



# MIVI MACHINERY

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Yangzhou MiviMachinery Manufacturing Co.,Ltd.



## 企业简介 COMPANY PROFILE

扬州美岳机械装备有限公司地处扬州北郊槐泗工业园区，占地25000平方米，交通便利，是集开发、制造、销售为一体的专业焊管机组、模具制造企业。主要生产WF系列高频焊管机组；BG系列不锈钢焊管机组；GW系列型材冷弯成型机组；CQ系列车圆机以及各种焊管模具（12机组至508机组）型材模具。采用ISO9001:2000国际质量标准，拥有完善的质量保证体系、严格的管理制度、先进的检测手段和一流的售后服务队伍。

Yangzhou Mivi Machinery Manufacturing Co.,Ltd.is located in the industrial park of huaisi town,Yangzhou city.Our company covers an area of 25000square metres,which has convenient transportaion.The company specializes in producing the welded pipe units,the di-emaking enterprise,including the development,the manufacture and the sale.

The main products if our company:

WF series high-frequency welded pipe machine unit;

BG series stainless steel welded pipe machine unit;

GW series cold-bending forming machine;

CQ series rim machines,

Each kind of mould for the welded pipe and the forming machine.

Our company adopts the ISO9001:2000 international quality specification,it has a integrated quality assurance system,such as strice control system,advanced examination method and first-class post-sale service troop.

## 流程化产品制造中心

PRODUCT MANUFACTURING CENTER BY FLOW

先进精良的机加工设备、严格完善的管理，才能制造出高品质的产品。

Only with the advanced and excellent processing equipments, and strict and consummated management, a company can yield products with high quality.



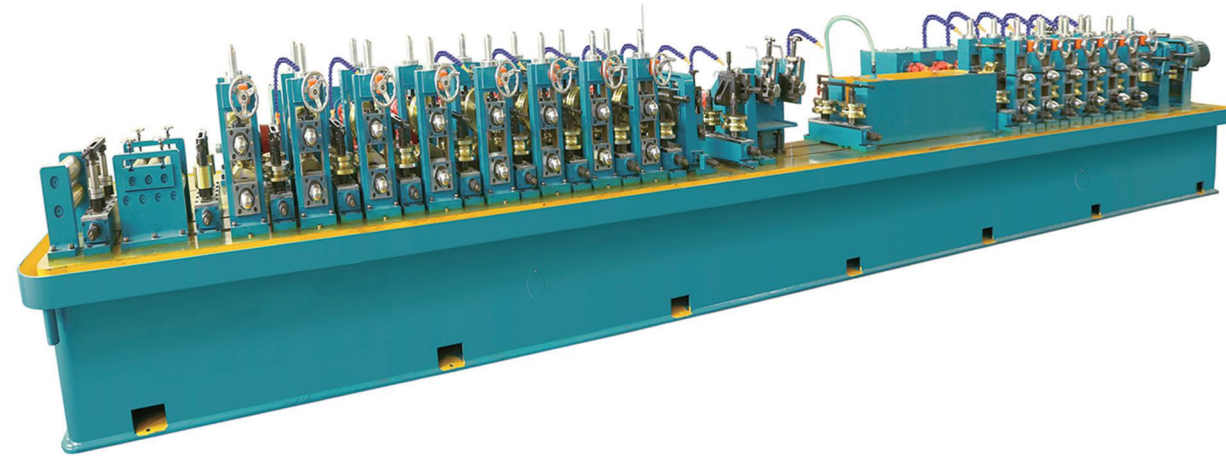
落地镗、铣、车等大型专业加工设备，为公司制造出一流的大中型管机，提供了有力保障。  
The brand new fall to floor boring machine, milling machine, lathe, etc, all of these professional processing equipments ensure our company produce the first class medium and large scale pipe making machine.

