



峻懿企業有限公司

Hi-Weld Enterprise Co., Ltd.

LPG Bottle 生產設備說明

陳軍橫(偉強)



台灣LPG鋼瓶市場規格

台灣 *LPG* 鋼瓶市場規格



4kg — 2 片式.
10/16/20/50kg — 3 片式

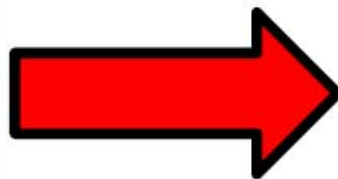
20 kg 鋼瓶





50 kg 鋼瓶

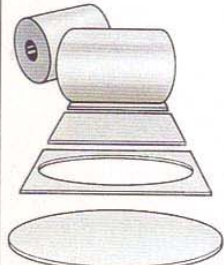
台灣LPG鋼瓶市場規格 4kg -----2 片式.



COMPLETE LINE OR PARTS

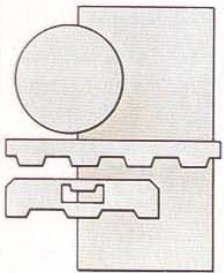
1 BLANKING

The material, which can be of steel, stainless steel or aluminium in strips or in coil, is straightened and fed into the AP&T blanking press.



produce blanks for ends, bodies, handles, base rings etc.

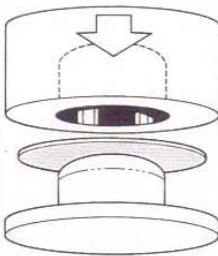
This blanking line can also be used as a cut-to-length line.



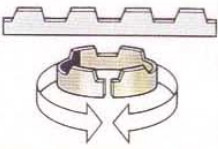
Blank feeding
The palletized blanks are fed into the forming operations manually or automatically by AP&T transferring systems.

2 FORMING

Forming operations are performed in different specialized machines, such as the hydraulic AP&T deep drawing press.



The necessary tools for operations such as drawing, rolling, embossing

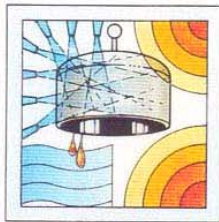


and coining will be provided by our experienced tools shop.

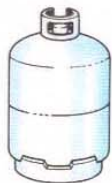


3 DEGREASING

Oil is removed from all the parts by spraying them with a hot alkaline solution. After being covered with this solution, the parts are rinsed in a rinsing zone and then transferred to a drying oven.

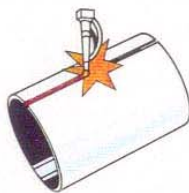


The entire degreasing process takes place in a closed facility that does not discharge any alkaline polluted water.

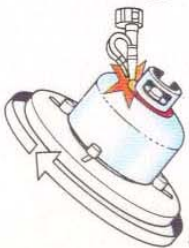
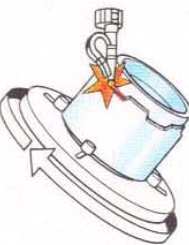


4 WELDING

The cylindrical vessel is placed on a heavy-duty support boom with a water-cooled backing bar made of copper. The two edges to be welded together are clamped to the backing bar by a number of clamping fingers pneumatically operated. Welding is done from outside only.



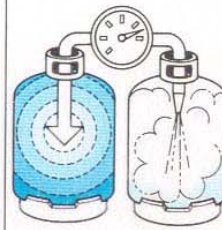
A nipple, a handle and a base ring are welded in a machine with a fixed welding head while the workpiece is rotated. The angle of the rotating axis can be steplessly adjusted from horizontal to vertical.



LPG production line

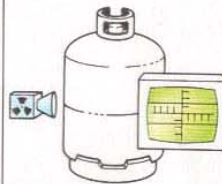
6 TESTING

The vessel is pressure tested for leaks. A measuring instrument is connected that automatically fills it with testing fluid. After testing, the vessel is emptied by means of compressed air.



The test is a 100 % reliable way of detecting leaking vessels which then can easily be removed for repair.

Sophisticated X-ray instruments provide high resolution examination and permit exceptional magnification.

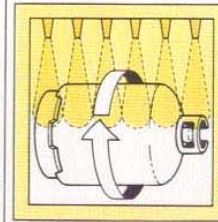


This ensures reliable and continuous inspection of welded joints.



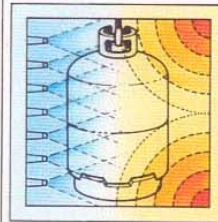
7 SURFACE TREATMENT

In the shot blasting machine, the vessel receives a perfectly clean surface structure which ensures excellent adhesion for paint.



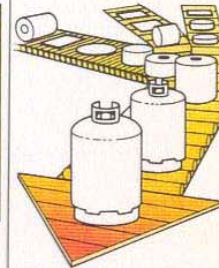
The process is entirely dust-free and the machine can therefore be positioned next to the painting station.

The vessels are painted electrostatically using the powder painting technique. This is an economical and reliable method of painting, which ensures that the paint will cover the entire surface. The paint powder is non-toxic and does not contain any solvents. After painting, the powder is hardened in a furnace to give an impact-resistant surface with a high gloss finish.



8 MATERIALS HANDLING

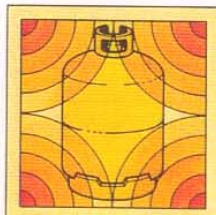
Efficient materials handling is an important element in all industrial systems.



Consequently, complete transport systems within and between the various manufacturing stations are tailored to suit each individual plant.

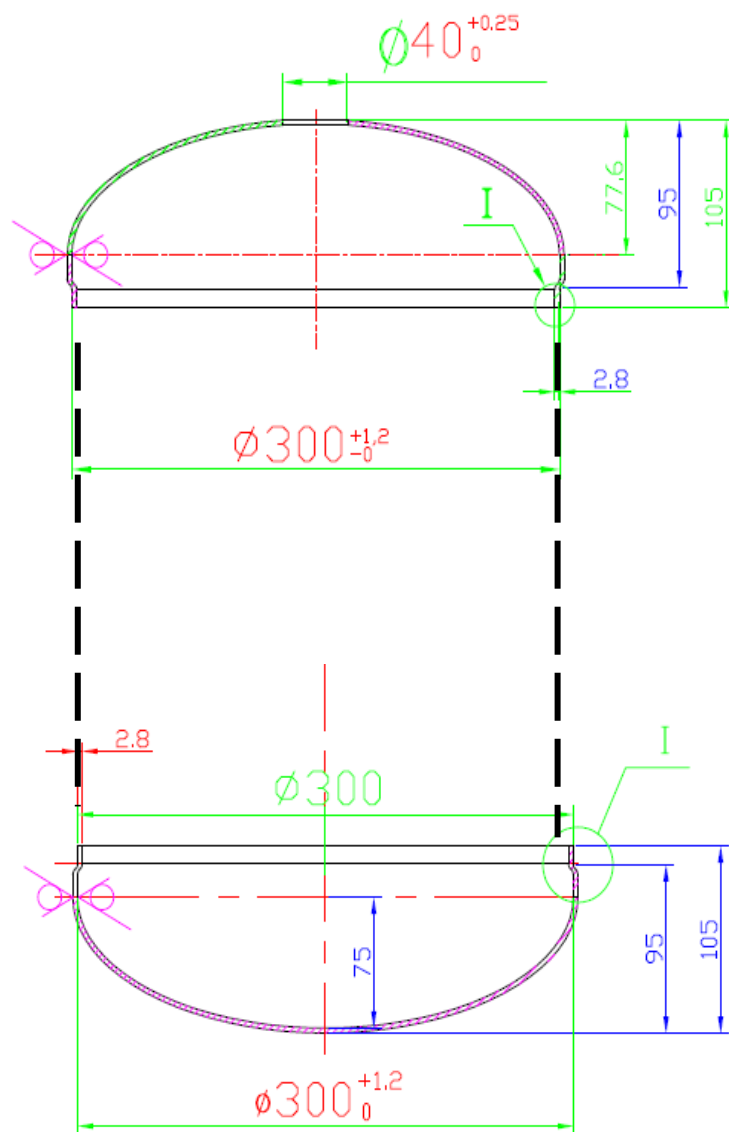
5 HEAT TREATMENT

The welded vessel is heat treated in a furnace with or without a protective gas atmosphere. Different optional heating systems are available.

