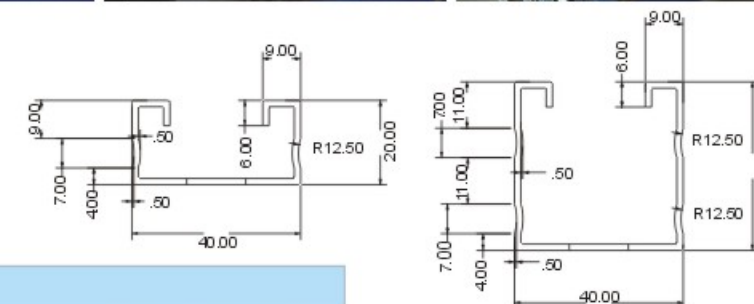
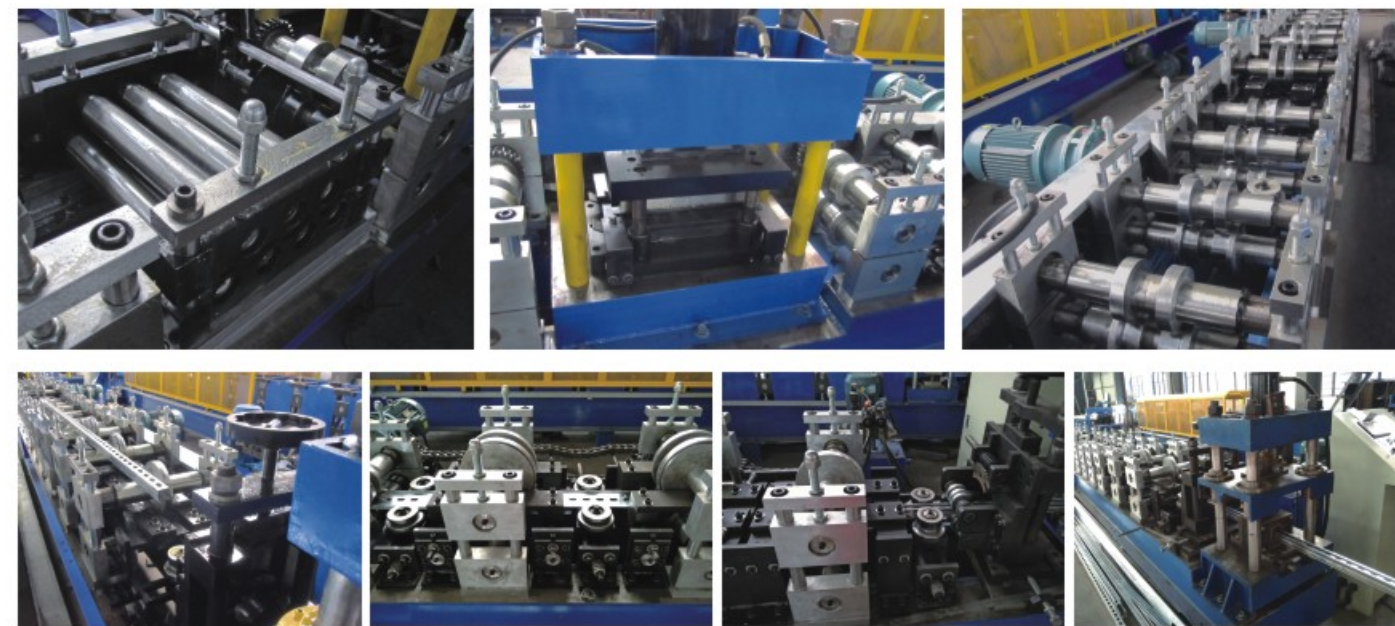
Profile of HC-600A
Yield strength of material: less than 235Mpa
Thickness of material: 1.0mm-1.5mm

152	202	252	352	452	552	652
100	150	200	300	400	500	600

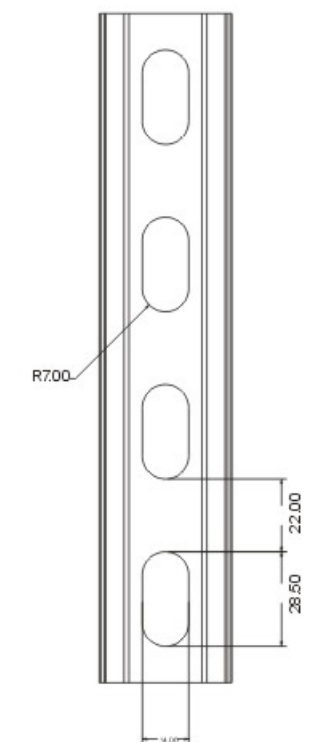


Application		
A cable tray system, is "a unit or assembly of units or sections and associated fittings forming a rigid structural system used to securely fasten or support cables and raceways." Cable trays are used to hold up and distribute cables. Cable tray roll forming machine is special designed for its production.		
Technical Parameters		
1	Suitable Material	Galvanized Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.6-1.2 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Leveler	1 set
3	Servo Roll Feeder	1 set
4	Hydraulic Pre-Punching Or Mechanical Punching Press	1 set
5	Hydraulic Pre-Cutting Or Mechanical Shearing Machine	1 set
6	Powered Roller Conveyor	1 set
7	Cantilevered Type Rollformer with tooling	1 set
8	Run out table	1 set
9	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set

