



Hai Roll Fone
海路丰

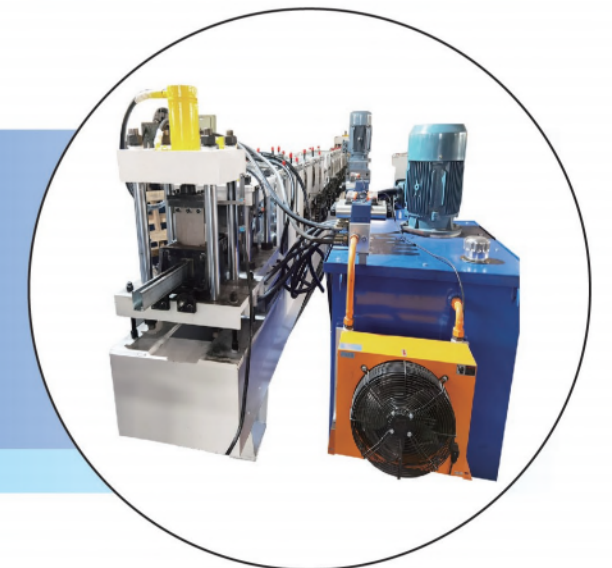
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PRECISION MACHINERY

CREATING BRAND, HIGH QUALITY SERVICE AND INNOVATIVE TECHNOLOGY

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WUXI HAI ROLL FONE SCIENCE&TECHNOLOGY CO.,LTD.

Company Profile>>

Wuxi Hai Roll Fone Science&Technology Co.,Ltd. is registered in January 2012, with registered capital of 20 million yuan and annual output value of about 100 million yuan. Our company is a professional manufacturer of welded pipe sets and their supporting roll molds, with a history of more than ten years, and is a famous enterprise in the welded pipe industry. Our company covers an area of 13000 square meters, the existing plant 8500 square meters, office area 1500 square meters, the second phase of the company is under construction, covering an area of 30.4 acres, the construction of 15000 square meters of industrial plants and 1500 square meters of office area, the third phase of land 24.7 acres of planning for 12,000 square meters of industrial plants; our company has 120 employees, the annual output of 120-150 welded pipe production, is the national production line. Our company has 120 employees and an annual production capacity of 120-150 welded pipes, and is a national high-wage technology enterprise with ISO9001 quality certification system and CE certification. Our company is a high-tech enterprise integrating science, industry and trade, with a large number of high-level technical professionals. The company's export business accounts for 45% of the total production volume. The equipment manufactured by the company has won many awards and has 29 invention patents and 3 high-tech products, and is the first choice for large and medium-sized enterprises at home and abroad to purchase equipment.



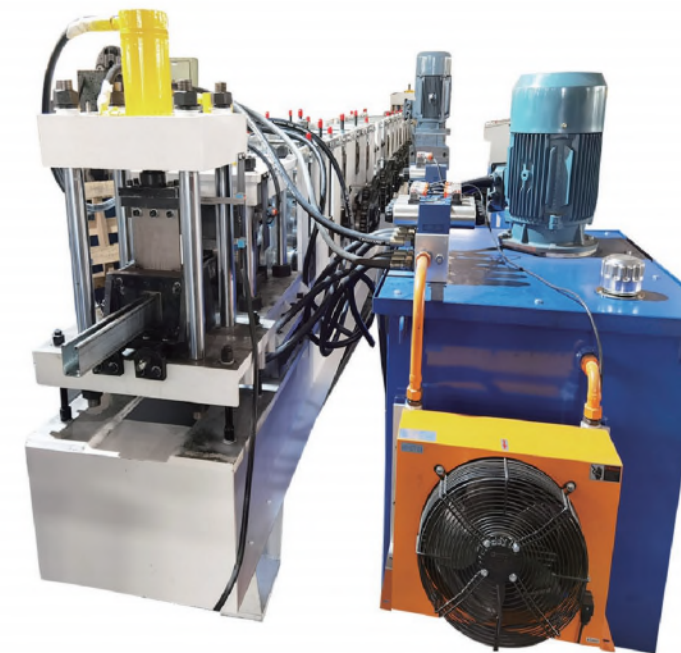
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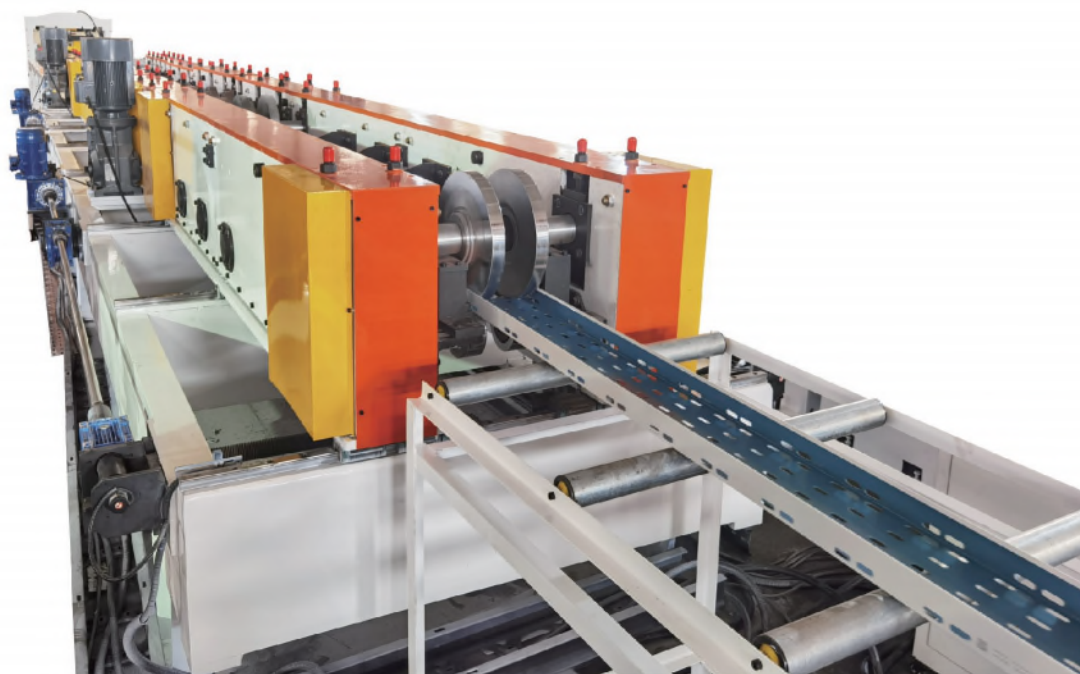
Scaffolding roll forming machine