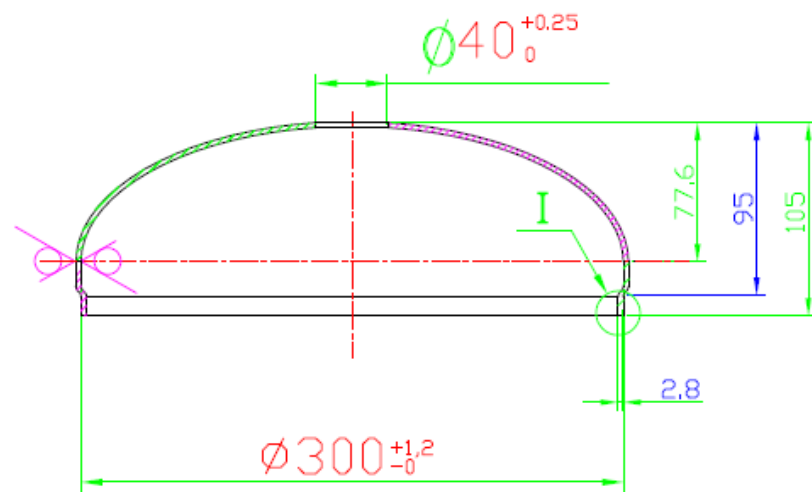




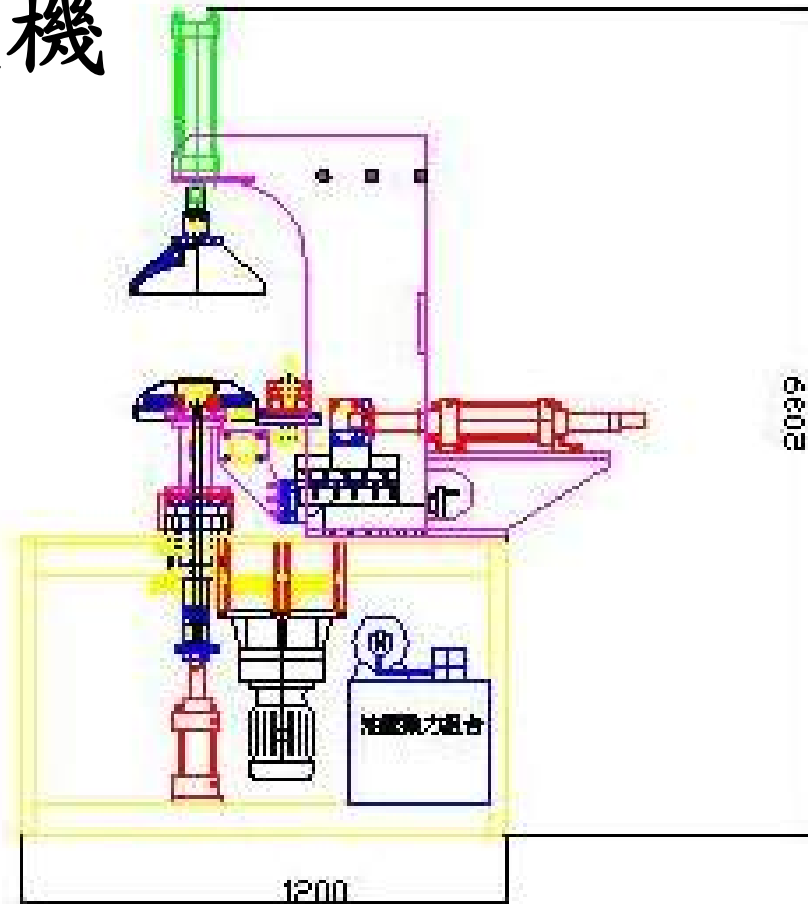
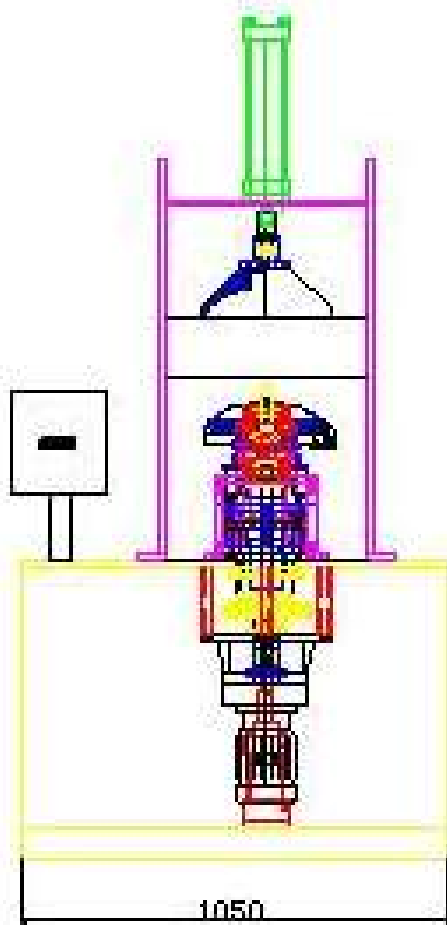
端蓋加工設備

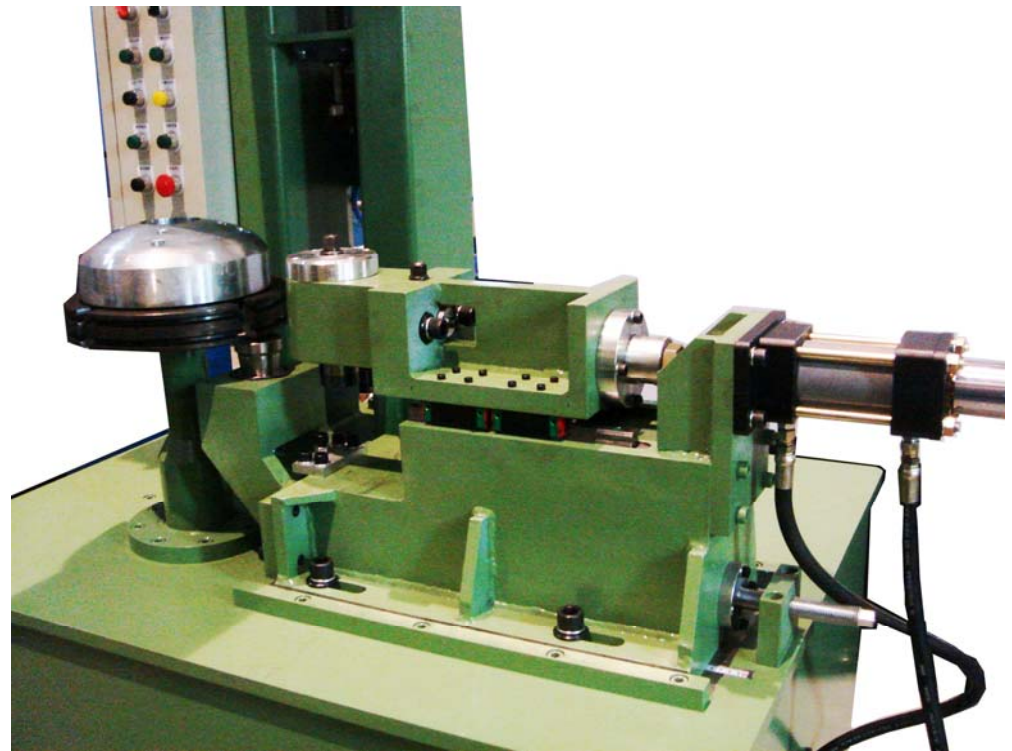


端蓋加工設備



曲邊機



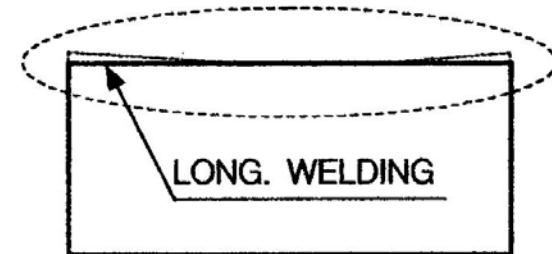
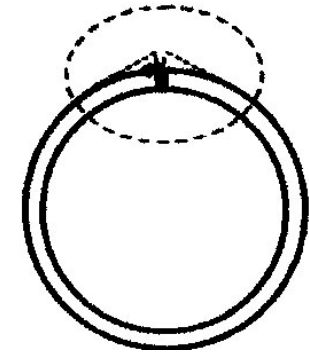








