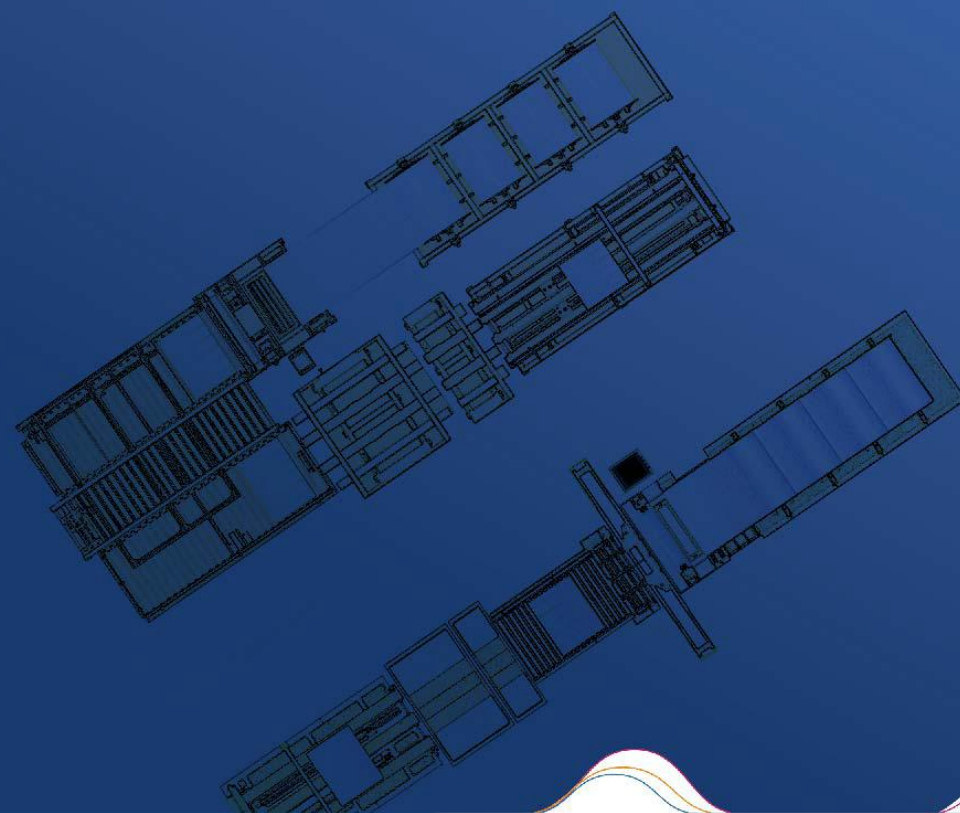




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# HVAC INTELLIGENT DUCT EQUIPMENT



**Our company** which was established in 1996, located in Mingjue industry area, Shiqiu Town, Lishui district, Nanjing City, Jiangsu Province, China. We professional produce HVAC Intelligent duct equipment, such as rectangular V, duct auto line V, auto line IV, auto line III, auto line II and Auto line I, spiral duct machine. And we also can make TDF flange forming machine, Pittsburgh lock forming machine, TDF & flat folding machine, shearing machine, punching machine, duct seam closing machine, round elbow machine and other related equipments.

In 2008, we started to produce spiral duct forming machine from imported technology, we now have worked together with a local largest manufacturing company for better development. Nowadays, we are not only a single manufacturing company, but also established an fully experienced design team and multi-directional sales channels, with the help of Alibaba, Made-in-China, Google and Youtube and other useful platforms to expand our business to all over the world.

We are sincerely looking forward to cooperating, growing and developing with you. we believe your not only positive feedback but also negative feedback is the most important for us to grow. From such precious feedback, we know how we have been doing and how we can improve in the future.

**Looking forward to your inquiry, we will reply you immediately.**



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## HVAC Duct Equipment

### Square Duct

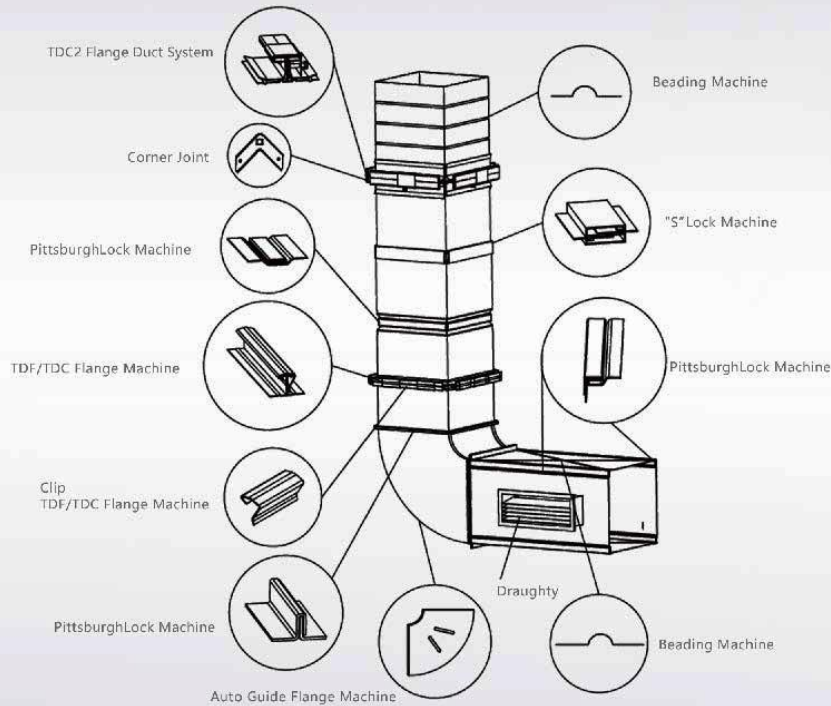


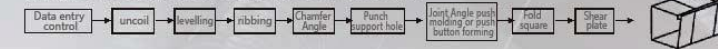
Table 3.2.1-1 Sheet thickness of steel rectangular air duct (mm)

Duct side length b	General purpose air duct		Dust removal system duct
	Medium and low pressure systems	High pressure system	
$b \leq 320$	0.5	0.75	1.5
$320 < b \leq 450$	0.6	0.75	1.5
$450 < b \leq 630$	0.6	0.75	2.0
$630 < b \leq 1000$	0.75	1.0	2.0

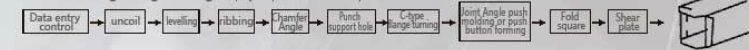
Table 2.0.10-1 Common specifications of rectangular air ducts (mm)

Duct side length				
120	320	800	2000	4000
160	400	1000	2500	—
200	500	1250	3000	—
250	630	1600	3500	—

#### 1. Angle steel flange straight pipe production process



#### 2. C.S cutting flange straight pipe production process



#### 3. TDC2 flange straight pipe production process



Note: Angle steel flanges, C.S cutting flanges, TDC2 flanges air duct processing process can be completed with economic half line.

#### 4. TDC1 flanged straight pipe production process

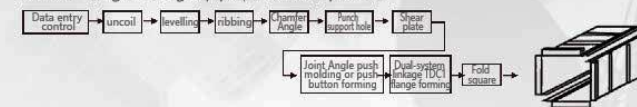


Table 3.1.5-1 Connection types of metal rectangular air ducts and applicable air duct side lengths

Connection form		Accessory size (mm)		Applicable duct side length (mm)		
Horned orich		M6 bolt	L25X3	Low pressure duct	Medium pressure duct	High pressure duct
		M8 bolt	L30X3	$\leq 1250$	$\leq 1000$	$\leq 630$
		M8 bolt	L40X3	$\leq 2500$	$\leq 2500$	$\leq 1600$
		M8 bolt	L50X3	$\leq 4000$	$\leq 3000$	$< 2500$
Sheet steel flange		Spring clip type	The thickness of the spring splint is greater than or equal to 1.0mm and the thickness of the top wire card is greater than or equal to 3mm and the top wire screw M8	$h=25, \delta_1=0.6$	$\leq 630$	—
		Plug-in type		$h=25, \delta_1=0.75$	$\leq 1000$	—
		Top wire clip type		$h=25, \delta_1=1.2$	$\leq 2000$	$\leq 2000$
		Combined type		$h=25, \delta_1=0.75$	$\leq 2000$	—
S-strip		Flat cutting	Greater than the wall thickness of the air duct and greater than or equal to 0.75mm	$\leq 630$	—	—
		Vertical cutting	Greater than the wall thickness of the air duct and greater than or equal to 0.75mm $h \geq 25mm$	$\leq 1000$	—	—
C-strip		Flat cutting	Greater than the wall thickness of the air duct and greater than or equal to 0.75mm	$\leq 630$	$< 450$	—
		Vertical cutting	Greater than the wall thickness of the air duct and greater than or equal to 0.75mm $h \geq 25mm$	$< 1000$	$\leq 630$	—
Right Angle cut		Right Angle cut	Equal to the wall thickness of the air duct and greater than or equal to 0.75mm $h \geq 25mm$	$\leq 630$	—	—
		Vertical bite	The thickness of the edge plate is equal to the thickness of the air pipe arm $h \geq 25mm$	$\leq 1250$	—	—
Vertical joint corner cut		Vertical joint corner cut		$\leq 1250$	—	—
		Vertical bite		$\leq 1000$	$\leq 630$	—

