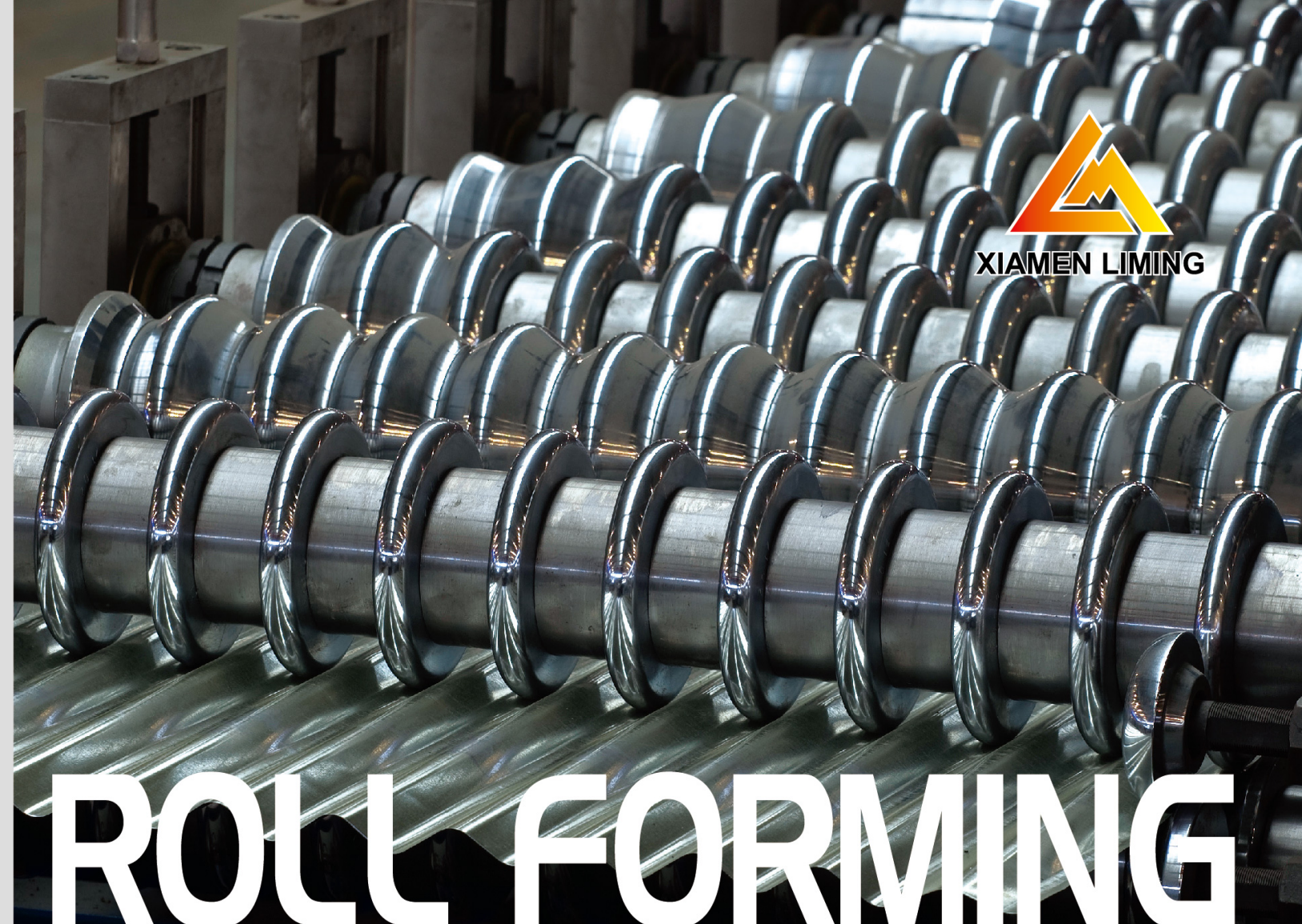




XIAMEN LIMING ROLL FORMING

XIAMEN LIMING MACHINERY CO., LTD.
XIAMEN ZHENG LIMING METALLURGICAL MACHINERY CO., LTD.



XIAMEN LIMING

厦门正黎明冶金机械有限公司

厦门黎明机械有限公司

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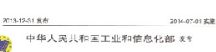
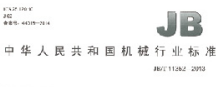
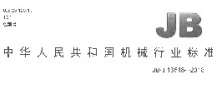
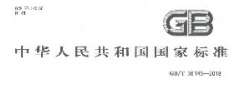
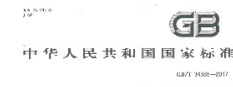
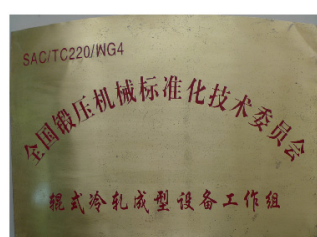
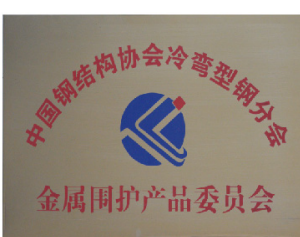
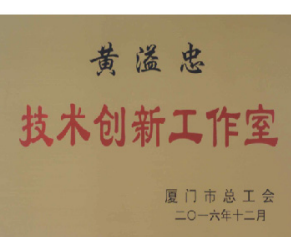
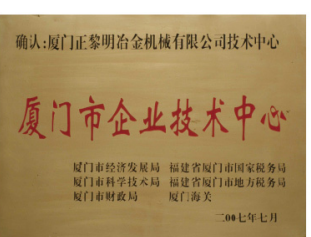
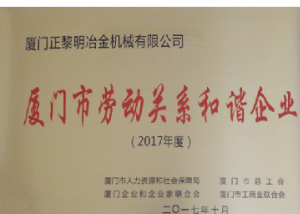


厦门正黎明冶金机械有限公司
厦门黎明机械有限公司

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公司简介

Introduction

厦门黎明机械有限公司（厦门正黎明冶金机械有限公司），1989年创建于风景优美的鹭岛——厦门，占地面积10万多平方米。作为国内首家专业从事制造金属板冷轧（辊轧冷弯）成套成型设备的厂家，经过二十余年的不断发展，凭借现代化的管理理念、强大的科研技术、先进的生产工艺、完善的服务体系，黎明已成为装备制造行业中最具有影响力的企业之一。

公司注重原有产品的不断改进和新产品的研发，成立市级企业技术中心，容纳了近百名的各类专业技术人才，目前已获得近50项专利。黎明不仅通过ISO9001—2008质量管理体系认证，而且在行业公认的道德规范和标准审定中荣获AA信用等级，成为集“设计、研发、生产、销售、服务”为一体的成长型高新技术企业。

黎明注重品牌建设，荣获“福建省名牌产品”、“用户满意产品”和“第四届中国冷弯型钢技术设备优质奖”，目前已成功地在88个国家登记注册“LM”商标，此外许多产品已通过CE认证。公司产品结构轻巧、设计合理、不断改进而备受钢结构行业青睐，使产品不仅畅销全国各地，而且远销亚洲、非洲、欧洲、南美洲、澳洲等一百多个国家和地区，形成了遍及世界各地的“LM”产品销售网络。

长期以来，黎明坚持“敬业、团结、创新、共赢”的企业精神，秉承“保质量，重信誉”的经营宗旨，为用户提供“产品开发设计、生产安装、调试培训、售后服务”一体化的优质服务，不断维护并扩大公司的影响力，同时我们愿与国内外同行携手合作，共同发展。

XIAMEN LIMING MACHINERY CO., LTD. (XIAMEN ZHENG LIMING METALLURGICAL MACHINERY CO., LTD.), covering an area of over 100,000 square meters, was founded in 1989 in a beautiful city—Amoy (XIAMEN). As one of China's first manufacturers specialized in research & development of various cold rolling mills / roll forming lines and subsidiary machinery, through persistent development for more than 20 years and with the modernized administration, vigorous scientific research technology, advanced manufacture technics as well as perfected service system, LIMING has developed into one of the most influential companies in the manufacturing industry of cold rolling mills / roll forming lines.

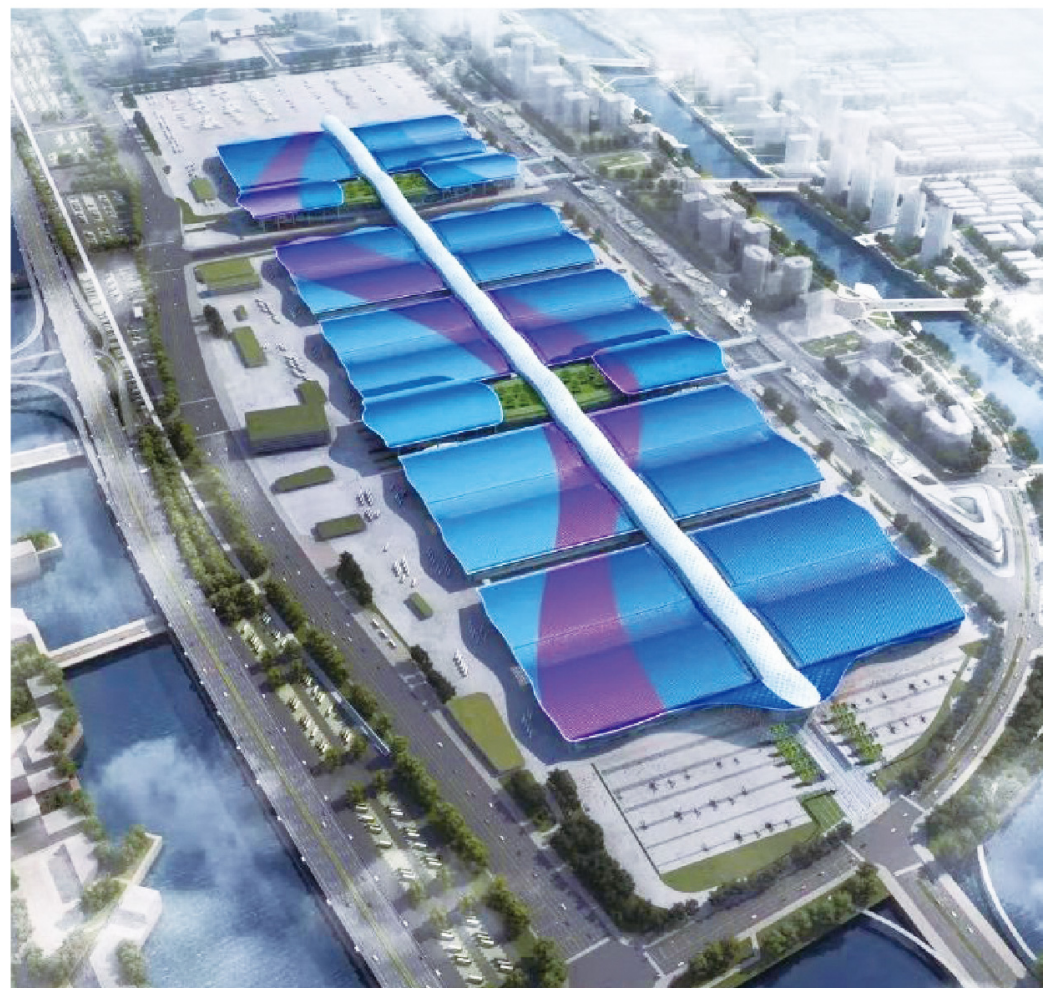
As we pay great attention to keeping improvement to the current products as well as developing new ones, we founded an enterprise technology center of city level, attracted hundreds of professionals, and have achieved 50 patents by now. Not only passing ISO 9001-2008 quality control system authentication, but also achieving the AA credit level in the generally-recognized ethic and standard evaluation, LIMING has become a HI-TECH enterprise integrated with “design, R & D, manufacture, sales and service”.

LIMING has been making great effort to build up its brand, and has successfully been registered as “LM” label in 88 countries so far. Our machinery has been awarded the “famous-brand product” and “user-satisfying products” in China, and many products have gone through CE Certification. With the advantages of being light structure, reasonable design and updating styles, LIMING products sell well not only in domestic market but also more than one hundred countries and regions in Asia, Africa, Europe, South America, Australia, etc, formed into LIMING' special sales network throughout the world.

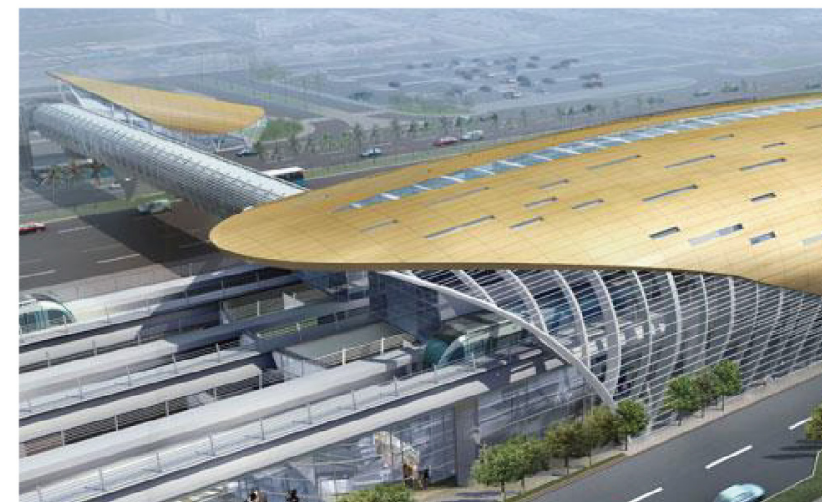
Since founded, LIMING has been persevering with “commitment, comity, creativity, win-win” as the company's spirit, and taken “quality assurance” & “reliable reputation” as its business principles. We provide clients with excellent and integrative services consisting of development & design, manufacturing & installation, and testing & training. We sincerely hope to strengthen business relations with friends both at home and abroad to create a more brilliant future.



