

无锡马尔利科技有限公司

Wuxi Marley Machinery Technology Co., Ltd.



Introduction of LSAWpipe equipment

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Decorative
Pipe
Machine



Manufactur
Tube
Machine



Precision
Tube
Machine



Industrial
Tube
Machine

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Overview

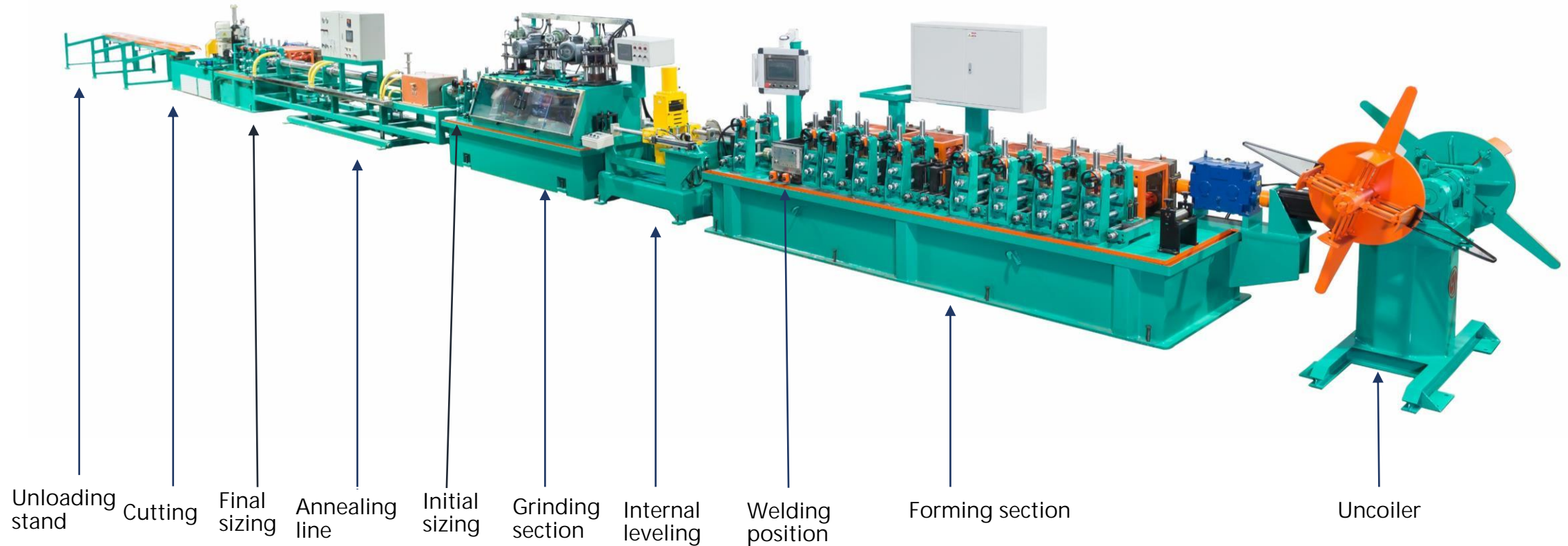
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1. Overall Program Overview

(1) Equipment Reference Chart



1.Overall Program Overview

(2) Unloading stand

1. The equipment adopts internal leveling and on-line annealing process, which can meet the production of welded pipes for water pipes, automobiles, petroleum, chemical industry and so on.
2. the equipment combines the pipe welding process, automation control technology, advanced testing methods to improve production efficiency and product quality.
3. The equipment adopts quick-disassembling structure for horizontal rollers, which greatly improves the speed of moldchange and reduces the waste of time caused by mold change.
4. The equipment adopts linkage lifting structure to improve the speed of installation and debugging, while parallel adjustment can reduce the damage of horizontal roller bearings to extend the service life.