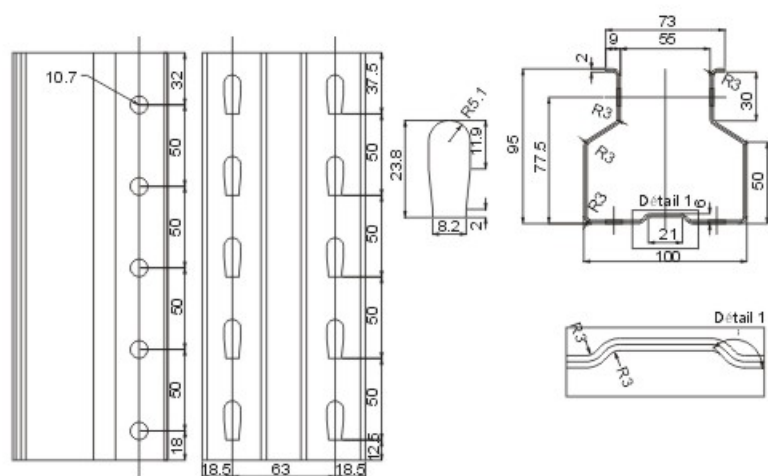
Strut Channel Roll Forming Machine



Application		
Strut channel is a standardized formed galvanized steel (or sometimes aluminium) structural system used in the construction and electrical industries for light structural support, often for supporting wiring, plumbing, or mechanical components such as air conditioning or ventilation systems. Strut channel roll forming machine is the essential for its production.		
Technical Parameters		
1	Suitable Material	Galvanized Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	1.5-2.0 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Leveler	1 set
3	Servo Roll Feeder	1 set
4	Hydraulic Pre-Punching Device Or Mechanical Punching Press	1 set
5	Rollformer with tooling	1 set
6	Strengthening Device	1 set
7	Hydraulic cut-off machine (Option: Flying Shear)	1 set
8	Run out table	1 set
9	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set

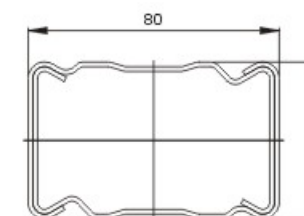


Shelving And Racking Roll Forming Machine



Application		
With the production advantage of the shelving & storage racks roll forming machine, an extensive catalogue of shelving, heavy duty shelving, warehouse shelving and racking for the home and office are developed rapidly.		
Technical Parameters		
1	Suitable Material	Hot Rolled Steel
2	Material Width	According to Profile Drawing
3	Material Thickness	1.8-2.5 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Leveler	1 set
3	Servo Roll Feeder	1 set
4	Hydraulic Pre-Punching Device Or Mechanical Punching Press	1 set
5	Rollformer with tooling	1 set
6	Hydraulic cut-off machine (Option: Flying Shear)	1 set
7	Run out table or automatic stacking device	1 set
8	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set

Box Beam Roll Forming Machine



Application		
Box beams are made from two identical channel sections nested together to form a box, Box beam is the most widely used beam, as the structure is the most strong compare with other type of beam.Box beam roll forming machine is the essential for its production.		
Technical Parameters		
1	Suitable Material	Hot Rolled Steel
2	Material Width	According to Profile Drawing
3	Material Thickness	1.8-2.5 mm
4	Roll forming speed	10-15 m/min (Exclude Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Entry Guide + Five(5)-Roll Leveling device	1 set
3	Rollformer with tooling	1 set
4	Hydraulic cut-off machine	1 set
5	Run out table	1 set
6	Box Beam joining machine	1 set
7	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set

Shelving Panel Roll Forming Machine

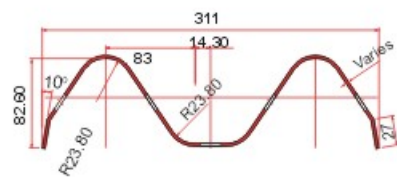
Application		
With the production advantage of the shelving panel roll forming machine, it can automatic produce shelf panel.		
Technical Parameters		
1	Suitable Material	Galvanized Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.8-1.2 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Entry Guide + Five(5)-Roll Leveling device	1 set
3	Hydraulic Pre-Punching & Notching Device	1 set
4	Hydraulic Pre-Cutting Device	1 set
5	Rollformer with tooling	1 set
6	Hydraulic L bending(Front & Rear)	1 set
7	Roller conveyor(After bending)	1 set
8	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting	1 set



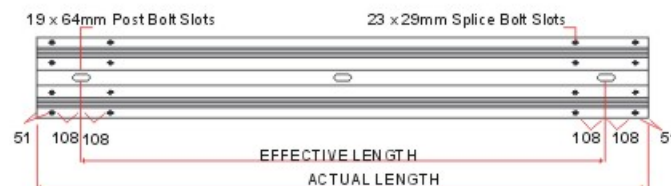
Guardrail Beam Roll Forming Machine



W-Beam Profile



W-Beam Dimensions



Application

A crash barrier or guardrail is a barrier on a road designed to prevent vehicles from leaving the roadway to improve road safety. Guardrail beam roll forming machine is special designed for its production.