Bending machine 捲圓機







16/20 Kg 捲圓機



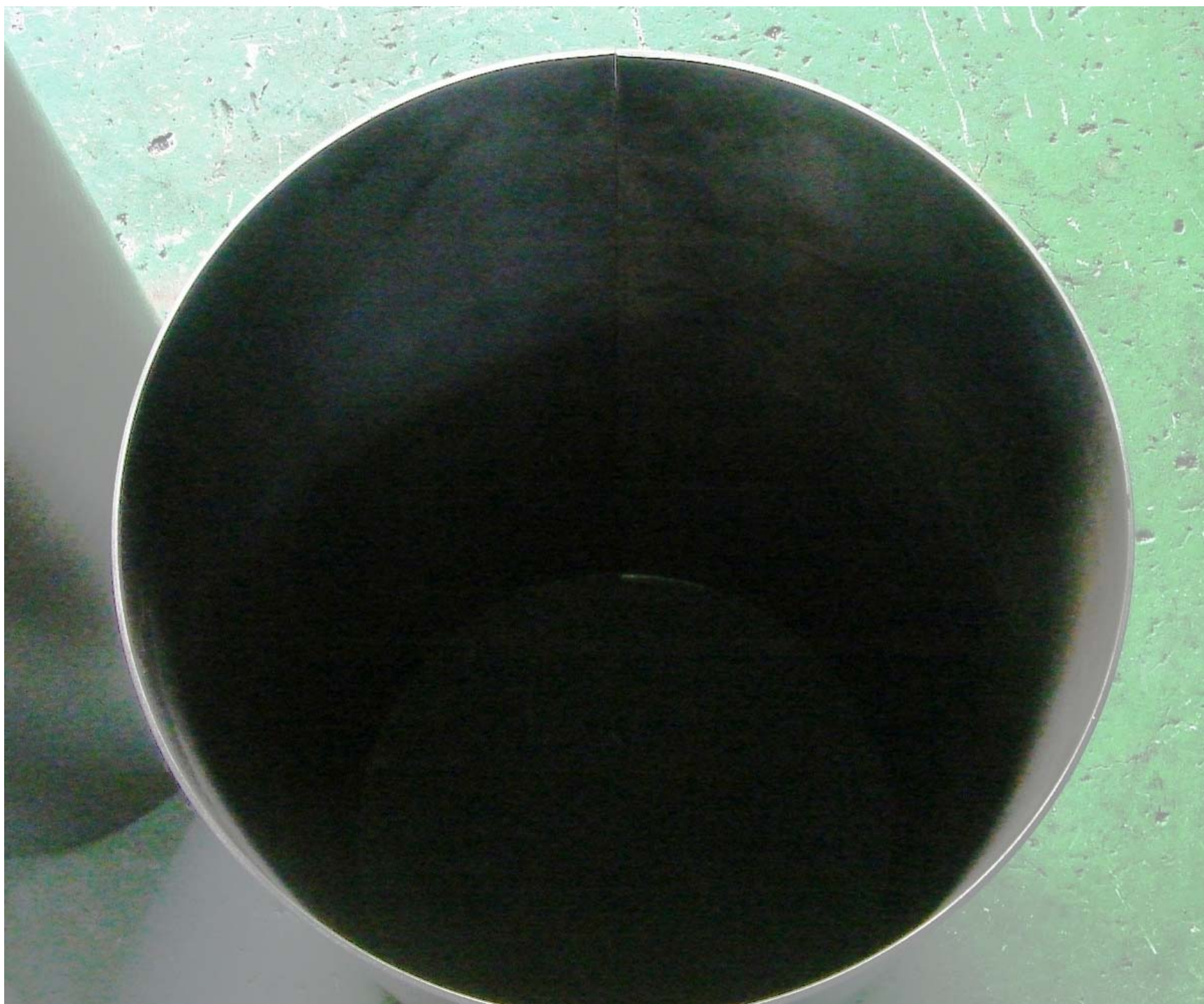




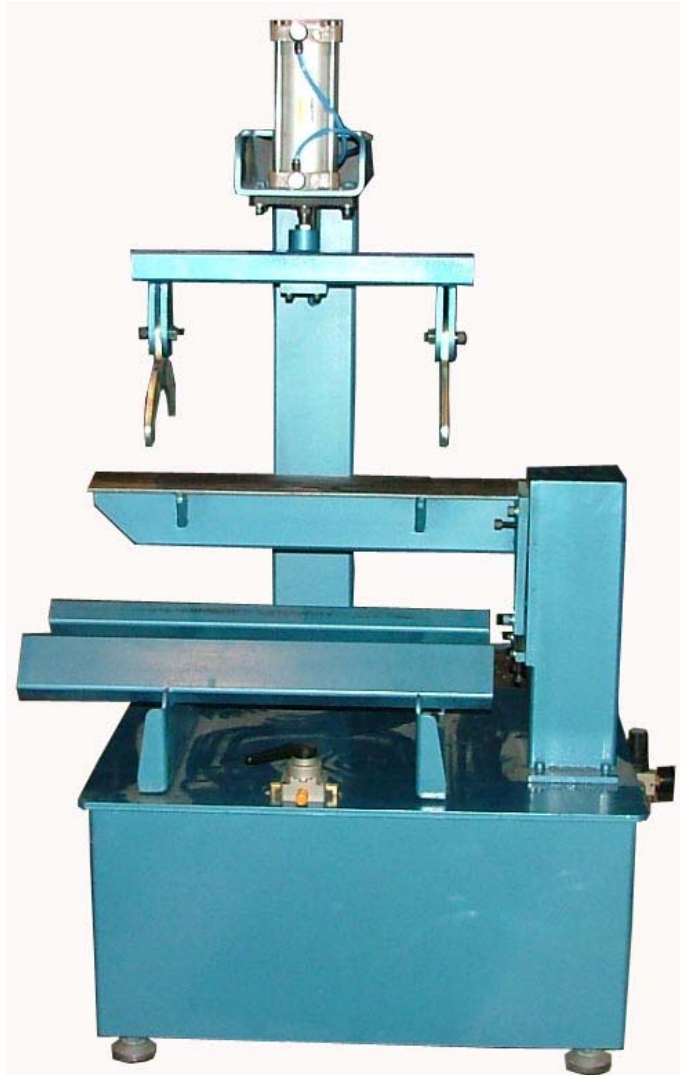


捲板成型





預點機



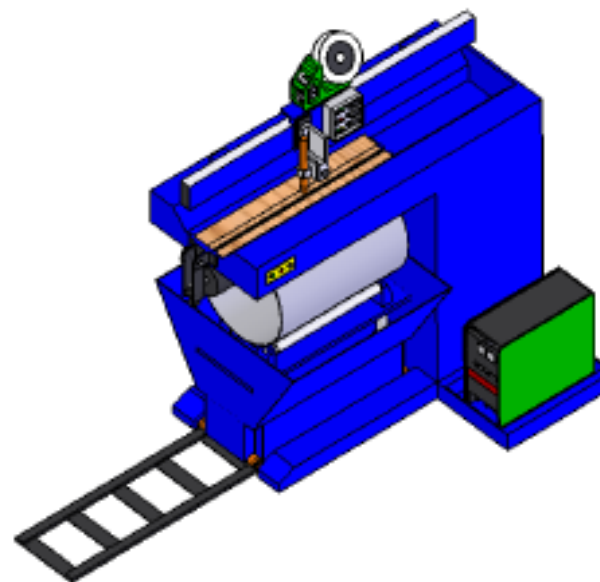
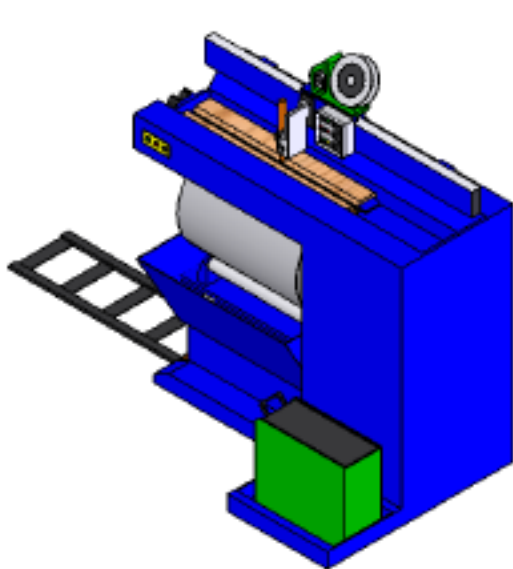
Tack welding



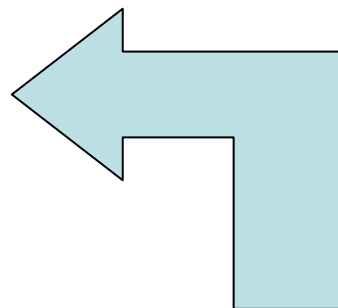
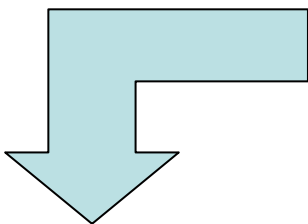


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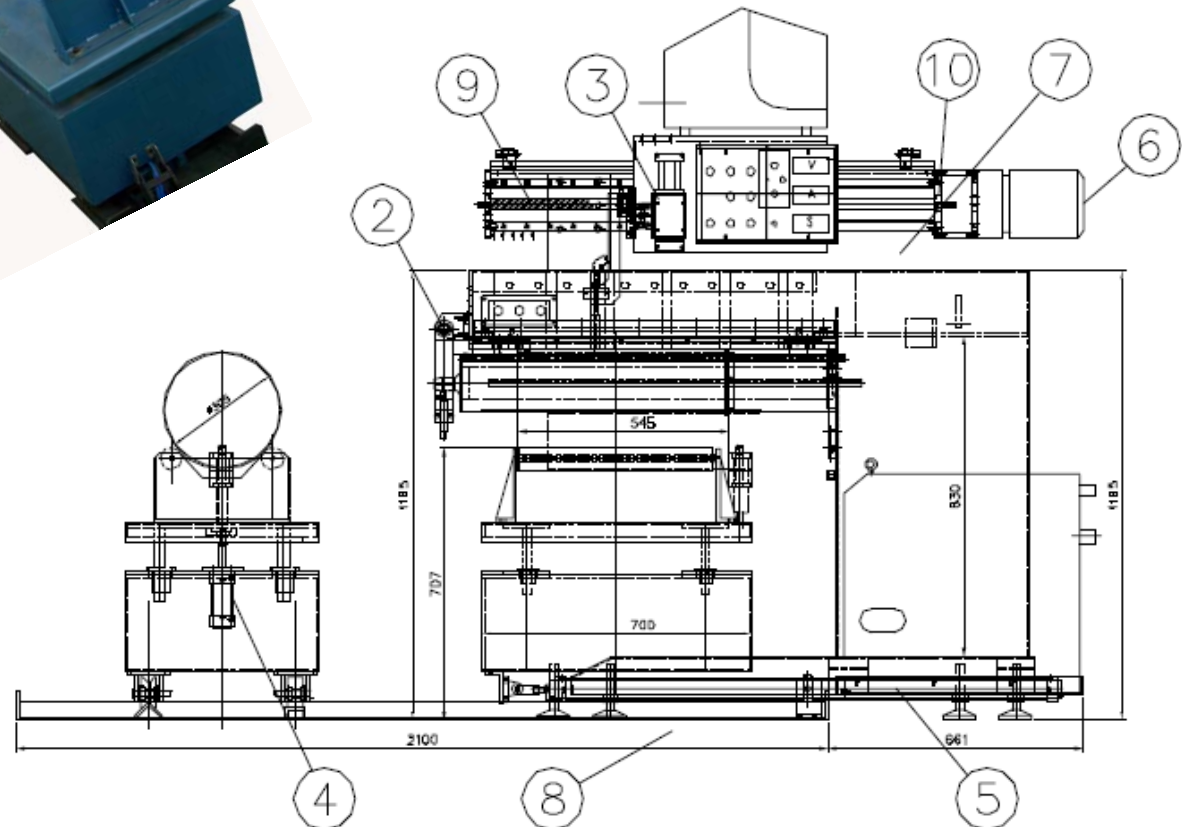
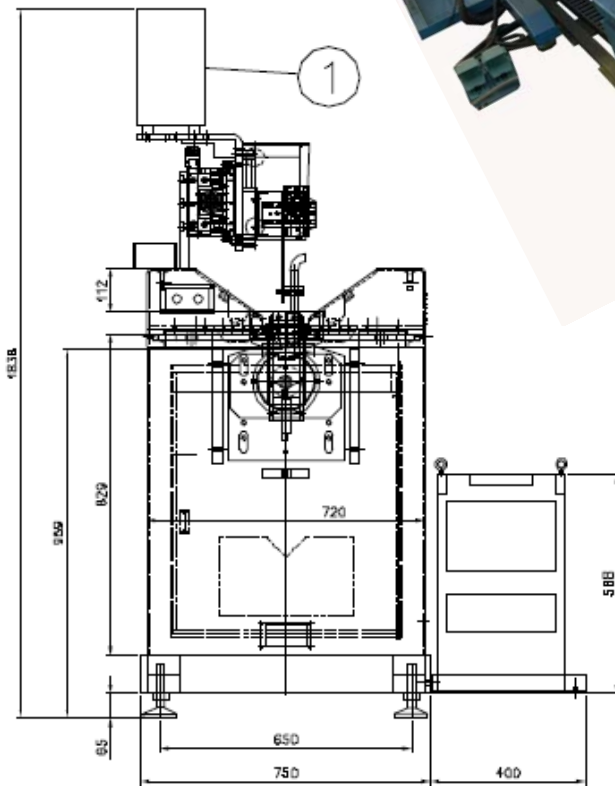
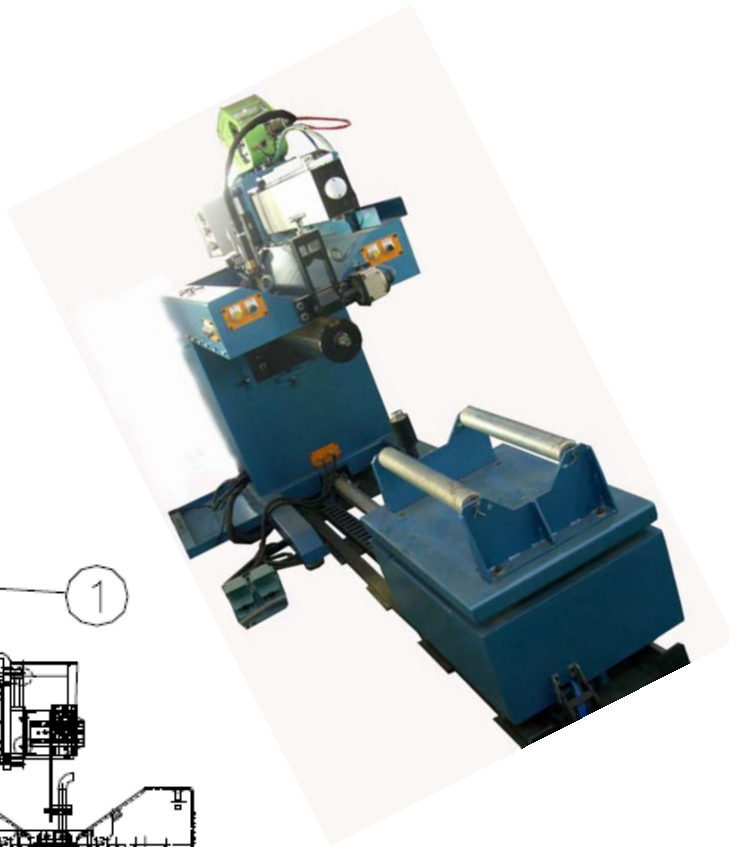
Hi-Weld Enterprise Co., Ltd.