1.Overall Program Overview

(3) Product Showcase



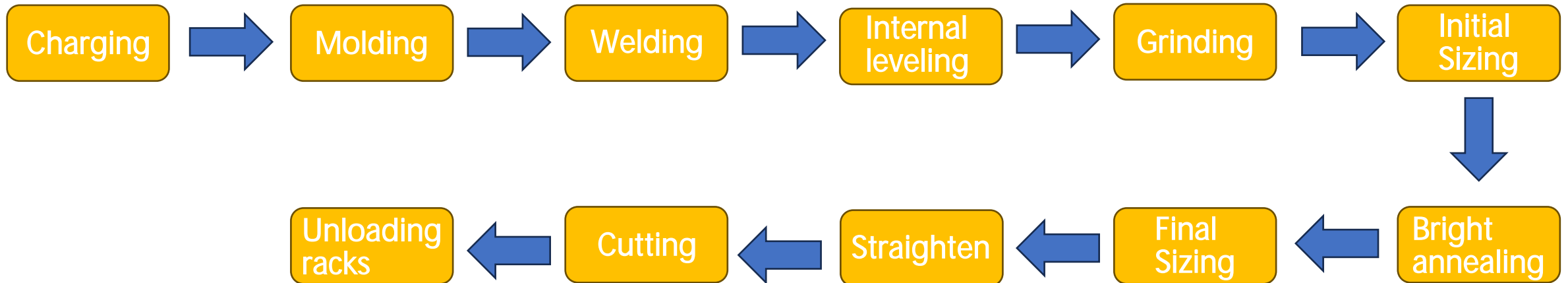
1. Overall Program Overview

(4) Product Showcase



2. Production process

(1) Process



2. Production process

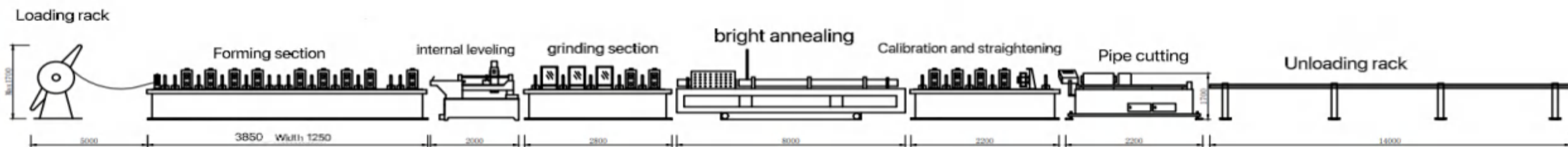
(2) Technical Parameters

Model	Horizontal axis diameter	Vertical axis diameter	Welded pipe range	Wall thickness	Power	Grinding head set	Straightening frame
Precision small ST40	Φ40mm	Φ25mm	Φ6mm-Φ38mm	0.25-1.5mm	5.5KW*2	3*3kw	2PCS
ST40	Φ40mm	Φ25mm	Φ9.5mm-50.8mm	0.25-2.0mm	7.5KW*2	3*3kw	2PCS
ST50	Φ50mm	Φ30mm	Φ25.4mm-Φ76.2mm	0.4-2.5mm	11KW*2	3*3kw	2PCS
ST60	Φ60mm	Φ40mm	Φ50.8mm-Φ114mm	0.5-3.0mm	15KW*2	3*3kw	2PCS
ST80	Φ80mm	Φ50mm	Φ76mm-Φ168mm	1.0-4.0mm	22KW*2	3*4kw	2PCS
ST100	Φ100mm	Φ70mm	Φ114mm-Φ219mm	1.5-4.5mm	30KW*2	3*5kw	2PCS

2. Production process

(3) Unit arrangement

Schematic diagram of the plane arrangement of the "body" (the following arrangement is for reference only, the actual please refer to the technical parameters)



K J V HVHVHVHVVVHVHVHVH V' V' HV LZ VDVDVDHVHV Bright annealing HVHVHVH
TQ1 TQ2 V

