



# AUTOMATIC CHARMING MACHINE

[www.tengdimc.com](http://www.tengdimc.com)





今天的质量明天的市场

THE PRESENT QUALITY IS SUBSEQUENT MARKET

## COMPANY PROFILE

### 企业简介

Shijiazhuang Tengdi Machinery Co, Ltd. integrates R&D, production sales and service.

Factory area: 8000 square meters;

Company personnel: 50 people;

Engineer team: 10 engineers, 3 senior engineers;

Sales and operations Team: 10 people;

A total of 30 workers, two joint ventures.

Following the concept of independent innovation, the Tengdi team has designed a series of production lines that are easy to operate and maintain.

This is just a small part of the reasons why customers trust Tengdi.

石家庄腾迪机械设备有限公司集研发、生产、销售、服务于一体。

厂房面积：8000平方米；

公司人员：50人；

工程师团队：工程师10人，高级工程师3人；

销售和运营团队：10人；

共计30名工人，两家合资企业。

腾迪团队遵循自主创新的理念，设计了一系列易于操作和维护的生产线。

这只是客户信任腾迪的一小部分。



# ENTERPRISE QUALIFICATION

## 企业资质



Honor comes from hard work.

Every recognized qualification certificate is the crystallization of our hard work, every honor is a signpost, a journey.

We will also take every honor as a starting point, keep forging ahead and surpass ourselves.

The team has obtained more than 20 patents through independent research and development, and passed ISO9001 quality management system certification, SGS certification and environmental management system certification.

荣誉源于用心。

每一份认可的资质证书都是凝聚我们奋力拼搏的结晶，每一份荣誉都是一个路标，一次历程。

我们也将以每次荣誉为起点，不断锐意进取，超越自我。

团队自主研发获得20多项专利，通过ISO9001质量管理体系认证、SGS认证和环境管理体系认证等。



# ADVANTAGES

## 优势特点



使用寿命长



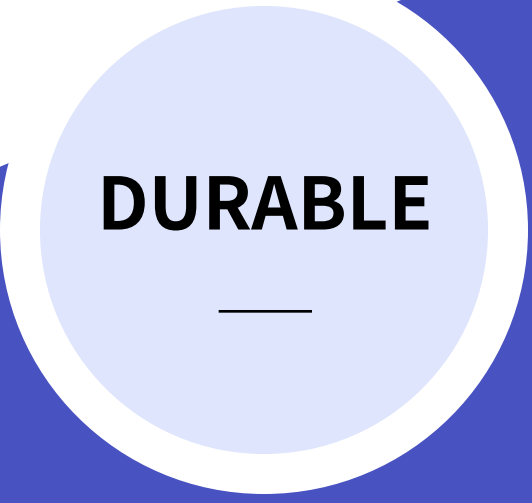
换刀次数少



维修方便



稳定性好



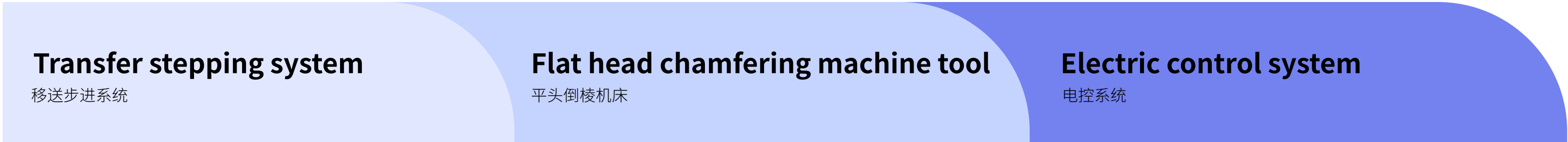
持久耐用

- 1. The tool feed system is designed with a reinforced spindle box.
- 2. The linear guide rail adopts Taiwan Shangyin, and the distance between the guide rails is increased.
- 3. The design structure of the cutter head can use the formed CNC cutter to reduce the number of tool changes and improve the operating rate.
- 4. The lateral movement adopts servo control, the idle stroke is accelerated, and the pipe is approached to the branch position to wait for the hooking and dropping of the pipe at a slow speed to prevent the pipe from moving in series.
- 5. The touch screen adopts the design of industrial control all-in-one machine, which can record the number of tool changes at any time, detect 4-6 fault points, and facilitate maintenance.
- 6. The cutter head has the functions of flat head and chamfering, and it can be completed at the same time.
- 7. The transmission shaft adopts a sandwich structure, which is installed and positioned precisely, and improves the overall durability of the traverse.
- 8. Equipped with a proximity switch for loose clamp detection to prevent the clamping cylinder from malfunctioning and causing accidents.
- 9. The parameters of multi-standard steel pipes can be set. When changing the specifications, the operator does not need to reset the parameters every time, just select the specifications.
- 10. The feed ball screw adopts Taiwan Shangyin 63-10, which is durable.

- 1.采用加强主轴箱设计进刀系统；
- 2.直线导轨采用台湾上银，导轨间距加大，导轨选型65-100，型号加大，提高使用寿命；
- 3.刀盘设计结构，可以选用成形数控刀，减少换刀次数，提高开机率；
- 4.横移采用伺服控制，空行程加快，接近分管位等待勾管和落管慢速，防止管串动；
- 5.触摸屏采用工控一体机设计，随时记录换刀次数，检测4-6个故障点，方便维修；
- 6.刀盘具备平头和倒棱多功能，具备同时平头和倒棱一次完成；
- 7.传动轴采用夹壳结构，安装定位精准，提高横移整体耐用性；
- 8.配备松夹检测接近开关，防止夹紧气缸误动作，造成事故；
- 9.可设置多规格钢管参数，更换规格时，操作人员不用每次重新设置参数，选择规格就可以；
- 10.进刀滚珠丝杠采用台湾上银63-10，持久耐用。

# EQUIPMENT COMPOSITION AND FUNCTION

## 设备组成及功能



### Transfer stepping system

移送步进系统

Including automatic branching and automatic pushing system. The steel pipes on the inlet cooling bed will be automatically transported to the position of leveling and flat chamfering, and then the steel pipes with flat chamfering will be transferred to the outlet cooling bed.

含自动分管和自动推齐系统。将入口冷床上的钢管自动运送到推齐和平头倒棱位置，再将平头倒棱完成的钢管移到出口冷床上。

### Flat head chamfering machine tool

平头倒棱机床

Including cutter head motor, clamping system, servo feed control system, can be installed with three internal and external chamfering and flat head knives. Finish the flat end and chamfer at the same time.

含刀盘电机、夹紧系统，伺服进刀控制系统，可安装内外倒棱和平头的三把刀。同时完成平头和倒棱。

### Electric control system

电控系统

Including power cabinet and console. Omron PLC control, 10 inch Buke touch screen man-machine interface. Set the feed amount and feed speed of flat head chamfering, and select the specification. 2 cutter head frequency converters (major domestic brands), 1 transfer stepping servo controller (Weichuang), 2 feed servo controllers (Weichuang), feed reducer and ball screw (2 sets).

含动力柜和操作台。欧姆龙PLC控制，10寸步科触摸屏人机界面。设置平头倒棱进刀量和进刀速度，规格选择。刀盘变频器2台（国内大品牌），移送步进伺服控制器1台（伟创），进刀伺服控制器2台（伟创），进刀减速机和滚珠丝杠（2套）。

# PARAMETER DESCRIPTION

## 参数描述

平头机规格 Flat head machine specification (mm)	平头范围 Flat head range (mm)	平头倒棱机范围 Range of flat head chamfering machine (mm)	平头倒坡口范围 Range of flat end chamfer (mm)
50	20-50	20-50	
76	42-76	32-76	
89	50-89	42-89	
114	76-114	60-114	
140	89-140	76-140	
165	114-165	89-165	
219	114-219	114-219	114-219
273	165-273	140-273	140-273
355	219-355	165-355	165-355
406	219-406	219-406	219-406
508	219-508	219-508	219-508

Flat head machine, flat head chamfering machine, chamfering machine Technical proposal and quotation basis

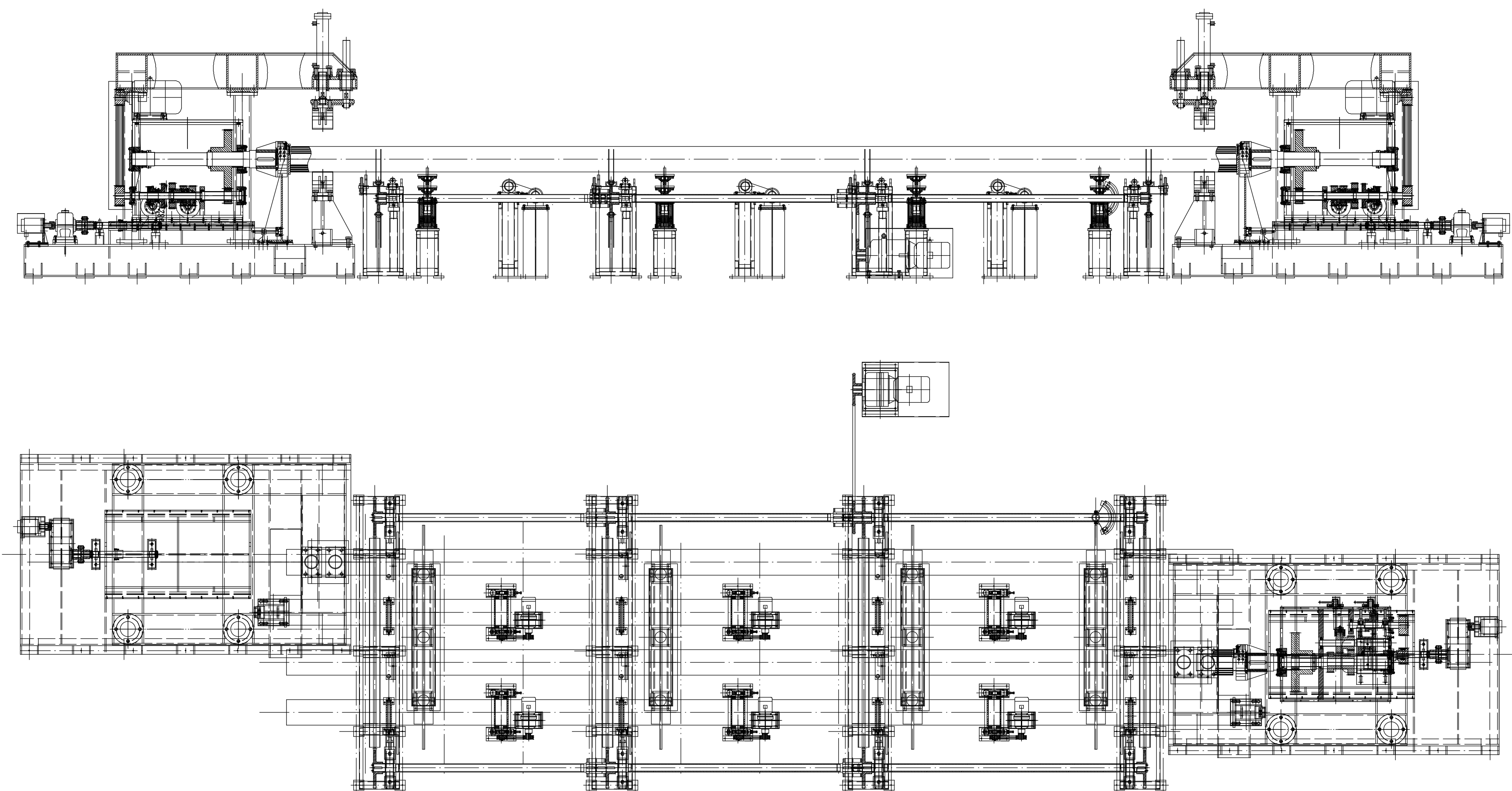
- 1. Differences among flat head machine, flat head chamfering machine and chamfering machine:**  
**1.1 Flat head machine:** specially used for flat head and deburring of pipe orifice, applicable to pipe diameter below 219. Generally, it is station 2 and station 3.  
**1.2 Flat head chamfering machine:** for flat head and internal and external chamfering of pipe orifice, the pipe orifice is in trapezoidal structure, and the general chamfer is 30-35 °, which is applicable to pipe diameter below 219. They are generally stations 1, 2 and 3.  
**1.3 Chamfering machine:** for large pipes, thick wall pipe orifices are chamfered to facilitate butt welding of two steel pipes. Two knives are required for chamfering, one is flat and the other is external chamfering. It is generally used for straight seam welded pipe with wall thickness of 8-25 and outer diameter of 273-508.  
**2.** API standard beveling machine requires that the flatness deviation of pipe end face is less than 0.8-1.5mm. That is, the thickness of the plane is less than 0.8-1.5mm, and the deviation varies according to the outer diameter and wall thickness.  
**3.** Scheme and quotation basis of flat head machine, chamfering machine and chamfering machine: **outer diameter range, material range, wall thickness range, length range, flat head, chamfering and groove options.**

平头机、平头倒棱机、倒坡口机技术方案和报价依据

- 1.平头机、平头倒棱机、倒坡口机的区别：**  
1.1平头机：专门对管口平头，去毛刺，适用于管径219以下。一般为2、3工位。  
1.2平头倒棱机：对管口平头和内外倒角，管口成梯形结构，一般倒角为30-35°，适用于管径219以下。一般为1、2、3工位。  
1.3倒坡口机：对大管，厚壁管口倒外坡口，目的是两根钢管对接焊接方便。倒坡口需要两把刀，一个平口，一个倒外角。一般用于壁厚8-25，外径273-508直缝焊管。

2.API标准倒坡口机，要求管端面平口偏差小于0.8-1.5mm。即平面的厚度小于0.8-1.5mm，根据外径和壁厚不同，偏差有区别。

3.平头机、倒棱机、倒坡口机做方案和报价依据：**外径范围、材质范围、壁厚范围、长度范围、平头、倒棱、坡口选项。**





## PRODUCT DISPLAY

产品展示





**SOLD KOREAN**

STAINLESS STEEL CHAMFERING MACHINE

出口韩国不锈钢倒棱机





# THANKS

TENGDI LOOKS FORWARD TO YOUR JOINING!



**TENGDI**