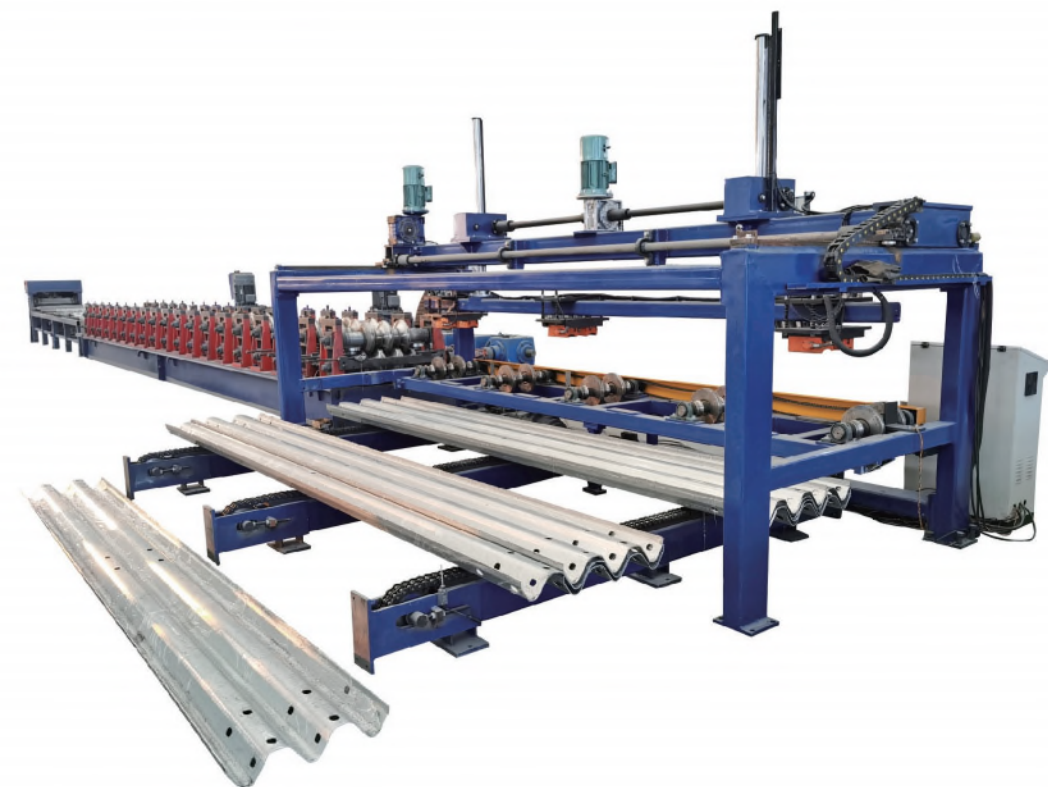
Door frame roll forming machine



Cable tray roll forming machine



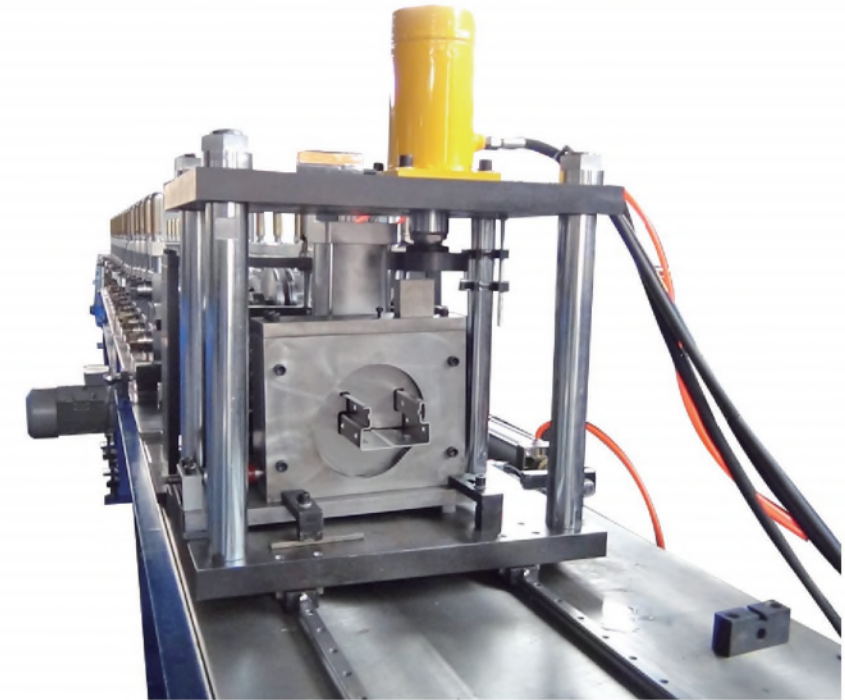
Guardrail roll forming machine



Continuous type sandwich panel making machine



Supermarket upright forming machine



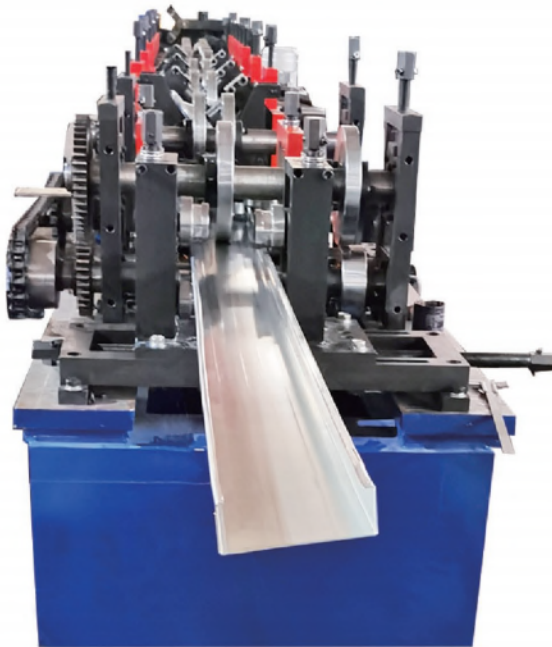
Electrical cabinet roll forming machine



Corrugated roll forming machines



CZ purlin roll forming machine



Greenhouse gutter roll forming machine



Discontinuous type sandwich panel making machine



Light keel roll forming machine



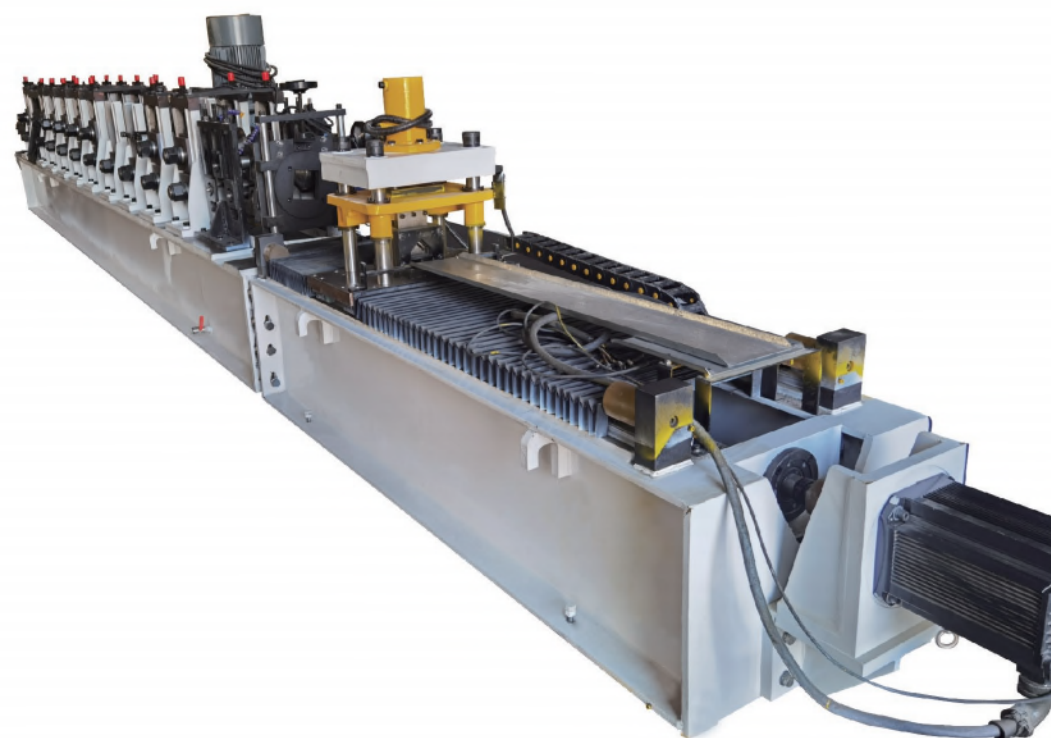
Metal deck roll forming machine



Shutter door roll forming machine



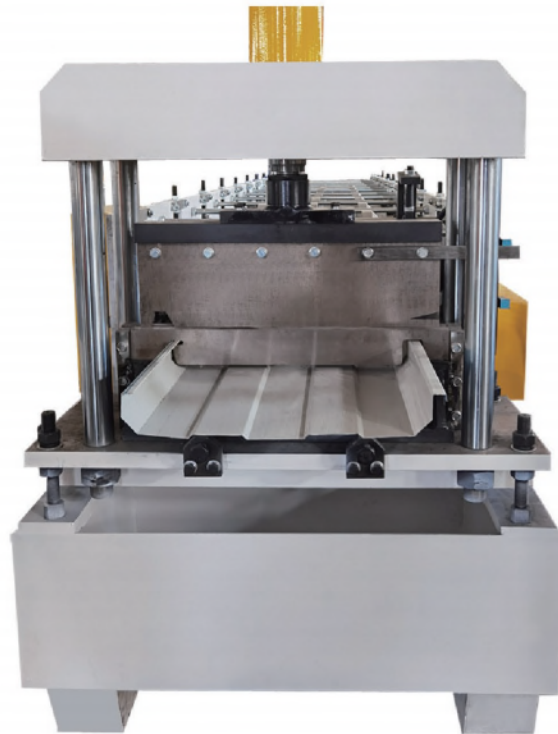
Shelf panel roll forming machine



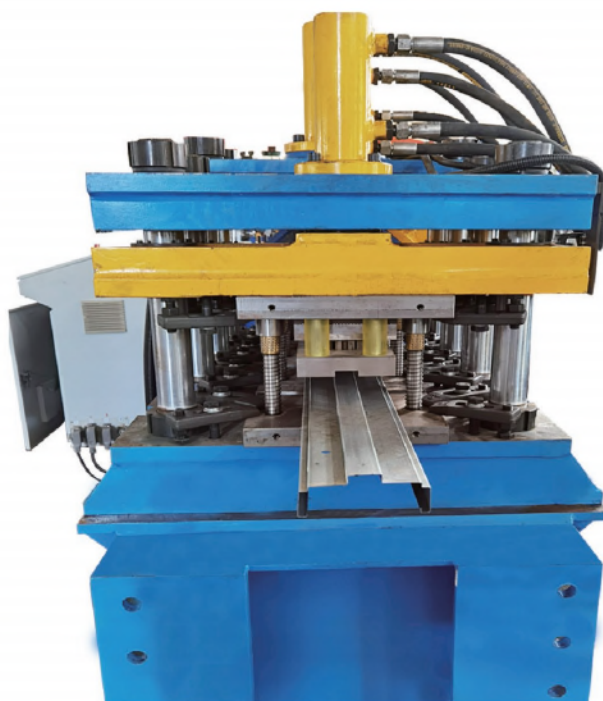
Solar strut channel forming machine



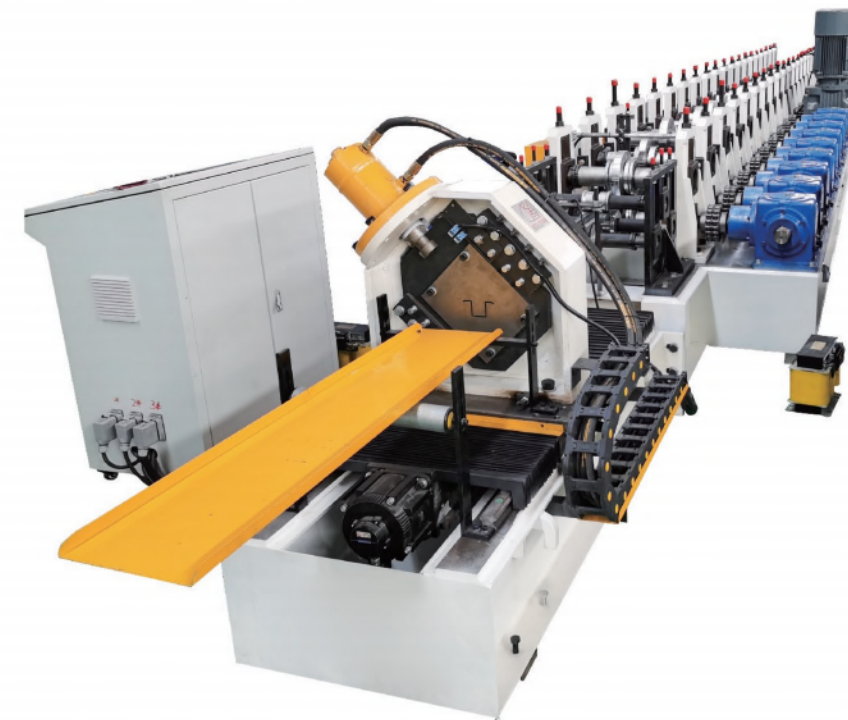
Standing seam roll forming machine



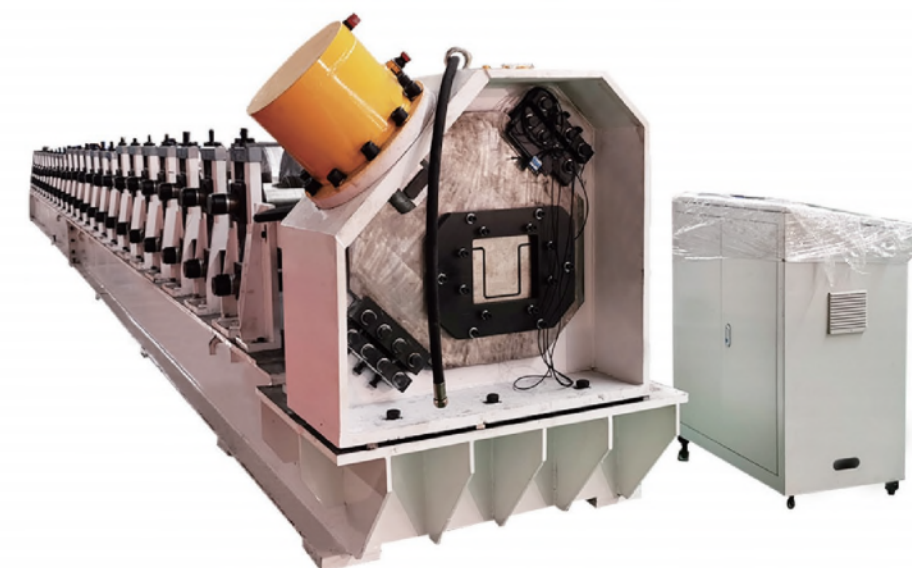
Steel door making machine



Top hat roll forming machine



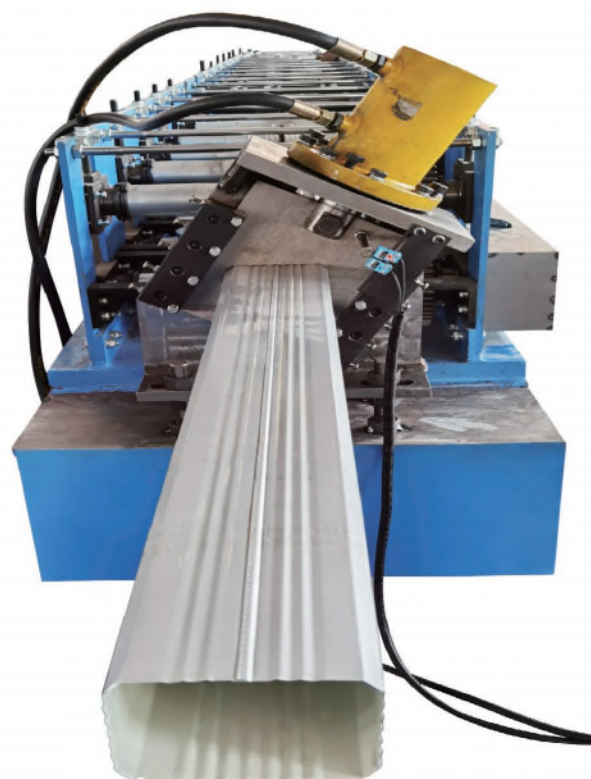
U purlin machine



Grain silo roll forming machine



Downspout pipe roll forming machine



Cut to length line

The whole line flow chart

Hydraulic coil car-hydraulic double tapered decoiler--guiding&pressing and shoveller head unit--center aligning --2 pinch rolls&19rolls leveling machine--pit-guiding-4 rolls leveling for measuring the length-sheet transmission table--high-speed shearing machine-sheet transmission belt--auto stacker---hydraulic control system and electrical control cabinets



Cut to length line

Main tech parameter

Type				
Material Thickness (mm)	0.11-1.2	0.2-2.0	0.3-3.0	0.5-4.0
Material width range (mm)	200-1300mm	200-1600mm	300-1550&1800mm	300-1600&1800mm
Linear Speed	0-60m/min	0-60m/min	0-60m/min	0-60m/min
Cutting length Range (mm)	300-4000	300-4000	300-4000	300-6000
Stacking Range (mm)	300-4000	300-4000	300-6000	300-6000
Cutting length Precision (mm)	±0.3	±0.3	±0.5	±0.5
Coil Weight (T)	10&15T	15&20T	20&25T	20&25
Leveling Diameter (mm)	65 (50)	65 (50)	85 (65)	100 (80)



Cut to length line

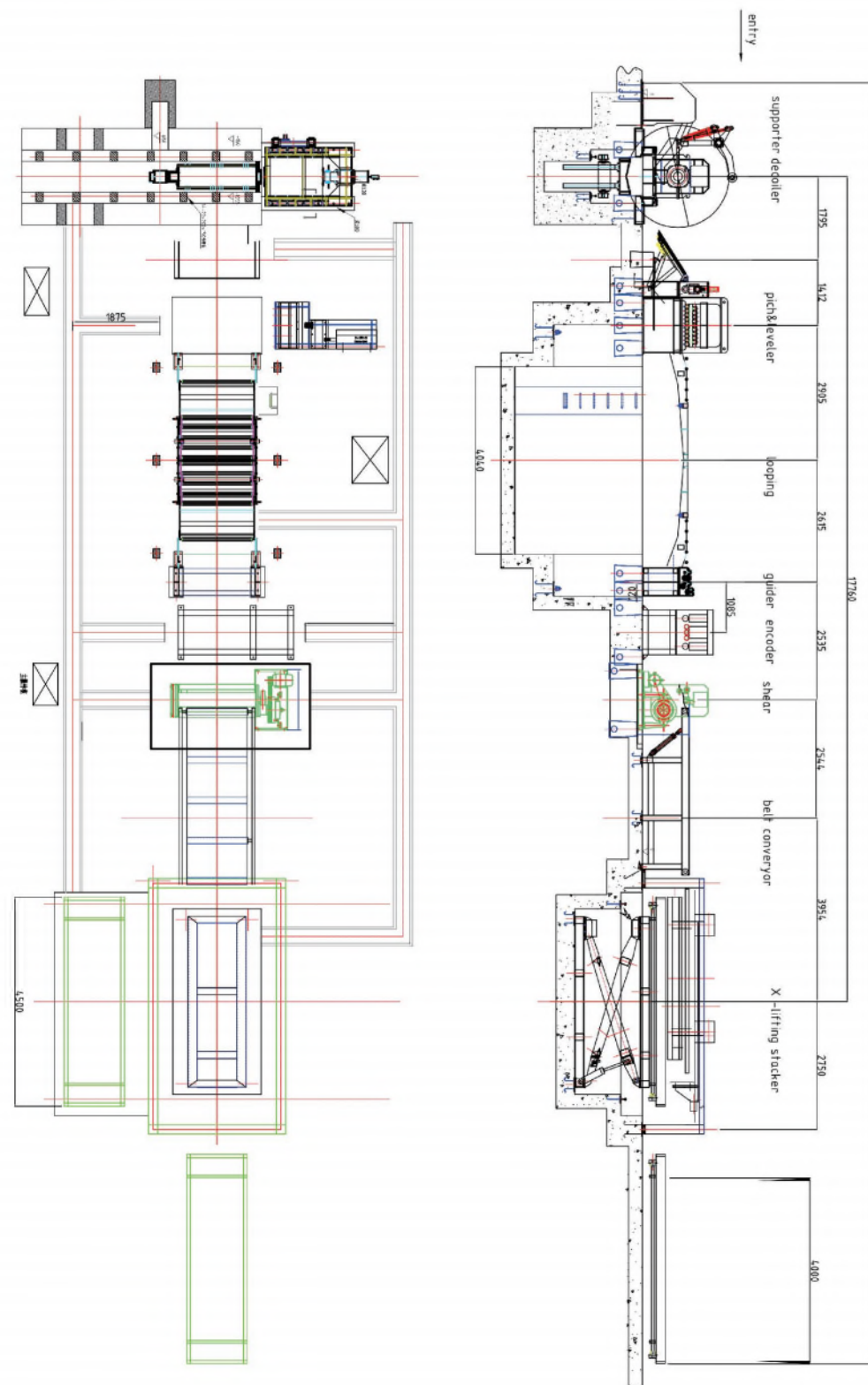


Main tech parameter

Type	3×1600	6×2000	8×2000	10×2200	12×2200	16×2200	20×2500	25×2500
Material Thickness (mm)	0.3-3	1-6	2-8	2-10	3-12	4-16	6-20	8-25
Material width range (mm)	1600	2000	2000	2200	2200	2200	2500	2500
Cutting Length (mm)	300-4000	500-6000	600-8000	600-10000	800-12000	800-12000	800-12000	800-12000
Cutting precision (mm)	±0.5	±0.5	±1	±1	±1	±1	±1	±1
Roller Numbers	15	15	13	13	11	11	9	9
Roller Diameter (mm)	Φ85	Φ140	Φ155	Φ160	Φ180	Φ200	Φ230	Φ260