Technical Parameters

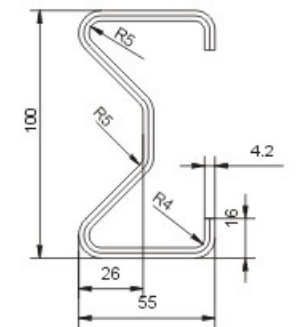
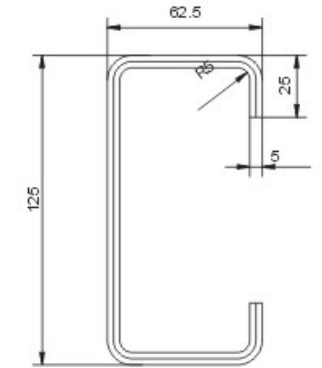
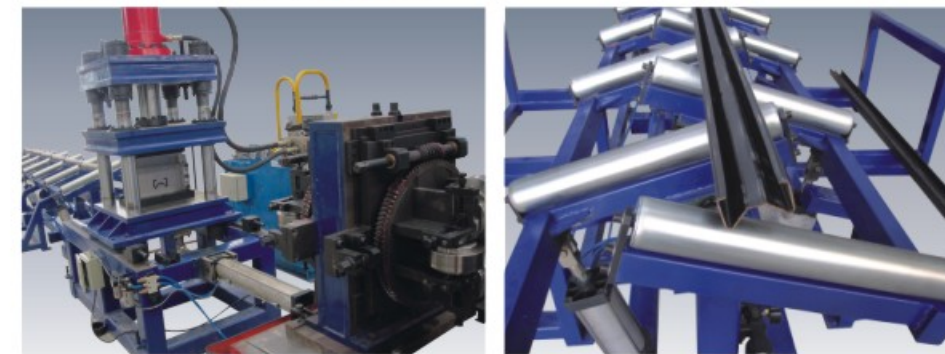
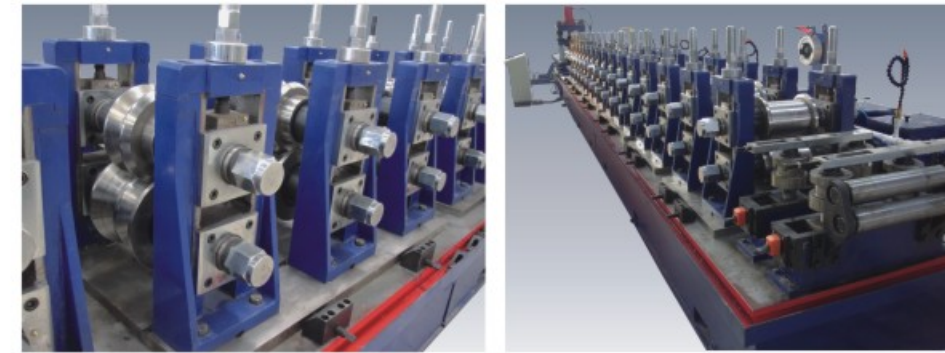
1	Suitable Material	Hot Rolled Steel
2	Material Width	According to Profile Drawing
3	Material Thickness	2.7-3.5 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)

Equipment List

1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Loading Coil Car (Option)	1 set
3	Peeler Table And Pressure Pad	1 set
4	Leveler	1 set
5	Hydraulic Crop Shearing And Butt-Welding Equipment(Optional)	1 set
6	Entry Looping Pit	1 set
7	Servo Roll Feeder	1 set
8	Online Hydraulic Punching Equipment Or Mechanical Punching Press	1 set
9	Exit Looping pit	1 set
10	Rollformer with tooling	1 set
11	Straightening Device	1 set
12	Flying cut-off machine	1 set
13	Run Out Table or automatic stacking device	1 set
14	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting.	1 set



Sigma Post/C/U Post Roll Forming Machine



Application

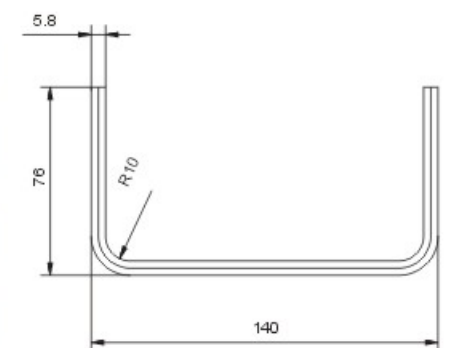
Guardrail beam is mounted with sigma/C/U shape post. Sigma/C/U shape post roll forming machine is special designed for its production.