Table 3.2.1-3 Maximum allowable spacing (mm) for rectangular air duct connections

Stiffness class	Duct side length b	Maximum allowable spacing							
		$\leq 500$	630	800	1000	1250	1600	2000	2500
Low pressure duct	F 1	1000							
	F 2	2000	1600	1250					
	F 3	2000	1600	1250	1000			non-use	
	F 4	2000	1600	1250	1000	800	800		
	F 5	2000	1600	1250	1000	800	800	800	
	F 6	2000	1600	1250	1000	800	800	800	800
Medium pressure duct	F 2	1250							
	F 3	1600	1250	1000				non-use	
	F 4	1600	1250	1000	800	800			
	F 5	1600	1250	1000	800	800	800	625	
	F 6	2000	1600	1000	800	800	800	800	625
	F 3	1250							
High pressure duct	F 4	1250	1000	800	625			non-use	
	F 5	1250	1000	800	625	625			
	F 6	1250	1000	800	625	625	625	500	400

Table 3.2.1-4 Maximum allowable spacing (mm) for rectangular air duct connection with sheet steel flange

Stiffness class	Duct side length b	Maximum spacing							
		$\leq 500$	630	800	1000	1250	1600	2000	2500
Low pressure duct	Fb1	1600	1250	625	500				
	Fb2	2000	1600	1250	650	500	400		
	Fb3	2000	1600	1250	1000	800	600	non-use	
	Fb4	2000	1600	1250	1000	800	800		
Medium pressure duct	Fb1	1250	650	500					
	Fb2	1250	1250	650	500	400	400		
	Fb3	1600	1250	1000	800	650	500	non-use	
	Fb4	1800	1250	1000	800	800	800		

## HVAC Duct Equipment

### Round Duct

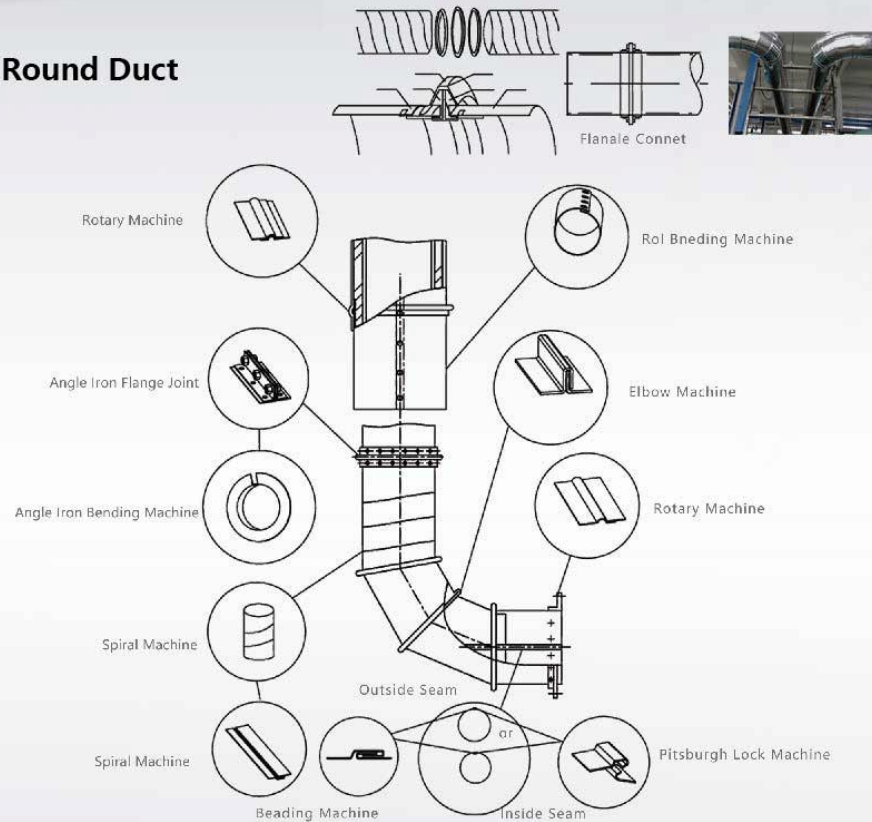


Table 2.0.10-2 Specifications of round air ducts (mm)

Duct diameter	Basic series	100	120	140	160	180	200	220	250	280	320	360	400	450	
	Auxiliary series	80	90	110	130	150	170	190	210	240	260	300	340	380	420
	Basic series	50	560	630	700	80	90	100	1120	1250	1400	1600	1800	2000	
	Auxiliary series	480	530	600	670	750	850	950	1060	1180	1320	1500	1700	1900	

Table 3.2.6-1 Thickness of circular air duct sheet (m)

Duct diameter D	Low pressure duct		Medium pressure duct		High pressure duct	
	Spiral suture	Straight slit	Spiral suture	Straight slit	Spiral suture	Straight slit
D≤320	0.50		0.50		0.50	
320 < D≤450	0.50	0.60	0.50	0.75	0.60	0.75
450 < D≤1000	0.60	0.75	0.60	0.75	0.60	0.75
1000 < D≤1250	0.75	1.00	0.75	1.00	1.00	
1250 < D<2000	1.00	1.20	1.20		1.20	
D < 2000	1.20		By design			



Table 3.1.5-2 Connection modes and application scope of metal circular air ducts

Connection form		Accessory size (mm)	Connection requirement	Scope of application
Angle steel flange connection	Normal	L25x3 L30x3 L40x4	The connection between the flange and the house reform shall be riveted or welded	Low, medium and high pressure air ducts
	Angle reinforcement	—	Insert depth greater than or equal to 30mm, there should be sealing measures	Low pressure air duct with diameter less than 700mm
	Compression reinforcement	L25x3 L30x4	Insert depth greater than or equal to 20mm, there should be sealing measures	Low, medium and high pressure air ducts
	Core connection	—	Insert depth greater than or equal to 20mm, there should be sealing measures	Low, medium and high pressure air ducts
Vertical rib and hoop connection		The thickness of the hoop plate is greater than or equal to the thickness of the air duct wall	The air pipe flanging matches with the hoop, and the combination is firm and tight	Low, medium and high pressure air ducts
Hoop connection		The thickness of the hoop plate is greater than or equal to the thickness of the air duct wall	The tube end should be straight, and the hoop should be centered	Low and medium pressure air pipe hoop width is greater than or equal to 10m

Table 3.1.8 Allowable deviation (mm) for making air ducts and flanges

Duct side length b or diameter D		Allowable deviation	Allowable deviation	Allowable deviation	Allowable deviation	Allowable deviation
Air duct of metal	b(D) ≤ 320	≤ 2	≤ 10	≤ 10	≤ 2	≤ 2
	b(D) > 320	≤ 3	≤ 10	≤ 10	≤ 2	≤ 2
Non-metal air duct	b(D) ≤ 320	≤ 2	≤ 3	≤ 3	≤ 2	≤ 3
	320 < b(D) ≤ 2000	≤ 3	≤ 5	≤ 5	≤ 4	≤ 5

Table 3.2.6-2 Allowable deviations of core tube length, number of screws, and diameter (mm)

Duct diameter D	Low pressure duct		Medium pressure duct		Medium pressure duct	
	Spiral suture	Straight slit	Spiral suture	Straight slit	Spiral suture	Straight slit
D ≤ 320	0.50		0.50		0.50	
320 < D ≤ 450	0.50	0.60	0.50	0.75	0.60	0.75
320 < D ≤ 450	0.60	0.75	0.60	0.75	0.60	0.75
320 < D ≤ 450	0.75	1.00	0.75	1.00	1.00	
320 < D ≤ 450	1.00	1.20	1.20		1.520	
320 < D ≤ 450	1.20	By design				

Table 3.2.6-2 Allowable deviations of core tube length, number of screws, and diameter (mm)

Duct diameter D	Core length (mm)	Number of tapping screws or rivets per end of core tube (PCS)	Allowable deviation of core diameter (mm)
120	120	3	-3 ~ 4
120	160	4	

Table 3.1.4 Connection form and application range of metal air duct sheet

name	Connection mode	Scope of application
Single bite	Inside flat bite Outer flat bite	Low, medium and high pressure systems
Joint corner bite	—	Low, medium and high pressure systems
Corner bite	—	Low, medium and high pressure systems, rectangular air ducts and accessories with four corner bites
Button bite	—	Low, medium and high pressure systems, rectangular air ducts and accessories with four corner bites
Vertical bite	—	Round and rectangular air pipes are connected horizontally or longitudinally, and round elbows are made without rivets
weld	See Figure 3.21	Low, medium and high pressure systems