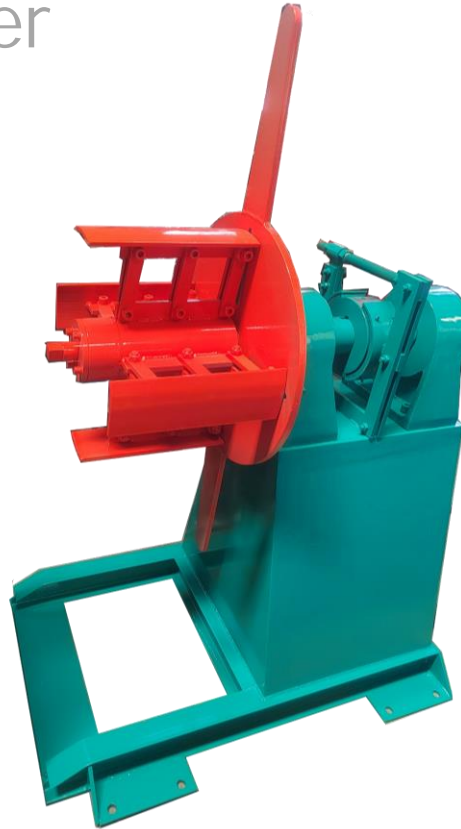
Notes: K: Uncoiler J: Guide frame H: Horizontal roll frame V: Vertical roll frame V': Welding protection box/welding roll frame D: Weld seam grinding unit TQ: Calibration unit LZ: Internal levelling

3. Equipment Configuration

(1) Equipment Uncoiler



ST small 40 (ST40)
Equipment Uncoiler



ST50 (ST60)
Equipment Uncoiler



ST80 (ST100)
Equipment Uncoiler

3. Equipment Configuration

(2) Equipment body



The body of the machine is welded with steel plate, the panel is made of the whole zigzag, and the inside of the bed is welded with reinforcing bars into a meter structure and the welding between the table top and side panels, reinforcement boards, and so on is smooth and stable. The welding surface is flat and stable, and the welding seam is full and continuous. After the bed body welding is completed, the whole aging treatment is carried out to eliminate the residual stress and deformation and then finish machining is carried out to ensure that the precision of the equipment is stable.

The body of the machine is firstly roughened by CNC three-axis gantry milling machining center, and then finely milled to process the positioning steps, positioning keyway 《GB/T 1096-2003》, positioning holes, etc. All one-time positioning processing ensures that the parallelism and flatness of the processed surface is $\leq 0.03\text{mm}$, and the arithmetic average deviation of the surface contour is $\leq 1.6\mu\text{m}$, which lays an important foundation for the consistency of the center line of the unit.

3. Equipment Configuration

(3) Equipment main motor



Motor reference diagram

The main motor brand of the equipment is Siemens Beder motor or Shandong Furi motor (frequency conversion), the motor is a three-phase asynchronous AC motor, rated voltage 380V, frequency 50HZ (exported to foreign countries can be customized) rated speed 1650r/min. The corresponding power size according to the different models of pipe making machine required torque to choose.

3. Equipment Configuration

(4) Equipment gearbox



1248 gearbox reference diagram

The 1248 gearbox is directly connected to the motor. The gearbox is one of the core components of mechanical transmission and can adjust the torque during the transmission process of the pipe making machine. The 1248 gearbox is divided into 4 gears, namely "1", "2", "4", and "8". The gear number is the transmission ratio corresponding to each gear.

3. Equipment Configuration

(5) Reduction gearbox



Gearbox reference diagram

The reduction gearbox is connected to the gearbox to increase the torque again and then connected to the horizontal axis frame through the drive shaft to provide power for mold forming.