北京大兴国际机场



深圳国际会展中心



阿联酋迪拜地铁工程



澳门北安码头工程图



伦敦奥运场馆



上海浦东机场T2航站楼（白天）



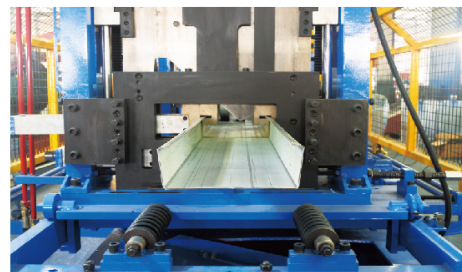
刚果布拉柴维尔机场



武汉绿地中心



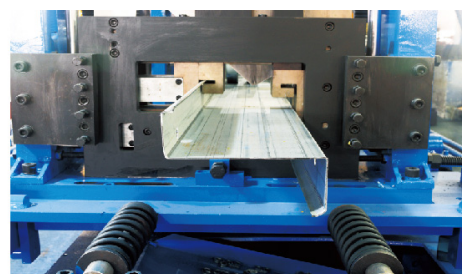
全自动C/Z互换一体机 Auto Size-changing C/Z Purlin Machine



本机是辊压成型C/Z型檩条的专用设备，采用单边架体固定，另一边架体无极调整。单C单Z可以采用自动换型，C/Z互换也采用自动换型。檩条的腹板宽度与腰高的调节，通过手动控制按钮达到自动换型/或者输入参数进行自动换型的目的（仅限于C范围之内或Z范围之内）。配备前剪（剪料头料尾）、前切断、万能剪。前冲孔系统，手动换型。

板型参数：板厚度范围1.5-3.0mm，C型腹板宽度C100-300mm，腰高40-100mm/Z型腹板宽度Z120-300，腰高50-100mm。

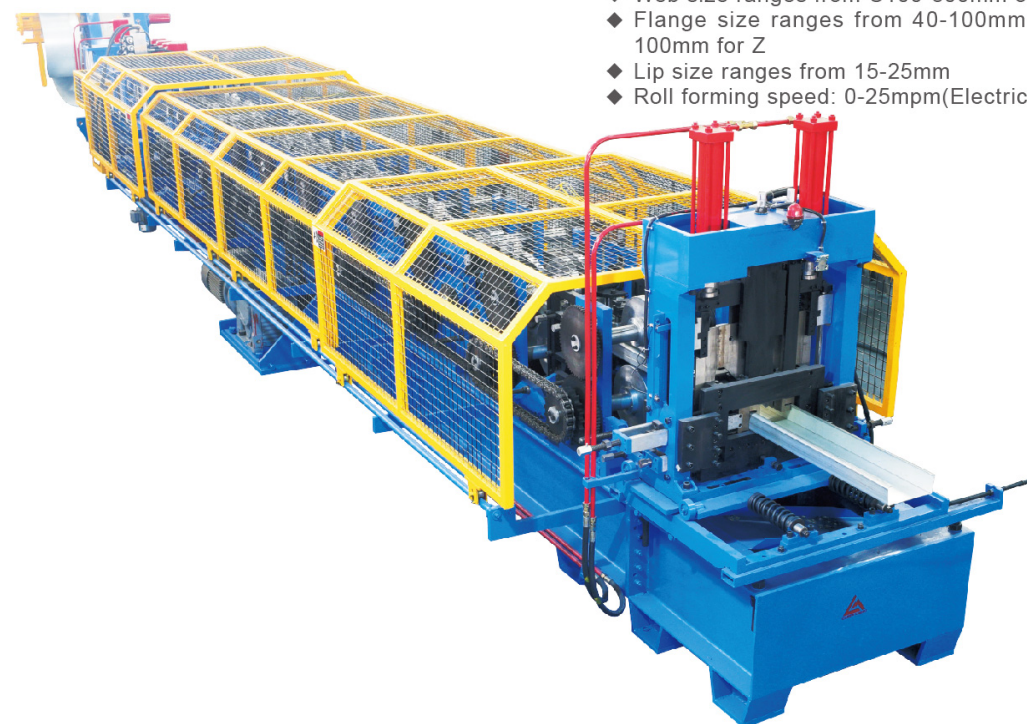
最大成型速度：0-25米/分钟（电机传动）。



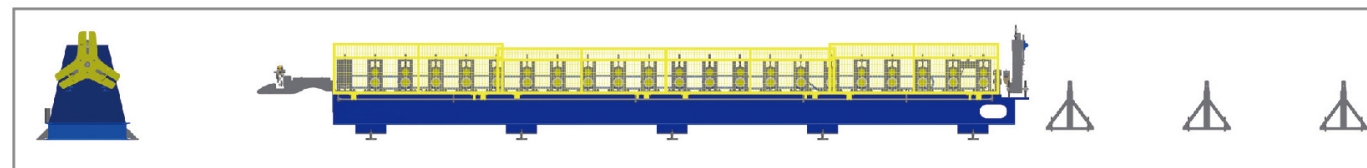
This machine is designed for the purpose of Automatic size-changing via one side fixed and the other side freely adjustable within C100-300 or Z120-300. Change between C and Z, Web and Flange freely adjustment is available by pushing button/or input data in touch panel to achieve. Shearing is equipped with pre-shear and post shear which is fixed size blade design or free size blade design as per customer requirement. Pre-punching is to be changed by manual handling.

Profile Parameters:

- ◆ Thickness: 1.5-3.0mm, 345mpa
- ◆ Web size ranges from C100-300mm or Z120-300mm
- ◆ Flange size ranges from 40-100mm for C, and 50-100mm for Z
- ◆ Lip size ranges from 15-25mm
- ◆ Roll forming speed: 0-25mpm(Electric Motor driven)



工艺流程图 Producing Process Sketch



导轨式C/Z互换成型机 Mobile Guide-rail C & Z Purlin Machine

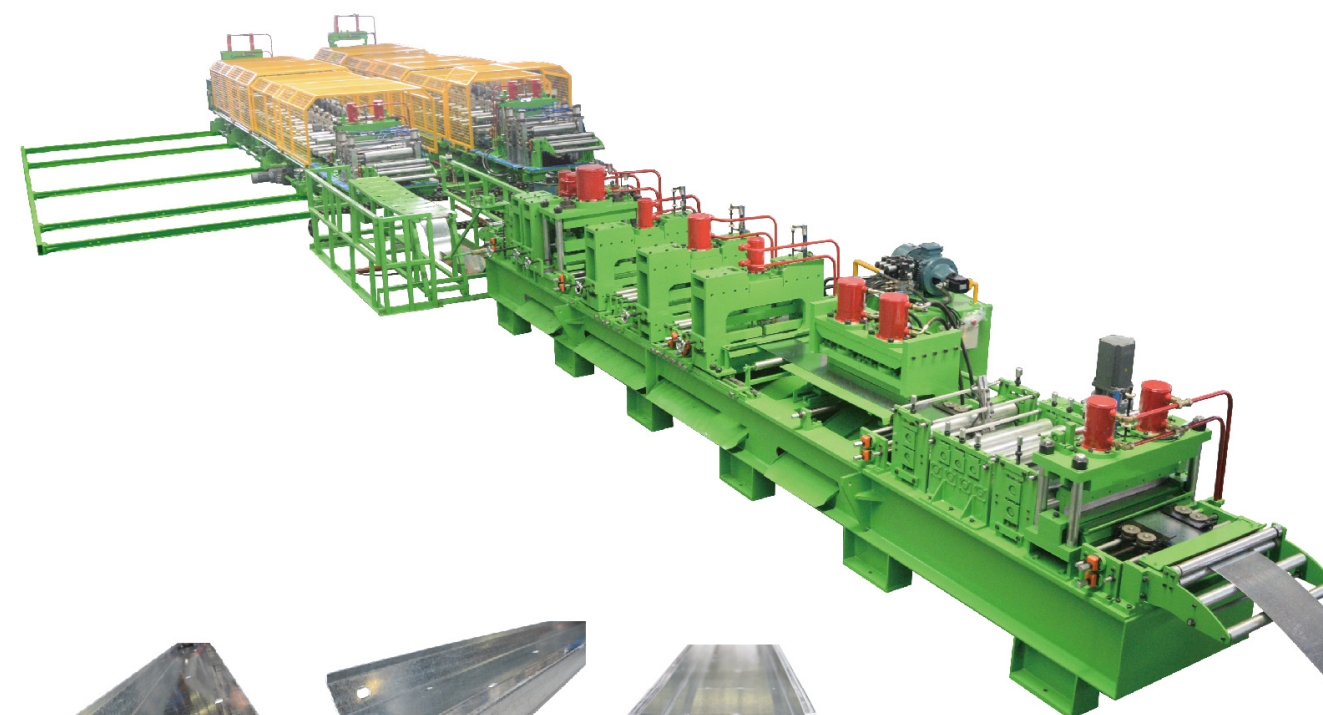


导轨式C/Z互换设备配置了独立的C型檩条成型机和Z型檩条成型机，通过轨道移动方式实现C/Z设备互换，C/Z换型无需调整辊轮，实现稳定檩条生产；同时配备了独立的伺服送料冲孔系统，提高冲孔效率及精度，伺服步进引送，配套了多套组合冲孔模具，保证了生产订单多样化，满足市场的不同需求。



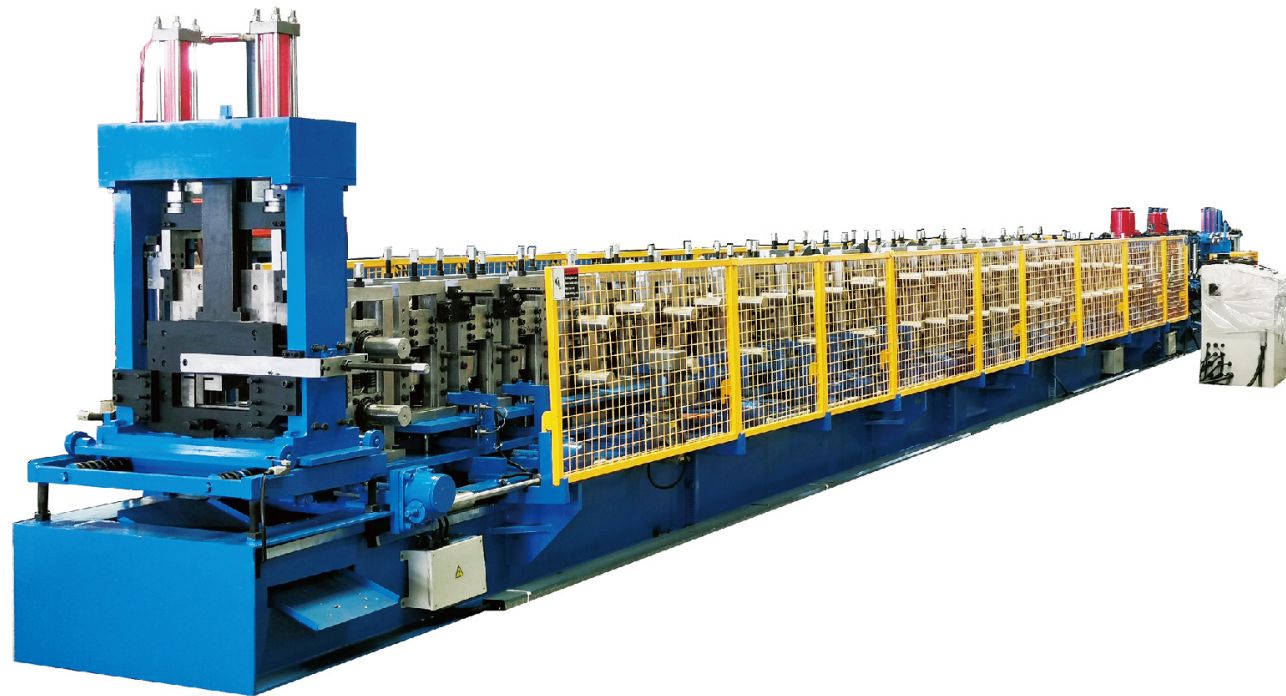
Mobile Guide-rail C & Z Purlin Machine:

- ◆ Including separate Auto Size-changing C purlin machine and Z purlin machine, sharing the same part - servo-feed punching system
- ◆ Features: working independently and on shift, one-button auto size-changing, high efficiency and accuracy with servo-inching feed
- ◆ Advantages: capable of meeting diversified order requirements and the changing market

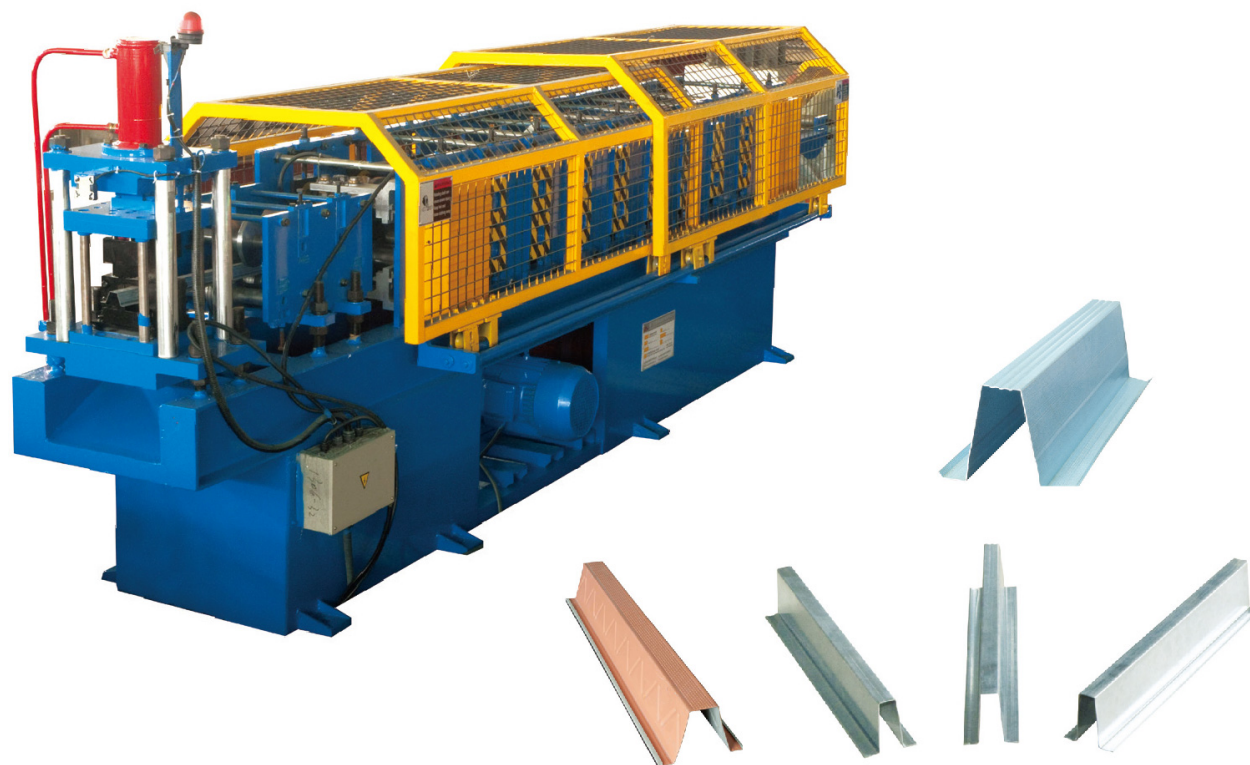




全自动几字型成型机 Auto Size-changing Roll Forming for Omega



龙骨机冷轧成型机 Cold Rolling Mills for Top Hat/Batten



MPA300轻钢龙骨系统成型生产线 Roll Forming Line for MPA300 Framing System Solution



本机为轻钢龙骨自动化生产线。采用前冲前剪以及自动换型的设计，配备先进的控制软件，将完整的系统转换为轻钢产品，并一步到位，从而实现“端到端”无缝式、无误差的钢结构解决方案。

板型参数：型号范围可实现从C75-C300，常用型号C75/C90/C140/C250。

板厚度范围：0.8-2.0mm，450-550mpa。

成型主机最高线速度：30m/min。

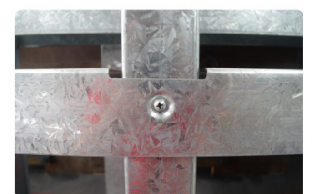
This machine is a fully complete line for framing system truss. Machine is designed with pre-punching/pre-cutting and automatic size changing and equipped with advanced Pro-CAD/Pro-CAM software by which Truss products are converted from to achieve an "end to end" seamless and error free solution to Steel Framing.

Profile Parameters:

Size range from C75-300, normal size C75/C90/C140/C250

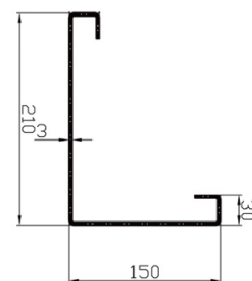
Thickness range: 0.8-2.0mm, 450-550mpa;

Maximum roll forming speed:30m/min

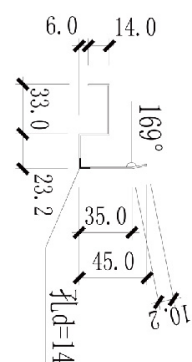




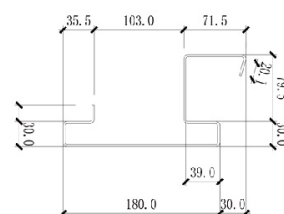
 立柱 YX150-210 Roll Forming Machine for Stiffener



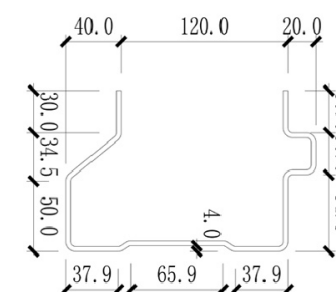
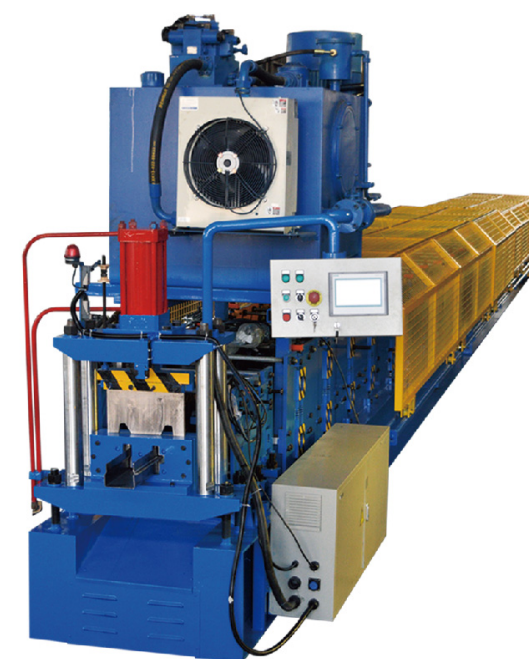
 **泛水槽 YX21-35** Roll Forming Machine for Gutter



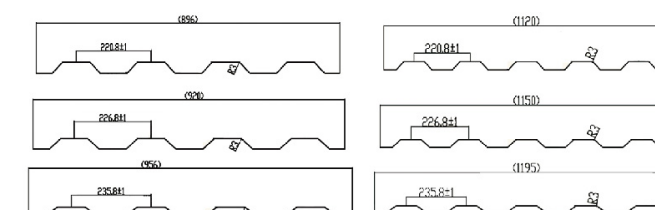
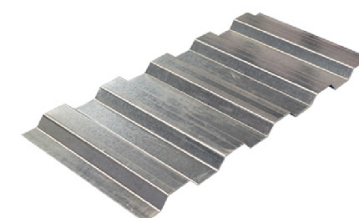
 **上梁 YX74-160** Roll Forming Machine for Top Beam

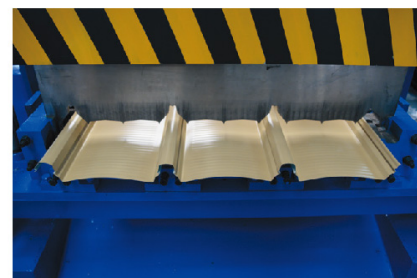
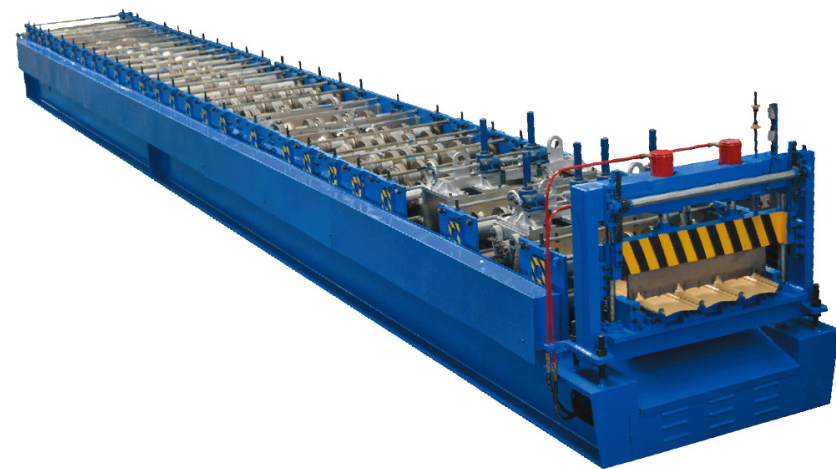


 **底梁 YX90-141** Roll Forming Machine for Bottom Beam

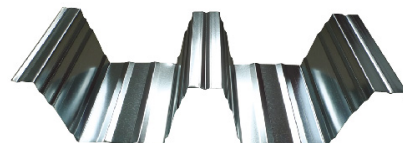
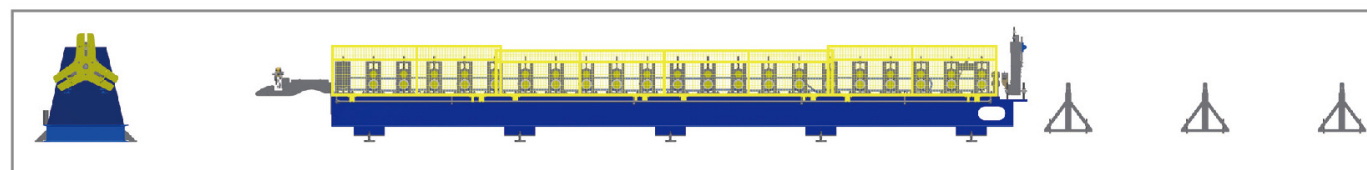
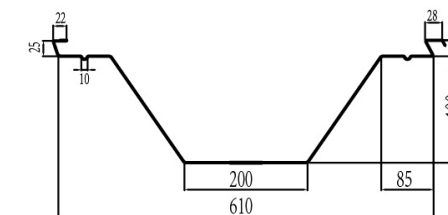
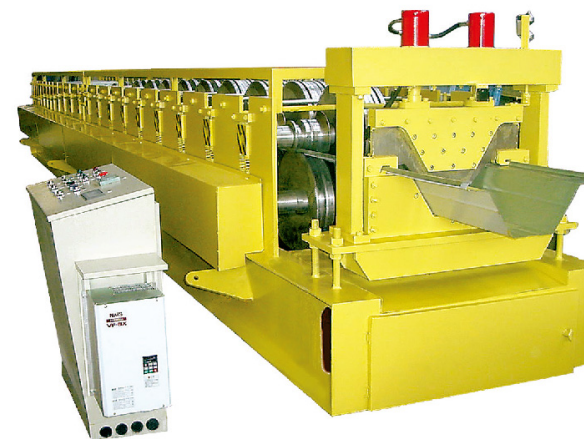


 **墙板** Roll Forming Machine for Wall Profile

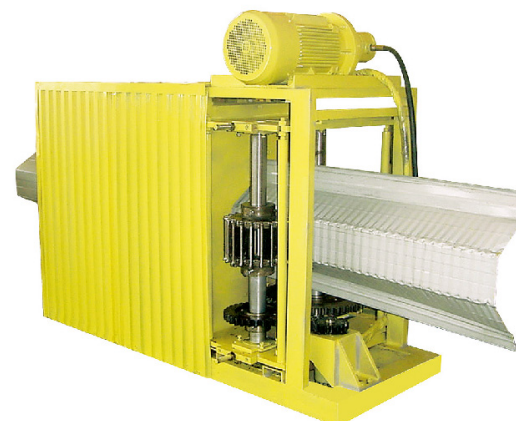


YX41.3-233.3-700 辊压成型机 Roll Forming Machine for YX41.3-233.3-700 Profile


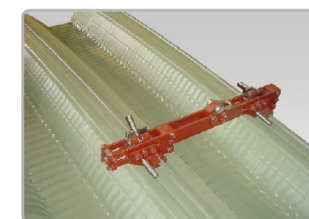
进料板厚 Material Thickness	进料宽度 Material Width	有效板宽 Effective Width	成型道次 Forming Steps	主要用途 Main application
0.40-0.80mm	940mm	700mm	25+2	屋顶 Roofing