Table 3.4.1 Thickness of aluminum sheet air duct (mm)

Duct side length b or diameter D	Aluminum sheet thickness
100 < b(D) ≤ 320	1.0
320 < b(D) ≤ 630	1.5
630 < b(D) ≤ 2000	2.0
2000 < b(D) ≤ 4000	By design

Table 3.3.1 Sheet thickness of stainless steel air ducts and fittings

Duct side length b or diameter D	Stainless steel thickness
100 < b(D) ≤ 500	0.5
500 < b(D) ≤ 1120	0.75
1120 < b(D) ≤ 2000	1.0
2000 < b(D) ≤ 4000	1.2

Table 3.2.6-2 Allowable deviations of core tube length, number of screws, and diameter

Duct diameter D	Flange material specification		Bolt specification
	Flat steel	Steel Angle	
D ≤ 140	20x4	—	M6
140 < D ≤ 280	25x4	—	
280 < D ≤ 630	—	25x3	M8
630 < D ≤ 1250	—	30x3	
1250 < D ≤ 2000	—	40x4	



## HVAC Duct Equipment

### U Shape Auto Duct Line VI

#### Function

Mainly completing the forming of common plate flange/angle iron flange or "C" type flange, with a daily processing capacity of 1500-2000 square meters. As long as the size of the air duct is input, the production line automatically completes uncoiling, leveling, beading, punching angle, punching center hole and flange hole, shearing, lock forming, TDF flange/angle iron flange or "C" shaped flange forming, folding square ducts.



#### Performance Features

- 1.Honest strengthens the basis in the pursuit of customer satisfaction and Constant innovation helps customer to achieve their goals.
- 2.Driving feeding mechanism with pneumatic servo manipulator helps to ensure stability and speed of the machine, and the accuracy of its locating system.
- 3.It only takes 20-25 seconds to make one L-shaped workpiece and the efficiency will double comparing with the linear type.
- 4.Without moving back and forth the fixed locking machine is able to improve the efficiency.
- 5.All the rolling reels are made of bearing steel so that the lifetime prolongs by more than 5 times.
- 6.Under the material-saving mode of CNC system, waste is less than 20mm per roll.
- 7.With production memory functions, the production orders can be tracked and checked.
- 8.The production of the center hole and flange hole makes the lifting of the air duct more stable and safe.



#### Main Import Configuration

- 1.Beijing Huade plus hydraulic system from Taiwan
- 2.Japan Omron encoder

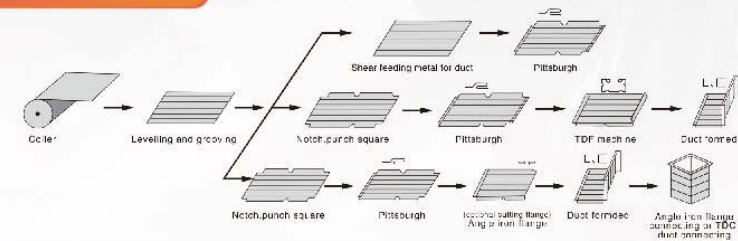
- 3.Taiwan Hiwin linear guideways
- 4.Japan Mitsubishi Electric System or Germany Siemens Electric System

#### Basic Configuration

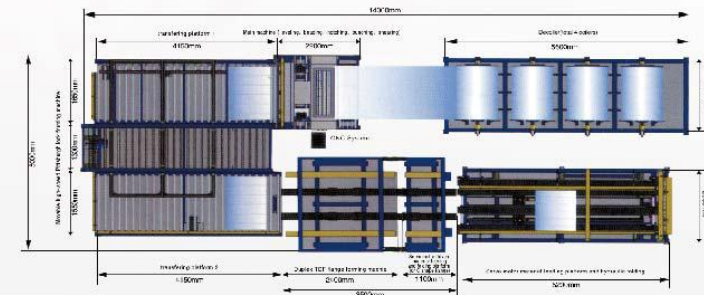
- 1.Four electric coil frames , max capacity of each frame is 8 tons.
- 2.One rack
- 3.One Set Main Machine of Auto Duct Line II.
- 4.Two stainless steel roller convey platforms
- 5.One fixed joint Pittsburgh lock forming machine

- 6.One duplex TDF flange forming machine (Option one duplex angle steel flange machine )
- 7.One servo motor power material feeder platform
- 8.One hydraulic folding machine
- 9.One set of PLC Controller

#### Working Schematic Diagram



#### Work Flow



#### Main Technical Parameters

Model	Sheet thickness (mm)	Max width (mm)	Max working speed (m/min)	Coiler max weight (T)	(mm) Dimensions			Power (Kw)	Weight (T)
					L	W	H		
BYL-VI-1300	0.5-1.5	1300	15	8	14000	5000	1500	30	13
BYL-VI-1500	0.5-1.5	1500	15	8	14000	5000	1500	30	13.5

## HVAC Duct Equipment

### U Shape Auto Duct Line V

#### Function

It's mainly used for TDF/angle steel/C-shaped flange duct making, the daily capability is 1500-2000 square meters. Only input duct size into controller, the production duct line can automatically complete uncoiling, leveling, beading, notching, shearing, duplex locking, forming TDF/angle steel/C-shaped flange and folding.

**20-25s**

One piece of L film is completed in 20-25 seconds



#### Performance Features

1. Honest strengthens the basis in the pursuit of customer satisfaction and Constant innovation helps customer to achieve their goals.
2. Driving feeding mechanism with pneumatic servo manipulator helps to ensure stability and speed of the machine, and the accuracy of its locating system.
3. It only takes 20-25 seconds to make one L-shaped workpiece and the efficiency will double comparing with the linear type.
4. Without moving back and forth the fixed locking machine is able to improve the efficiency.
5. All the rolling reels are made of bearing steel so that the lifetime prolongs by more than 5 times.
6. Under the material-saving mode of CNC system, waste is less than 20mm per roll.
7. With production memory functions, the production orders can be tracked and checked.



#### Main Import Configuration

1. Beijing Huade plus hydraulic system from Taiwan
2. Japan Omron encoder

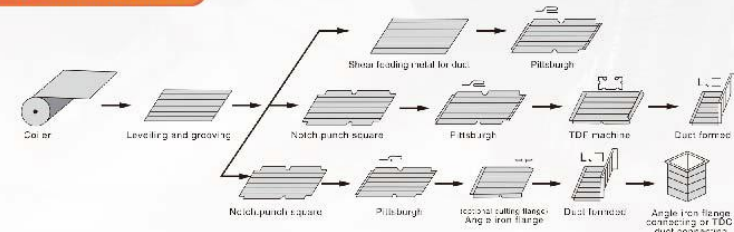
3. Taiwan Hiwin linear guideways
4. Mitsubishi electrical system

#### Basic Configuration

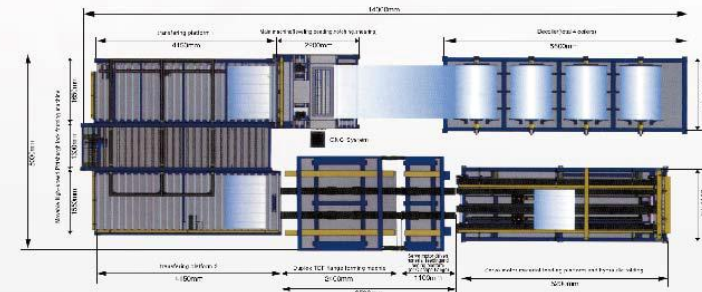
1. Four electric coil frames, max capacity of each frame is 8 tons
2. One rack
3. One Set Main Machine of Auto Duct Line II
4. Two stainless steel roller convey platforms
5. One fixed joint Pittsburgh lock forming machine

6. One duplex TDF flange forming machine (Option one duplex angle steel flange machine)
7. One servo motor power material feeder platform
8. One hydraulic folding machine
9. One set of PLC Controller

#### Working Schematic Diagram



#### Work Flow



#### Main Technical Parameters

Model	Sheet thickness (mm)	Max width (mm)	Max working speed (m/min)	Coiler max weight (T)	(mm) Dimensions			Power (Kw)	Weight (T)
					L	W	H		
BYL-V-1300	0.5-1.2	1300	15	7	14000	5000	1500	30	13
BYL-V-1500	0.5-1.2	1500	15	7	14000	5000	1500	30	13.5



## Auto Duct Line III

### Function

Duct production line 3 can drive blanking for duct. Meantime, it's very suitable for multi-production like TDF/angle steel/inserted flange forming; the angle steel flange and inserted flange can be bent into square-shaped pipe automatically.

### Performance Features

1. Aluminium alloy suspension arm makes the machine easy to operate.
2. The build-in control cabinet reduces wiring as a whole structure and makes it easy to move.
3. The imported configuration is very stable and comfortable to use.

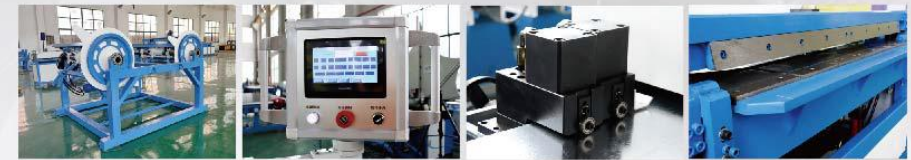


### Main Import Configuration

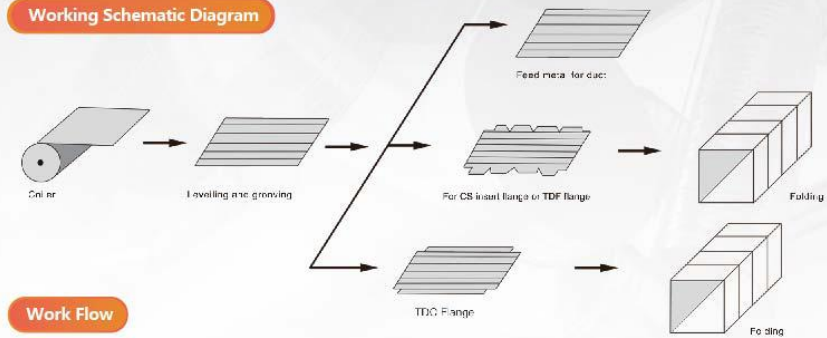
1. Mitsubishi electrical system
2. Beijing Huade or hydraulic system from Taiwan
3. Japan Omron encoder

### Basic Configuration

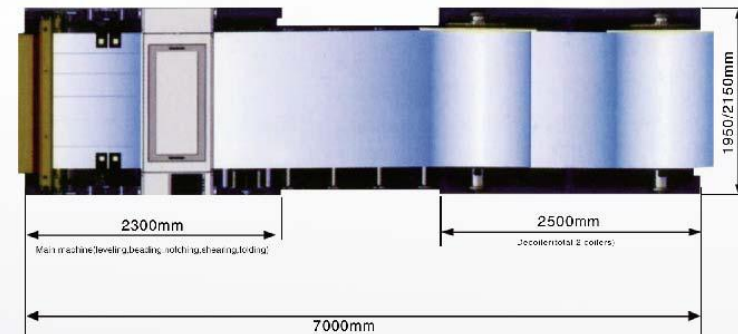
1. One electric coil cradle (two material trays)
2. One set of leveling and beading equipment
3. Hydraulic angle-shearing machine with four sets of die
4. Hydraulic sheet-shearing machine, hydraulic bending machine, hydraulic press machine
5. A set of CNC computer control system and production software



### Working Schematic Diagram



### Work Flow



### Main Technical Parameters

Model	Sheet thickness (mm)	Max width (mm)	Max working speed (m/min)	Coiler max weight (T)	(mm) Dimensions			Power (Kw)	Weight (T)
					L	W	H		
BYL-III-1300	0.5-1.2	1300	15	7	3500	1900	1700	8.5	3.5
					2000	1800	1300		
BYL-III-1500	0.5-1.2	1500	15	7	3500	2100	1700	8.5	4
					2000	2000	1300		

## Auto Duct Line II

### Function

Duct production line 2 can do blanking for duct, and also suitable for TDF flange forming machine. Working together with TDF flange forming machine, rolling reel machine, folding machine and corner accordingly can make high quality ducts.

### Performance Features

1. Aluminium alloy suspension arm makes the machine easy to operate.
2. The build-in control cabinet reduces wiring as a whole structure and makes it easy to move.
3. The imported configuration is very stable and comfortable to use.



### Main Import Configuration

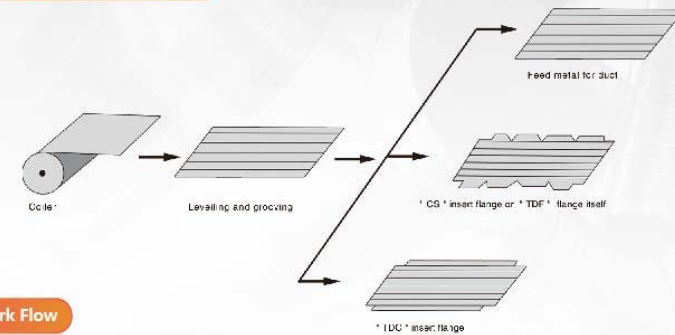
1. Mitsubishi electrical system
2. Beijing Huade or hydraulic system from Taiwan
3. Japan Omron encoder

### Basic Configuration

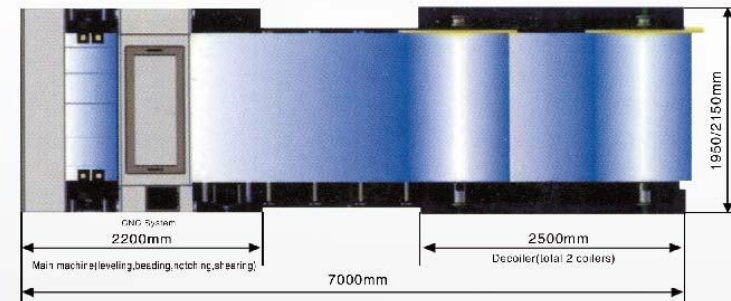
1. One electric coil cradle (two material trays)
2. One set of leveling and beading equipment
3. Hydraulic angle-shearing machine with four sets of die
4. Hydraulic sheet-shearing machine
5. A set of CNC computer control system and production software



### Working Schematic Diagram



### Work Flow



### Main Technical Parameters

Model	Sheet thickness (mm)	Max width (mm)	Max working speed (m/min)	Coiler max weight (T)	(mm) Dimensions			Power (Kw)	Weight (T)
					L	W	H		
BYL-II-1300	0.5-1.2	1300	15	7	3300	1900	1700	8.5	3.2
					2000	1800	1300		
BYL-II-1500	0.5-1.2	1500	15	7	3300	2100	1700	8.5	3.7
					2000	2000	1300		



### CNC Plasma Cutting Machine

#### Function

It's mainly for automatically lofting and cutting the deformed workpiece. You can select a drawing from the new version of CAM-DUCT and input dimensions and choose a way of connection, then the software will start calculating, composing, jacking and cutting automatically according to your requirements.

#### Performance Features

1. Vertical control cabinet with 10 inch touch screen (15 inch screen is optional)
2. New version of CAM-DUCT software from Hypertherm of United states and encrypting Chinese version.
3. Original generator of Hypertherm of United States or homemade generator of Huayuan (economy version)

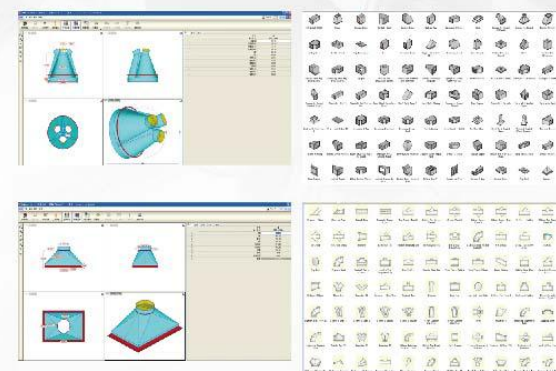


#### Software

The machine adopts the latest CAM-DUCT software from Auto Desk company and the software combines technology, data procedure with management and meets cutting requirements of duct workpiece by using pre-designed standard duct drawings and parameter settings.

The software is easy to learn and operate because it only requires machining dimensions to develop an unfolded view of deformed duct automatically.

#### Software Library



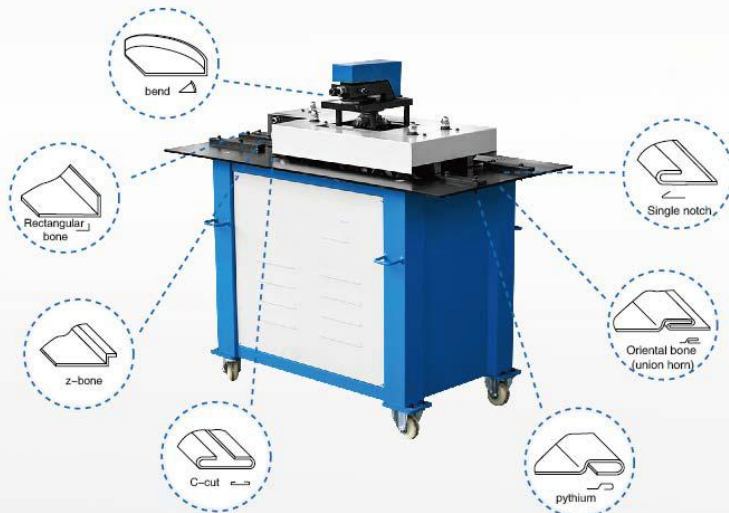
#### Main Technical Parameters

Model	Working range (mm)	Sheet thickness (mm)	Power (Kw)	(mm) Dimensions L*W*H	Weight (Kg)
BY-1340	1300x4000	0.4-3	10	4600x1900x1500	1200
BY-1540	1500x4000	0.4-3	10	4600x2200x1500	1300

## Pittsburgh Lock Machine

### Performance Features

Pittsburgh lock machine is necessary equipment for duct industry, because it can produce all kinds of seam locks for all requirements. Standard model can do 0.5- 1.5mm galvanized sheet, and our company would specially introduce high-strength rolling reels made of GCr15, a kind of steel which prolongs the machine life by more than 5 times and improve the efficiency dramatically.