# 精密高频焊管机组

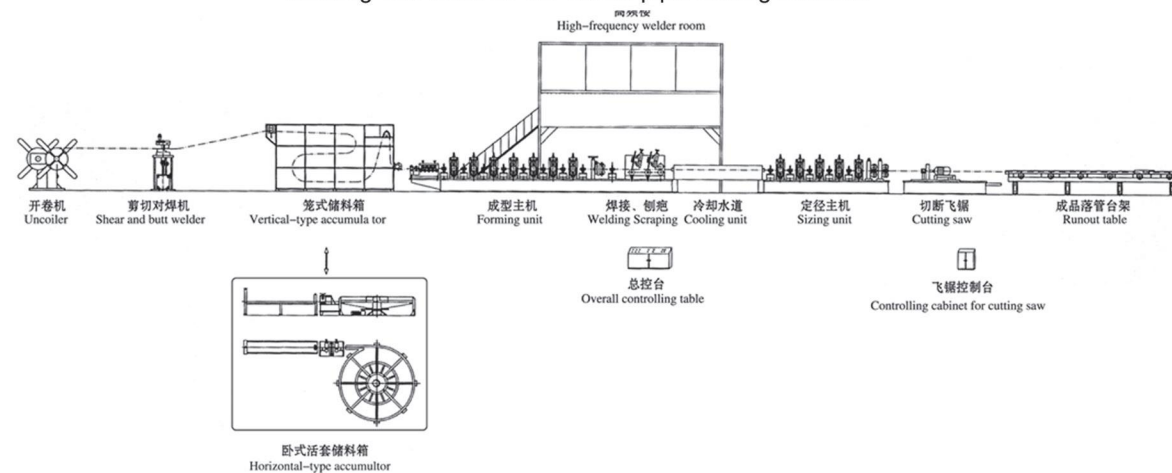
High-frequency Welding Pipe Making Machine Line

我公司引进美国、日本、台湾等国家和地区的先进技术，专业设计制造的精密高频焊管机组生产线，工艺布置合理，制管精度高，产品质量稳定，自动化程度高。

With the introduction of advanced technology from American, Japan, taiwan into our company, the high-frequency welding pipe making machine line we specialize in, is well distributed in craftwork, high productivity, easily operated and the equipments are of reliable quality, and have achieved automation on a high level.