直線銲接設備說明



HWLS-07C















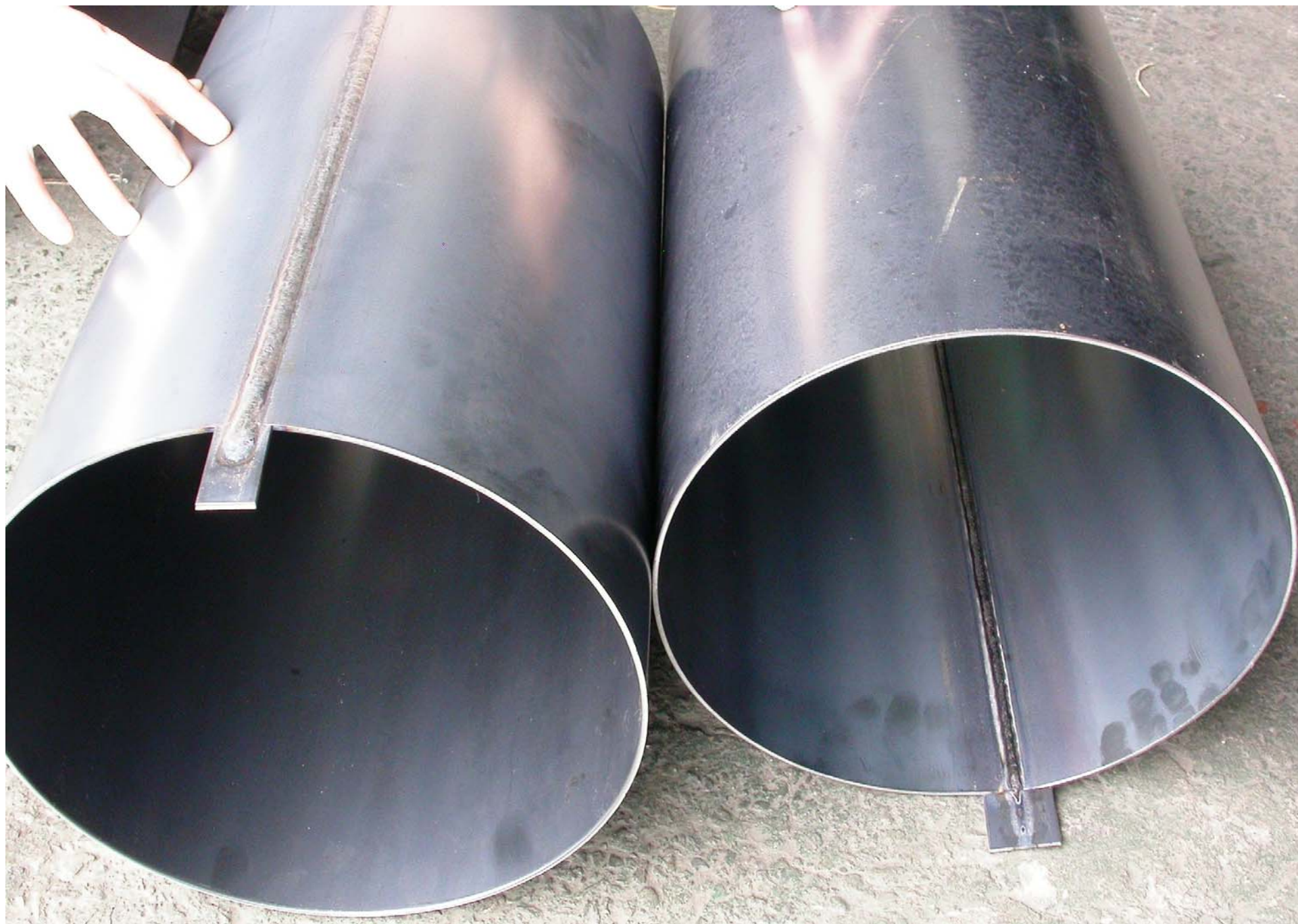


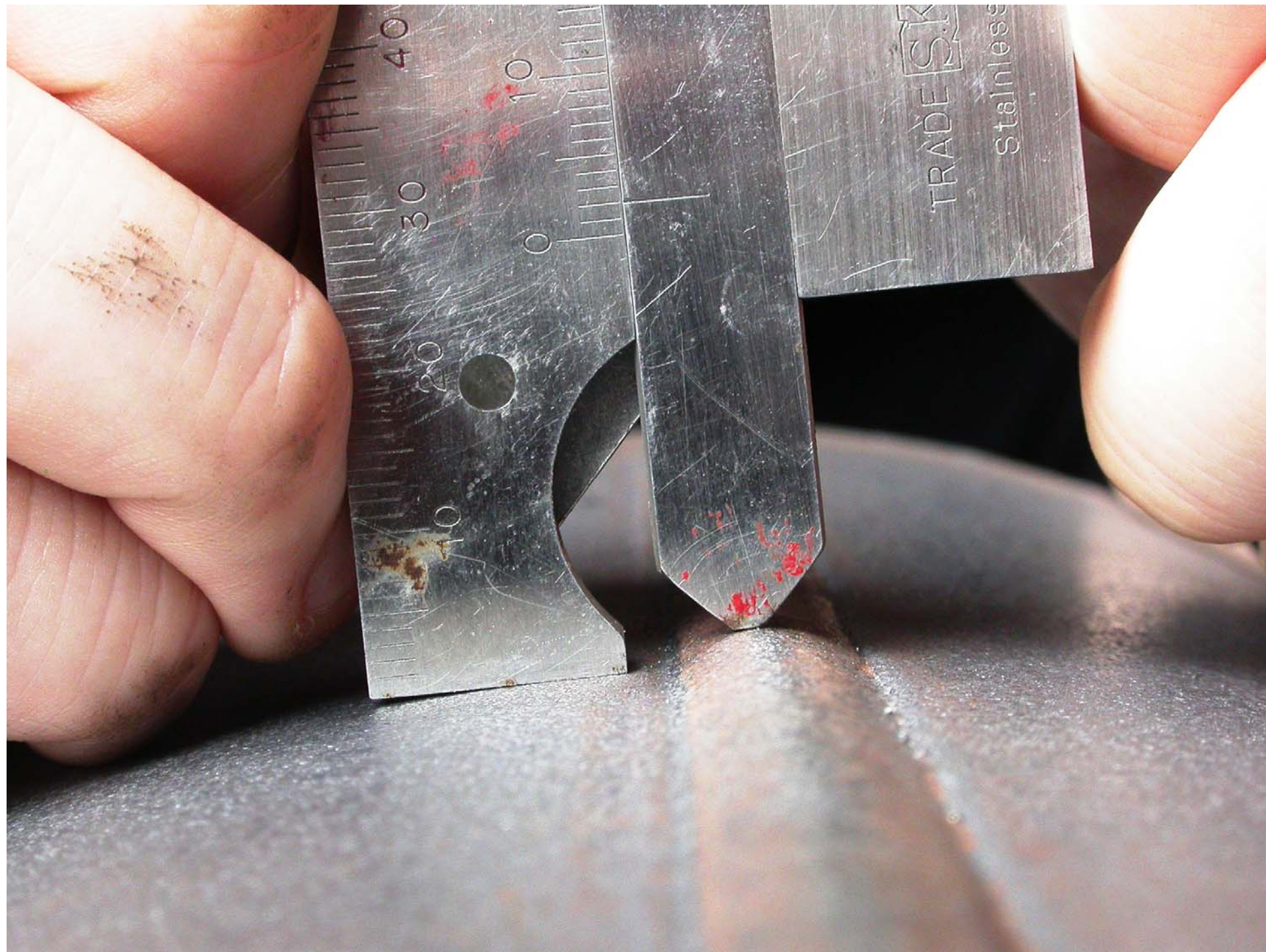
Hi_weld Hi_weld Hi_weld Hi_weld Hi_weld Hi_weld Hi_weld











Backing condition

北月鉾通

北月鉾通





28x945x545 x149H
T659143-(8)