Technical Parameters

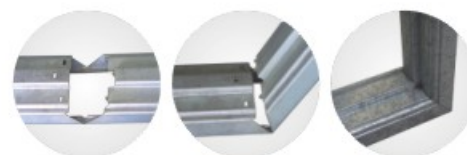
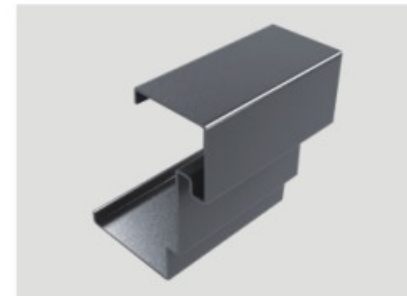
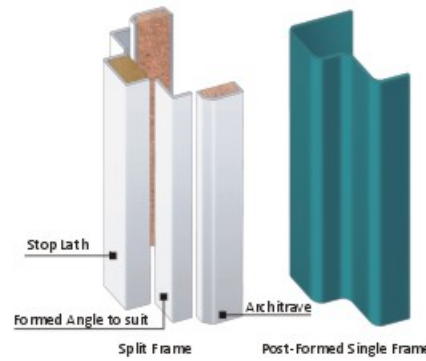
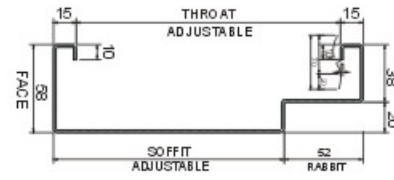
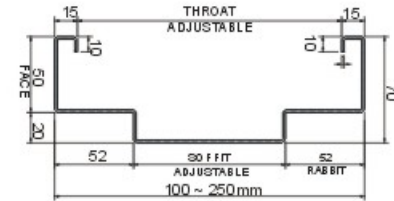
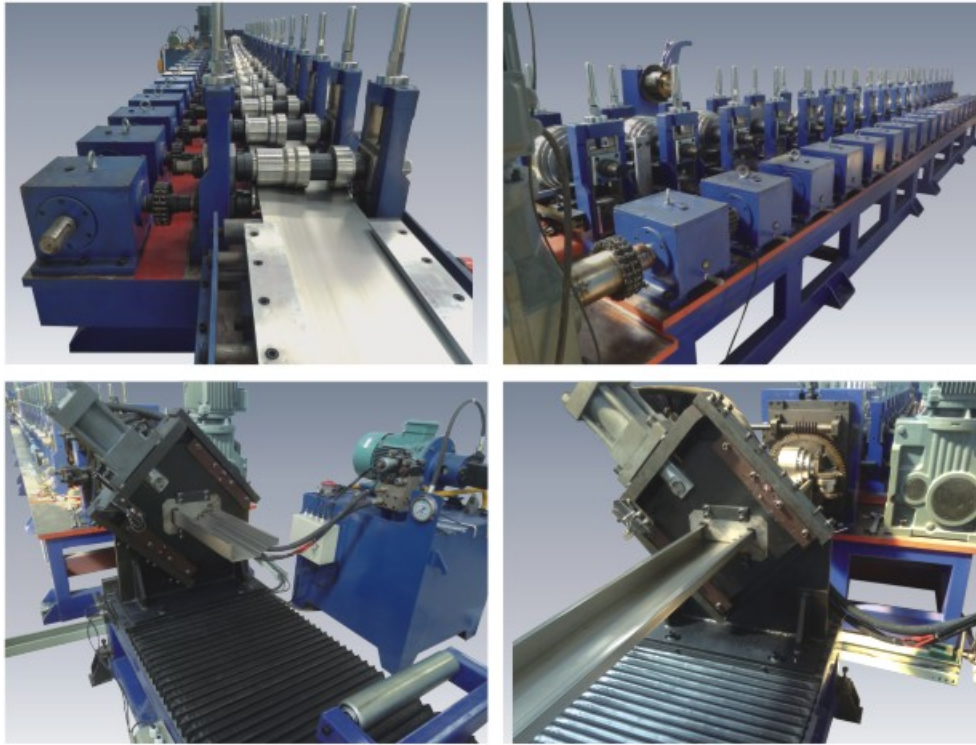
1	Suitable Material	Hot Rolled Steel
2	Material Width	According to Profile Drawing
3	Material Thickness	4.0-6.0 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)

Equipment List

1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Loading Coil Car (Option)	1 set
3	Peeler Table And Pressure Pad	1 set
4	Leveler	1 set
5	Hydraulic Crop Shearing And Butt-Welding Equipment(Optional)	1 set
6	Entry Looping Pit	1 set
7	Servo Roll Feeder	1 set
8	Online Hydraulic Punching Equipment Or Mechanical Punching Press	1 set
9	Exit Looping pit	1 set
10	Rollformer with tooling	1 set
11	Straightening Device	1 set
12	Flying cut-off machine	1 set
13	Run Out Table or automatic stacking device	1 set
14	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting.	1 set