高波屋面板辊压成型机 Roll Forming Machine for High-Ribs Roofing Profile

工艺流程图 Producing Process Sketch

V610 辊压成型机 V610 Roll Forming Machine for Big-Span Roof Profile


进料板厚 Material Thickness	进料宽度 Material Width	有效板宽 Effective Width	成型道次 Forming Steps	电机功率 Motor Power	主要用途 Main Application
0.6~1.2mm	914mm	610mm	22	15KW	无钉大跨度拱形屋面板 Curved Big-Span-Roof Panel

V610 滚弯机 V610 Curving Machine


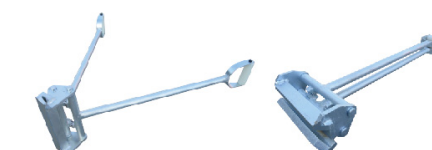
跨度 Roof Span	Max.12000mm
电机功率 Motor Power	15KW


V610吊钩
V610 Hook

V610电动锁边机
V610 Electric Lock Seaming M/C

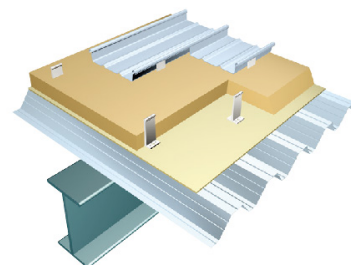
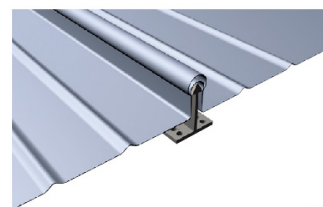
YX92-418 隐藏式屋面板 YX92-418 Hidden Roof Panel

锁边机 Electric Seamer

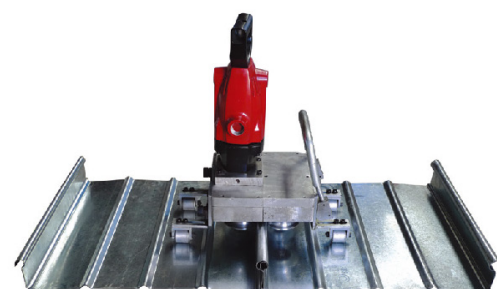
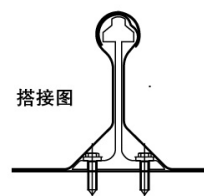
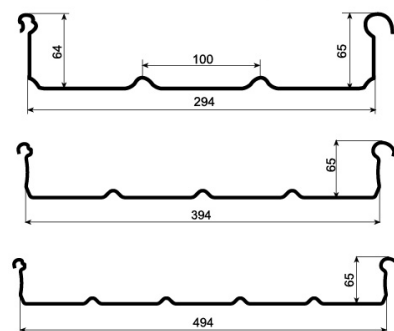
咬边钳 Hand Pincer




▲ 直立缝板辊压成型机 Roll Forming Machine for Straight Standing Seam Profile



▲ 电动锁边机
Electric Seamer



▲ 正反弧弯曲机<直立缝板型> Convex/Concave Curving Machine for Standing Seam Profile

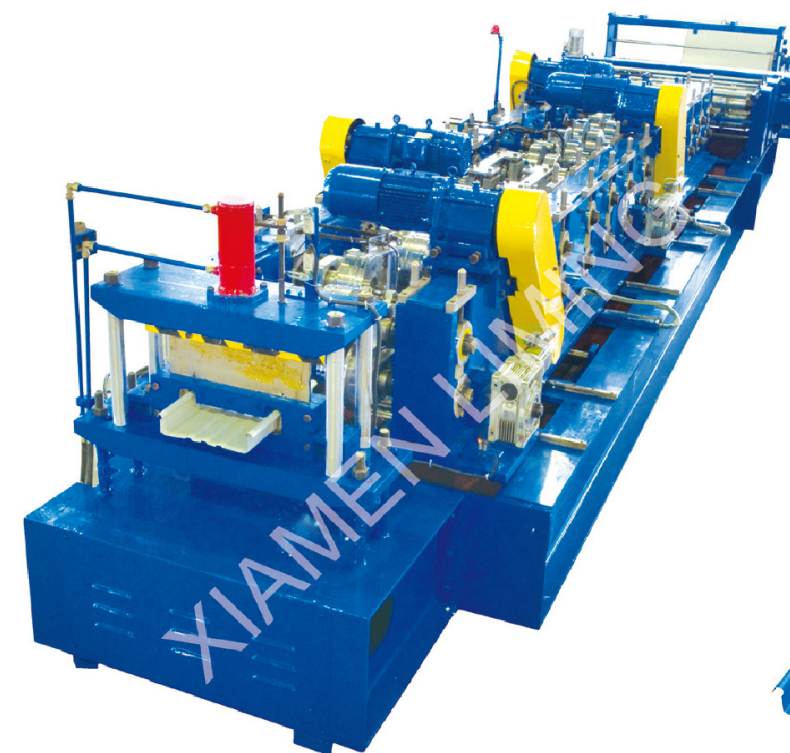


◆该滚弯机系直立缝板型板(standing seam profile)配套的成型拱形专用设备，它通过分别对该板的两侧及底面的滚弯，使该板在同一断面上发生局部塑性变形，从而达到弯曲成弧的目的。本机采用伺服减速电机升降装置的进退来实现圆弧，可实现反弧、正弧以及正反复合弧的生产，PLC自动控制，具有生产率高、弧度调节范围广、操作方便、安全稳定等优点。

本机采用自动控制，配置有编码器和变频器，通过触摸屏和PLC设置可以在同一块板上生产不同半径的正反连续弧。

• The curving machine is an important accessory machine to make the standing seam profile become curved through roll-bending the both sides and the bottom of the profile sheet.
This curving machine actualizes concave, convex and both in one sheet through screw jacking device by servo motor goes.
It is controlled by PLC automatically with high working efficiency, big span of the arch adjustment, convenient handle and high grade safe factor.
It configures with encoder / inverter / servo motors and is able to produce the sheet with different consecutive radius and options for concave / convex by parameter-setting through touch screen.

▲ 扇形直立缝板型自动成型机 Auto Taper Roll Forming Machine for Standing Seam Profile



▲ 直立缝板型自动控制扇形弯弧机 Auto Taper Curving Machine for Standing Seam Profile



◆该滚弯机是对扇形直立缝型板进行弯弧的专用设备，通过对型板的两侧和底面进行连续滚弯，从而达到弯弧的目的。

本机采用PLC自动控制，方便的人机界面输入（通过触摸屏输入扇形板的大头尺寸、小头尺寸、单片板长度即可），弯曲进给、扇形进给、角度调节均采用伺服电机驱动。

板型参数：大头MAX500mm，小头MIN270mm，扇形角度0°~2.5°，弯曲半径MIN10米。

本机具有生产率高、操作方便、安全稳定等优点。

• The curving machine is to use for curving standard-seaming profile with tapered shape; after consecutive curving on both sides and pan to get an arc profile.

It is controlled by PLC automatically; Simatic panel (for input of both end-section size and length); curve feeding, taper feeding and angle adjustment are driven by servo motor.

Profile parameter: Wider End: MAX500mm, narrow End: MIN 270mm; tapered Angle: 0°~2.5°, Curving Radius: MIN10 meter.

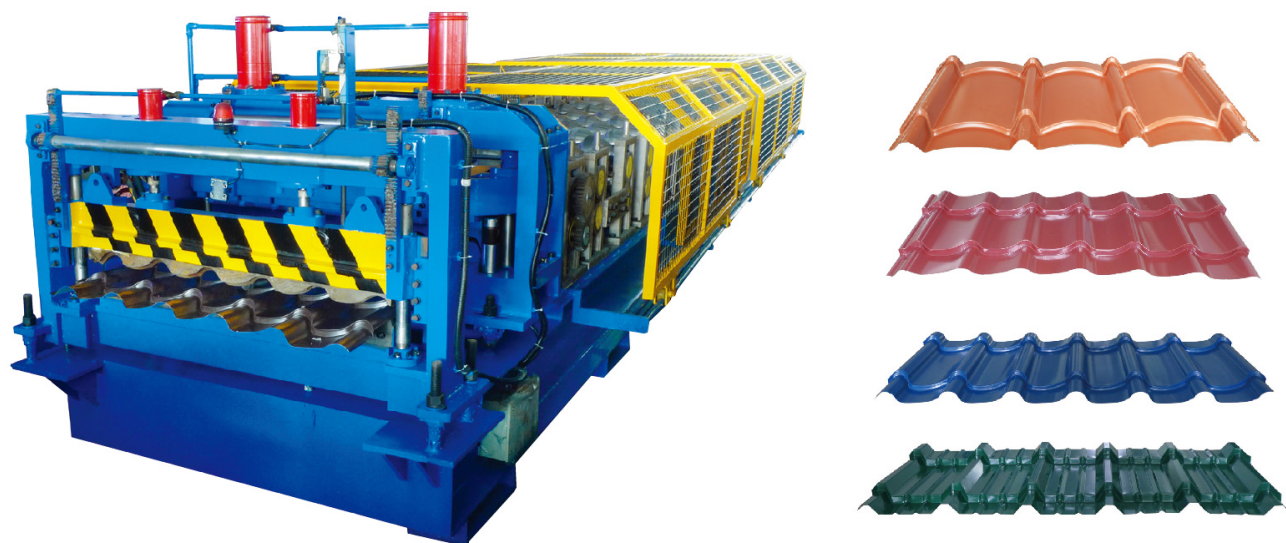
This curver takes on high efficiency, easy handling and safe property.





琉璃瓦辊压成型机 Roll Forming Machine for Tile Roof Profile

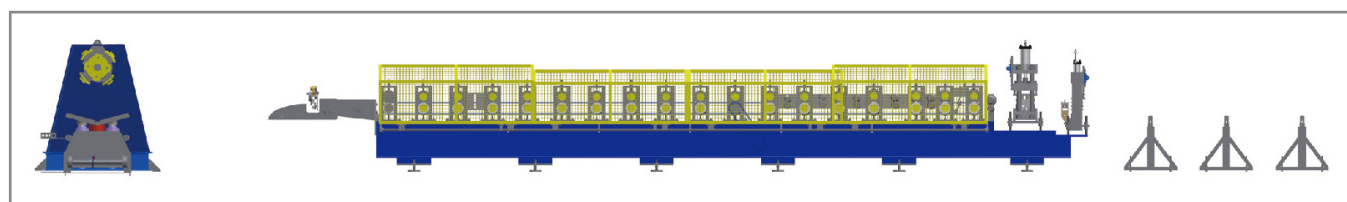
交流电机传动 AC Motor Driving



水槽板辊压成型机 Roll Forming Machine for Gutter Profile



工艺流程图 Producing Process Sketch



屋脊瓦辊压成型机 Roll Forming Machine for Ridge Cap Profile

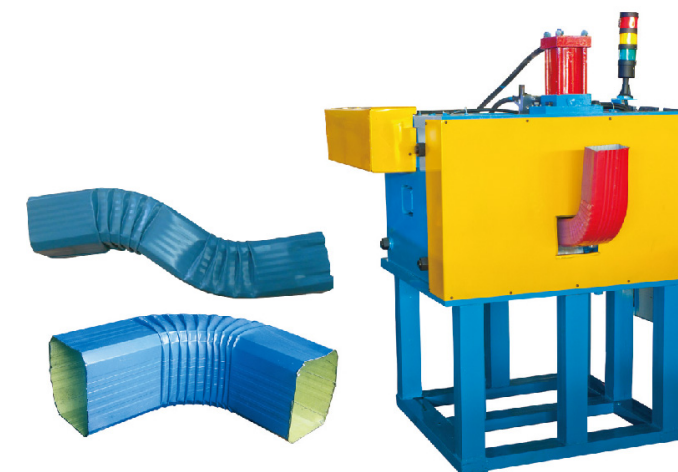
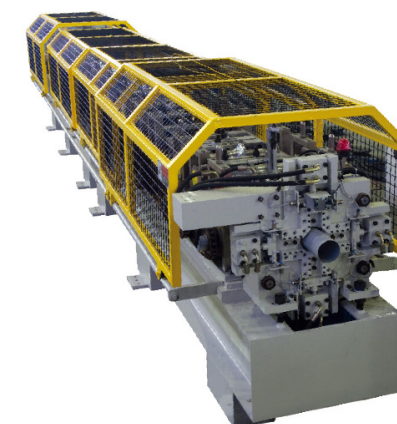
Option 1: 顶部不带压筋 Ridge Cap without Top-rib