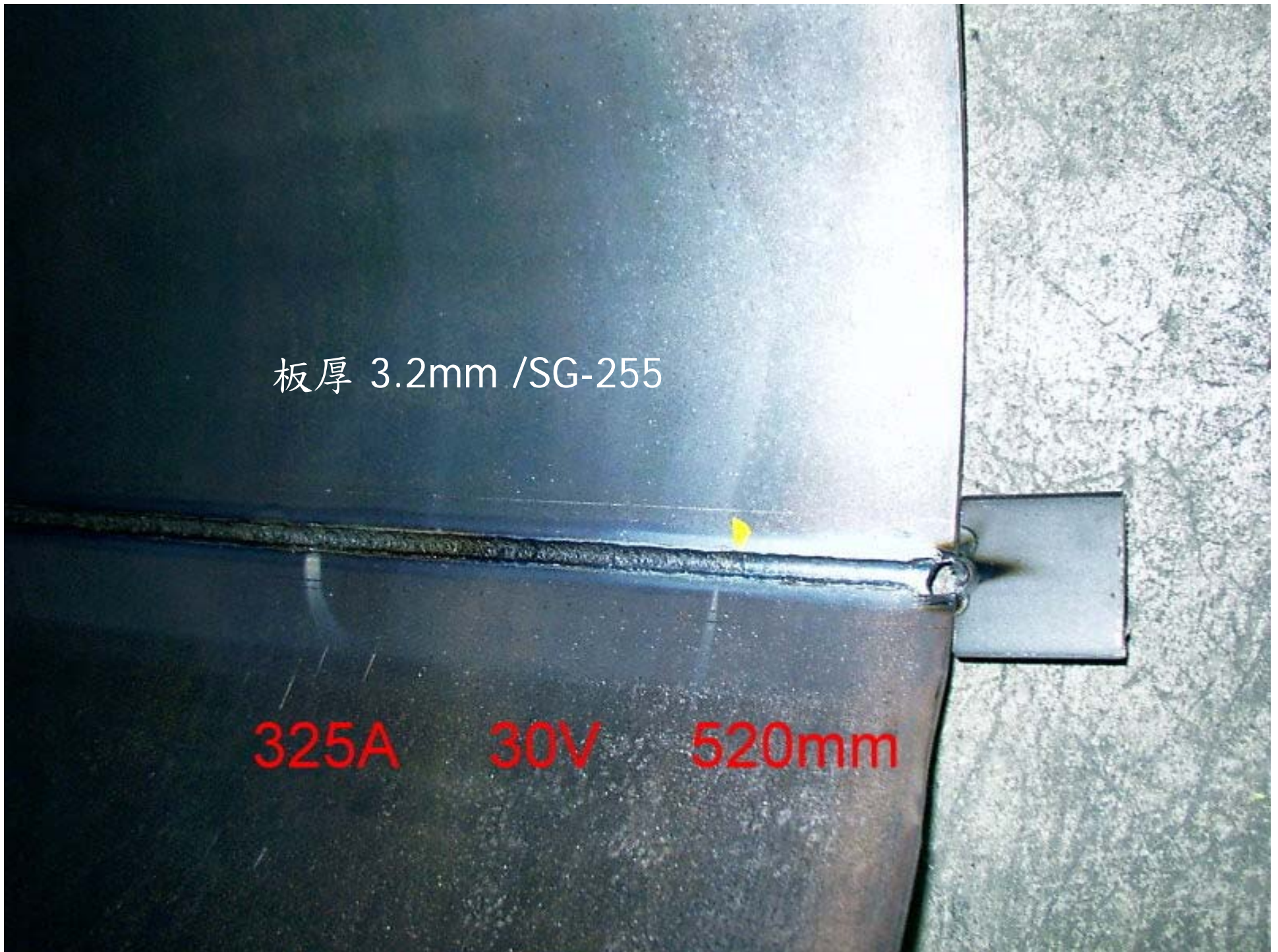
45/50KGS LPG BOTTLE :1.2M SEAMER

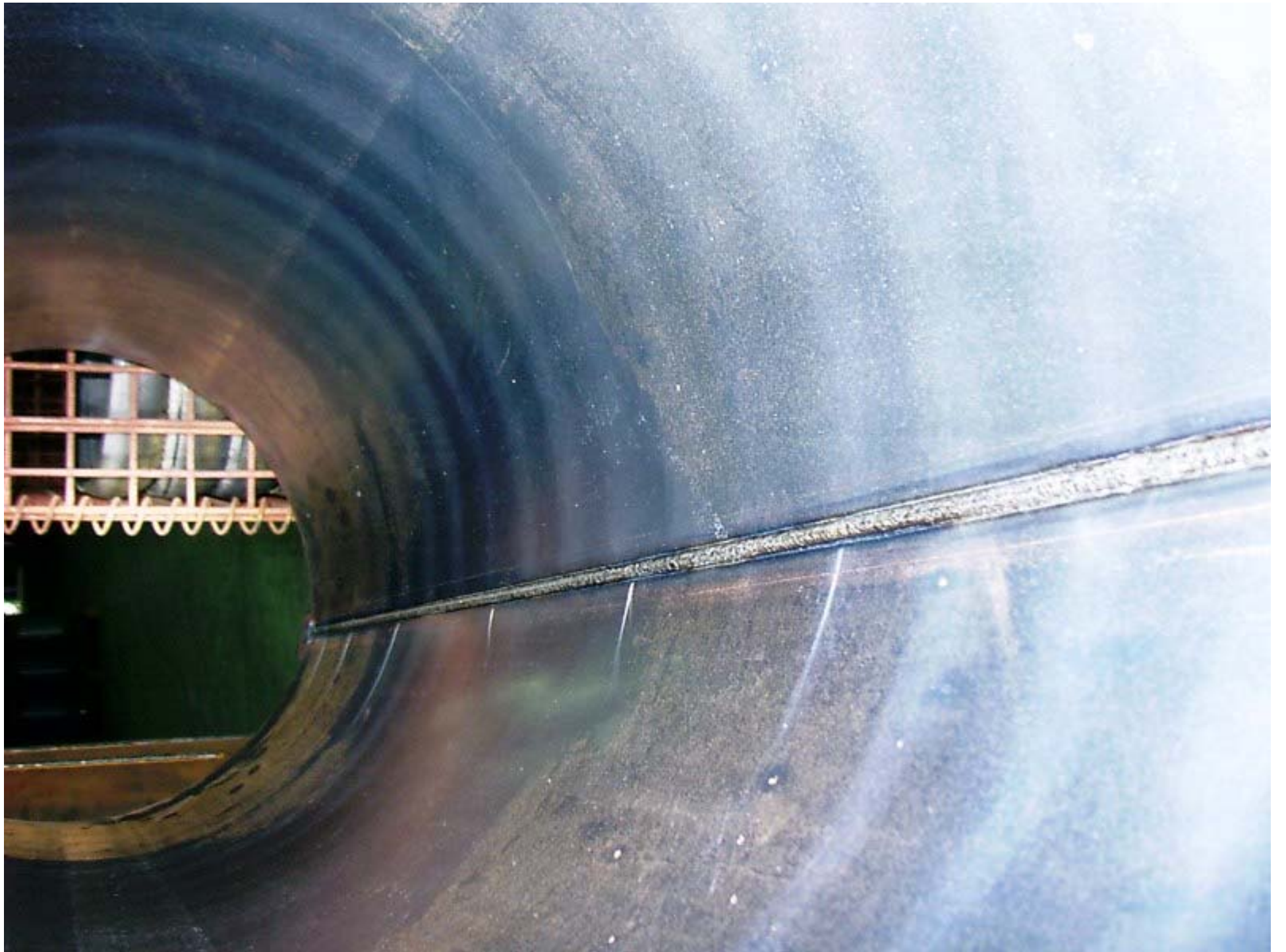




板厚 3.2mm /SG-255

325A 30V 520mm



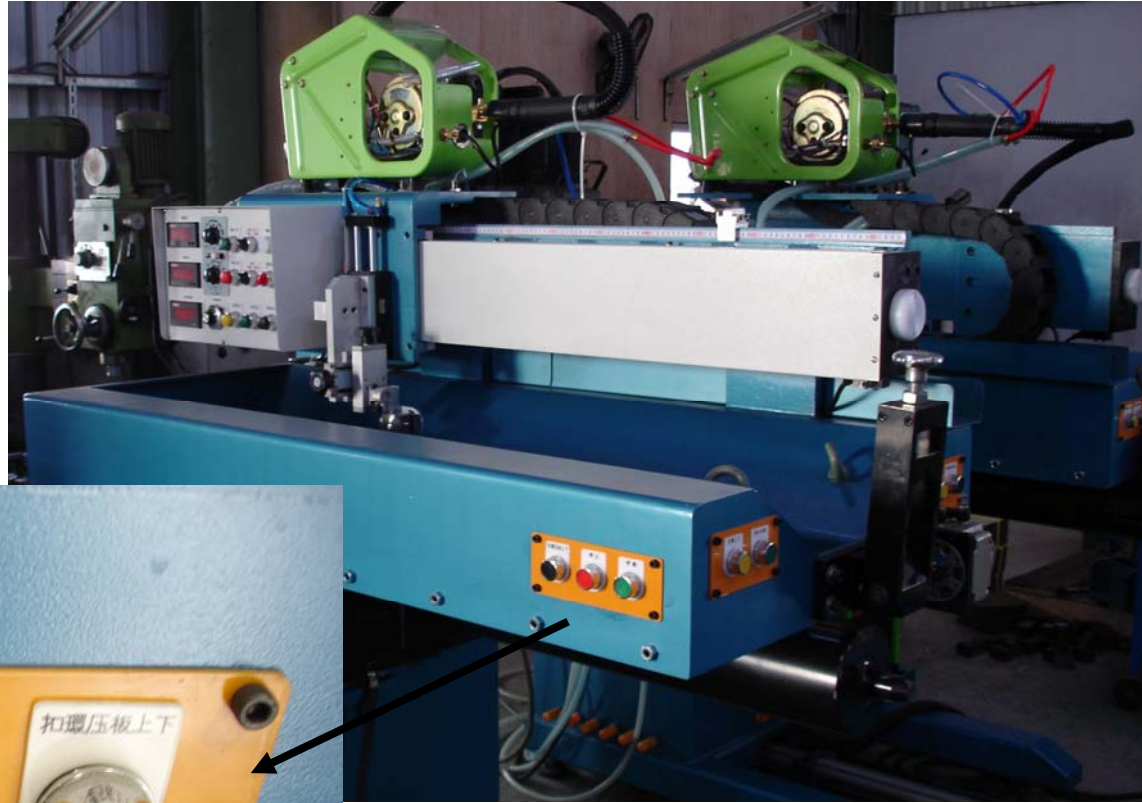


直線銲接機控制面板

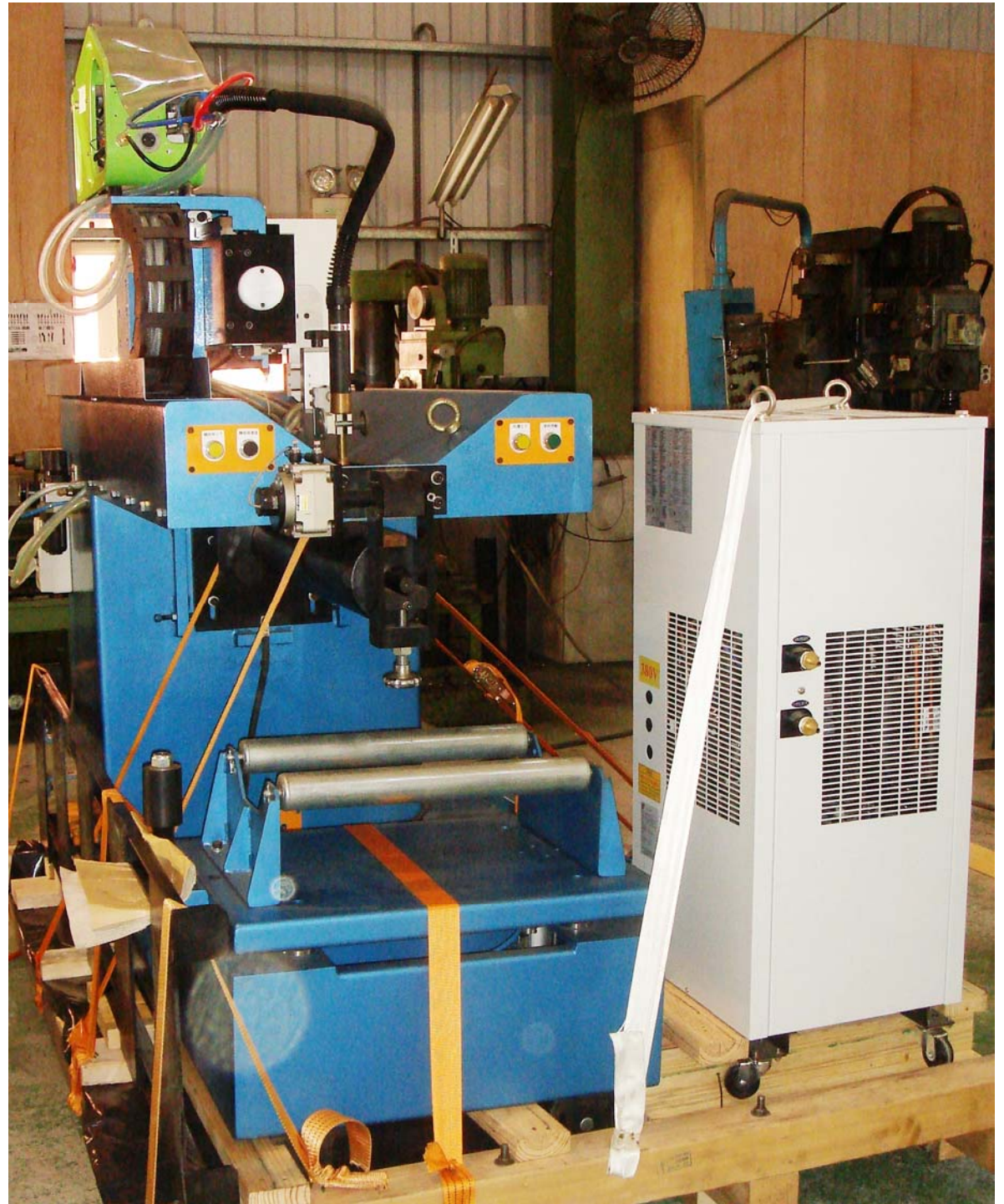


J3 按鈕