Door Frame Roll Forming Machine



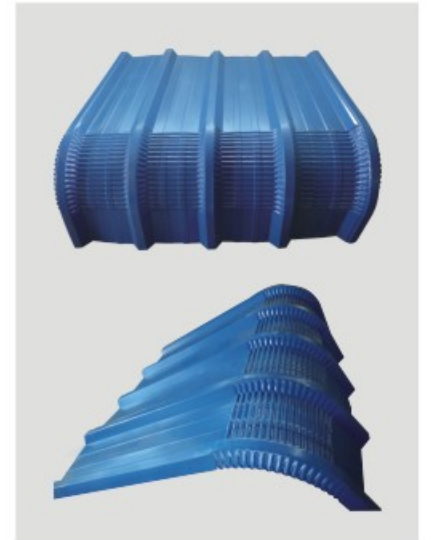
Hydraulic Uncoiler With Coil Car



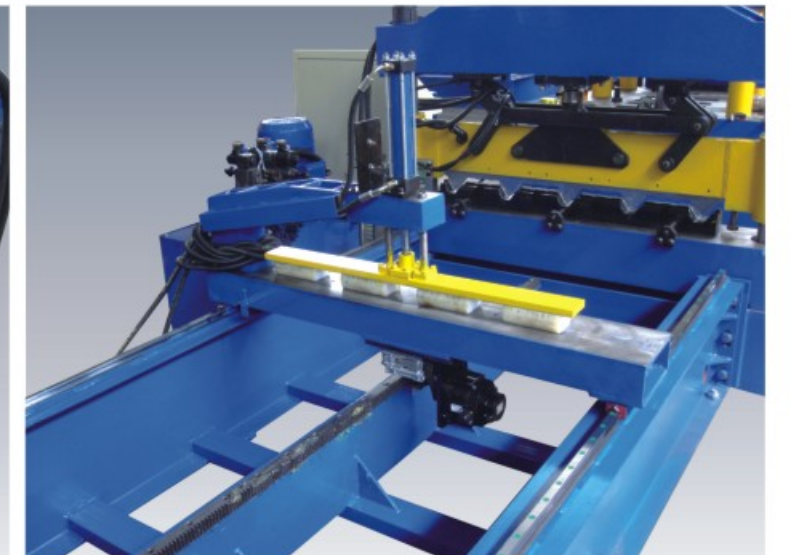
Simple Slitting Machine



Automatic Stacker



Servo Drive Crimping Machine



Application		
Steel door frame have always been the best choice for strength and durability, which result in a finished product of the best quality and greatest strength, providing much needed security. Door frame roll forming machine is the essential for its production.		
Technical Parameters		
1	Suitable Material	Galvanized Steel Coil
2	Material Width	According to Profile Drawing
3	Material Thickness	0.8-1.2 mm
4	Roll Forming Speed	10-15 m/min (Exclude Punching & Cutting Time)
Equipment List		
1	Hydraulic Decoiler with Breaking device is equipped for coil processing	1 set
2	Loading Coil Car (Option)	1 set
3	Leveler	1 set
4	Servo Roll Feeder	1 set
5	Online Hydraulic Punching Equipment	1 set
6	Roll former with tooling	1 set
7	Straightening Device	1 set
8	Flying cut-off machine	1 set
9	Run Out Table or automatic stacking device	1 set
10	Siemens Or Mitsubishi PLC and Touchable Screen are used for data processing and setting.	1 set

RE12/16/25/28/32 ERW Carbon Steel Welded Tube Mill

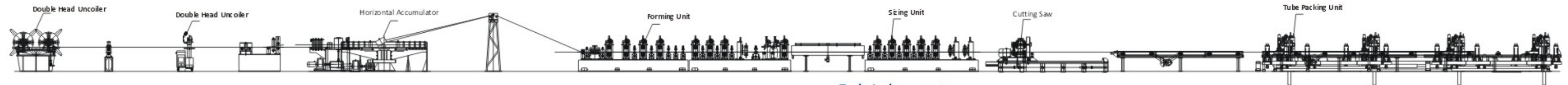


RE50/60/76 ERW Carbon Steel Welded Tube Mill



Work Flow:

Coil loading—Uncoiling—Pinching & Leveling—End Shearing—Strip joining—Horizontal Spiral Accumulator—Forming—HF Welding—Outside burr removal—Water Cooling—Sizing & straightening—Measuring roll—Flying saw cutting—Run out conveyor



Work Flow:

Coil loading—Uncoiling—Pinching & Leveling—End Shearing—Strip joining—Hoop cage—Forming—HF Welding—Outside burr removal—Water Cooling—Sizing & straightening—Measuring roll—Flying saw cutting—Run out conveyor

Technical parameters:

	RE12	RE16	RE25	RE28	RE32
Raw Material	Hot rolled steel, cold rolled steel, galvanized steel				
Round Tube Outer Diameter	7-16 mm	8-25 mm	8-30 mm	10-38 mm	13-50.8 mm
Round Tube Wall Thickness	0.3-1.0 mm	0.3-1.0 mm	0.4-1.2 mm	0.6-1.5 mm	0.6-2.0 mm
Square Tube		10×10-20×20, etc	10×10, 20×20, etc	10×10, 20×20, 30×30, etc	10×10, 20×20, 30×30, 40×40, etc
Rectangular Tube		30×10, etc	20×10, 30×10, etc	20×10, 30×10, 40×20, etc	20×10, 30×10, 40×20, 60×20, etc
Square & Rectangular Tube Wall Thickness		Max. 0.8 mm	Max. 1.0 mm	Max. 1.2 mm	Max. 1.5 mm
Tube Welding Speed	30-90 m/min	30-90 m/min	30-90 m/min	30-100 m/min	30-90 m/min
Main DC Drive	22kW	22kW	30kW	45kW	90kW
High Frequency Welder	60kW	60kW	100kW	100kW	100kW

Technical parameters:

	RE50	RE60	RE76
Raw Material	Hot rolled steel, cold rolled steel, galvanized steel		
Round Tube Outer Diameter	15-63.5 mm	16-63.5 mm	25-80 mm
Round Tube Wall Thickness	0.8-2.5 mm	1.0-3.0 mm	1.2-4.0 mm
Square Tube	19.05×19.05, 22.2×22.2, 25.4×25.4, 31.8×31.8, 38.1×38.1, 50.8×50.8	19.05×19.05, 22.2×22.2, 25.4×25.4, 31.8×31.8, 38.1×38.1, 50.8×50.8	20×20, 30×30, 40×40, 50×50, 60×60
Rectangular Tube	38.1×19.05, 38.1×25.4, 50.8×25.4, 50.8×38.1	38.1×19.05, 38.1×25.4, 50.8×25.4, 50.8×38.1	20×10-80×40
Square & Rectangular Tube Wall Thickness	Max. 2.0 mm	Max. 2.5 mm	Max. 3.5 mm
Tube Welding Speed	40-80 m/min	40-80 m/min	30-70 m/min
Main DC Drive	110kW	132W	160kW
High Frequency Welder	150kW	200kW	300kW

RE90/115/127 ERW Carbon Steel Welded Tube Mill



Work Flow:

Coil loading—Uncoiling—Pinching & Leveling—End Shearing—Strip joining—Horizontal Spiral Accumulator—Forming—HF Welding—Outside burr removal—Water Cooling—Sizing & straightening—Measuring roll—Flying saw cutting—Run out conveyor



Technical parameters:

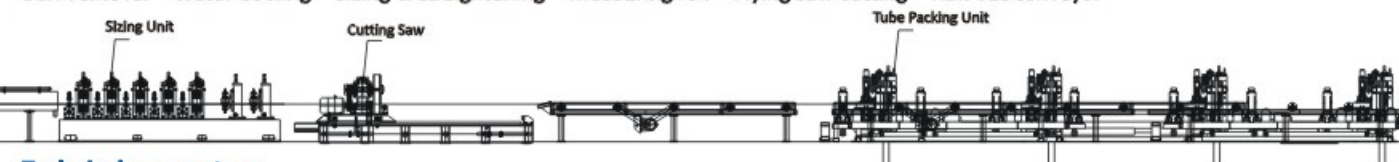
	RE90	RE115	RE127
Raw Material	Hot rolled steel, cold rolled steel, galvanized steel		
Round Tube Outer Diameter	32-100 mm	40-120 mm	32-127 mm
Round Tube Wall Thickness	1.5-4.5 mm	2.0-5.0 mm	1.5-5.0 mm
Square Tube	25×25, 30×30, 40×40, 50×50, 60×60, 70×70	35×35-90×90	25×25-100×100
Rectangular Tube	20×40, 25×40, 28×40, 30×40, 20×50, 25×50, 30×50, 40×50, 25×55, 25×60, 30×60, 40×60, 50×60, 40×70, 50×70, 40×80, 50×80, 72×80, 120×40	40×20-120×60	30×20-120×60, 130×70
Square & Rectangular Tube Wall Thickness	Max.4.0 mm	Max.4.5 mm	Max.5.0 mm
Tube Welding Speed	20-60 m/min	15-50 m/min	30-60 m/min
Main DC Drive	110kW×2	132kW×2	90kW×2
High Frequency Welder	300 kW	400kW	350kW

RE140/165/219 ERW Carbon Steel Welded Tube Mill



Work Flow:

Coil loading—Uncoiling—Pinching & Leveling—End Shearing—Strip joining—Horizontal Spiral Accumulator—Forming—HF Welding—Outside burr removal—Water Cooling—Sizing & straightening—Measuring roll—Flying saw cutting—Run out conveyor



Technical parameters:

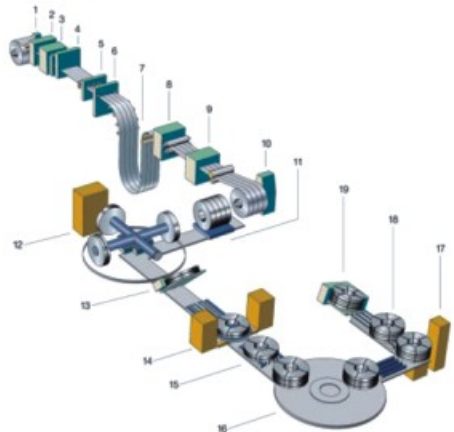
	RE140	RE165	RE219
Raw Material	Hot rolled steel, cold rolled steel, galvanized steel		
Round Tube Outer Diameter	60-140 mm	76-165 mm	114-219 mm
Round Tube Wall Thickness	1.5-4.0 mm	2.0-6.0 mm	3.0-8.0 mm
Square Tube	50x50- 110x110	70×70, 90×90, 110×110, 130×130	90×90-100×100, 125×125, 150×150, 170×170, etc
Rectangular Tube	60x40-150x70	60×80, 80×100, 100×170, 120×140	60×125, 80×150, 125×170, 150×200, etc
Square & Rectangular Tube Wall Thickness	Max. 3.5 mm	Max. 5.5 mm	Max. 6.0 mm
Tube Welding Speed	20-60 m/min	15-50 m/min	15-40 m/min
Main DC Drive	132kW×2	160kW×2	200kW×3
High Frequency Welder	400kW	600kW	800kW

Slitting Line



Slitting line for cutting narrow coils from main coils. For widths of up to 2000 mm, thicknesses of up to 20 mm and speeds of up to 150 m/min. The lines are composed of high-precision slitters with quick tooling change for slitter, tensioning device and recoiler. High-capacity recoilers . Extraction from coils without banding. Scrap ballers or scrap choppers. Moving tensioning devices with incorporated levelling. Totally computer-controlled with diagnosis, automatic coil feed and quality control. For carbon steel, exposed and non exposed materials , stainless steel, pre-painted steel, aluminium and other metals.