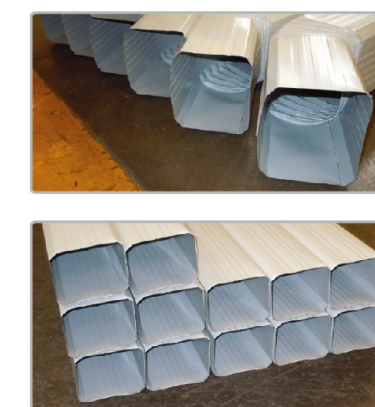
Option 2: 顶部带压筋 Ridge Cap with Top-rib



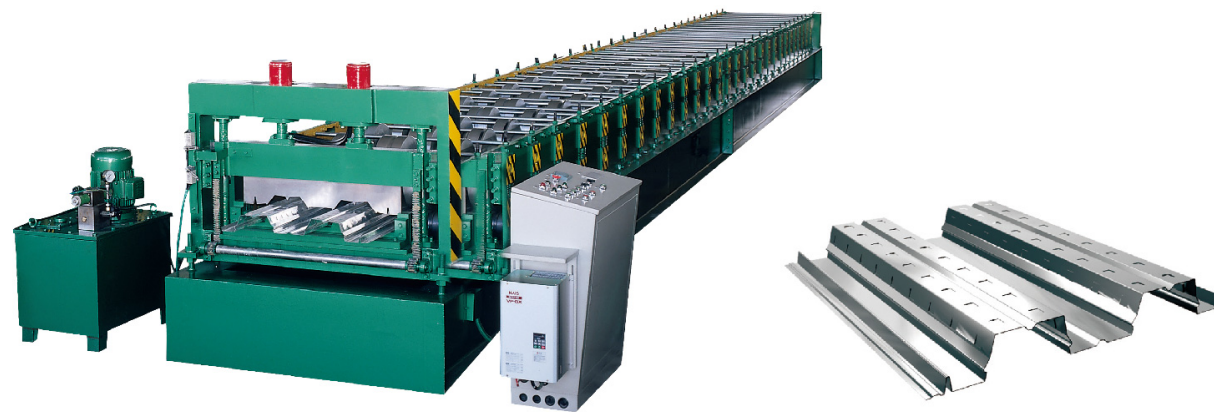
圆形落水管辊压成型机 Roll Forming Machine for Circular Rainspout



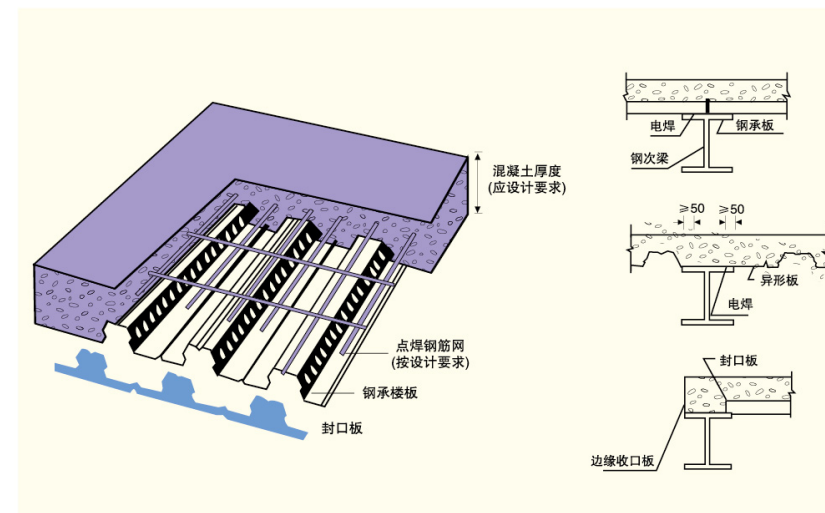
方形落水管辊压成型机 Roll Forming Machine for Rectangular Rainspout



YX76-344-688 楼承板辊压成型机 YX76-344-688 Roll Forming Machine for Floor Decking Profile



施工示意图 Illustrative Construction



安装工程实例



YX53-200-600 燕尾槽楼承板辊压成型机 YX53-200-600 Roll Forming Machine for Floor Decking Profile



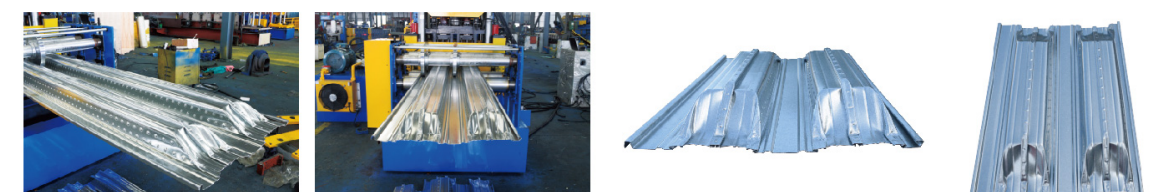
进料板厚 Material Thickness	进料宽度 Material Width	有效板宽 Effective Width	成型道次 Forming Steps	主要用途 Main Application
0.75~1.2mm	1000mm	600mm	29	楼面结构钢承板 Floor Decking Panel

闭口式楼承板辊压成型机 Roll Forming Machine for Closed Floor Decking



进料板厚 Material Thickness	进料宽度 Material Width	有效板宽 Effective Width	成型道次 Forming Steps	主要用途 Main Application
1.0 ~ 1.5mm	1000mm	600mm	36	楼面结构钢承板 Floor Decking Panel

端口挤压式楼承板辊压成型机 Roll Forming Machine for Closed Floor Decking





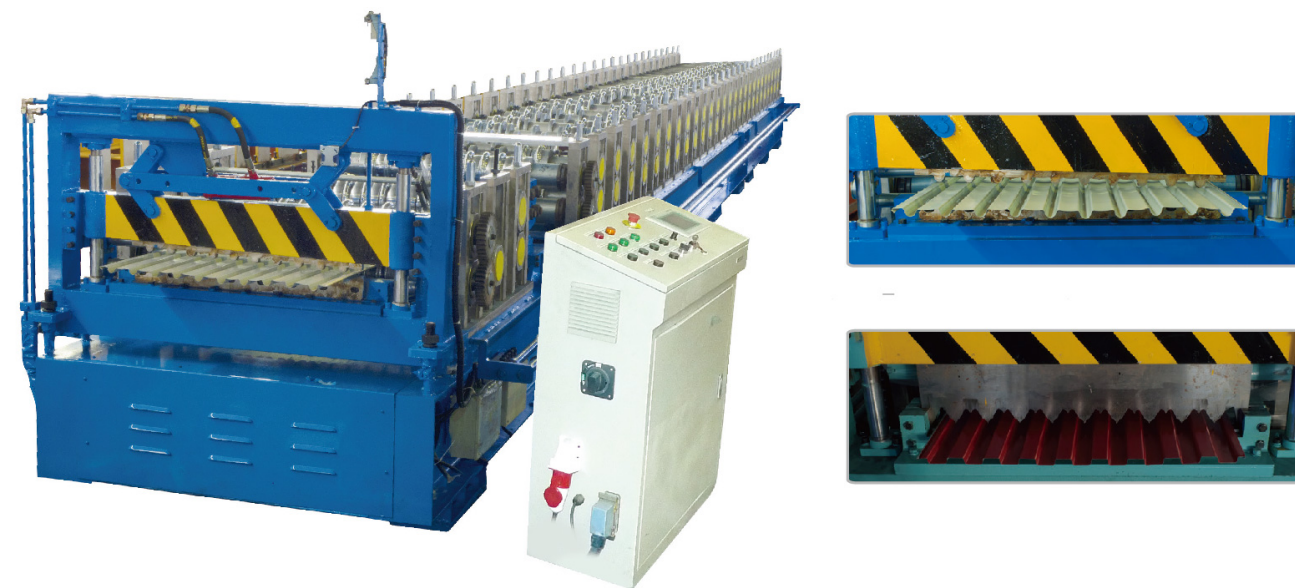
△ 门导轨辊压成型机 Roll Forming Machine for Door Rail



△ 包边包角辊压成型机 Roll Forming Machine for Flashing Profile



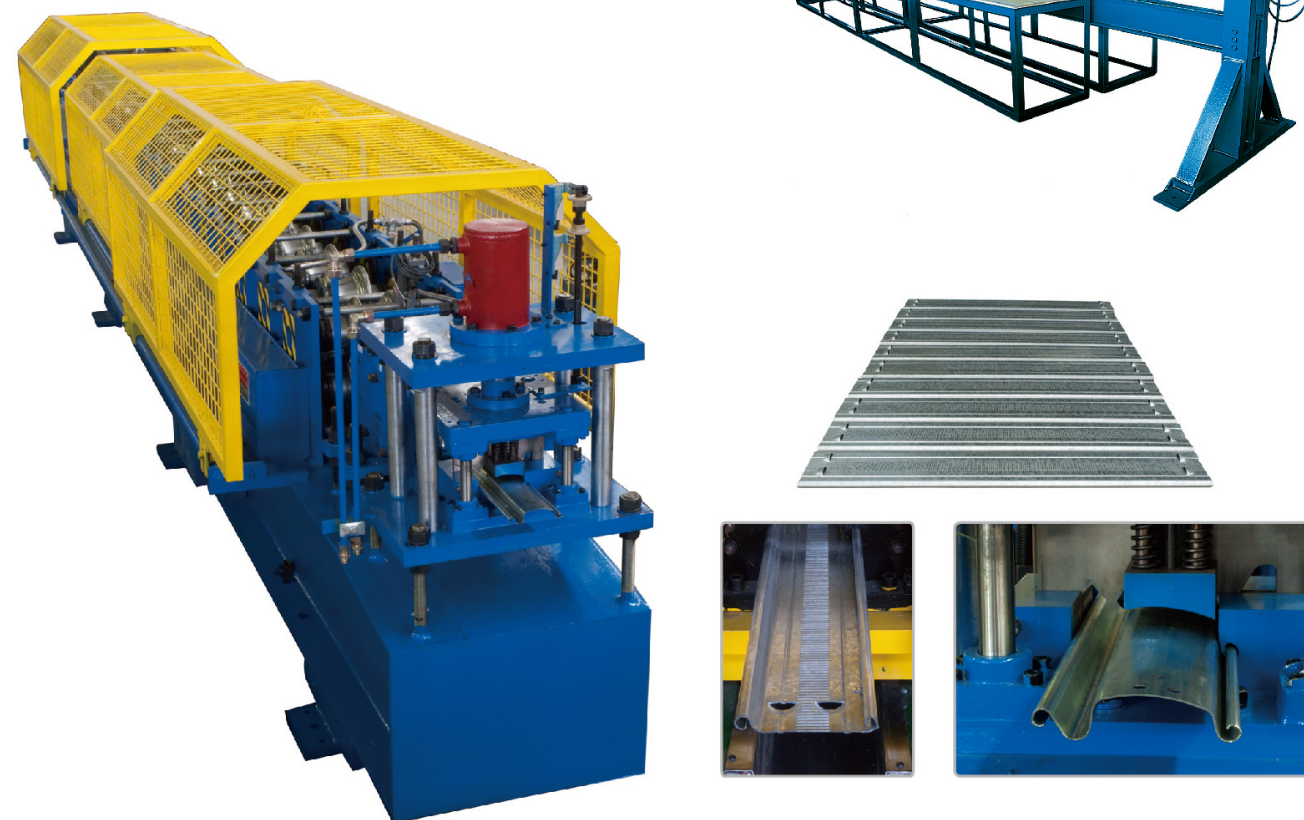
△ 卷闸门辊压成型机 Roll Forming Machine for Shutter Door Panel