### Main Technical Parameters

Model	Sheet thickness (mm)	Shape	Power (Kw)	Weight (T)	(mm) Dimensions L*W*H
SA-12HB	0.5-1.2		1.5	220	1050×570×1020mm
SA-15HB	0.8-1.5		2.2	280	1150×600×1100mm
SA-12B	0.5-1.2		1.5	215	1050×570×1020 mm
SA-12	0.5-1.2		1.5	200	1050×570×870 mm
SA-12C	0.5-1.2		1.5	200	1050×570×870 mm

## Snap Lock Machine

### Function

Snap lock machine is station with two seams, two bite used for wind pipe linking. Machinable plate thickness 0.4-1.0mm, the machine is nine rows of molding roller, production speed up to 18 meters / points, the traditional production of more than a few times.



### Main Technical Parameters

Model	Shape	Sheet thickness (mm)	Power (kw)	Weight (kg)	(mm) Dimensions L*W*H
SNAP		0.4-1.0	2.2	250	1450* 570*1000

## S Lock Machine

### Function

S lock machine is made of two kinds of ventilation pipe connection flange of the wind industry, the products with high quality finishing roller, high quality motor, high precision bearings, heavy-duty chassis; sturdy, shaft after grinding, welding steel structure bracket, ensure the machine efficiency and long life, cost saving you. .



### Main Technical Parameters

Model	Shape	Sheet thickness (mm)	Weight (kg)	Power (kw)	Dimensions L*W*H (mm)
S-12		0.4-1.0	350	3	1500*650*1000




## LS Standing Lock Machine

### Performance Features

Standing S lock machine is another way of connecting two wind pipes. It replaces the status of the traditional flat S bone, because the vertical S bone is duplex in the connection surface of the wind pipe. Although the flat type S bone in the wind pipe connection can ensure uniform appearance, but it can not be applied in a large area of the duct, but the vertical bone S is to solve this problem, because it contains a high 25mm flange to enhance its rigidity, thus expanding the scope of application of vertical bone S.



### Main Technical Parameters

Model	Shape	Power (kw)	Capacity (mm)	Weight (kg)	Package size L*W*H(mm)
LS Standing lock machine		4	0.5-0.8	1200	4200*850*1000

## CNC Angle Steel Flange Production Line

### Function

Fully automatic angle steel flange production line, or CNC angle steel flange production line, is mainly for punching and cutting duct angle steel flange. The machine are designed to feed, punch, cut automatically in order to save labor and improve efficiency. It's very fast, accurate and highly automatic.

### Performance Features

- 1.It's a brand new design which can keep angle steel tailing less than 350mm.
- 2.It's controlled by servo motor and its feeding dimensions are accurate.
- 3.It only requires to input the size of workpiece, distance between holes and how many holes to punch when programming, which is very easy to operate.
- 4.With production memory functions, the production orders can be tracked and checked.
- 5.The new design mold can complete the angle steel switching within 5 seconds, with the durable punch.

### Main Import Configuration

1. Beijing Huade or hydraulic system from Taiwan
- 2.Cutter and punching die which are both made of Japan SKH51
- 3.Servo motor-driven feeding system



### Main Technical Parameters

- 1.Scale of angle steel to process: #3-#5 angle steel
- 2.Common punching sizes: big-sized 9.5X13mm small-sized 4.2/5.2mm
- 3.The number of punches which can be installed simultaneously: 2
- 4.Common length of angle steel: 6000mm
- 5.Machining accuracy not more than: 0.5mm
- 6.Feeding speed of angle steel: 15-20m/min

Model	Working range	Power (Kw)	Weight (kg)	(mm) Dimensions L*W*H
XT-1050	30/40/50 Steel Angle	7.5	900	3000X900X1300

### TDF Flange Machine

#### Performance Features

TDF flange machine can be divided into three types according to the working requirements: single type T-12 and T-15, duplex type 2-T-12. Single type machine like T-12 and T-15 can form flange edge at one side and crimping edge at the other side; duplex type like 2-T-12 can form flange edge at both sides simultaneously to improve efficiency and save time. Additionally, duplex type can add flange edge or crimping edge outside at either side. Our company would specially introduce high-strength rolling reels made of GCr15, a kind of steel which prolongs the machine life by more than 5 times and outputs stainless steel TDF flange. The outer diameter width of the standard TDF flange is 35mm and the width of the inner diameter is 32mm. Other widths can be customized according to customer needs.



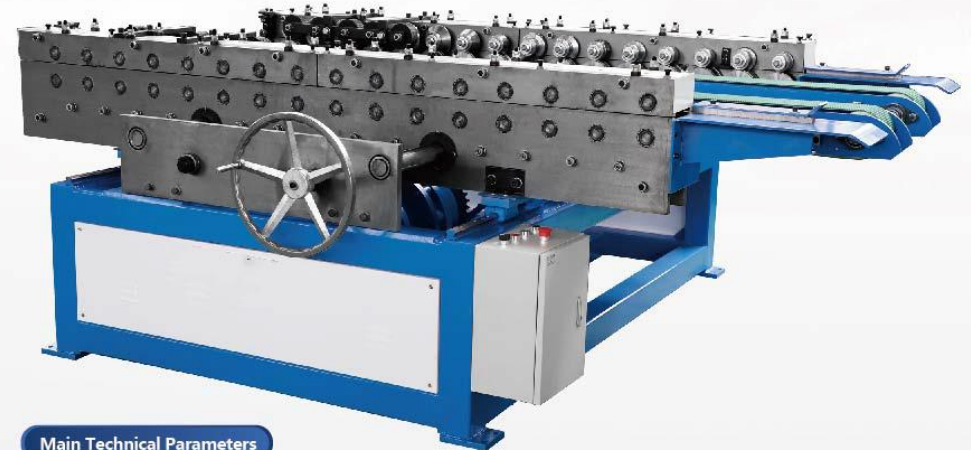
#### Main Technical Parameters

Model	Sheet thickness (mm)	Shape	Power (kw)	Weight (kg)	(mm) Dimensions L*W*H
T-12	0.5-1.2		3	840	2700X700X1110mm
T-15	0.8-1.5		4	950	2800X700X1110mm

### Double TDF Flange Machine

#### Performance Features

Duplex TDF flange forming machine can form flange at two sides of duct simultaneously. It's double-sided driven and able to meet mobile requirements of high load and high accuracy with linear guideways of Taiwan Hiwin. Comparing with single type, duplex type help us improve efficiency, reduce delivery duration and save up labor. Our company would specially introduce high-strength rolling reels made of GCr15, a kind of steel which prolongs the machine life by more than 5 times and outputs stainless steel TDF flange. The outer diameter width of the standard TDF flange is 35mm and the width of the inner diameter is 32mm. Other widths can be customized according to customer needs.



#### Main Technical Parameters

Model	Sheet thickness (mm)	Shape	Power (kw)	Weight (kg)	(mm) Dimensions L*W*H
S-T-12	0.5-1.2		5.5	2100	2800X2800X1100
S-T-15	0.8-1.5		7.5	2300	2800X2800X1100



## HVAC Duct Equipment

### TDC Flange Machine

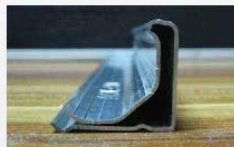
#### Performance Features

TDC flange is one of the most widely used air pipe flanges in the world. It has the characteristics of time saving, material saving, high efficiency, good seal, strong durability and strong refutation. It is especially suitable for the wind pipe with large section area of the ventilation pipe. TDC flange machine is mainly composed of feeding frame, cold rolling molding machine and cutting part. The high speed steel circular saw blade cutting system is configured. The ruler can be cut off. Cutting off the burr is small, and it can be fully automated. It works at a speed of 6 meters per minute. According to the working performance and strength of flange and seal level can be divided into five type:LT-20, LT-25, LT-30, LT-35, LT-40, the corresponding connection corner is LT-20DC, LT-25DC, LT-30DC, LT-35DC, LT-40DC.