Layout Drawing



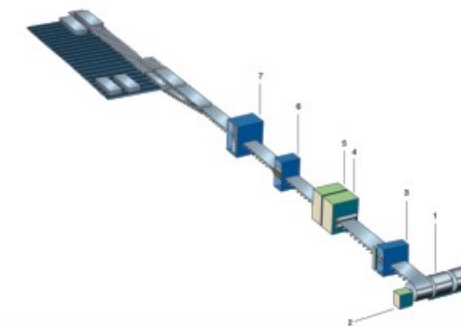
- 1. Leveller
- 2. Straightener
- 3. Inspection station 1
- 4. Cross-cut shear
- 5. Slitting shear
- 6. Trimming scrap chopper
- 7. Looping pit
- 8. Braking unit
- 9. Cross-cut shear
- 10. Reel
- 11. Coil car
- 12. Coil banding (outer)
- 13. Downer
- 14. Coil banding (inner)
- 15. Delivery frame/stacker
- 16. Rotary feed table
- 17. Pack banding
- 18. Coil transfer car
- 19. Up-ender

Model	Thickness(mm)	Width(mm)	Slitting number	Slitting speed m/min	Coil Weight(Ton)
RE-0.5×1000	0.15-0.5	300-1000	12	50-150	7
RE-0.5×1300	0.15-0.5	500-1300	24	50-150	7
RE-2×650	0.3-2	200-650	10-30	50-150	7
RE-2×1000	0.3-2	300-1000	10-30	50-150	7/15
RE-2×1300	0.3-2	500-1300	12-30	50-180	7/15
RE-2×1600	0.3-2	500-1600	12-30	50-180	7/15
RE-3×1600	0.3-3	500-1600	8-30	50-180	15
RE-3×1800	0.3-3	900-1800	8-30	50-180	20
RE-4×1600	1.0-4.0	900-1600	6-30	50-180	20
RE-6×1600	1.0-6.0	900-1600	5-30	50-80	30
RE-10×2000	2.0-10.0	900-2000	5-30	30-50	30
RE-12×2000	3.0-12.0	900-2000	5-30	20-40	30
RE-16×2000	3.0-16.0	900-2000	5-30	20-40	40
RE-20×2000	5.0-20.0	1000-2000	3-30	20-40	40

Cold Rolled Steel Cut to length Line



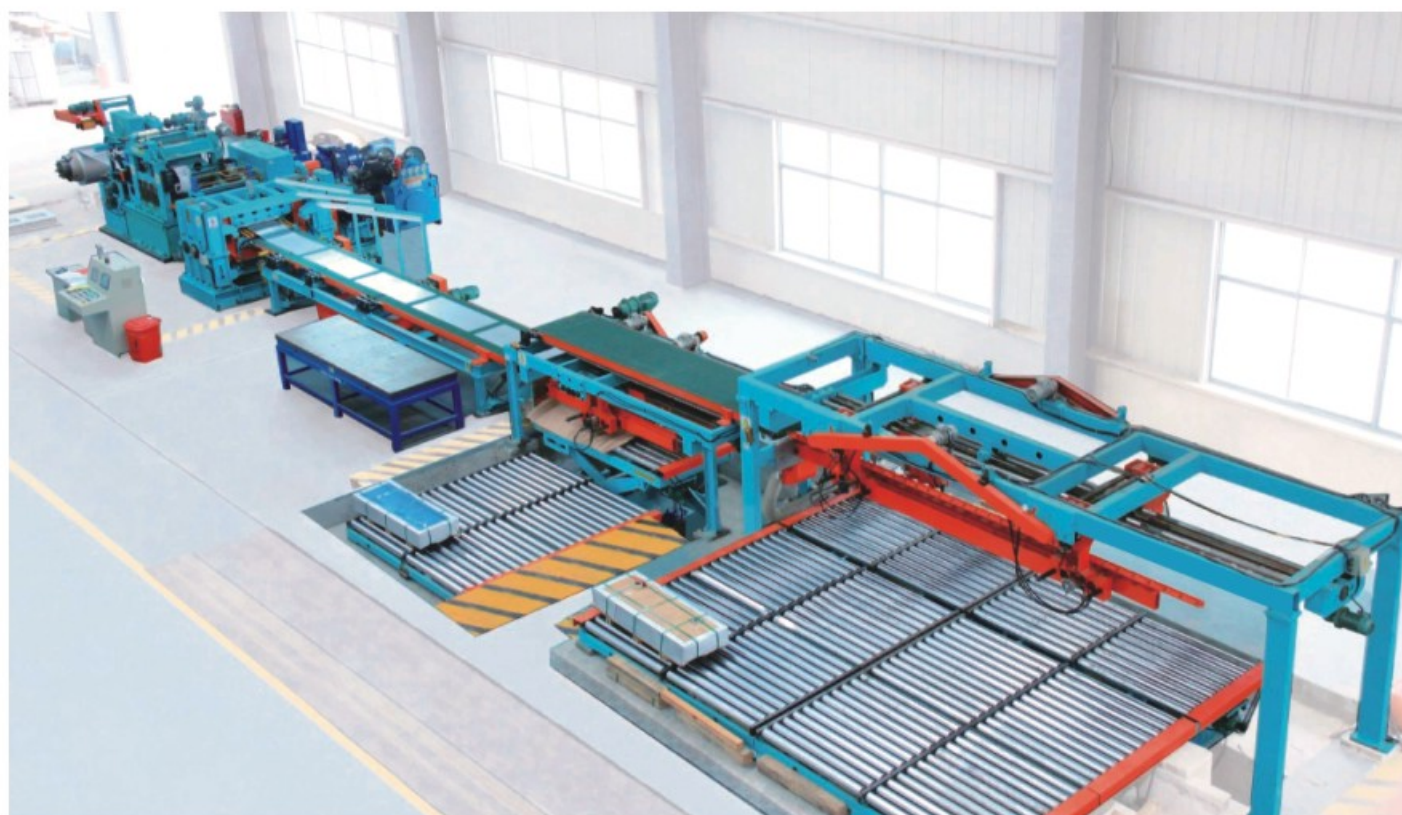
Cold Rolled Cut to Length Line is used for processing the Cold rolled steel/ pre-painted or galvanized steel and stainless steel coils less than 3mm thickness through decoiling, leveling & cutting then turned into flattened plate with desired length.