△ 气动缝边机<6米长>
Pneumatic Seamer<6 Meters Long>

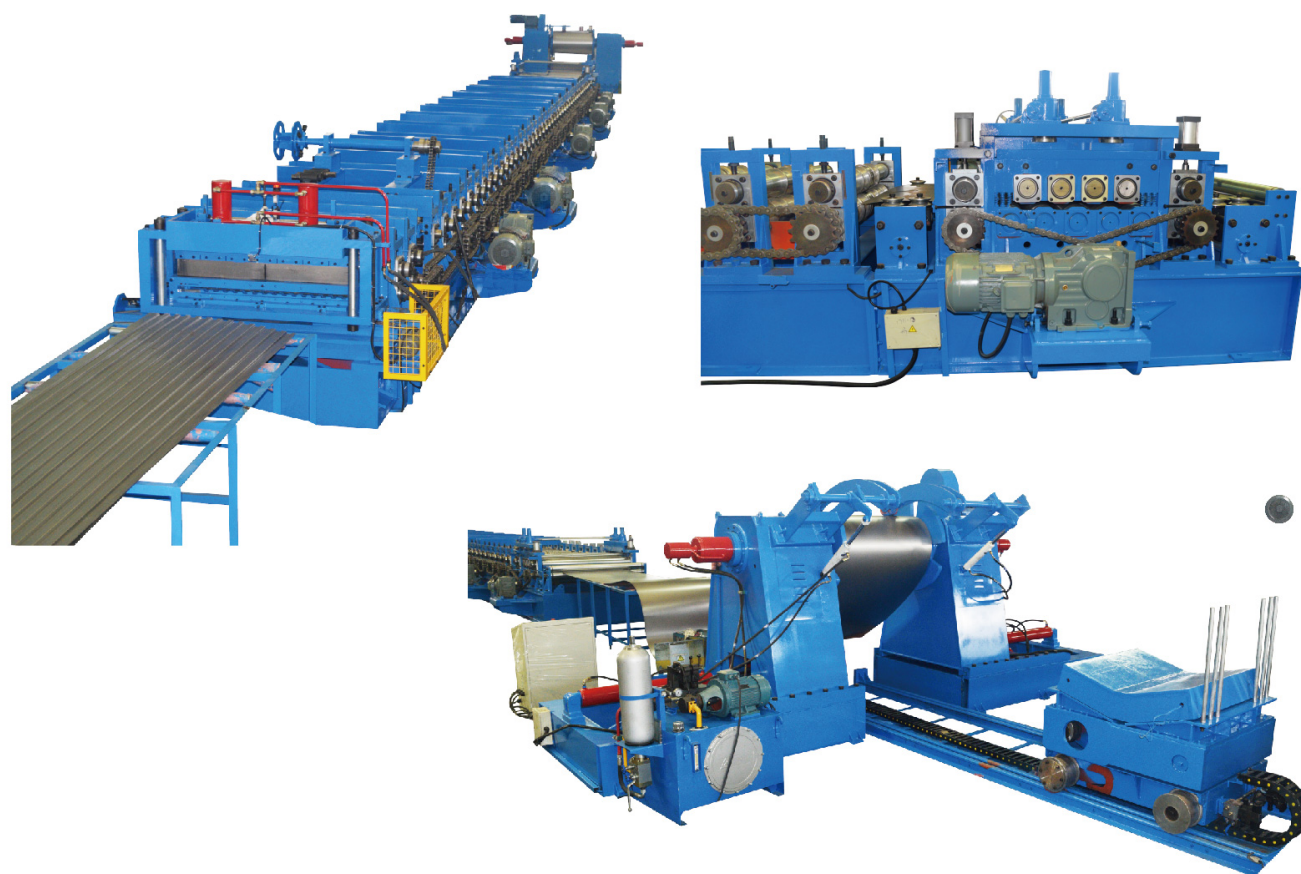


△ 卷闸门辊压成型机
Roll Forming Machine for Roll Shutter Door





▲ 车厢板 Roll Forming Machine For Truck Trailer Wall Panel



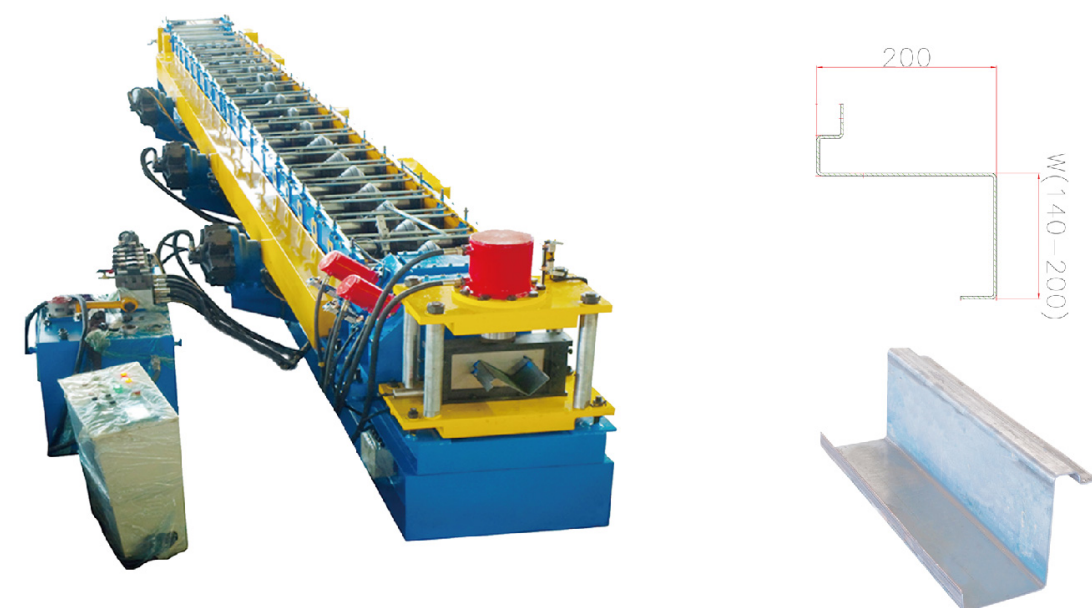
▲ A型板 A-type Adjustable Roll Forming Machine



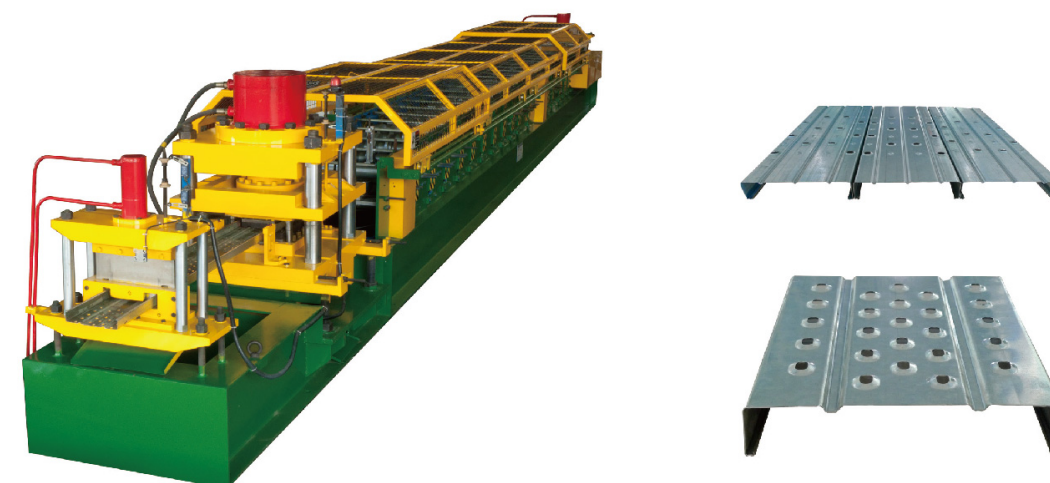
▲ 车台板成型机 (浪板) Roll Forming Machine For Car Bedplate



▲ 车库边梁成型机 Roll Forming Machine For Garage Side Beam



▲ 脚踏板成型设备 Roll Forming Machine for Stair Plate

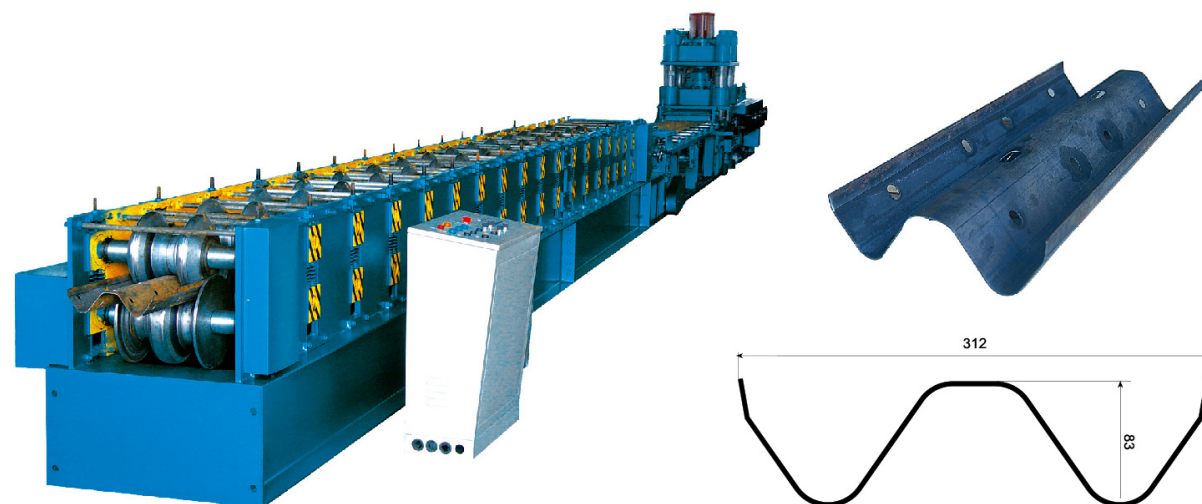




道路围挡板 Roll Forming Machine For Road Fencing

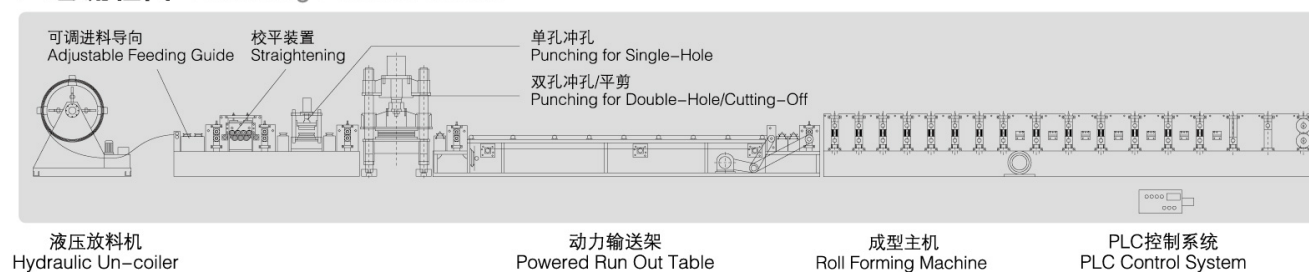


高速公路护栏板辊压成型机 Roll Forming Machine for Guard Rails Of Highway



进料板厚 Material Thickness	进料宽度 Material Width	有效板宽 Effective Width	成型道次 Forming Steps	电机功率 Motor Power
3.0mm	483mm	312mm	17	18.5KW

工艺流程图 Producing Process Sketch



侧梁板辊压成型机 Roll Forming Machine for Upright Profile



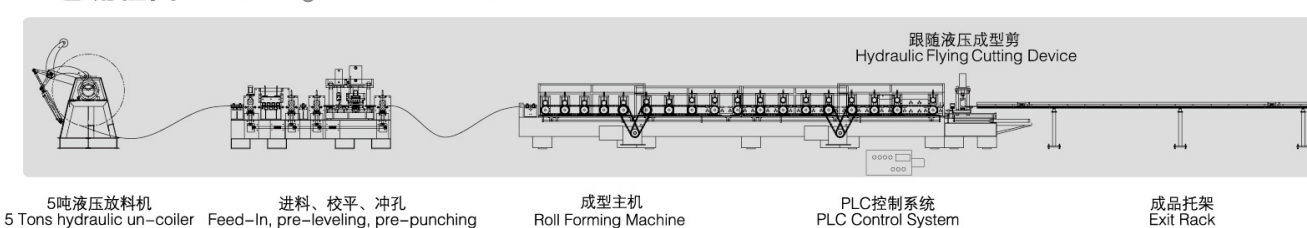
货架托板辊压成型机 Roll Forming Machine for Shelving Panel