#### Main Technical Parameters

Model	Rolls Shape	Strip Width	Sheet thickness (mm)	Power(Kw)	Weight(Kg)	Dimensions(LxWxH)
LT-20A		86mm	0.8mm	3kw/2.4kw	1800kg	4650*1020*1380mm
LT-25A		96mm	0.8mm	3kw/2.4kw	1900kg	4650*1020*1380mm
LT-30A		118mm	1.0mm	3kw/2.4kw	2000kg	4650*1020*1380mm
LT-35A		128mm	1.0mm	4kw/2.4kw	2100kg	4900*1020*1380mm
LT-40A		146mm	1.2mm	4kw/2.4kw	2200kg	4900*1020*1380mm
Model	Rolls Shape	Strip Width	Sheet thickness (mm)	Power(Kw)	Weight(Kg)	Dimensions(LxWxH)
LT-20B		90mm	0.8mm	3kw/2.4kw	2000kg	5100*1020*1380mm
LT-25B		99mm	0.8mm	3kw/2.4kw	2100kg	5100*1020*1380mm
LT-30B		123mm	1.0mm	3kw/2.4kw	2200kg	5100*1020*1380mm
LT-35B		132mm	1.0mm	4kw/2.4kw	2300kg	5400*1020*1380mm
LT-40B		151mm	1.2mm	4kw/2.4kw	2400kg	5400*1020*1380mm



### BYL- 1500 Spiral Duct Machine



#### Main Technical Parameters

Model	BYL-1500
Tube diameter	80-1500mm
Tube length	120-3000mm
Suitable material	Galvanized steel, Stainless steel, Aluminum
Thickness of strip	0.4-1.2mm
Width of strip	137mm
Strip speed	1-25m/min
Lock seam	Outside tube, on the inside on request
Controlling system	PLC automatic control
Main motor power	5.5KW
Cutting motor power	4KW
Cutting system	Sawing cutting
Weight	约2200KG
Packing dimension	2700*1700*2300mm

## HVAC Duct Equipment

### BYL-1600 Spiral Duct Machine



#### 主要技术参数 Main Technical Parameters

Diameter Range	100-1800mm	
Thickness	Galvanized steel: 0.4-1.2mm	Stainless steel : 0.4-0.8mm
Steel width	137mm	
Working Speed	35 m/min	
Motor power	16 KW Main Motor	
Cutting Method	Roller cutter ( plasma cutter optional)	
Drive system	Electric Power and Pneumatic for cutter	Hydraulic for rolls running
Weight	2000 KG	
Dimension	3400 x 1700 x1700 mm	2000x1000x1000 mm, tube holder

### BYL-1602 Spiral Duct Machine

#### Performance Features

The module technique gives the customer the possibility to choose between a number of options, allowing him to create a machine a number of options, allowing him to create a machine for his specific needs.

The frequency controlled main drive ensures a smooth acceleration and an almost noiseless operation.

The outstanding patented flying slitter cuts the tubes to length without noise or hot sparks as known from the saws and provides smooth tube ends without deburring.

The design and options fulfill the needs in HVAC to produce in mild steel, galvanized steel, stainless steel or aluminum The corrugation unit allows a reduction in material costs and makes the bigger diameter tubes more rigid.



#### Main Technical Parameters

Model	BYL-1602
Tube diameter	80-1500mm
Tube length	120-8000mm
Suitable material	Galvanized steel, Stainless steel, Aluminum
Thickness of strip	0.4-1.2mm
Width of strip	137-140mm
Strip speed	1-50m/min
Lock seam	Outside tube, on the inside on request
Controlling system	PLC automatic control
Main motor power	5.5KW
Mold	Fixed mold
Cutting system	Flying slitter cutting
Weight	about 3200kg
Packing dimension	3400*2150*1600mm



Electric Elbow Making Machine

Performance Features

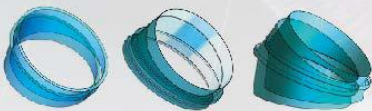
It's used for rounding angle steel flange and 40Cr steel with overall heat treatment makes the machine more durable.



Main Technical Parameters

Model	Sheet thickness (mm)	Machining diameter (mm)	Power (Kw)	Weight (Kg)	(mm) Dimensions L*W*H
DCP-1000	1.2	Φ120-1000	3	460	2220X920X1050mm

DCH-1250 Hydraulic Elbow Machine



Voltage	380V/50Hz/3Ph or Customizable voltage
Power	5KW
Hydraulic Oil	55L
Compressed gas consumption	75L/hour 6bar
MAX Speed	120m/min
Diameter range	137-140mm
Weight	750Kg
Galvanized steel	0.4-1.2mm
Stainless steel	0.4-0.8mm
Aluminum	0.4-1.2mm

### FO-3000 Oval Duct Machine

#### Performance Features

Oval-shaped duct machine can make a spiral pipe into a straight or elliptical pipe. The PLC control, the LCD operation panel, stores all the parameters so that it can be used quickly during the actual operation.



#### Main Technical Parameters

Thickness range	0.4-1.2mm
Maximum duct length	3000mm
Arm range	Minimum diameter 330mm
Die specification	φ 150, φ 200, φ 250, φ 300, φ 350, φ 400, φ 450, φ 500
Tray specification	50, 100, 200, 300, 400, 500, 600mm
Motor power	18.5Kw
Weight	2720kg
Dimension	5630mmX1250mmX1130mm

### Beading Machine

#### Performance Features

Line 5/line 7 beading machines are used to make reinforced ribs in the duct area, and it can output 5 or 7 reinforced ribs at one time. Customer can customize multiple-line beading machine according to different requirements.



#### Main Technical Parameters

Model	Sheet thickness mm	Max width mm	Power kw	Weight (T)	(mm) Dimensions L*W*H
G1.2X1300	1.2	1300	1.5	460	1550×900×1060
G1.2X2000	1.5	2000	3	650	2300×900×1120

### Electric Three-Roller Machine

#### Performance Features

It has Pre-bending function, make straight edges narrower, and it can even roll small round pipe with diameter of 100mm. with manual worm gear and eccentric wheel device so that the machine can quickly move side rollers up and down to improve efficiency.



#### Main Technical Parameters

Model	Max thickness (mm)	Max width (mm)	Minimum diameter (mm)	Power (kw)	Weight (T)	(mm) Dimensions L*W*H
W11G-2X1000	2	1000	100	1.5	240	1400X600X1100 mm
W11G-1.5X1300	1.5	1300	100	1.5	260	1700X600X1100 mm
W11G-1.2X1500	1.2	1500	100	1.5	280	1900X600X1100 mm



## HVAC Duct Equipment

### Electric Angle Rolling Machine

#### Performance Features

It's used for rounding angle steel flange and 40Cr steel with overall heat treatment makes the machine more durable.

#### Main Technical Parameters

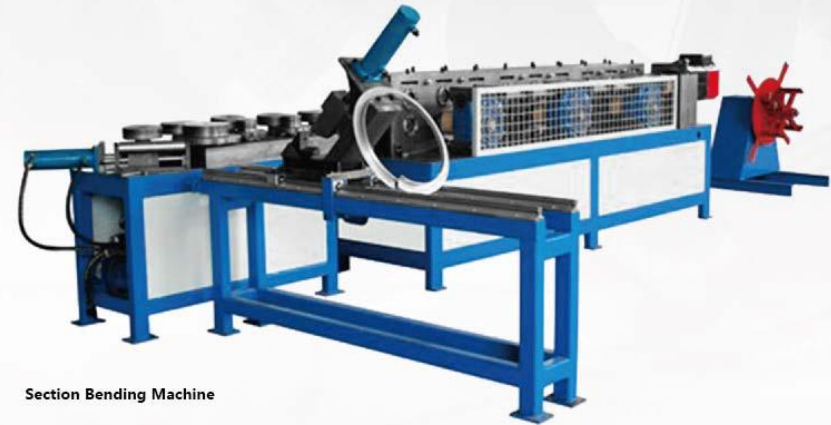
Model	Yield limit	Minimum diameter (mm)	Maximum working capacity	Power (Kw)	Weight (Kg)	(mm) Dimensions L*W*H
J24Y-50	≤245	400mm	L 50X5	2.2kw	350kg	770×900×1180



### Angle Rolling And Punching Machine

#### Performance Features

The machine employs coilers to form angle iron flange, and then cut off the processed workpieces with pleasant appearance and accurate dimensions. It is a perfect choice when connecting round ducts or blower fan flange.