3. Equipment Configuration

(6) Feed frame



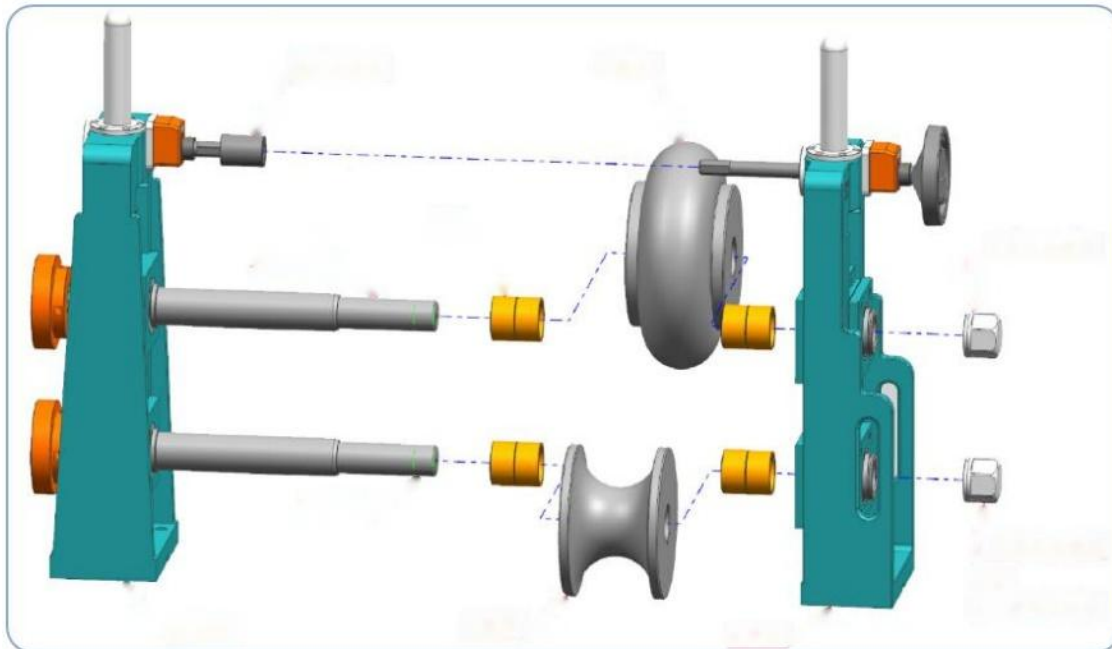
ST40 (ST50) feed frame



ST60 feed frame

3. Equipment Configuration

(7) Equipment Horizontal Axis Racks

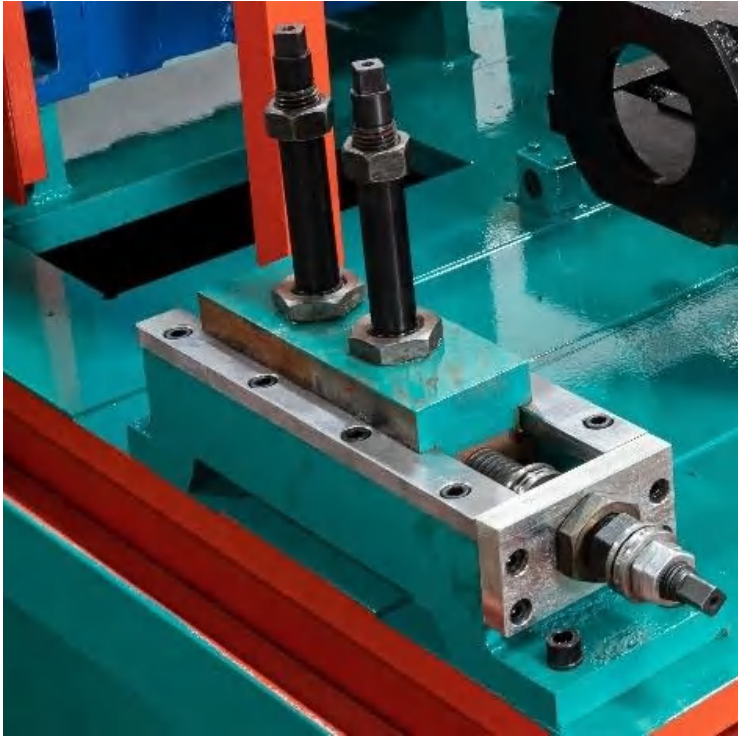


Horizontal axis rack reference diagram

The main function of the Horizontal Axis Rack is to mount the Horizontal Axis Forming Die.

3. Equipment Configuration

(8) Equipment vertical shaft frame

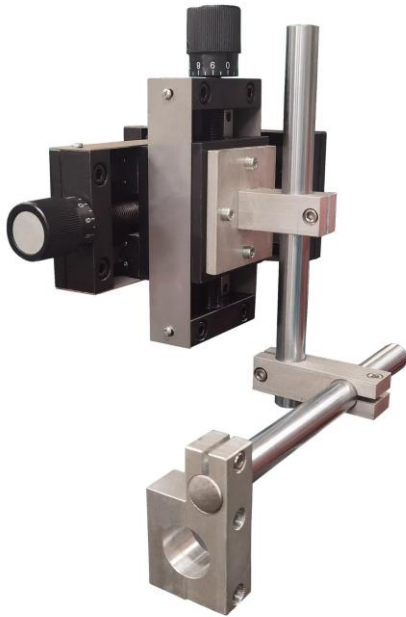


The main function of the vertical shaft frame is to install the vertical shaft forming mold.