横梁板辊压成型机 Roll Forming Machine for Close Beam

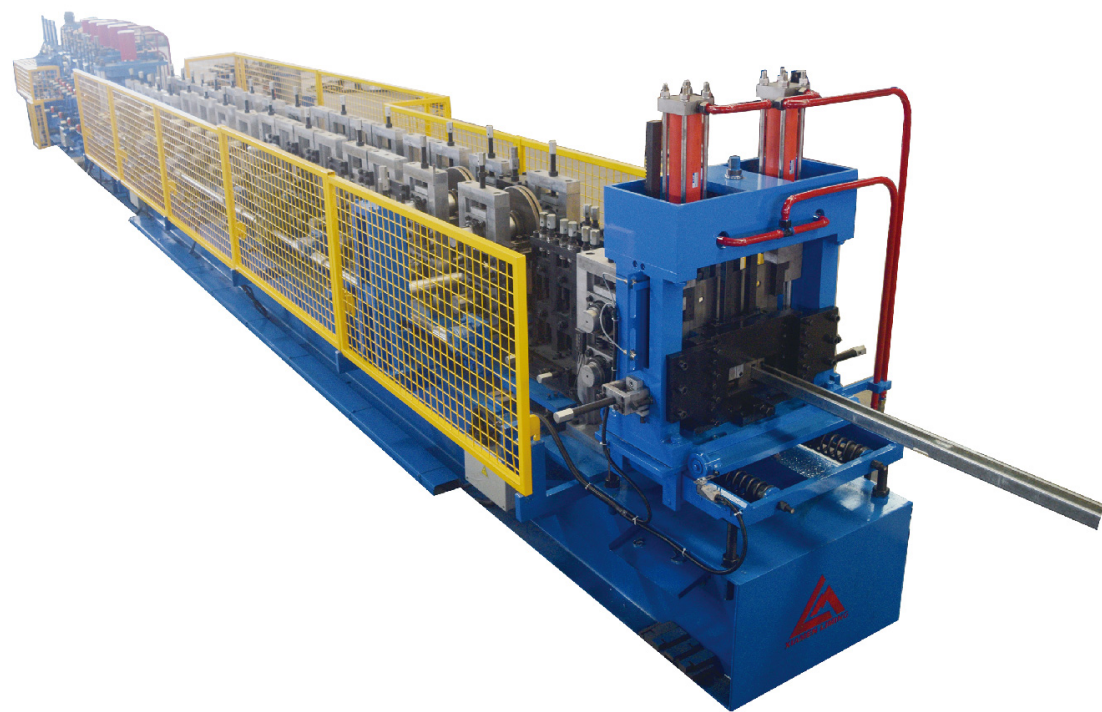


工艺流程图 Producing Process Sketch

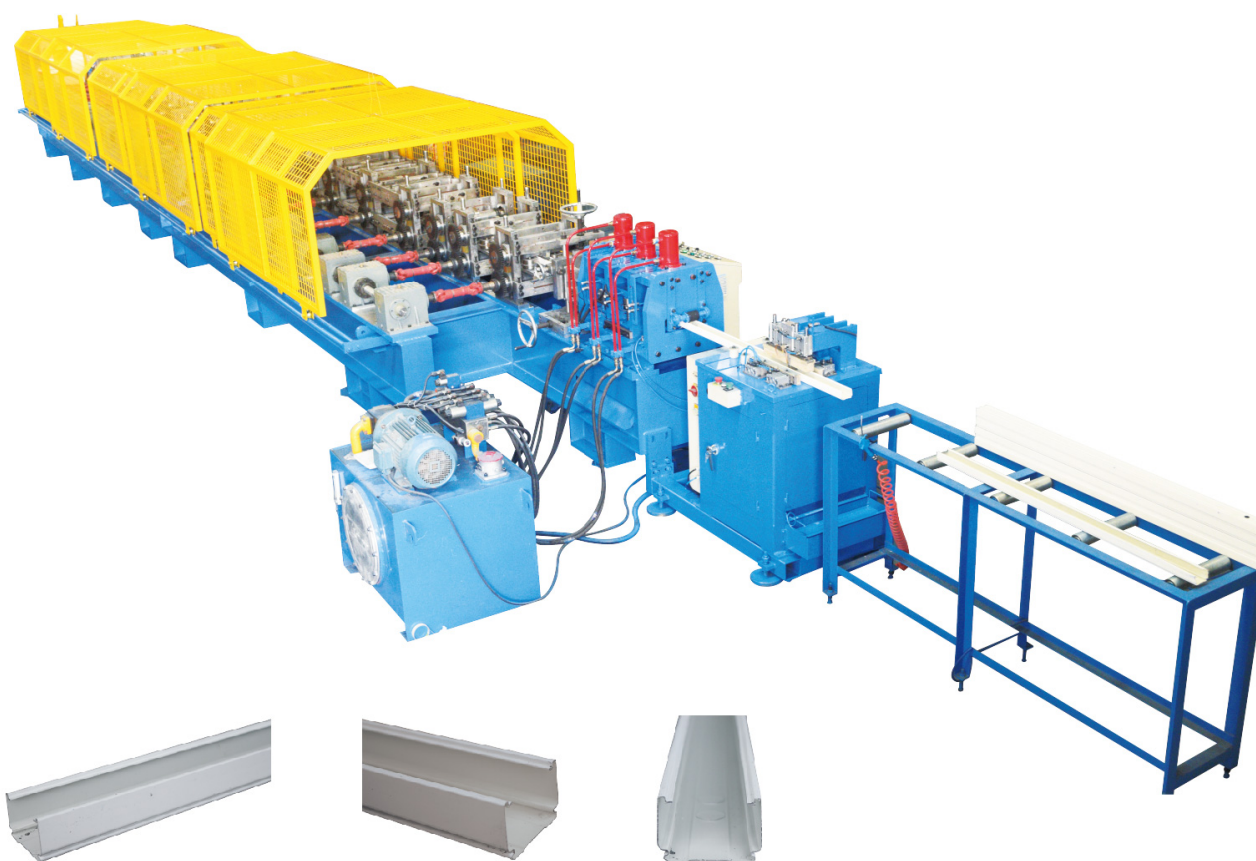




▲ 光伏支架设备图 Roll Forming Machine For PV Bracket Panel



▲ 灯体上壳成型机 Roll Forming Machine For LED Shell



▲ 双层数控折弯机 Double Layer CNC Bending Machine

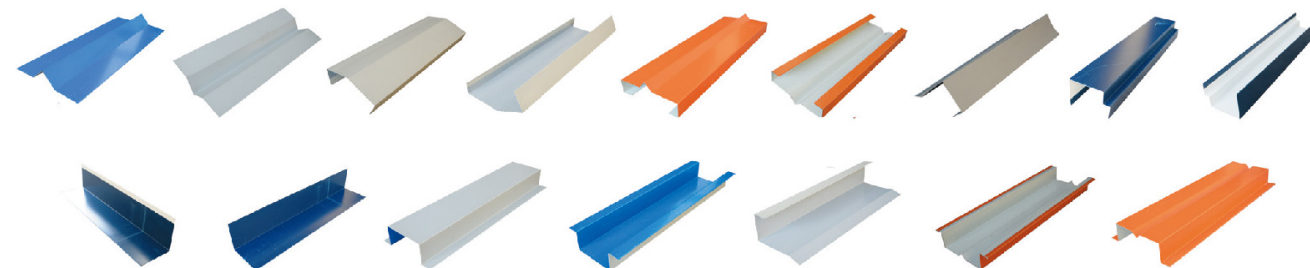


▲ CNC长板数控折弯机（带分条） CNC Slitting/Folding Machine



最大折弯长度 Max.Bending Length	喉口深度 Depth	最大折弯厚度 Max.Bending Thickness
4000mm	1000mm	1.0mm
6000mm	1000mm	1.0mm
8000mm	1000mm	1.0mm

▲ 折弯样品 Folding Samples

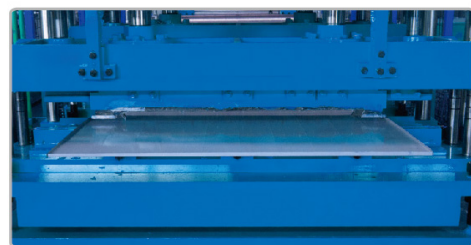




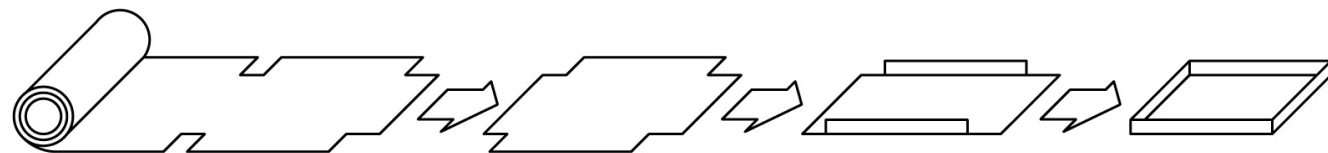
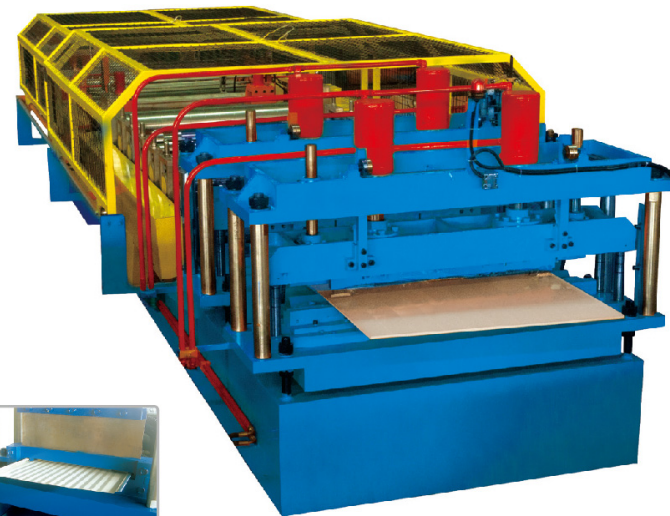
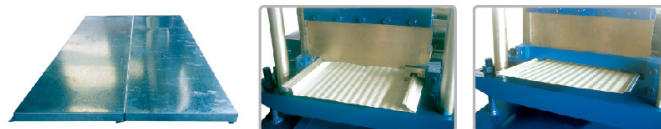
▲ 保温板辊压成型机<盒状> Roll Forming Machine for Heat-Preserving Panel<Box Shape>



▲ 保温板辊压成型机<盒状>,宽度可调 Roll Forming Machine for Heat-Preserving Panel<Box Shape>



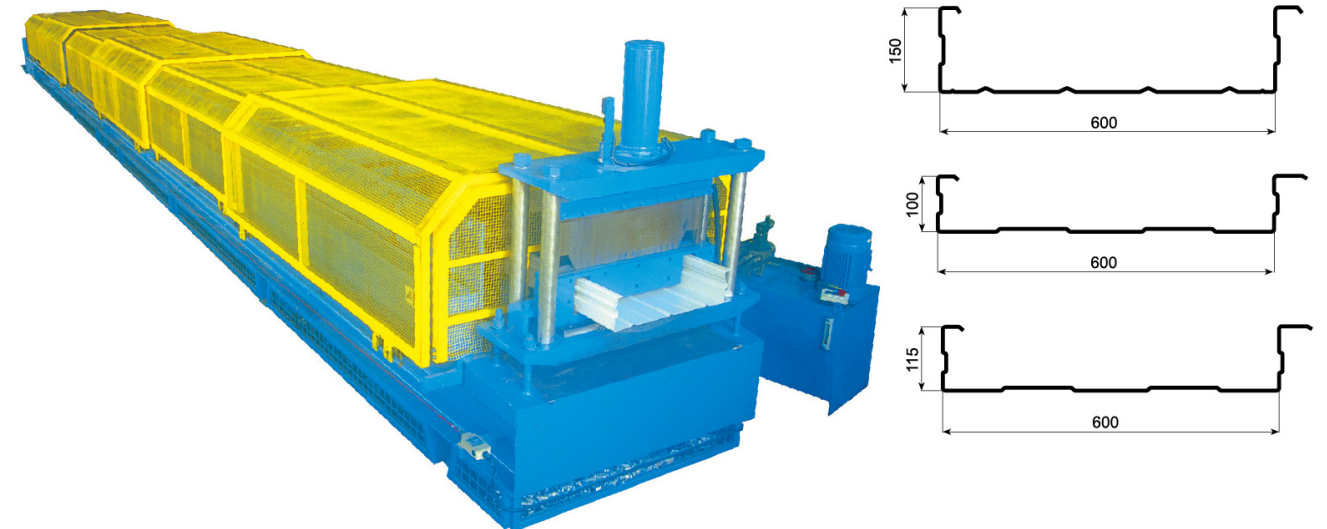
宽度无级调整，带头尾端折边
Width Stepless Adjustable,
End-Bending



进料板厚 Material Thickness	进料宽度 Material Width	有效板宽 Effective Width	成型道次 Forming Steps	电机功率 Motor Power	主要用途 Main Application
0.8mm	350-1200mm	宽度可调 Width Variable	12/13	5.5KW	冷库墙体保温板 Heat-Preserving Panel

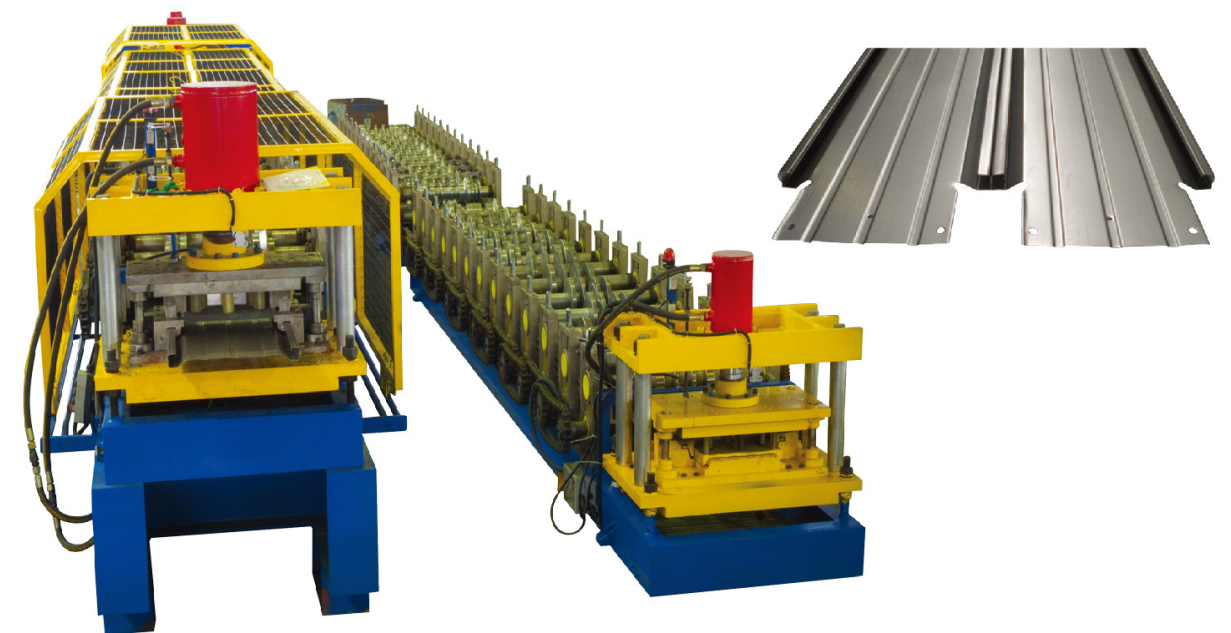


▲ YX150-600 保温板辊压成型机 YX150-600 Roll Forming Machine



进料板厚 Material Thickness	进料宽度 Material Width	有效板宽 Effective Width	成型道次 Forming Steps	电机功率 Motor Power	主要用途 Main Application
0.75~1.0mm	1000mm	600mm	26	18.5KW	保温板 Heat Preserving Panel