Cut to length line

Process flow



Coil slitting machine

The whole lineflowchart

Coil loading car---Decoiler---loop pit 1-center aligner--slitting machine--waste scrap winder- loop pit 2--pre-separator--tensioner--pressing separator--recoiler--manual packing-Unloading coil car



Coil slitting machine



Coil slitting machine

Main tech parameter

Type	Thickness	Width Range	Coil Weight	Min strip	Strips No	Line Speed	Blade shaft
3×1600	0.3-3mm	1600&1800mm	25T	≥20mm	5-30	0-150m/min	Φ240
4×1600	0.5-4mm	1600&1800mm	30T	≥30mm	3-30	0-80m/min	Φ240
6×1600	1-6mm	1600&1800mm	30T	≥40mm	5-20	0-60m/min	Φ260
8×2000	2-8mm	1600&2000mm	35T	≥70mm	5-20	0-50m/min	Φ300
10×2200	3-10mm	2000&2200mm	35T	≥80mm	5-18	0-40m/min	Φ320
12×2200	3-12mm	2000&2200mm	35T	≥100mm	5-20	0-30m/min	Φ320
16×2500	4-16mm	2000&2500mm	35T	≥100mm	≤5	20m/min	Φ400
20×2500	6-20mm	2200&2500mm	35T	≥100mm	≤4	20m/min	Φ480