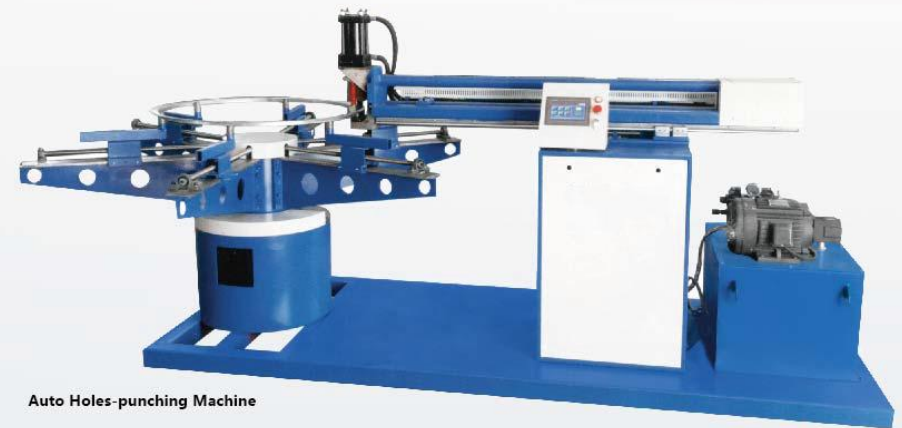


Section Bending Machine

### JY50/63 Hydraulic Angle Rolling Machine

#### Main Technical Parameters

Item	Model	JY-50	JY-63
Yield limit		≤245	≤245
Minimum beading dimensions		300	300
Angle		L 50*5	L 63*6
Model size(mm)	L	760	980
	W	660	860
	H	1020	1020
Weight(Kg)		350	430
Main motor(Kw)		3	4



Auto Holes-punching Machine

## HVAC Duct Equipment

### Hydraulic Vertical Seam Closer



#### Performance Features

You can use the vertical seam closer and production line of wind pipe, T12 flange machine and reel bone machine. With mouth and a right angle edge is an ideal interface for connecting wind pipe linking machine SL-12 without any other auxiliary connection tools, can be combined with the high quality of the mouth of the gap, not only beautiful, but also does not damage the metal surface, low noise, tight linking and smooth, good effect. Suitable for different plate thickness, fast and safe linking. Using MITSUBISHI PLC control, long time work performance is stable and excellent. Vertical layout, in line with the design of human body mechanics, the operation is convenient, and the production efficiency of air duct is greatly improved.

#### Main Technical Parameters

型号 Model	加工片厚 Sheet thickness (mm)	风管长度 Wind pipe length (mm)	重量 Weight (Kg)	功率 Power (Kw)	外形尺寸(mm) Dimensions L*W*H
SL-12	1.5	1000-1500	680	4	1000X1000X2240



### Pneumatic Seam Closer

#### Performance Features

It's used for locking rectangular duct within 1250mm and pneumatic operation can save labor and improve efficiency.

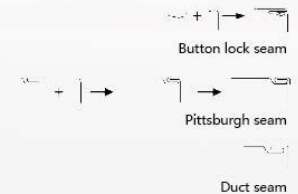
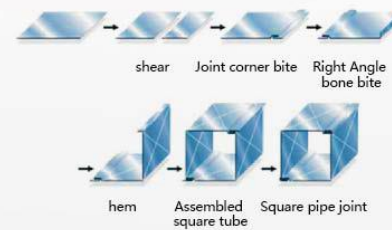
#### Main Technical Parameters

Model	Sheet thickness (mm)	Fluid pressure (Mpa)	Weight (Kg)	(mm) Dimensions L*W*H
HFJ-1250	1.2mm	0.6-0.8	650	3200X1000X1030

### Duct Seam Closer

#### Performance Features

The traditional wind pipe joint by vertical roller bending forming to both ends of bone, occlusal flange, reel bone machine will be the traditional wind pipe joint "three steps" to be made one, save labor and production costs.



#### Main Technical Parameters

Model	Sheet thickness (mm)	Minimum duct size (mm)	Support height (mm)	Support length (mm)	Number of supporting arms (pcs)	Processing height (mm)
H-10	0.4-1.0	150*150	700	1550	2*3	800
H-08	0.4-0.8	100*100	700	1550	2*3	800



## HVAC Duct Equipment

### HE-12 Hand Operated Electric Duct Closer



#### Main Technical Parameters

Power	220V
Frequency	50/60Hz
400N/MM Material strength	0.75-1.25mm
Work speed	4-7m/min
Rotating speed	160/min
Rated power consumption	1400w
Weight	9kg
ID	≥300mm
OD	≥400mm
Protection of insulation	Level II

### TDC Electric Riveting Machine



#### Main Technical Parameters

Thickness (mm)	0.8-1.2
Pressure(KN)	25
Power(kw)	1.4
Weight(kg)	12
Dimension L*W*H (mm)	411*358*200

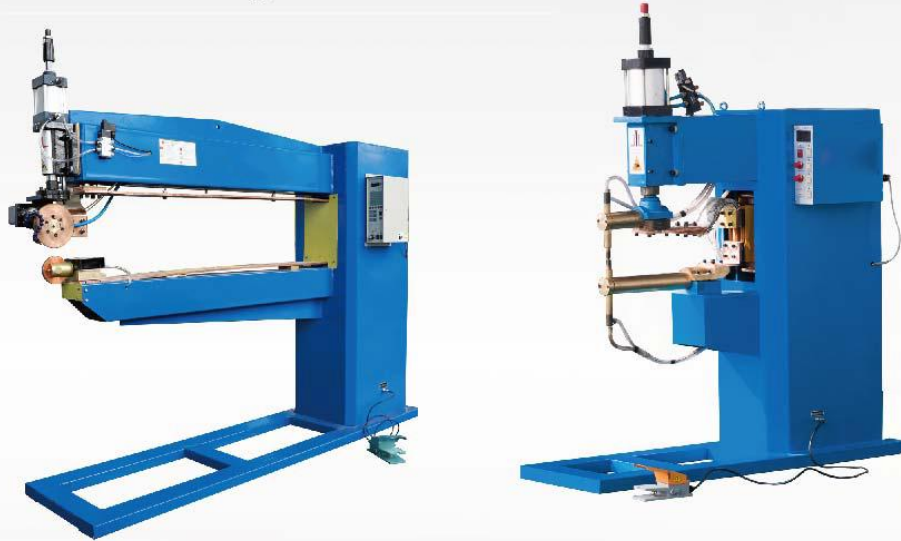
### Round Duct Seam Closer



#### Main Technical Parameters

Model	BYHF-1.5*2000	BYHF-1.5*1500
Max. length	2000mm	1500mm
Max. thickness	1.5mm	1.5mm
Min. diameter	φ 100	φ 100
Power	0.55 KW	0.55 KW
Weight	550KG	455KG
Dimension	2700×600×1500	2200×600×1500

## Pneumatic Welding Machine



### Main Technical Parameters

Model	FN-35	FN-55	FN-75	FN-100
Plate thickness	0.4-1.0mm	0.4-1.0mm	0.4-1.0mm	0.4-1.0mm
Max input capacitance	45K V A	55K V A	75K V A	100K V A
Max short circuit current	6200A	11000A	16000A	26000A
Max electrode pressure	400K GF	600K GF	1000K GF	1000K GF
Cooling water flow	6L/min	6L/min	6L/min	6L/min
Arm extension length	600mm	600mm	600mm	600mm
Electrode stroke	80mm	80mm	80mm	80mm
Welding speed	0.5-3m/min	0.5-3m/min	0.5-3m/min	0.5-3m/min
Weight	328kg	378kg	428kg	4788kg
Overall dimension	1800×610×1930	1800×610×1930	1800×610×1930	1800×610×1930

## SWM-500 Welding machine



### Main Technical Parameters

Model	SWM-500
Rated welding capacity	40KVA
Rated load duration	40%
Wire feeding speed	6.0--12 m/min
Wire diameter range	Φ3.0 mm
Secondary output voltage	1.6--3.2 V (when the controller energy is maximum)
Secondary voltage regulation series	6
Minimum diameter of welded work piece	100 mm
Maximum length of welded work piece	500 mm
Welding work piece material thickness range	cold rolled steel plate 80.5-1.0mm
Motor speed control mode	AC electromagnetic motor
Dimension	2200*1100*1600 mm



## Pneumatic Corner Mounting Machine

### Performance Features

It's used for installing rectangular duct corner code automatically to replace workers, which is fast, time-saving and effective.

### Main Technical Parameters

Model	Sheet thickness mm	Fluid pressure Mpa	Weight kg	(mm) Dimensions L*W*H
CM-12	1.2mm	0.6-0.8	450	1500X800X1050



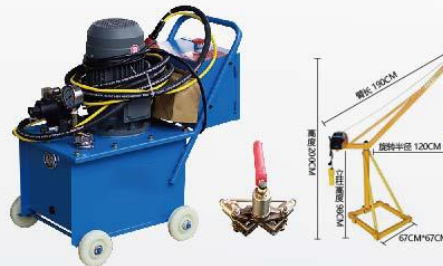
## JM-12 Hydraulic TDF corner mounting machine

### Performance Features

Mainly used for corner code installation of rectangular air ducts, replacing manual smashing of corner codes, fast, time-saving, and efficient. Convenient to carry and move, paired with column brackets for more labor-saving and convenient use.

### Main Technical Parameters

Model	Pressure (mm)	Corner (mm)	Power kw	Weight (T)	(mm) Dimensions L*W*H
JM-12	10-12	30	1.5	80	700×400×650mm



## Electric Shearing Machine

### Performance Features

The machine is overall steel-welded and gate-type with chain drive. The motor has its own brake, which means no power consuming when not shearing. It's suitable for processing sheet metal less than 3mm in thickness.