出貨



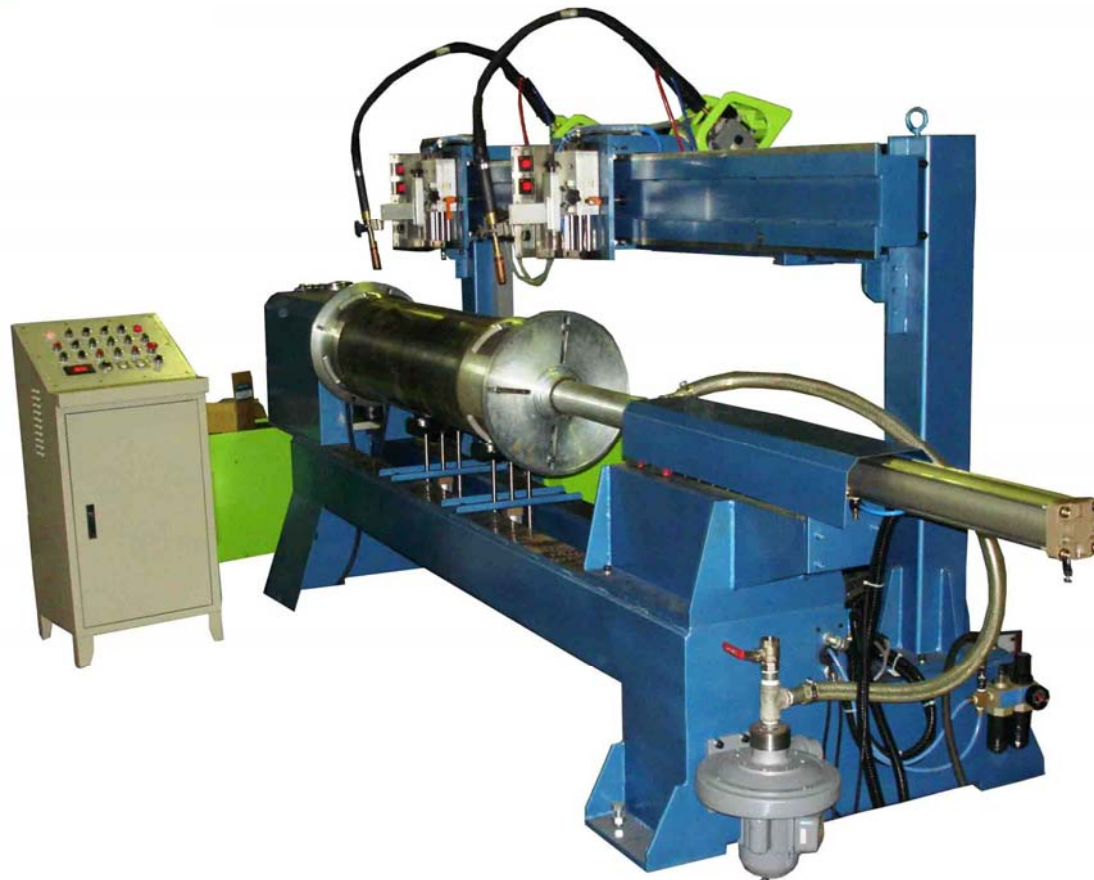
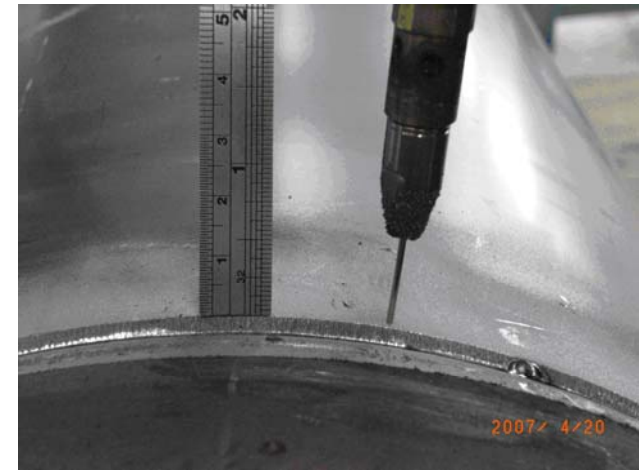
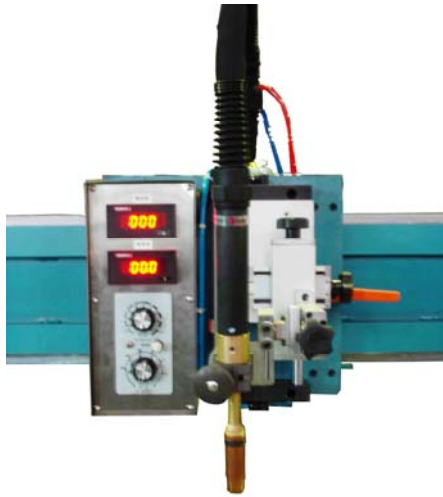


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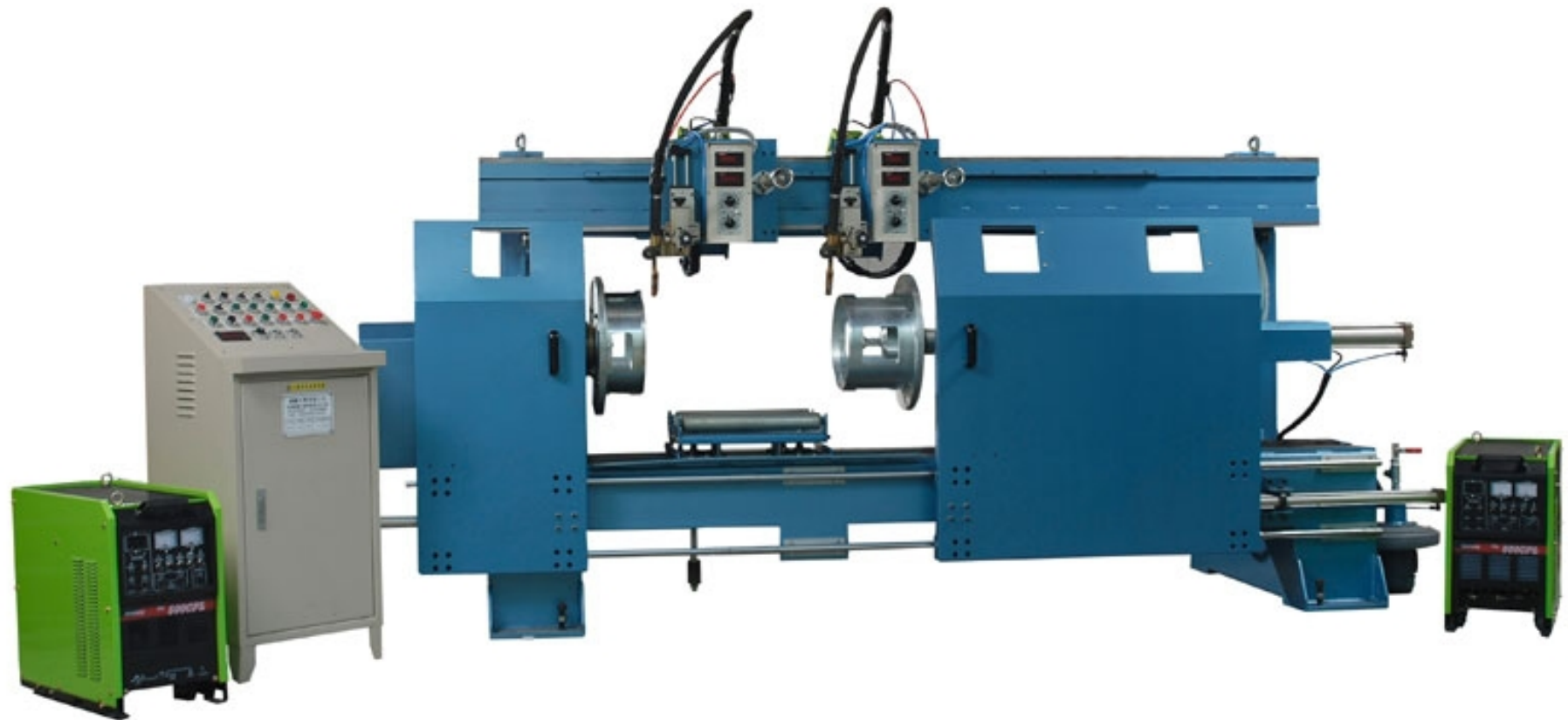
Hi-Weld Enterprise Co., Ltd.