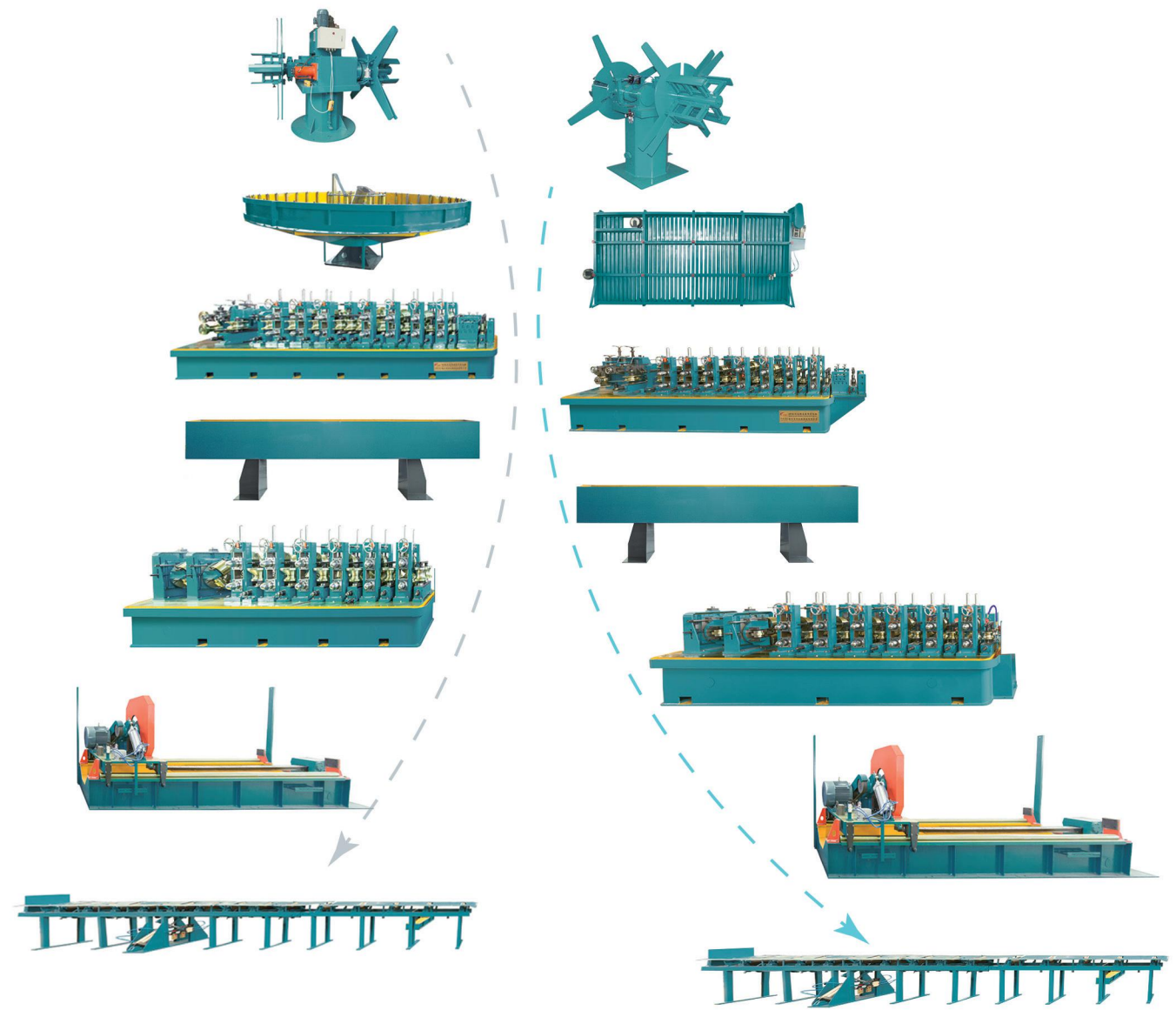


WF系列高频焊管机组工艺流程示意图  
Working-flow chart for WF series pipe-making machine



# WF高频直缝焊管机组系列

Straight seam and high frequency welded pipe mill line



## WF-16型直缝焊管机组

High-Frequency Straight seam pipe-making line ModelWF-16

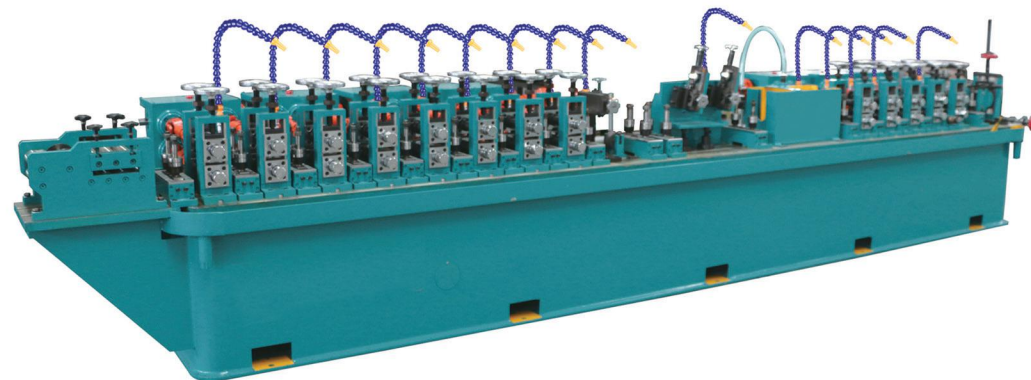
序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	双头开卷机 Double-head uncoiler	1	
2	储料仓 Accumulator	1	
3	矫平 Flattening	1	
4	刨疤刀架 Deburr frame	1	
5	平辊 Horizontal roller	13	
6	测速轮 Speed testing wheel	1	
7	电脑飞锯 Computer-controlled flying saw	1	
8	下料架 Run out table	1	
9	立辊 Vertical roller	15	
10	土耳其头 Turk's head	1	
11	传动箱 Transmission box	7	
12	主传动 Main driving spindle	1	
13	高频感应焊机 High-frequency induction welding machine	1	外购件 Purchasing parts

◆ 制造能力:

1. 制造管径:7mm-25mm
2. 制造厚度:0.3mm-1.0mm
3. 生产速度:30-100m/min

◆ Capacity:

1. Pipe ID: 7mm-25mm
2. Thickness: 0.3mm-1.0mm
3. Speed: 30-100m/min



## WF-25型直缝焊管机组

High-Frequency Straight seam pipe-making line ModelWF-25

序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	双头开卷机 Double-head uncoiler	1	
2	储料仓 Accumulator	1	
3	矫平 Flattening	1	
4	刨刺刀架 Deburr frame	1	
5	平辊 Horizontal roller	13	
6	测速轮 Speed testing wheel	1	
7	电脑飞锯 Computer-controlled flying saw	1	
8	下料架 Run out table	1	
9	立辊 Vertical roller	15	
10	土耳其头 Turk's head	1	
11	传动箱 Transmission box	7	
12	主传动 Main driving spindle	1	
13	高频感应焊机 High-frequency induction welding machine	1	外购件 Purchasing parts

◆ 制造能力:

1. 制造管径:8mm-32mm
2. 制造厚度:0.4mm-1.2mm
3. 生产速度:30-100m/min

◆ Capacity:

1. Pipe ID: 8mm-32mm
2. Thickness:0.4mm-1.2mm
3. Speed:30-100m/min



## WF-28型直缝焊管机组

High-Frequency Straight seam pipe-making line ModelWF-28

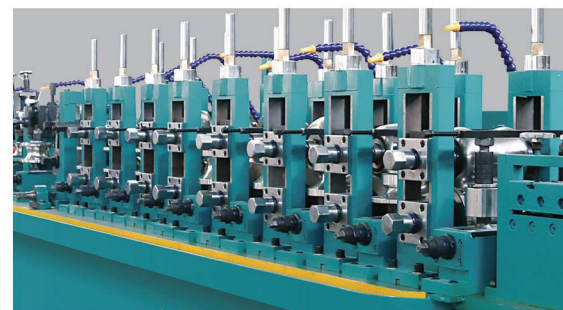
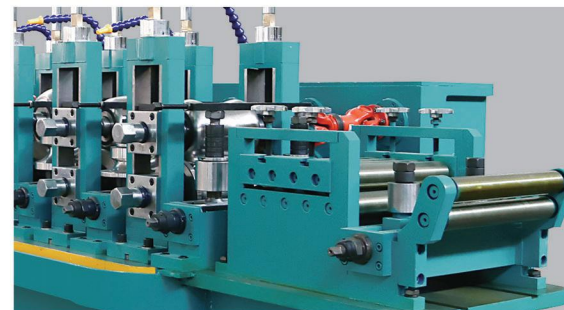
序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	双头开卷机 Double-head uncoiler	1	
2	储料仓 Accumulator	1	
3	矫平 Flattening	1	
4	刨刺刀架 Deburr frame	1	
5	平辊 Horizontal roller	13	
6	测速轮 Speed testing wheel	1	
7	电脑飞锯 Computer-controlled flying saw	1	
8	下料架 Run out table	1	
9	立辊 Vertical roller	15	
10	土耳其头 Turk's head	1	
11	传动箱 Transmission box	7	
12	主传动 Main driving spindle	1	
13	高频感应焊机 High-frequency induction welding machine	1	外购件 Purchasing parts

### ◆ 制造能力:

1. 制造管径:10mm-50.8mm
2. 制造厚度:0.5mm-1.8mm
3. 生产速度:30-100m/min

### ◆ Capacity:

1. Pipe ID: 10mm-50.8mm
2. Thickness: 0.5mm-1.8mm
3. Speed: 30-100m/min



## WF-32型直缝焊管机组

High-Frequency Straight seam pipe-making line ModelWF-32

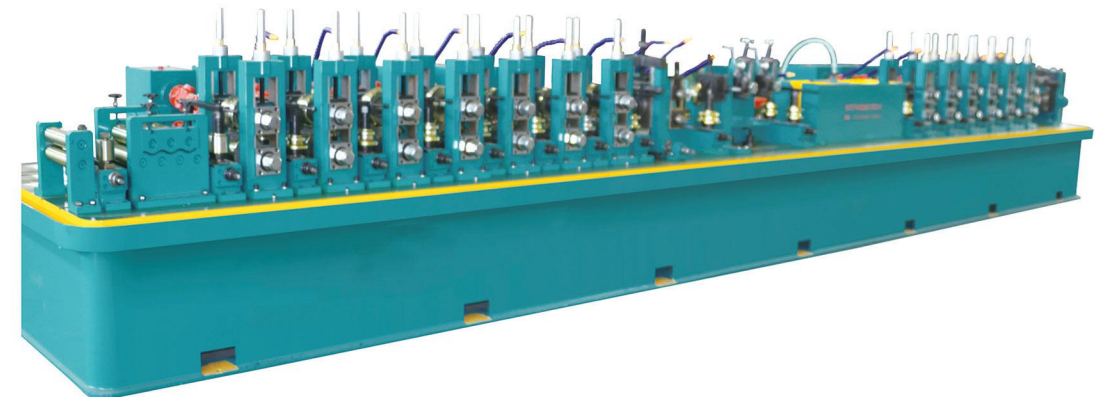
序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	双头开卷机 Double-head uncoiler	1	
2	储料仓 Accumulator	1	
3	矫平 Flattening	1	
4	刨刺刀架 Deburr frame	1	
5	平辊 Horizontal roller	14	
6	测速轮 Speed testing wheel	1	
7	电脑飞锯 Computer-controlled flying saw	1	
8	下料架 Run out table	1	
9	立辊 Vertical roller	16	
10	土耳其头 Turk's head	1	
11	传动箱 Transmission box	14	
12	主传动 Main driving spindle	1	
13	高频感应焊机 High-frequency induction welding machine	1	外购件 Purchasing parts