- Layout**
- 1. Coil preparation
 - 2. Pay-off reel
 - 3. Pre-leveller
 - 4. Edge trimmer
 - 5. Trimming scrap shear
 - 6. Leveller
 - 7. Cross-cut sheer

Model	1250	1600	1800	2000
Processing Material	Cold rolled steel coil, Galvanized coil, pre-painted coil, stainless steel coil, Aluminium coil, etc			
Processing Sheet Thickness	0.3-2.3 mm	0.3-3.0 mm	0.5-3.0 mm	0.5-3.0 mm
Processing Sheet Width	Max. 1250 mm	Max. 1600 mm	Max. 1800 mm	Max. 2000 mm
Coil Weight	Max. 15 Ton	Max. 20 Ton	Max. 20 Ton	Max. 20 Ton
Cutting Accuracy	±0.3 mm	±0.4 mm	±0.5 mm	±0.5 mm
Line Speed	60-80m/min			

Rotary Shear Cut to length Line



This rotary shear Cut to Length line adopts 6-High leveler to carry out continuous leveling of the sheet. With double stacker, this Rotary Shear has a high working efficiency. It is capable of shearing 150 cuts per minute, with a maximum running speed of 100 meters per minute. With 6 High leveler, the processed plates are smooth and free of scrapes. This rotary shear cut to length line is suitable for cold rolled carbon steel, tinplates, stainless steel, and other metal with coated surfaces. It is widely used in home appliances, automobiles, hardware, steel products and other industries.

Feature:

1. The cutting part of our rotary shear is comprised of an upper blade holder and a lower blade holder. The two slide holders carry out synchronous rotation and are connected to a linear guide rail. When the crankshaft rotates, the cutting station cuts and conveys the material.
2. The upper blade is of rectangular shape and the lower one is of "V" shape. They are made of Cr12MoV. The upper slide rest can be conveniently adjusted to change the cutting clearance.
3. The drive motor of this rotary shear is AC servo spindle motor. It is connected to the transmission shaft with a conical connector, which has the capability of enduring frequent impact.

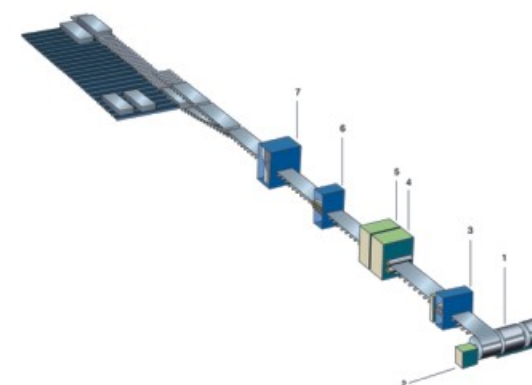
Model	Thickness (mm)	Width (mm)	Shearing Accuracy (mm)	Max. Line Speed m/min	Max. Cutting Speed (spm)	Coil Weight (ton)
RE-2x650	0.2-2	100-650	±0.3/1000 mm	60	150	8
RE-2x800	0.2-2	100-800		60	150	8
RE-2x1300	0.3-2	400-1300		70	150	15
RE-2x1600	0.3-2	400-1600		70	150	15
RE-3x1600	0.4-3	400-1600		70	120	15

Hot Rolled Steel Cut To Length Line



Hot Rolled Steel cut-to-length line suitable to process hot rolled steel coils up to 16 mm of thickness (medium/heavy gauge), 2500 mm wide, achieving quality on the surface.

Layout



1. Coil preparation
2. Pay-off reel
3. Pre-leveler
4. Edge trimmer
5. Trimming scrap shear
6. Leveler
7. Cross-cut shear

Model	12×2000	16×2100	25×2500
Processing Material	δ s ≤ 230 N/mm ² , Hot-rolled Coil, etc		
Processing Sheet Thickness	3.0~12.00 mm	4.0~16.0 mm	8.0~25.0 mm
Cutting Edge Thickness	≤ 10.0 mm	≤ 12.0 mm	≤ 16.0 mm
Coil Width	800~2000 mm	1000~2100 mm	1000~2500 mm
Coil Weight	≤ 25 T	≤ 30 T	≤ 40 T
Coil O.D	φ 610 mm ~ φ 820 mm	φ 610 mm ~ φ 820 mm	φ 610 mm ~ φ 820 mm
Cutting Range	500~12000 mm	500~12000 mm	500~12000 mm
Cutting Accuracy	± 1.5 mm	± 1.5 mm	± 1.5 mm
Line Speed	0~25 m/min	0~25 m/min	0~25 m/min