Coil slitting machine

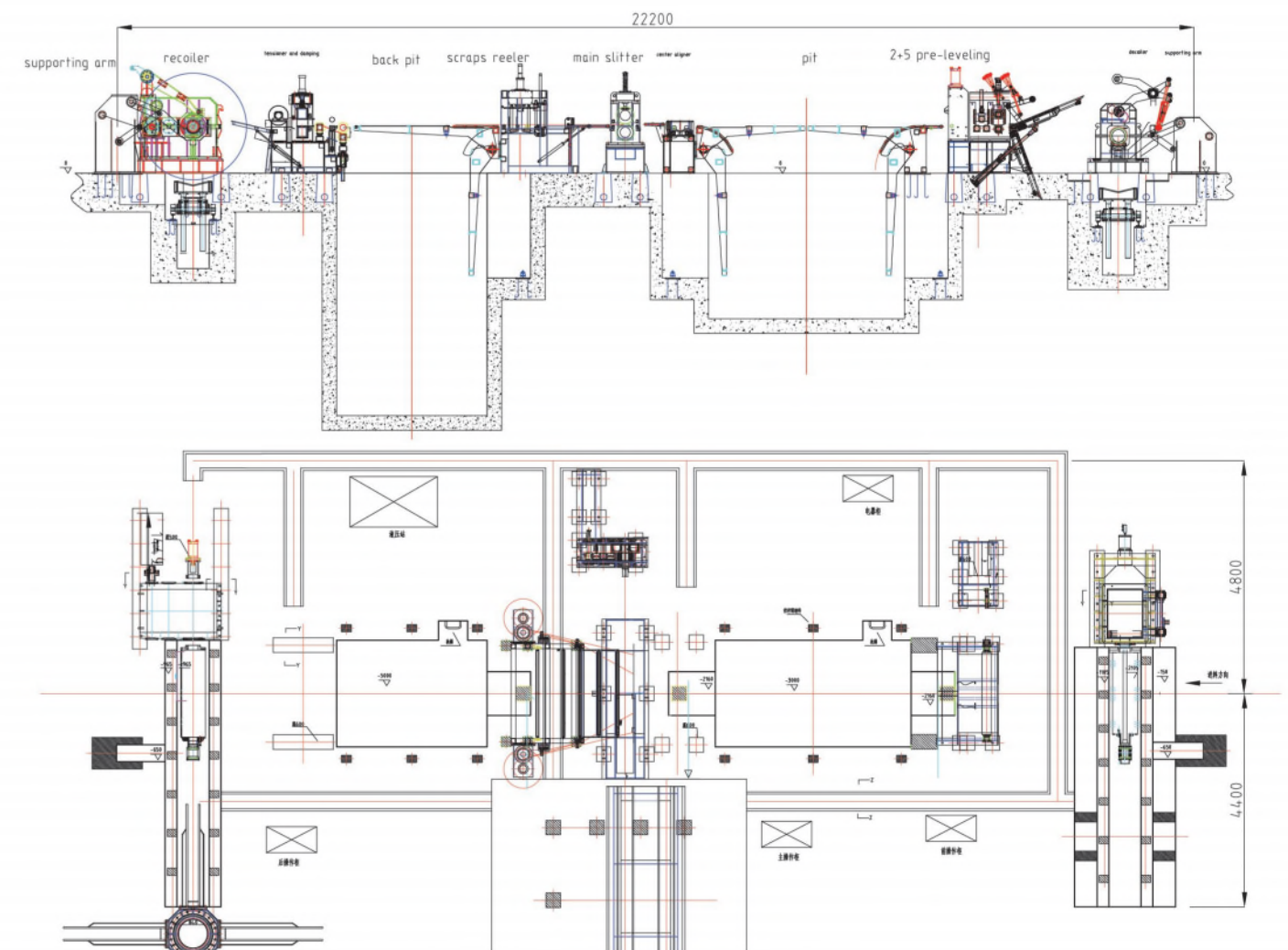


Main tech parameter

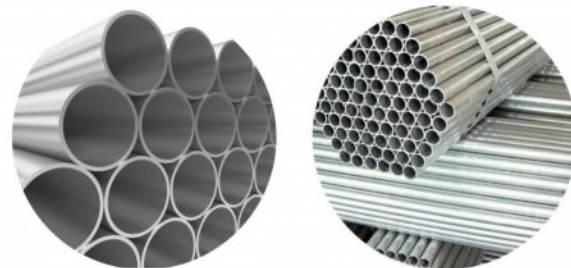
Type				
Material Thickness (mm)	0.15~1.5	0.15-2.0	0.3-3.0	0.5-4.0
Material width range (mm)	750&1300	1600&1800	1800&2000	200-1600
Slitting strips	2-20	2-20	2-15	2-15
Product precision (mm)	±0.1	±0.1	±0.15	±0.15
Linea speed (mm)	10-200 (250)	10-200 (250)	10-150 (200)	10-150 (200)
Coil Weight (T)	10	15	20	25
ID(mm)	Φ508 或 Φ610	Φ508 或 Φ610	Φ508 或 Φ610	Φ508, Φ610
OD(mm)	Φ508	Φ508	Φ508	Φ508
Blade shaft (mm)	Φ205	Φ220	Φ240	Φ240

Coil slitting machine

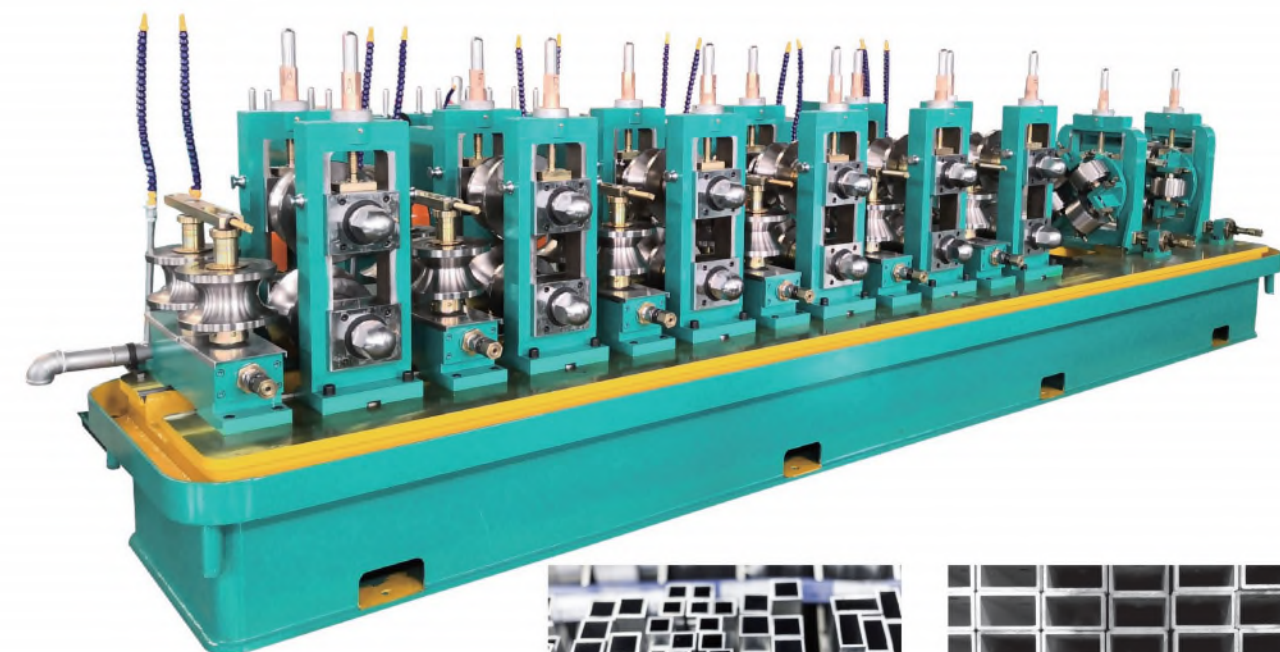
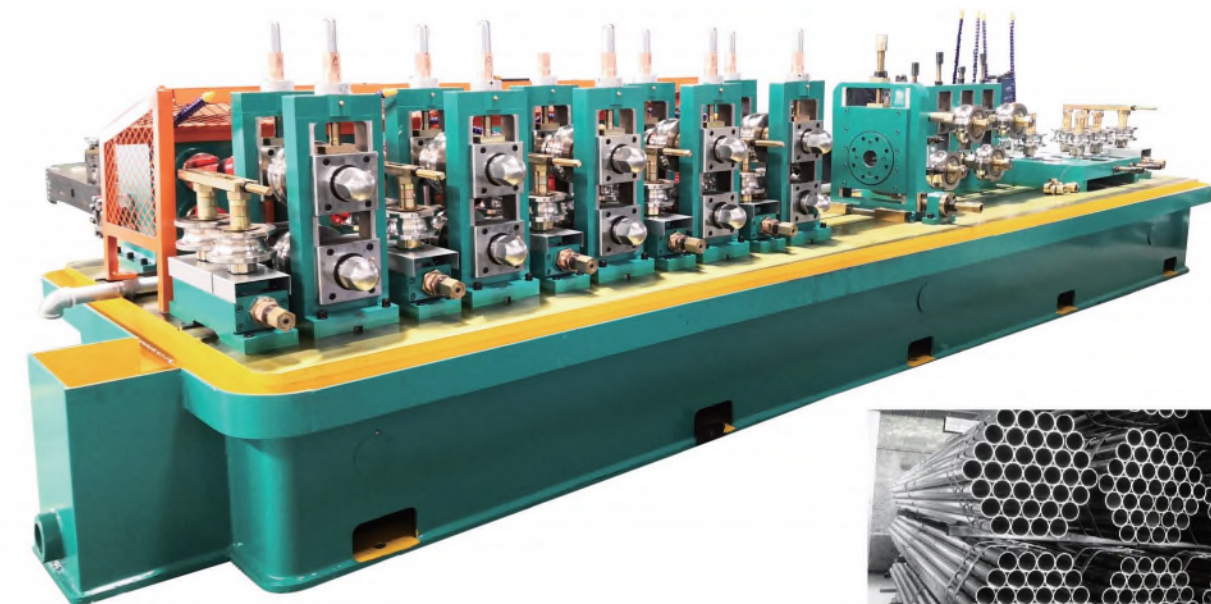
Process flow