### ◆ 制造能力:

1. 制造管径:13mm-50.8mm
2. 制造厚度:0.6mm-2mm
3. 生产速度:30-100m/min

### ◆ Capacity:

1. Pipe ID: 13mm-50.8mm
2. Thickness: 0.6mm-2mm
3. Speed: 30-100m/min



## WF-50型直缝焊管机组

High-Frequency Straight seam pipe-making line Model IWF-50

序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	双头开卷机 Double-head uncoiler	1	
2	储料仓 Accumulator	1	
3	成型机组 Forming	1	
4	冷却水槽 Sink for cooling water	1	
5	定径机组 Sizing line	1	
6	电脑飞锯 Computer Controlled Flying Saw	1	
7	辊道式下料架 Rail type run out table	1	

### ◆ 制造能力:

1. 制造管径: 19mm-76mm
2. 制造厚度: 0.7mm-2.75mm
3. 生产速度: 30-100m/min

### ◆ Capacity:

1. Pipe ID: 19mm-76mm
2. Thickness: 0.7mm-2.75mm
3. Speed: 30-100m/min



## WF-60型直缝焊管机组

High-Frequency Straight seam pipe-making line Model IWF-60

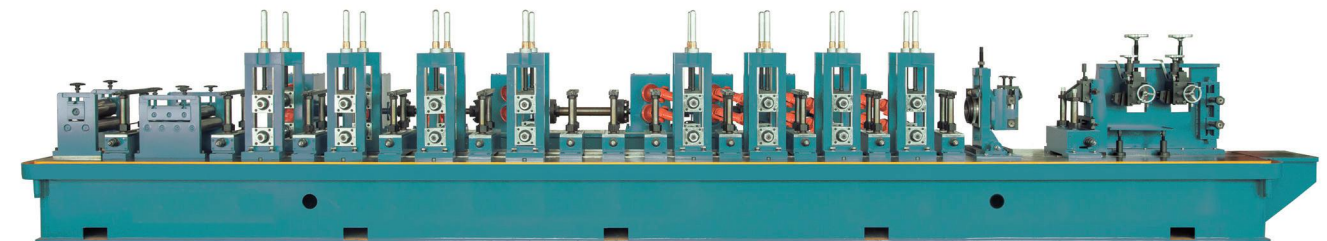
序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	双头开卷机 Double-head uncoiler	1	
2	储料仓 Accumulator	1	
3	成型机组 Forming	1	
4	冷却水槽 Sink for cooling water	1	
5	定径机组 Sizing line	1	
6	电脑飞锯 Computer Controlled Flying Saw	1	
7	辊道式下料架 Rail type run out table	1	

### ◆ 制造能力:

1. 制造管径: 25mm-80mm
2. 制造厚度: 1.0mm-3.25mm
3. 生产速度: 30-80m/min

### ◆ Capacity:

1. Pipe ID: 25mm-80mm
2. Thickness: 1.0mm-3.25mm
3. Speed: 30-80m/min



## WF-76型直缝焊管机组

High-Frequency Straight seam pipe-making line Model IWF-76

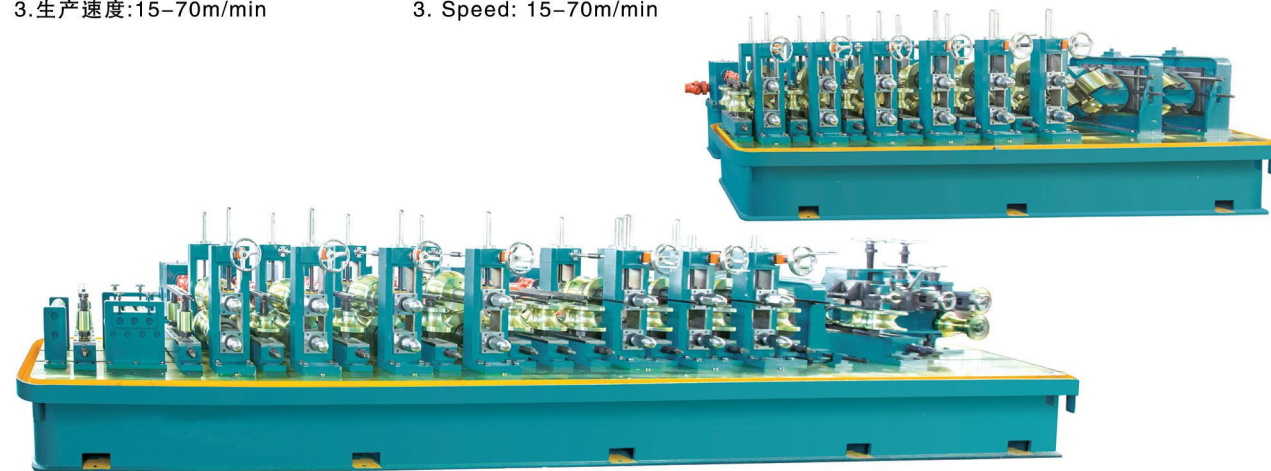
序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	单头开卷机 Single-head uncoiler	1	
2	水平螺旋活套 Horizontal accumulator	1	
3	成型机组 Forming	1	
4	冷却水槽 Sink for cooling water	1	
5	定径机组 Sizing line	1	
6	电脑飞锯 Computer Controlled Flying Saw	1	
7	辊道式下料架 Rail type run out table	1	