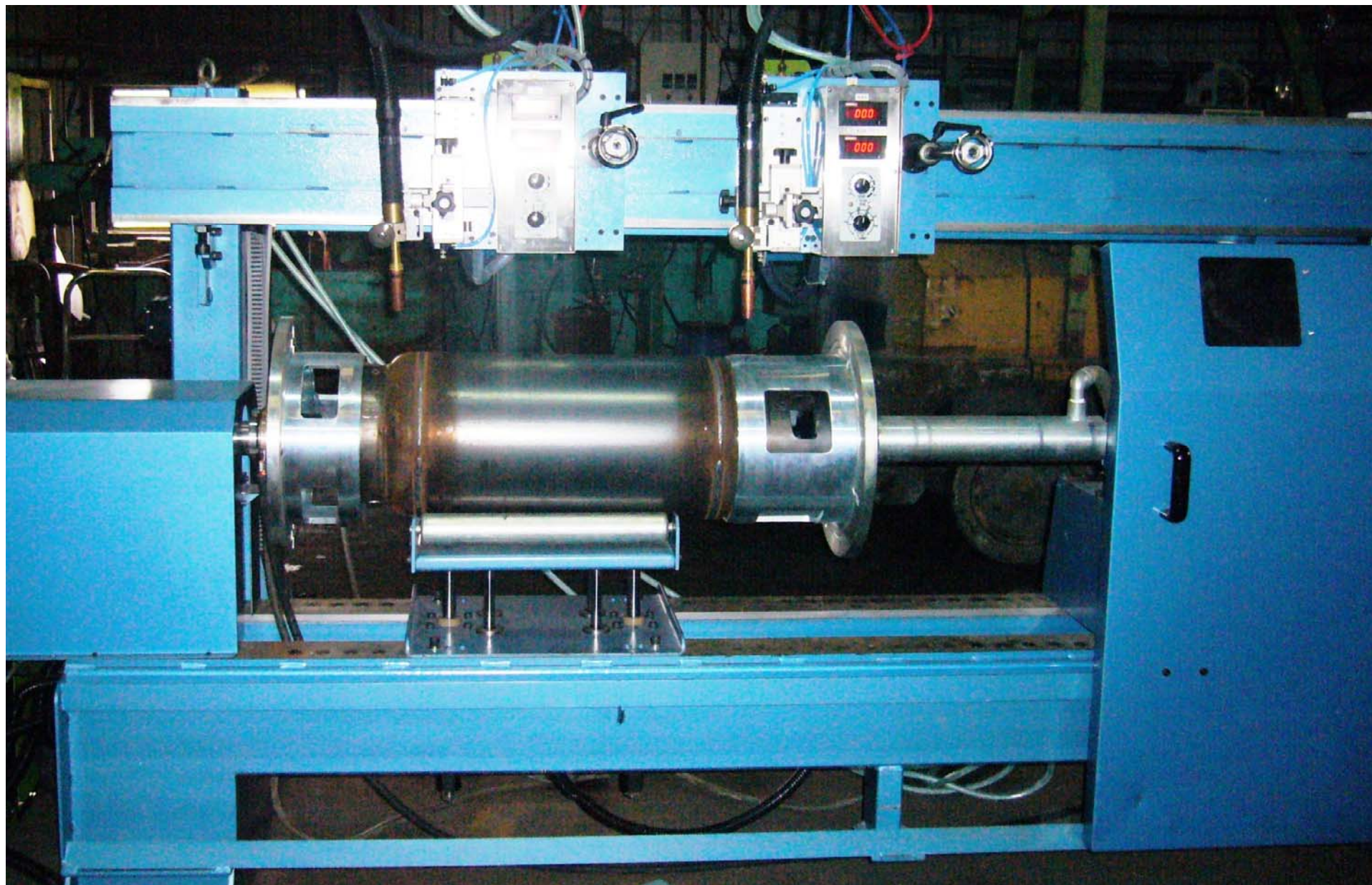
LPG Bottle c-line welder





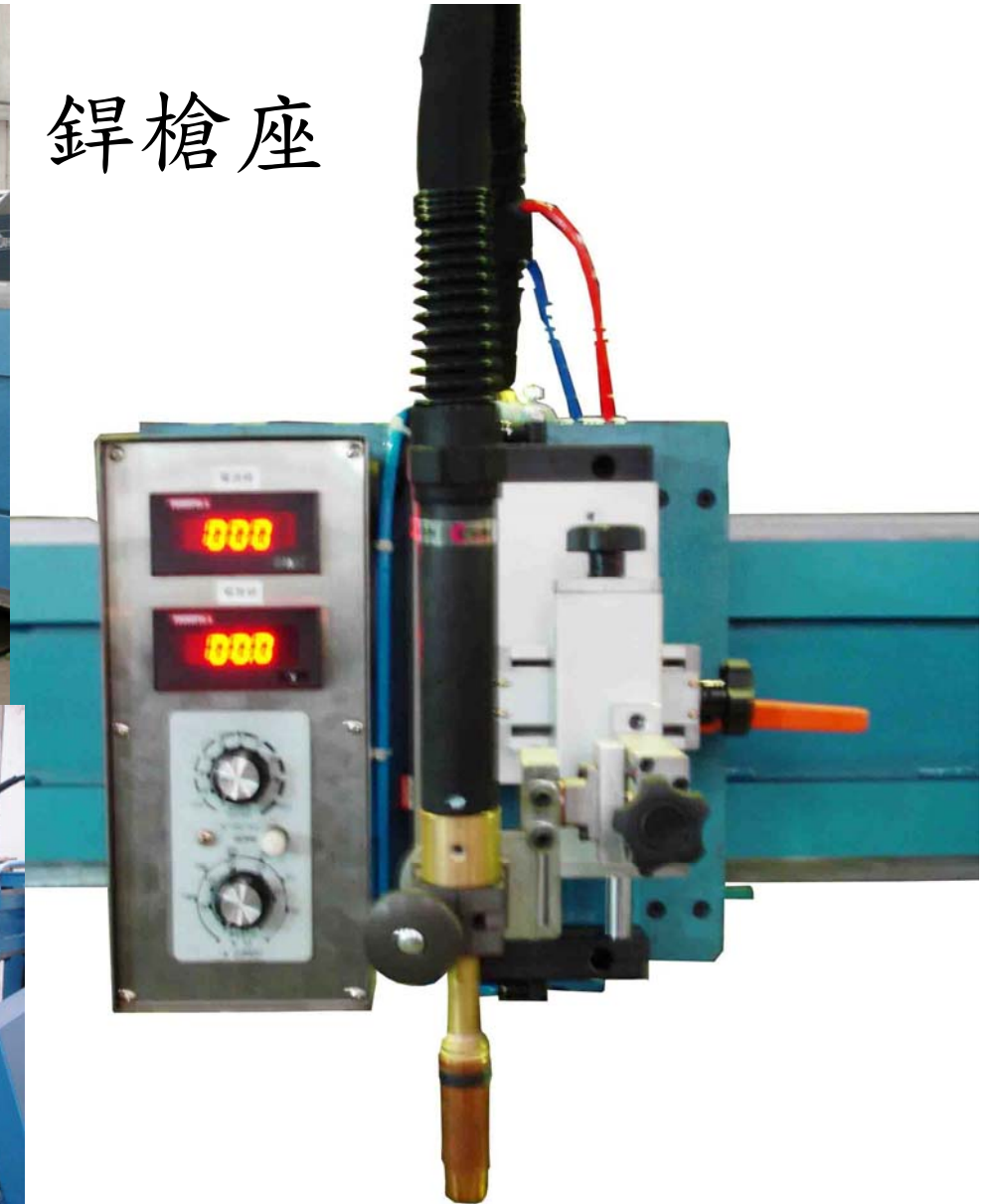
20kg臥式圓周鉚接機:HWL-100







鐸槍座



20kg臥式圓周銲接機控制面板











Handle bar



Nipple



配件銲接設備說明



Base ring





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Hi-Weld Enterprise Co., Ltd.

LPG Bottle: 上端蓋口基銲接

Nipple welder

設備用途:20Kg 口基銲接.
機器型號:HWVP-3



電源指示

焊槍下降

焊槍上昇

電源開關
OFF ON

压缸下降

压缸上昇

焊机
試驗 熔接

轉盤正轉

轉盤反轉

轉盤原點復歸

啓動

停止



熔接速度



轉盤延遲啟動時間



電壓錶



電流錶



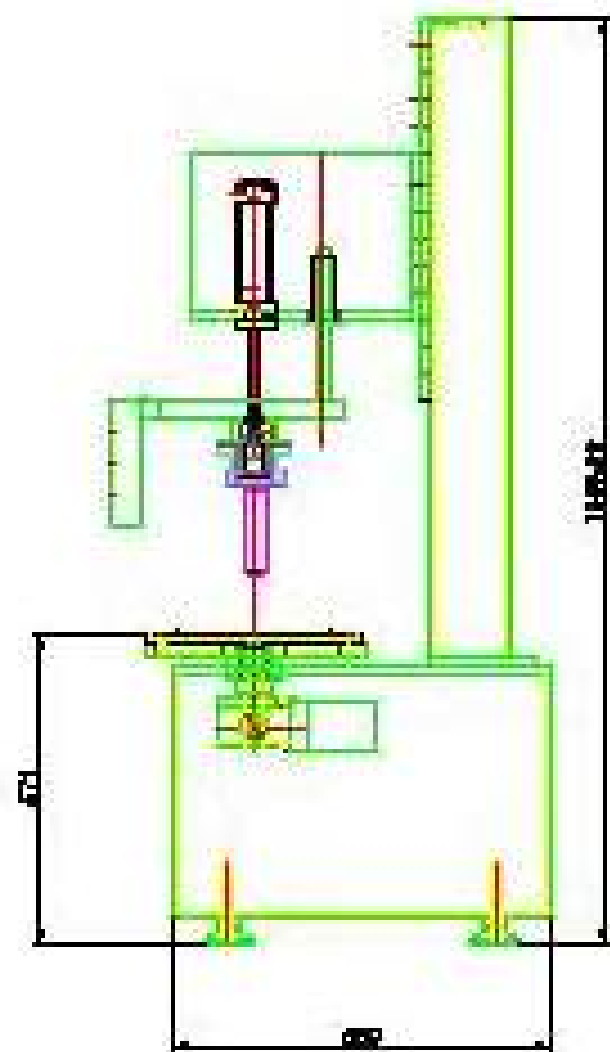
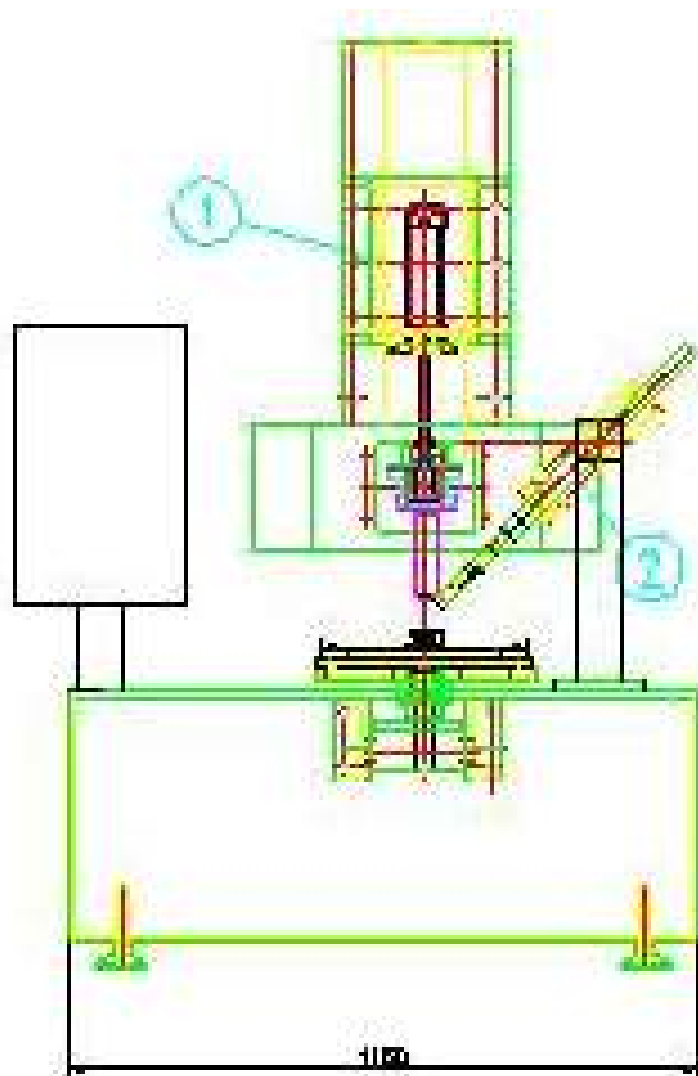
轉盤速度錶



重疊時間



平台式鐳接台





設備用途:口基銲接.





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LPG Bottle: 上端蓋護圈銲接

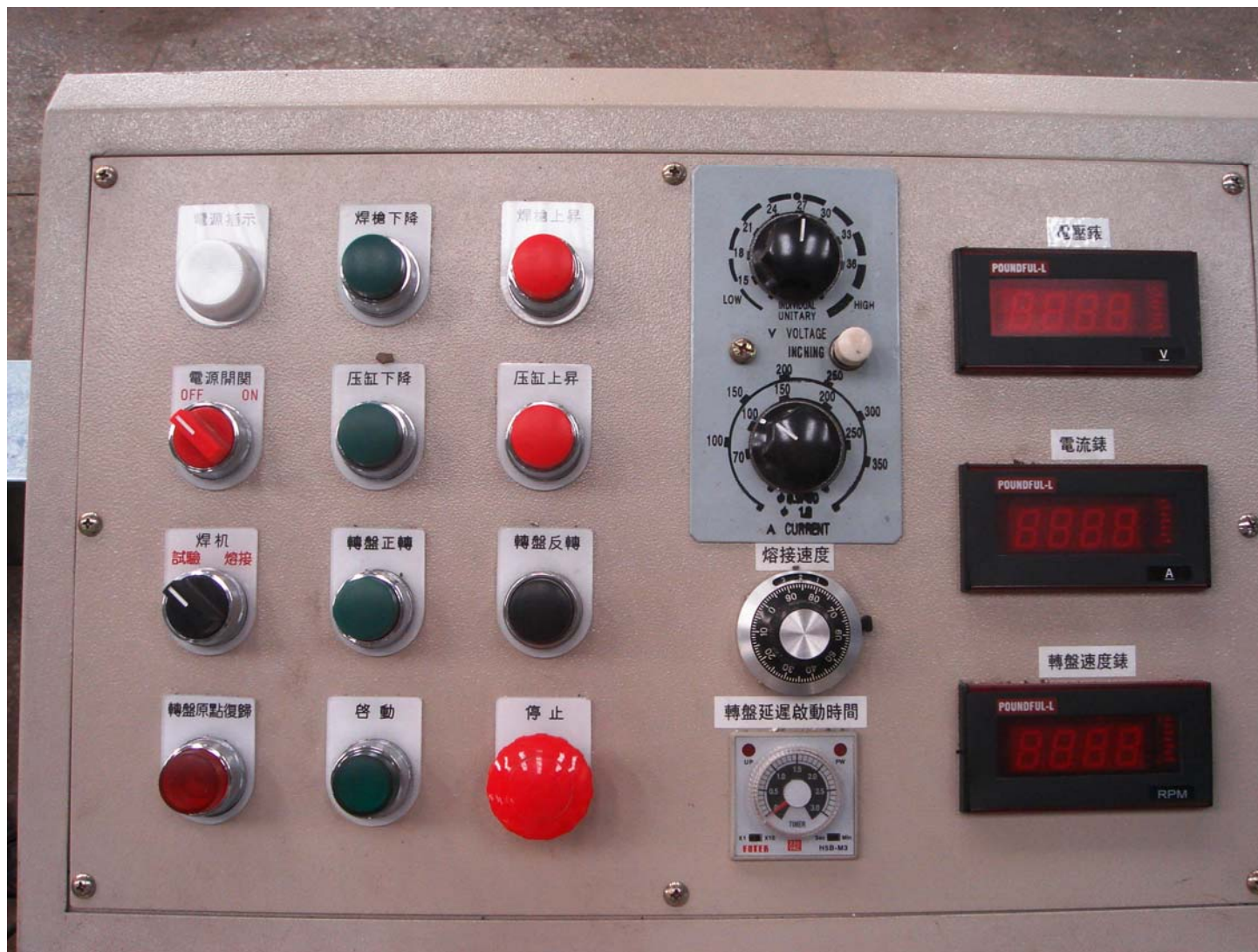
Handle Bar

設備用途:20Kg
護圈銲接.
機器型號
:HWVP-3B-1.