Pipe making machine



Pipe making machine



Pipe making machine

Process Floes:

Strip coil → Uncoiler → Shear and butt-welder → Accumulator → Levelling → Forming → Weld-ing →

External burr removing → Cooling → Sizing → Straightening → Cut size → Packing

Parameters for all models:

设备型号 Model	圆焊管管径 Tube O.D. (mm)	圆焊管壁厚 Wall Thickness (mm)	方/矩形管 Square/Rectangle (a:b≤2:1, mm)	方/矩形焊管壁厚 Wall Thickness (mm)	焊管速度 Speed (m/min)	主电机功率 Main motor (kw)	固态高功率 H.F.Welder (kw)
HRF-12	φ4~φ12	0.2~0.5	//	//	30~120	15	100
HRF-16	φ6~φ16	0.2~0.8	//	//	30~120	22	100
HRF-20	φ7~φ20	0.2~1.0	//	//	30~120	30	100
HRF-25	φ9~φ25.4	0.25~1.2	//	//	30~120	37(或22*2)	100
HRF-32	φ10~φ32	0.25~1.5	8x8~25.4x25.4 10x6~31.8x19.1	0.25~1.2	30~120	45(或30*2)	100
HRF-32z		0.5~2.0		0.5~1.5	30~100	55(或37*2)	100
HRF-40	φ12.7~φ40	0.3~1.8	10x10~31.8x31.8 20x10~40x20	0.3~1.5	30~110	75	150
HRF-40z		0.6~2.0		0.6~1.5	30~100	45*2	150
HRF-50q	φ16~φ50.8	0.4~1.5	12.7x12.7~40x40 20x10~50x25	0.4~1.2	30~110	90	150
HRF-50		0.5~2.0		0.5~1.5	30~90	45*2(或110)	200
HRF-50z		0.7~2.5		0.7~2.0	30~80	55*2	200
HRF-63q	φ19.05~φ63.5	0.6~2.0	15x15~50x50 20x10~60x30	0.6~1.5	30~90	132(或55*2)	150
HRF-63		0.7~3.0		0.7~2.5	30~80	75*2(或132)	200
HRF-63z		0.8~3.5		0.8~3.0	20~70	90*2	200
HRF-76q	φ25.4~φ76.2	0.8~2.5	20x20~60x60 30x15~80x40	0.8~2.0	30~90	160(75*2)	200
HRF-76		0.8~3.5		0.8~3.0	30~80	90*2	250
HRF-76z		0.8~4.0		0.8~3.5	20~70		300

Pipe making machine

HRF-90q	φ30~φ90	0.8~3.0	25x25~70x70 30x20~80x40	0.8~2.5	30~90	180(或90*2)	250
HRF-90		0.8~3.5		0.8~3.0	30~80	110*2 (或132*2)	250
HRF-90z		1.0~4.0		1.0~3.5	20~70		300
HRF-100q	φ31.8~φ101.6	1.0~3.0	25x25~80x80 30x20~100x50	1.0~2.5	30~90	200(或110*2)	250
HRF-100		1.0~3.75		1.0~3.25	30~80	110*2	300
HRF-100z		1.0~4.25		1.0~3.5	20~70	132*2	300
HRF-114q	φ35~φ114.3	1.0~3.0	30x30~90x90 40x20~120x60	1.0~2.5	20~80	110*2	300
HRF-114		1.2~4.5		1.2~4.0	20~70	132*2	350
HRF-114z	φ40~φ114.3	1.2~5.0		1.2~4.5	15~60		350
HRF-127q	φ40~φ127	1.2~3.5	40x40~100x100 60x30~120x80	1.2~3.0	20~70	132*2	350
HRF-127		1.5~5.0		1.5~4.5	15~60	160*2	400
HRF-127z	φ50~φ127	1.5~5.5		1.5~5.0	10~45	160*2	400
HRF-140q	φ50~φ141.3	1.2~4.0	50x50~110x110 60x40~150x75	1.2~3.5	15~60	160*2	400
HRF-140		1.5~5.5		1.5~5.0	10~50	180*2	400
HRF-140z	φ60~φ141.3	2.0~6.0		2.0~5.5	10~40	180*2	500
HRF-168q	φ60~φ168.3	1.5~5.0	60x60~130x130 80x40~160x80	1.5~4.5	10~50	180*2	400
HRF-168		2.0~6.0		2.0~5.5	10~50	200*2	500
HRF-168z	φ76.2~φ168.3	2.5~8.0		2.5~7.0	10~40	200+132*2 (或132*4)	600
HRF-219q	φ89.1~φ219.1	2.0~6.0	70x70~160x160 100x50~200x100	2.0~5.5	10~50	110*2+110*2	500
HRF-219		3.0~8.0		3.0~7.0	10~40	132*2+132*2	600
HRF-219z		4.0~10.0		4.0~9.0	10~40	132*2+160*2	800
HRF-273	φ114.3~φ273	4.0~10.0	90x90~200x200 120x60~260x130	4.0~9.0	10~40	160*2+160*2	800
HRF-273z		4.5~12.0		4.5~11.0	10~35	180*4	800