### ◆ 制造能力:

1. 制造管径: 30mm-90mm
2. 制造厚度: 1.0mm-4.0mm
3. 生产速度: 15-70m/min

### ◆ Capacity:

1. Pipe ID: 30mm-90mm
2. Thickness: 1.0mm-4.0mm
3. Speed: 15-70m/min



## WF-127型直缝焊管机组

High-Frequency Straight seam pipe-making line Model IWF-127

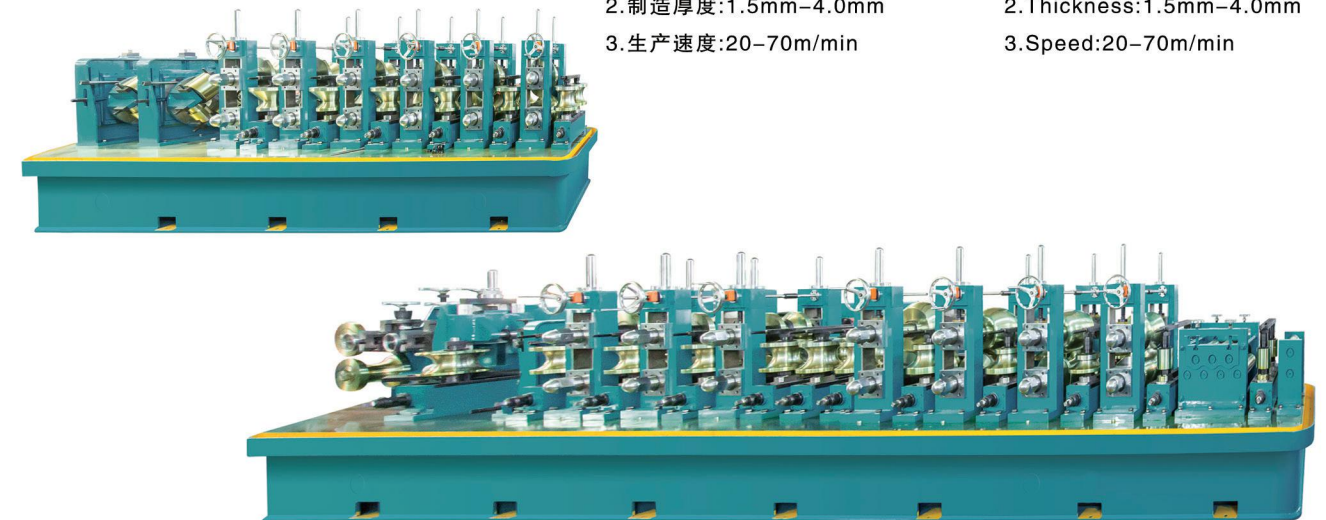
序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	单头开卷机 Single-head uncoiler	1	
2	水平螺旋活套 Horizontal accumulator	1	
3	成型机组 Forming	1	
4	冷却水槽 Sink for cooling water	1	
5	定径机组 Sizing line	1	
6	电脑飞锯 Computer Controlled Flying Saw	1	
7	辊道式下料架 Rail type run out table	1	

### ◆ 制造能力:

1. 制造管径: 32mm-127mm
2. 制造厚度: 1.5mm-4.0mm
3. 生产速度: 20-70m/min

### ◆ Capacity:

1. Pipe ID: 32mm-127mm
2. Thickness: 1.5mm-4.0mm
3. Speed: 20-70m/min



## WF-165型直缝焊管机组

High-Frequency Straight seam pipe-making line ModelWF-165

序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	单头开卷机 Single-head uncoiler	1	
2	水平螺旋活套 Horizontal accumulator	1	
3	成型机组 Forming	1	
4	冷却水槽 Sink for cooling water	1	
5	定径机组 Sizing line	1	
6	电脑飞锯 Computer Controlled Flying Saw	1	
7	辊道式下料架 Rail type run out table	1	

### ◆ 制造能力:

1. 制造管径:50mm-165mm
2. 制造厚度:2.0mm-5.0mm
3. 生产速度:30-50m/min

### ◆ Capacity:

1. Pipe ID: 50mm-165mm
2. Thickness: 2.0mm-5.0mm
3. Speed: 30-50m/min



## BG-20型不锈钢机组

BG-20 Stainless Steel Unit

序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	单头开卷机 Single-head uncoiler	1	
2	清洗槽 Clean slot	1	
3	带钢导向 Strip Steel Guide	1	
4	氩弧焊机 Argon Arc Welder	1	外购件 Purchasing parts
5	焊缝打磨 Weld Joint Polishing	2	
6	平辊 Horizontal roller	11	
7	切割飞锯 Cutting Saw	1	
8	下料架 Run out table	1	
9	立辊 Vertical roller	13	
10	齿轮箱 Wheel gear box	6	
11	主传动 Main driving spindle	1	

### ◆ 制造能力:

1. 制造管径:7mm-25mm
2. 制造厚度:0.3mm-1.2mm
3. 生产速度:3-7m/min

### ◆ Capacity:

1. Pipe ID: 7mm-25mm
2. Thickness:0.3mm-1.2mm
3. Speed:3-7m/min

## BG-30型不锈钢机组

BG-30 Stainless Steel Unit

序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	单头开卷机 Single-head uncoiler	1	
2	清洗槽 Clean slot	1	
3	带钢导向 Strip Steel Guide	1	
4	氩弧焊机 Argon Arc Welder	1	外购件 Purchasing parts
5	焊缝打磨 Weld Joint Polishing	2	
6	平辊 Horizontal roller	11	
7	切割飞锯 Cutting Saw	1	
8	下料架 Run out table	1	
9	立辊 Vertical roller	13	
10	齿轮箱 Wheel gear box	6	
11	主传动 Main driving spindle	1	

### ◆ 制造能力:

1. 制造管径:13mm-30mm
2. 制造厚度:0.4mm-1.5mm
3. 生产速度:3-7m/min

### ◆ Capacity:

1. Pipe ID: 13mm-30mm
2. Thickness:0.4mm-1.5mm
3. Speed:3-7m/min

## BG-50型不锈钢机组

### BG-50 Stainless Steel Unit

序号 Serial No.	设备名称 Name of products	数量 Quantity	备注 Remark
1	单头开卷机 Single-head uncoiler	1	
2	清洗槽 Clean slot	1	
3	带钢导向 Strip Steel Guide	1	
4	氩弧焊机 Argon Arc Welder	1	外购件 Purchasing parts
5	焊缝打磨 Weld Joint Polishing	2	
6	平辊 Horizontal roller	11	
7	切割飞锯 Cutting Saw	1	
8	下料架 Run out table	1	
9	立辊 Vertical roller	13	
10	齿轮箱 Wheel gear box	6	
11	主传动 Main driving spindle	1	

#### ◆ 制造能力:

1. 制造管径: 20mm-76mm
2. 制造厚度: 0.6mm-2.0mm
3. 生产速度: 3-7m/min

#### ◆ Capacity:

1. Pipe ID: 20mm-76mm
2. Thickness: 0.6mm-2.0mm
3. Speed: 3-7m/min

## WF25BG包钙管机组

### WF25BG Package Calcium Tube Unit

#### ◆ 原材料条件:

1. 钢带材质: 冷轧低碳钢钢带, 钢号: SPHC \SPHD、Q195L、Q195 ; 钢带力学性能:  $ReL \leq 195\text{Mpa}$ ,  $Rm \leq 345\text{Mpa}$
2. 钢带宽度: 28~50mm
3. 钢带厚度: 0.65-1.2mm
4. 钢带卷: 内径:  $\Phi 350 - \Phi 450\text{m}$ ; 外径:  $\Phi 600 - \Phi 1000\text{mm}$  卷重: 800kg
5. 钢带要求: 符合 yb/t4214-2010 包芯线用冷轧带钢。
6. 钙丝:  $\phi 7 - \phi 13\text{毫米}$ 。常用  $\phi 7\text{毫米}$ 。