20Kg 護圈銲接控制面板 (三段銲接靠下模塊方式定間隔)





設備用途：護圈鉚接。





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Hi-Weld Enterprise Co., Ltd.

LPG Bottle: 下端蓋鋼裙銲接.

Base ring

設備用途:20Kg 鋼裙銲接.

機器型號:HWVP-3B-1.



20Kg 鋼裙鉚接控制面板(1)



20Kg 鋼裙銲接控制面板(2)



電源指示

焊槍下降

焊槍上昇

電源開關
OFF ON

压缸下降

压缸上昇

焊机
試驗 熔接

轉盤正轉

轉盤反轉

轉盤原點復歸

啓動

停止



熔接速度



轉盤延遲啟動時間



電壓錶



電流錶



轉盤速度錶



重疊時間





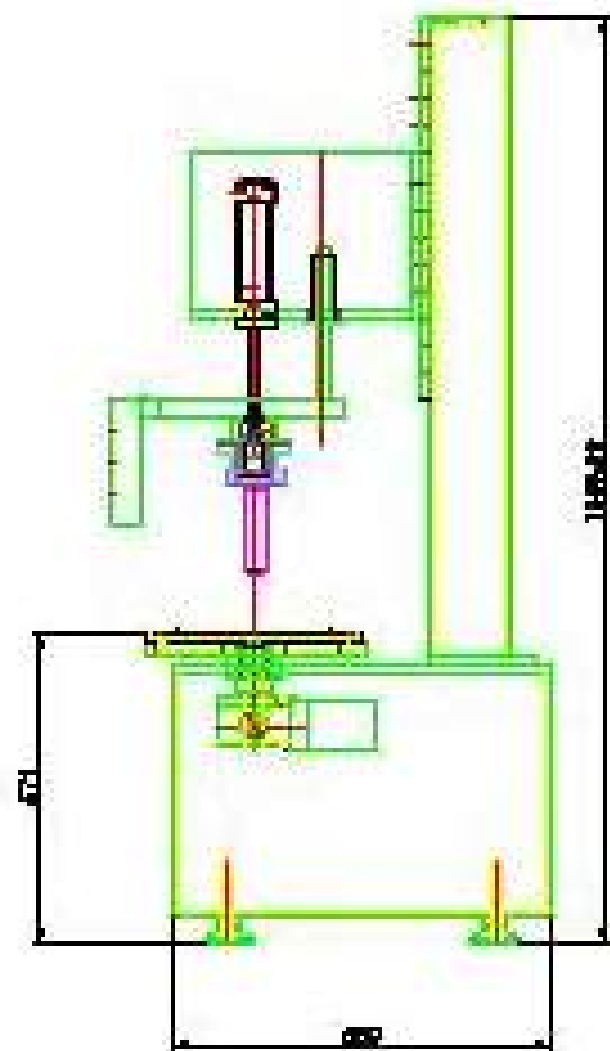
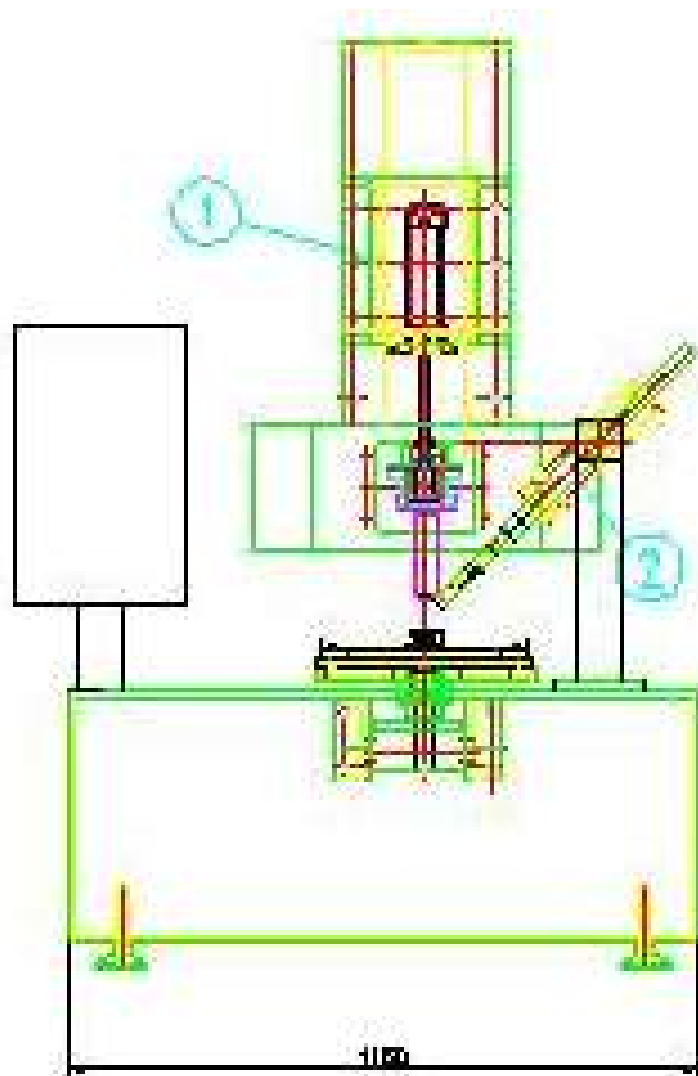
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Hi-Weld Enterprise Co., Ltd.

LPG Bottle: 下端蓋鋼裙(底圈)銲接.

Base ring

平台式鐳接台





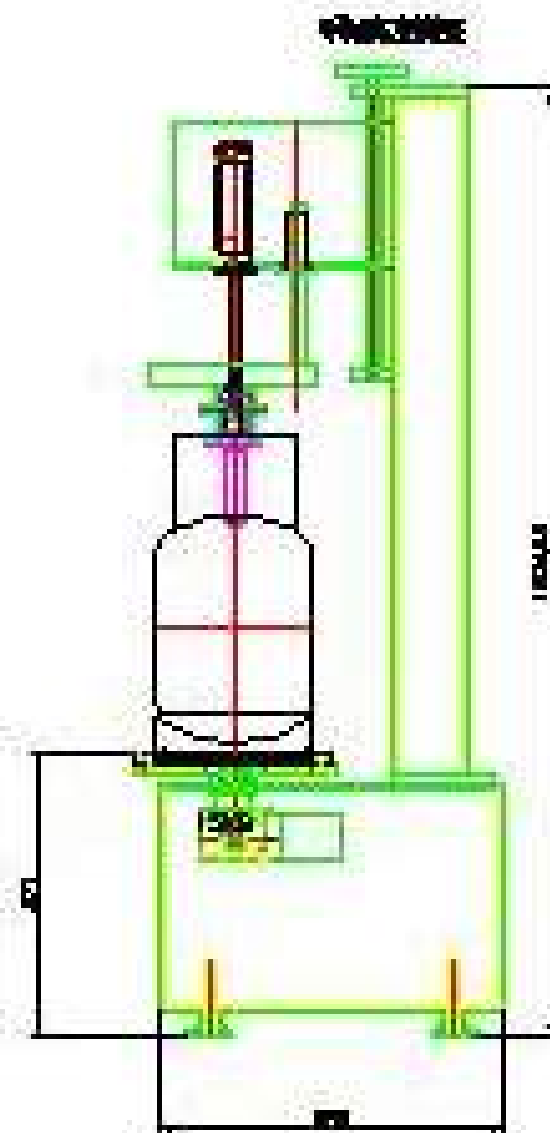
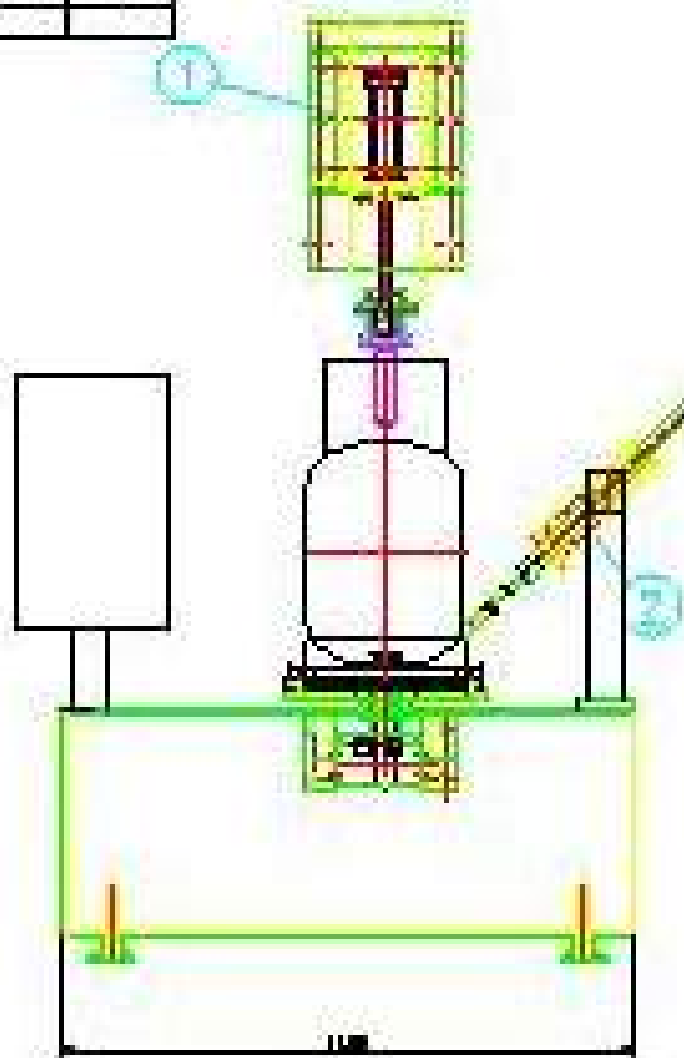
9Kg 鋼裙(底圈)



9kg 鋼瓶

序號	名稱	單位
1	主機-PLC	台
2	主機-PLC	台
3	主機-PLC	台
4	主機-PLC	台
5	主機-PLC	台

立式機台



主控制箱安裝至工作平台上.

--PLC 控制+人機介面控制.

--針對各式不同鋼裙銲接位置可進行預設與記憶功能.

--原點復歸功能