Vertical shaft frame reference drawing

3. Equipment Configuration

(9) Equipment Welding



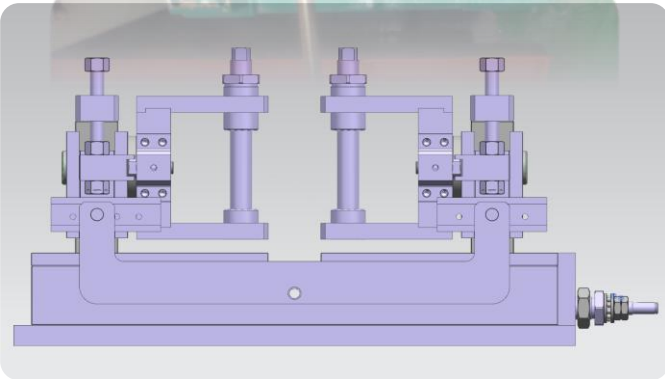
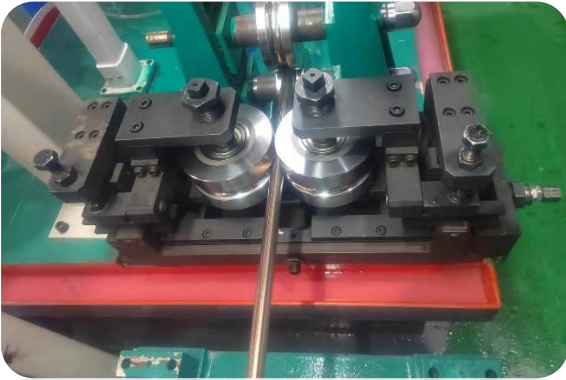
Torch Rack Reference Drawing



Welding Protection Box Reference Diagram

3. Equipment Configuration

(10) Deskewing device



Deskewing device reference diagram

Anti-torsion mechanism can be adjusted by adjusting the lifting screw to drive the rotation angle of the rotating roller shaft, driving the rotation of the mold to determine the position of the mold, as a way to eliminate the inner leveling through the mandrel tube displacement jitter when the inner leveling. (Note: large pipe does not need to correct the device).

3. Equipment Configuration

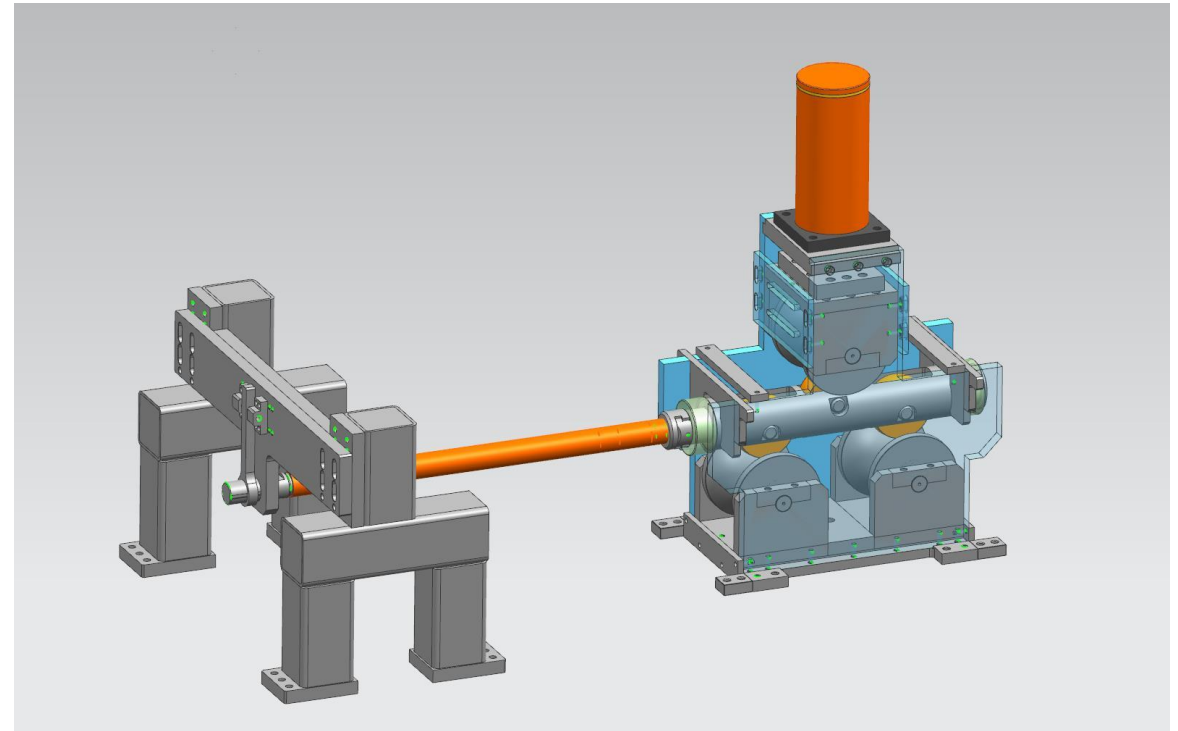
(11) Internal leveling



ST small 40(ST40, ST50)
Internal leveling



ST60 Internal leveling



ST80 Internal leveling

3. Equipment Configuration

(12) Equipment grinding



Equipment grinding part of the reference diagram

The new closed four-guide column automatic grinding, the use of dust-proof and waterproof grinding head motor, in addition to the grinding wheel without other wearing parts, low cost of use, the direct drive of the grinding head motor to avoid the traditional pulley drive do power loss, as well as high failure rate, noise, vibration, stability, etc., thus saving a lot of It also prolongs the service life, saving a lot of time and maintenance cost.

Fully automatic grinding control system automatically compensates the feed according to the loss of the millipede wheel and maintains the quality of the weld grinding without manual intervention. It is also possible to switch to manual mode for debugging the grinding position.

3. Equipment Configuration

(13) On-line annealing



On-line annealing reference diagram

On-line bright annealing equipment for on-line heating of welded tubes to 600 -1050 , followed by rapid cooling under gas protection, which is installed between the initial sizing and calibrating processes.

3. Equipment Configuration

(14) Equipment Straightening Rack



Straightening head (Turkey straightening head), is installed in a predetermined position through the straightening frame and the center of the horizontal plaque and standing plaque alignment, straightening head in the vertical and horizontal direction of adjustment, you can also adjust the worm so that the worm gear rotation angle to straighten the straightening cage around the center of the pipe rotating to the appropriate angle, through the adjustment of the roller distance between the rollers and the product (tube) radial in different directions to apply the appropriate pressure, in order to play the role of straightening the smoothness and straightness of the steel pipe. The straightening rollers can be changed according to the specifications of different tubes.

Straightening frame reference diagram

3. Equipment Configuration

(15) Cutting table



ST40 Cutting table reference diagram



ST80 Cutting table reference diagram

3. Equipment Configuration

(16) Unloading frame



ST40 (ST50) Unloading frame



ST60(ST80) Unloading frame

4. Enterprise situation

(1) Company Profile



Wuxi Marley Machinery Technology Co., Ltd. specializes in R&D, design, production and sales of metallurgical equipment and cooling and heat exchange equipment. It has been committed to closed cooling towers, stainless steel pipe making machines, high-frequency welding pipe making machines, pipe polishing machines, and pipes. Cutting machines, steel pipe inner wall polishing machines, embossing machines, internal leveling devices, online bright solution annealing equipment, steel slitting machines, steel leveling machines, cold rolling mills, and other production supporting equipment. The production equipment has high cost performance and quality assurance. The warranty period is 5 years, and consumable parts are provided free of charge during the warranty period. Welcome to consult and communicate.

4. Enterprise situation

(2) Equipment shipment



4. Enterprise situation

(2) Equipment shipment



5. Customer Cases

Dalian Customer Case



5. Customer Cases

Case of Jiangmen, Guangdong



5. Customer Cases

Hebei Customer Cases



5. Customer Cases

Shandong Customer Cases



5. Customer Cases

Shandong Customer Cases



5. Customer Cases

Shandong Customer Cases



5. Customer Cases

Chongqing Customer Cases



5. Customer Cases

Jiangsu Customer Case



5. Customer Cases

Taizhou Customer Case