#### ◆ 成品要求:

- 生产的产品为: 1.0毫米厚带钢包裹  $\phi 7\text{毫米}$  金属钙丝  $\phi 9\text{毫米}$  无缝包芯线, 用于炼钢中改质钢水质量。
- 包芯线圆管直径:  $\Phi 8 - \Phi 15\text{mm}$ ; 壁厚: 0.65~1.2mm
- 钢带内包裹  $\phi 7 - \phi 11\text{毫米}$  的金属丝或金属颗粒或粉剂。直径为:  $\phi 9 - \phi 15\text{毫米}$  的包芯线, 为实心, 常用为  $\phi 9\text{毫米}$ 。

## GW系列辊压冷弯成型机组

### GW series roll-forming mill line

#### 主要技术参数

#### Main technical parameters

机型	Model	GW150	GW200	GW250	GW300	GW350
轧制厚度(mm)	Milling thickness(mm)	$\delta 0.5 \sim 1.2$	$\delta 0.8 \sim 1.5$	$\delta 1.0 \sim 2$	$\delta 1.2 \sim 2.5$	$\delta 1.5 \sim 3.5$
轧制宽度(mm)	Milling width(mm)	50~150	50~200	50~250	100~300	100~350
轧制速度( m/min)	Milling speed( m/min)	5~25	5~25	5~20	5~20	5~15
主电机功率(kw)	Power of main motor(kw)	22	30	37	45	75

## WF-16B型制冷管生产线

### WF Refrigeration Production Equipment

#### 主要用于制冷行业冰箱、空调系列产品

Mainly used for refrigerator, air conditioner etc. Products in refrigeration industry.

#### 双头开卷机

一、简述: 回转式运动, 能快速更换钢卷并采用气动刹车装置

二、参数与说明:

- (1)、钢卷最大重量: 500kg (2)、卷料轴内径: 350mm-450mm  
(3)、钢卷最大外径: 1100mm (4)、钢卷最大宽度: 100mm

#### 主传动

1. 主机采用 Z4-160-11、22kw 直流电机传动
2. ZLY140 型减速机, 速比 4.2:1
3. 拖动采用进口欧陆直流装置。

#### 笼式集料箱

1. 型式: 由角钢、槽钢焊接而成
2. 进料速度:  $\geq 200\text{m/min}$
3. 储料能力:  $\geq 400\text{m}$

#### 宽度调整

能力: 22mm-80mm

#### 储料 辊轮(一组)

1. 材质: Gcr15
2. 送料轧轮: 125mm, 2只
3. 电机: 1.5kw, 1台

#### 收卷装置

以机组管速度, 再通过三辊圈装置把管收圈在小车里

#### 高频

1. 型式: GP100-0.6-H
2. 输入电源: 3P、380V、50HZ
3. 输出功率: 100kw
4. 输出控制方式: 微机调压
5. 高压整流器: 20A
6. 高压变压器: 3、380V、180KVA
7. 震荡电子管: FU-911S
8. 电子管灯丝变压器: 12V-AC
9. 电子管阳极水管: 聚乙烯增强管
10. 电容器: CCG81-2000P-20KV

#### Double-head uncoiler

Briefing: Rotary type to change coils easily with n pneumatic brake

Parameters:

- (1)The max. weight of coil: 500kg (2)The inside diameter of coil: 350-450mm  
(3)The max. outside diameter of coil: 1100mm (4)The max. width of coil: 100mm

#### Main drive

1. The main motor is driven by model Z4-160-11, 22kw DC motor
2. Model ZLY 140 speed reducer, the ratio is 4.2: 1
3. Imported OL DC control device to drag

#### Material collecting cage

1. Material: made of angle and channel iron
2. Feeding speed:  $\geq 200\text{m/min}$
3. Collecting capacity:  $\geq 400\text{m}$

#### Width adjustment

Range: 22-80mm

#### Rolls for collecting material

1. Material: Gcr15
2. Feeding rolls 115mm, 2pieces
3. Motor: 1.5kw, 1set

#### Wind-up Device

Wind the pipe in trolley with three-roller rolling device in the speed of pipe.

#### High-frequency

1. Model: GP100-0.6-H
2. Input power: 3P, 380V, 50HZ
3. Output power: 100kw
4. Control mode of output power: regulated by microprocessor
5. High voltage rectifier: 20A
6. High voltage transformer: 3, 380V, 180KVA
7. Electronic tube: FU-911S
8. Transformer of the electronic tube shaking: 12V-AC
9. Anode hydraulic pipe of electronic tube: Polythene reinforcing tube
10. Capacitor: CCG81-2000P-20KV

焊管模具—轧辊  
Welded pipe mould-rollers

冷轧机  
Cold Rolling Mill

本公司模具材料选用大型钢厂优质合金材料·模具的设计到加工运用国际先进的设计理念和生产流程·精益求精



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产品应用领域  
Products application fields