### Main Technical Parameters

Model	Shear plate thickness (mm)	Shear plate width (mm)	Number of strokes (/min)	Power (kw)	(mm) Dimensions L*W*H
Q11-3X1300	3	1300	30	4.5	2000×900×1250
Q11-3X1600	3	1600	30	4.5	2300×900×1250
Q11-3X2000	3	2000	30	5.5	2700×900×1250
Q11-2X2500	2	2500	30	5.5	3200×900×1250



## Q11 Electric shearing machine MD11 system

### Performance Features

Q11 mechanical electric shearing machine has simple structure, easy operation, elegant design, attractive appearance and low energy consumption. Use the MD11 post-material block control system, which is convenient for customers to cut different width boards according to their needs.

### Main Technical Parameters

Model	Cutting thickness (mm)	Cutting width (mm)	Cutting angle (°)	Power motor (KW)	(mm) Dimensions L*W*H
Q11-2*1300	2	1300	1°30'	3	1900*900*1100
Q11-2*2000	2	2000	1°30'	3	2700*900*1100
Q11-2*3000	2	3000	1°30'	3	3700*1200*1300
Q11-3*1600	3	1500	2°14'	4.5	2200*1100*1200
Q11-3*2500	3	2500	2°14'	5.5	3300*1100*1200
Q11-4*1600	4	1600	2°14'	5.5	2200*1100*1200
Q11-4*2000	4	2000	2°14'	5.5	2800*1100*1200



## HVAC Duct Equipment

### Manual Folding Machine



#### Performance Features

Manual folding machine is one of the modern sheet metal processing equipment, professional for thin plate bending process, has the advantages of light weight, simple operation, convenient transportation, more suitable for short-term temporary site bending processing, can be used in any environment. The length can be based on user customized.

#### Main Technical Parameters

Model	Folding angle	Weight (kg)	(mm) Dimensions (L*W*H)
WS-1.5X1300	60°	400	1900×700×1500
WS-1.5X1500	60°	440	2100×700×1500
WS-1.5X2000	60°	500	2600×750×1500
WS-1.5X2500	60°	600	3100×750×1500

### Manual TDF Folding Machine



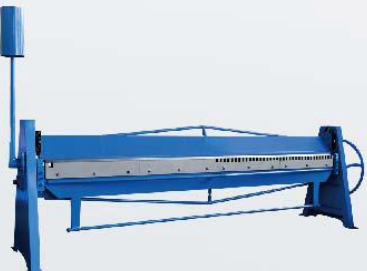
#### Performance Features

This machine is able to bend the flange sheet metal to get three folds, and it's also considered as a general crumpling machine.

#### Main Technical Parameters

Model	Folding angle	Weight (kg)	(mm) Dimensions (L*W*H)
TDF-1.5X1300	45°	450	1950×650×1550
TDF-1.5X2000	45°	600	2650×650×1550
TDF-1.5X2500	45°	700	3100×650×1550

### Manual Half TDF Folding machine



#### Performance Features

Manual folding machine are suitable for duct making, metal box forming and pan processing. They are in great demand all over the world for the light design, economical use and efficiency. They are perfect equipment for all occasion. Save electricity and simple operation.

#### Main Technical Parameters

Model	Max thickness (mm)	Max Width (mm)	Min Bending angle	Weight (kg)	(mm) Dimensions (L*W*H)
HTDF-1.5x1300	1.5	1300	45°	450	1950*650*1550
HTDF-1.5x2000	1.5	2000	45°	600	2600*650*1550
HTDF-1.5x2500	1.2	2500	45°	700	3100*700*1550

## Pneumatic Folding machine

#### Performance Features

This machine is pneumatic compressing and folding, no need electric power. It is easy to operate, with low energy consumption. The advantage is that both its up and down movements can be adjusted. There are two foot switches, left one for adjusting stroke, right one for pressing.



#### Main Technical Parameters

Model	Max thickness (mm)	Max Width (mm)	Min Bending angle	Weight (kg)	(mm) Dimensions (L*W*H)
WSQ-1.5x1300	1.5	1300	60°	380	1800*750*1150
WSQ-1.5x1500	1.5	1500	60°	500	2000*750*1150
WSQ-1.5x2000	1.5	2000	60°	600	2500*750*1500
WSQ-1.5x2500	1.5	2500	60°	700	3100*800*1500
WSQ-1.2x3000	1.2	3000	60°	800	3600*800*1500

## Pneumatic TDF Folding Machine

#### Performance Features

It is easy to operate, and low energy consumption. There are two foot switches, left one for adjusting stroke, right one for pressing.

This pneumatic folders are of many types and incorporate with all the outstanding features. The advantage is that both its up and down movements can be adjusted.



#### Main Technical Parameters

Model	Max thickness (mm)	Max Width (mm)	Min Bending angle	Weight (kg)	(mm) Dimensions (L*W*H)
QTDF-1.5x1300	1.5	1300	60°	380	1800*750*1150
QTDF-1.5x2000	1.5	2000	60°	500	2500*750*1500
QTDF-1.5x2500	1.2	2500	60°	580	3200*750*1500





## HVAC Duct Equipment

### Rotary Machine

#### Performance Features

There are manual and electric type of reel machine, and it's mainly used for beading round pipe and connection.

#### Main Technical Parameters

Model	Shape	Sheet thickness (mm)	Power (kw)	Weight (kg)	(mm) Dimensions L*W*H
LH-15		1.2	0.75	90	1000X530X1100 mm
LH-10		1.0	无	50	560X310X970 mm



### Reel Shearing Beading Machine

#### Performance Features

Real shear beading machine, or Ngau Tau scissors, is capable of shearing and beading, and it's also suitable for slitting.

#### Main Technical Parameters

Model	Sheet thickness (mm)	Shape	Power (kw)	Weight (kg)	(mm) Dimensions L*W*H
LQ-15	1.5		1.5	260	1250×650×1050



### Hydraulic Riveting Machine



#### Performance Features

It's widely used for riveting angle steel flange and galvanized sheet metal because the machine is easy to operate and move.

#### Main Technical Parameters

Model	Pressure (Mpa)	Rivet (mm)	Power (kw)	Weight (kg)	(mm) Dimensions L*W*H
DMY-1	10-12	4X10/5X10	1.5	65	600X400X650

### Foot/Pneumatic Notching Machine

#### Performance Features

There are two types: pedaled type and pneumatic type; and it's used for notching or cutting right angle on sheet metal.

#### Main Technical Parameters

Model	Sheet thickness (mm)	Angle size (mm)	Weight (kg)	(mm) Dimensions L*W*H
Q-1.2X80	1.2	80×80	50	420×290×950
QD-1.2X80	1.2	80×80	70	650×300×1000



## HVAC Duct Equipment

### JH21 Pneumatic power press Full -automatic angle code production line



#### Performance Features

This machine consists of material racks, CNC feeders, pneumatic punch, and molds. After the rolls are unfolded, the digital controlled feeder is used for precision transportation, and the plate is stamped on the plate through pneumatic precision punch to achieve automatic falling off the tin -plated plate. Production is fast and efficient, and high precision.

#### Main Technical Parameters

Model	(KN) Nominal Capacity (KN)	(KW) MOTOR (KW)	Weight (kg)	(mm) Dimensions L*W*H
JH21-45	450	5.5	3600	1390*1200*2400
JH21-63	630	5.5	5500	1580*1210*2520
JH21-80	800	7.5	7200	1640*1280*2700

### JB23 Mechanical punch Full -automatic corner production line

#### Performance Features

This machine consists of material racks, CNC feeders, mechanical punch, and molds. After the rolls are unfolded, the digital controlled feeder is used for precision transportation. The plate is stamped on the plate through a mechanical punch to achieve automatic falling off the tin -plated plate. Compared to artificial production, it is faster, time -saving and labor -saving.



#### Main Technical Parameters

Model	(KN) Nominal Capacity (KN)	(KW) MOTOR (KW)	Weight (kg)	(mm) Dimensions L*W*H
JB23-63T	630	5.5	2800	1700*1250*2400
JB23-80T	800	7.5	4100	1790*1320*2600
JB23-100T	1000	7.5	5200	1800*1360*2750

### JB23 Corner or G -shaped clip punch machine



#### Performance Features

The machine consists of mechanical punch and molds. The material is stamped on the plate through a mechanical punch, so as to make other items such as corner or G-shaped clips, which is widely used in air duct production.

#### Main Technical Parameters

Model	(KN) Nominal Capacity (KN)	(KW) MOTOR (KW)	Weight (kg)	(mm) Dimensions L*W*H
JB23-63T	630	5.5	2800	1700*1250*2400
JB23-80T	800	7.5	4100	1790*1320*2600
JB23-100T	1000	7.5	5200	1800*1360*2750