▲ 阳极板辊压成型机 Roll Forming Machine for Positive Plate

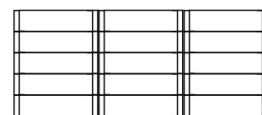
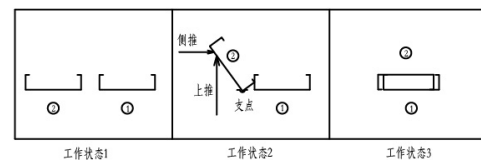
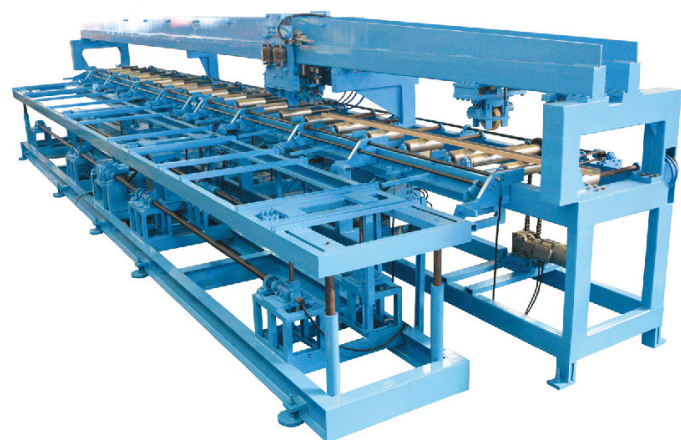




△ 双层气动垛料机 Double-Level Pneumatic Stacker



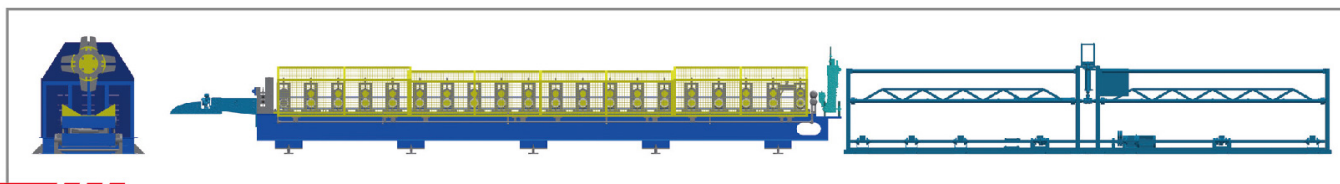
△ 单型号C型自动码垛机 Auto Staker for Single Size C-Purlin



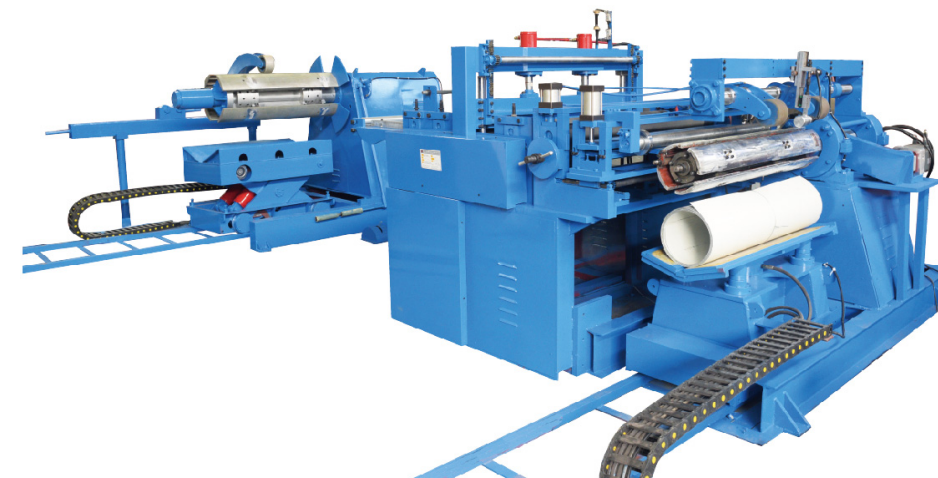
△ Z型钢成型设备带垛料机 Z-Purlin Machine with Auto Stacker



工艺流程图 Producing Process Sketch



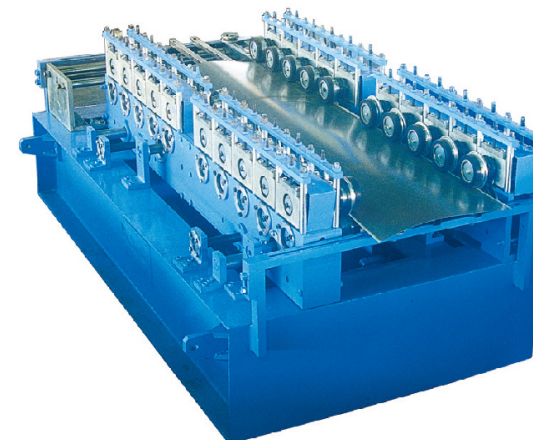
△ 剪板收料生产线
Plate Cutting And Receiving Production Line



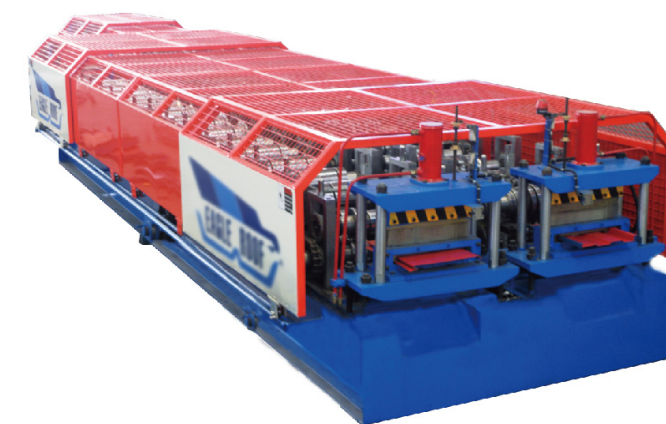
△ 电动定长剪
Electric Fixed Length Shear



△ 卷边机, 宽度可调
Hemming Machine Width Variable



△ 双侧成型机
Double Sides Roll Forming Machine





10吨液压放料机 (带小车)
10 Tons Hydraulic Un-Coiler<With Coil Car>



- 可选项 1: 液压斜楔式涨紧
Option 1: Hydraulic Tapered Expanding System
- 可选项 2: 顶部气缸压紧
Option 2: Pneumatic Holder On The Top
- 可选项 3: 钢卷对中装置
Option 3: Center Line Correcting

额定承重 Capacity	Max 10 Ton
放料宽度 Coil Width	1250mm
钢卷内径 In-Diameter	470~530mm

翻转机 Coil Tilter 额定承重: 10吨



无皱褶式浪板弯曲机
Smooth Curving M/C for Corrugated Profile

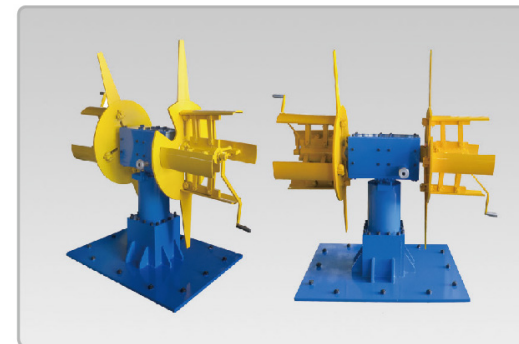
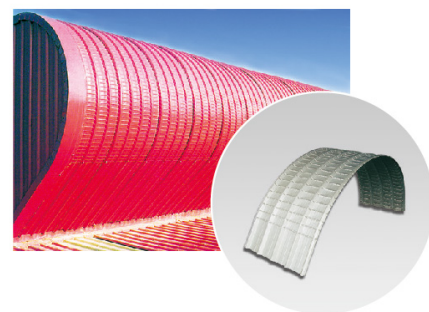


自动压皱式打弯机/正弦打弯 Auto Crimping Curved Machine/Convex Curving

水平位置
Horizontal Position



竖直位置
Vertical Position



1.5 Ton x 300mm 双头简易放料机
1.5 Ton x 300mm Twins Un-Coiler

额定承重 Motor Power	放料宽度 Coil Width	钢卷内径 In-Diameter
1.5Ton	300mm	400~580mm



5 Ton x 1250mm 千斤顶式放料架
5 Ton x 1250mm Jack-supported Un-coiling Rack

额定承重 Motor Power	放料宽度 Coil Width	钢卷内径 In-Diameter
5Ton	1250 mm	500mm



10 Ton x 1250mm 简易放料机
10 Ton x 1250mm Mandrel Un-Coiler

额定承重 Motor Power	放料宽度 Coil Width	钢卷内径 In-Diameter
10Ton	1250 mm	500~600mm



5 Ton x 1250mm 液压撑杆式放料机
5 Ton x 1250mm Hydraulic Un-Coiler(Link Connecting)

额定功率 Motor Power	额定承重 Motor Power	放料宽度 Coil Width	钢卷内径 In-Diameter
3+3 KW	5Ton	1000/1250mm	470~560mm



5 Ton x 1250mm 液压斜楔式放料机
5Ton x 1250mm Hydraulic Un-Coiler (Wedge Taper Type)

额定功率 Motor Power	额定承重 Motor Power	放料宽度 Coil Width	钢卷内径 In-Diameter
3+3 KW	5Ton	1000/1250mm	510±30



5 Ton x 650mm 液压放料机
5 Ton x 650mm Hydraulic Un-coiler

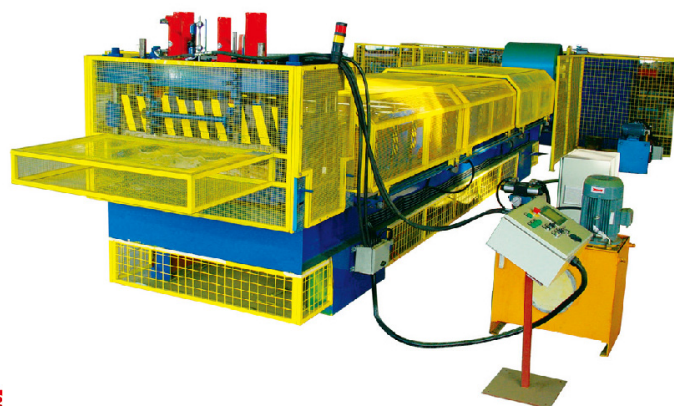
额定功率 Motor Power	额定承重 Motor Power	放料宽度 Coil Width	钢卷内径 In-Diameter
3+4 KW	5 Ton	650mm	470~560mm



双层辊压成型机 Dual-Level Roll Forming Machine



整线防护，CE认证设备 Full Safety Guarding, CE Certified



钢筋桁架楼承板生产线 Steel bar-Truss- Decking roll forming line

本生产线由钢筋桁架生产线、钢楼板点焊机、液压系统、电气控制系统等组成。
Steel Bar Truss-Decking line consists of Steel Bar Truss machine, Decking jog weld machine, hydraulic system and PLC control system.



放料机 Un-coiler



成型主机 Roll forming machine



电焊机 Welding machine



操作面板 Operation Panel

聚氨酯酚醛岩棉玻璃棉复合板生产线 PU(Mineral Wool)Sandwich Panel Production Line



双带机
Double belt conveyer



钢板对接机
sheet joint machine



晾板机
Panel cooling system



发泡机
PU foaming machine



带锯机
Band saw cutter



码垛机
Stacking machine



机加工车间 Machining Workshop

刀模车间 Tooling Workshop

装配车间 Assembly Workshop

机加工车间 Machining Workshop



龙门铣刨床
最大刨削长度: 9000mm
最大刨削宽度: 2000mm

Milling Planer
Plane & Cut Length: Max 9000mm
Plane & Cut Width: Max 2000mm



数控车床CY-K6180
床身上 $\phi 800$ mm、刀架上 $\phi 520$ mm
FANUC系统

CNC Lathe
Lathe Bed Upper $\phi 800$ mm
Cutter Upper $\phi 520$ mm
FANUC System

机加工车间 Machining Workshop



立式加工中心
工作台工作面宽度: 710mm
工作台工作面长度: 1400mm

Vertical Machining Center
width of working face on working table: 710mm
length of working face on working table: 1400mm



卧式铣镗床
镗轴直径 $\phi 130$ mm, 最大纵向行程1600mm
横向行程1600mm, 数显控制。

Lying Type Milling & Boring Machine
Boring Axis $\Phi 130$ mm; Lengthway Stroke
Max: 1600mm; Transverse Stroke 1600mm
Figure Display Control