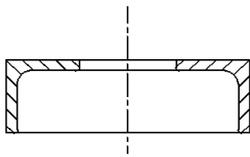
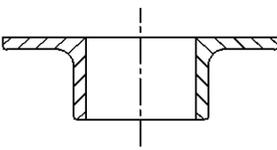
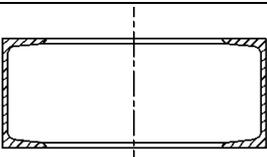
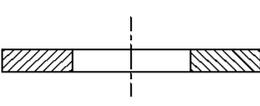
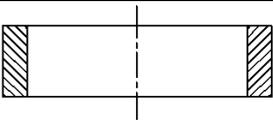
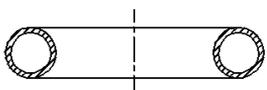


# W24NC-320 Hydraulic Arc Type Profile Bending machine technology parameter

## I. Main technical parameters

Type		W24NC-320	
Main technical parameter		320	
Max section modulud of elasticity (cm <sup>3</sup> )		245Mpa	
Profile yield limit			
angle iron incurvature		Max section	200×18
		Min bending dia.	3600
angle iron excurvature		Max section	180×14
		Min bending dia.	3600
Channel steel excurvature		Max section	40#
		Min bending dia.	2000
Channel iron incurvature		Max section	40#
		Min bending dia.	2000
Flat iron bend in hard way		Max section	190×50
		Min bending dia.	2400
Flat iron bend in easy way		Max section	360×60
		Min bending dia.	2000
Round steel		Max section	Φ 135
		Min bending dia.	1800
Pipe		Max section	Φ 245×8
		Min bending dia.	3000
Diameter of standard module (mm)		Φ 700	
Rolling speed (m/min)		3.5	
Main motor power (KW)		37	

## II. Main structure and work principle

The device is the 3-roller arc-adjustment profile bending machine, with pre-bend function. And it is composed of the base body, sides rollers, support rollers, drive part, electrical part, hydraulic part, mold and so on.

The 3 work rollers are the main drive rollers, and drive them by the motor, gear box, and bearing. The 2 sides rollers are lifted by the hydraulic system, and they do arc lift down and up movement around the fixed rotation center. On the both sides of the work rollers with support rollers and correct-guid rollers, so they help to assure quality when bend asymmetrical profile (like an angle).

## III. Manufacturers of main components

Component name		Specification
Work molds	Material	42CrMo
	Hardness	HB220-280/HRC45-50
	Manufacturer	Nanjing iron and steel group/Jiangsu Huaxiang Special Steel Forging Co.,Ltd
Work rollers	Material	45# forging round
	Hardness	HB220-280
	Manufacturer	Nanjing iron and steel group/Jiangsu Huaxiang Special Steel Forging Co.,Ltd
Base board and side brackets	Material	Q345
	Produce arts	Welded structure, stress handling, CNC boring and milling machine
	Manufacturer Nantong ChaoLi Rolling Machine Producing Co.,Ltd	
Motor	Type	Hydraulic motor
	Manufacturer	Ningbo Yifa/Zhongcheng

	Touch screen		Touch win (Canada)
	PLC		Omron(Japan)
Hydraulic system	Hydraulic pump	Type	Gear pump
		Manufacturer	Hefei Changyuan
	valve		Yuken(Japan)
	Main oil pump	Cylinder and piston rod	45# steel,heatment treatment HRC 48-50
		Manufacturer	Jiangsu Oupu/Sangpu
		Main oil pump seals	Yx series
Manufacturer		Taiwan Dingji	

#### IV. Services after sell and promise

A. Seller can supply export device install and debugging service, and help to train buyer's operator if buyer want; but buyer should pay all the fees during the work (like the round-trip tickets, board and lodging, traffic, communication abroad),besides these should pay the technician salary generally 50 USD/day (one person normally).

B. One year guarantee, repair all life. Offer call service in 3 hours and spot service in 3 days (internal) /7 days (external) to ensure buyer's normal produce.

V. This technical file as the annex of the contract, has law force at same time. Excepts the changes agree with two sides.

W24NC series Reference Pictures:

