

APPLICATION FIELD 应用领域



三片罐线
THREE-PIECE CAN MAKING LINE

我司生产的各类罐身组合机产品质量和技术在同行中处于前列，并可提供从剪刀机、焊机、拱房、组合机、检测机到码垛机的全套三片罐生产线设备服务，生产线最快速度可以达到 600CPM。

We can make kinds of combination machines for different type of can body, the quality and technology is leading in China. We also can supply the equipment of whole line from duplex slitter, welding machine, induction oven, leaking tester to palletizer. The maximum speed of the production line can reach 600 CPM.

根据多年的生产经验，专为两片罐生产设计的冲压系统，使得运行更稳定，设备寿命更长。同时可根据客户罐型的不同以及原材料马口铁或者铝材的差异，设计不同模具。

According to the years of production experience, it is specially designed the press for DRD can maker, which makes the operation more stable and the equipment life longer. Also, different toolings are designed for different cans and different materials such as tinplate or aluminum.

两片罐线
DRD CAN MAKING LINE




异型罐生产设备
EQUIPMENT OF SHAPED CAN

为提高客户的产品识别度，公司可以为客户设计和量身定做特殊罐型生产设备。提高客户产品附加值的同时也提高了客户产品的识别度。

To improve the recognition of can body, we can design the expanding machine to make individual cans for customers to distinguish theirs from other competitor's. Incidentally, promote the added value of the products.



金属制盖线
METAL END MAKING LINE

专为金属包装制造设计的冲压，配合公司多年的模具设计经验，可以最大限度的保证最终产品质量。行业领先的自动化机械手送料系统，保证送料顺畅、快速，充分提高产能。相比传统冲压系统，可大幅减少废料率，提高原材料利用率。Specially design of the punch press for metal end making system, years of experience in mold design are the basis for the quality of the final product.

Industry-leading automation manipulator feeding system, ensure the feeding smooth, fast, fully improve the capacity. Compared with the traditional punching system, can greatly reduce scrap rate, improve the utilization rate of raw materials.

专为喷雾罐顶盖设计的吸进式冲压系统，确保最终产品质量优异。公司的双通道冲压床拥有自主研发产权，最快速度可达 380 盖每分钟。

The transfer press system designed for aerosol cone ensures the excellent quality of the final product. The transfer press with double lanes can reach the max speed of 380 EPM.

气雾罐顶盖及封杯生产线
AEROSOL CONE AND MOUNTING CUP LINE




旋开盖线
TWIST-OFF CAP MAKING LINE

采用龙门式冲压，速度更快。冲压模具具备双导柱系统，可以在高速生产的同时定位更准。组合式制盖机集成注胶工位，机器运行更稳定，模具可靠性更强。可以根据客户需要增加垫片复合机。采用新型不含 PVC 的垫片取代传统注射内垫，确保食品安全。

Using the gantry type punch, the speed is faster. The punch die has double guide pillar system, which can be positioned more accurately at the same time of high-speed production. The combination cap maker include lining process, make all machine more stable, also better mold performance. The gasket composite machine can be added according to the needs of the customer. The new PVC free gasket is used instead of the traditional injection inner pad to ensure food safety.

采用铝箔 / 塑料膜和金属圈盖结合的方式，生产的易撕盖产品，可适用于干燥，可加热和热灌装的产品。不会产生溢出和飞溅，并且易于打开，不会损伤手指。

Our machine can make the peel off end by combining the aluminum foil or plastic foil with the curled ring. The peel off end can be used for the package of dried, retortable, hot filling products. The advantage of using peel off end is that cans be easily opened without any tools, and would not hurt fingers.

易撕盖设备
EQUIPMENT FOR PEEL OFF END

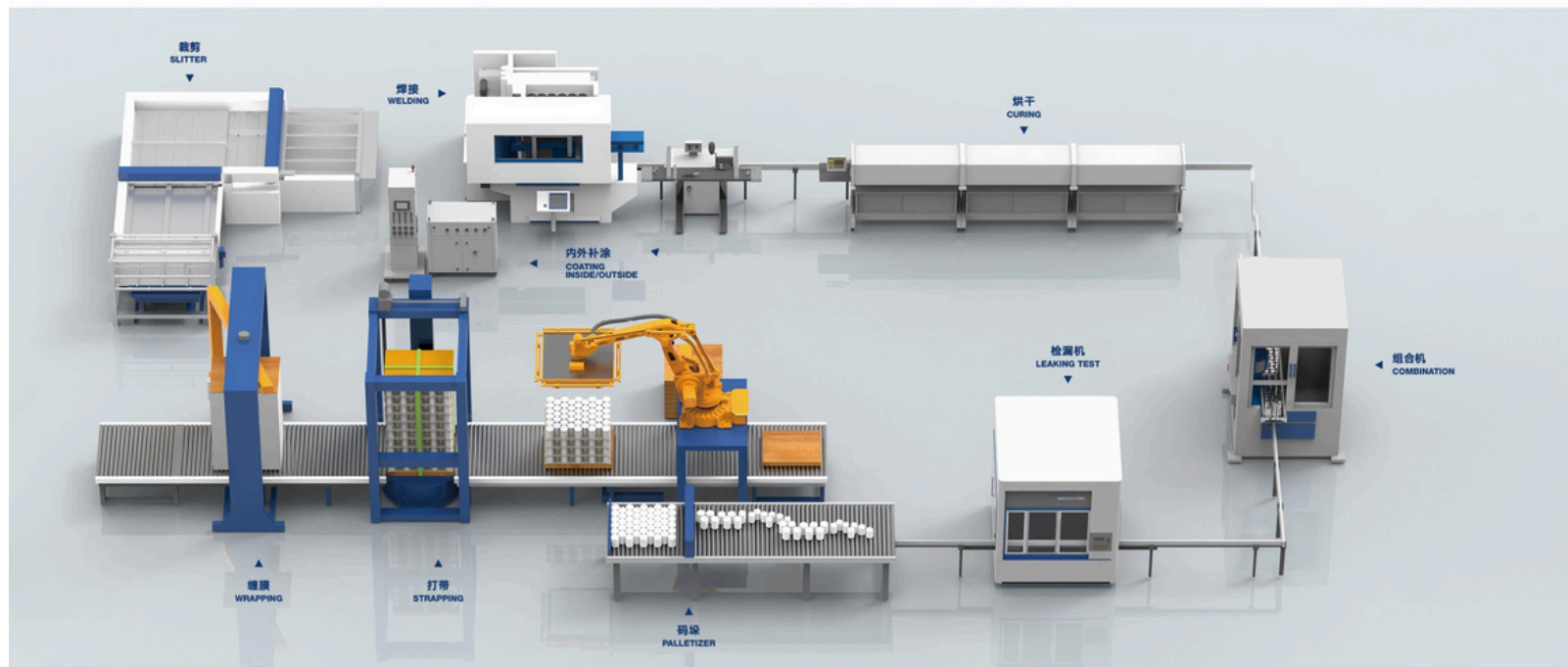
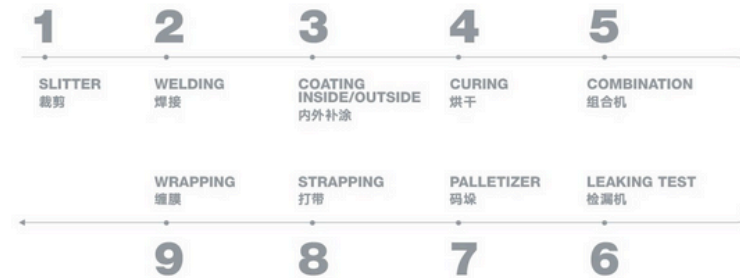



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METAL THREE-PIECE CAN MAKING MACHINE AND LINE SOLUTION 金属制罐设备及整线方案

凭借多年的生产经验，龙文公司不仅可以提供金属制罐生产所需的全套设备，同时还可以根据您的需要，为您提供最高效，经济和可靠的生产线组合，以及自动化解决方案。满足不同客户群体的需要。

With the company's years of production experience, LONGWEN not only provide the full set of equipment for the metal can making line, but also provide you with the most efficient, economical and reliable production line solution, as well as automation solutions according to your needs. Meet the needs of different customer groups.



CONTACT US

制罐线解决方案 Can making solution

全自动复式裁剪机 Automatic duplex slitter

AUTOMATIC DUPLEX SLITTER

全自动复式裁剪机

自动复式圆刀裁剪机，由供料机、第一道送料台、高精度圆刀裁剪机；第二道送料台、高精度圆刀裁剪机；和自动收料台组成。设备主轴使用进口加工中心制造，圆刀材料为特优硬质合金钢，剪切精度高。设备电气及控制系统均采用国际主流品牌，主要轴承使用日本NSK，自带双张检测系统，确保运行稳定。

The equipment is composed of the feeding machine, the first feeding table, the high precision round cutter cutting machine, the second feeding table, the high precision round cutter cutting machine, and the automatic collecting table. The main shaft of the equipment is made by imported machining center, and the round cutter material is high quality carbide with high shearing accuracy. The electrical and control systems of the equipment adopt the main brands of the world, and the main bearings are made of NSK in Japan. They are equipped with double sheet detection system to ensure stable operation.

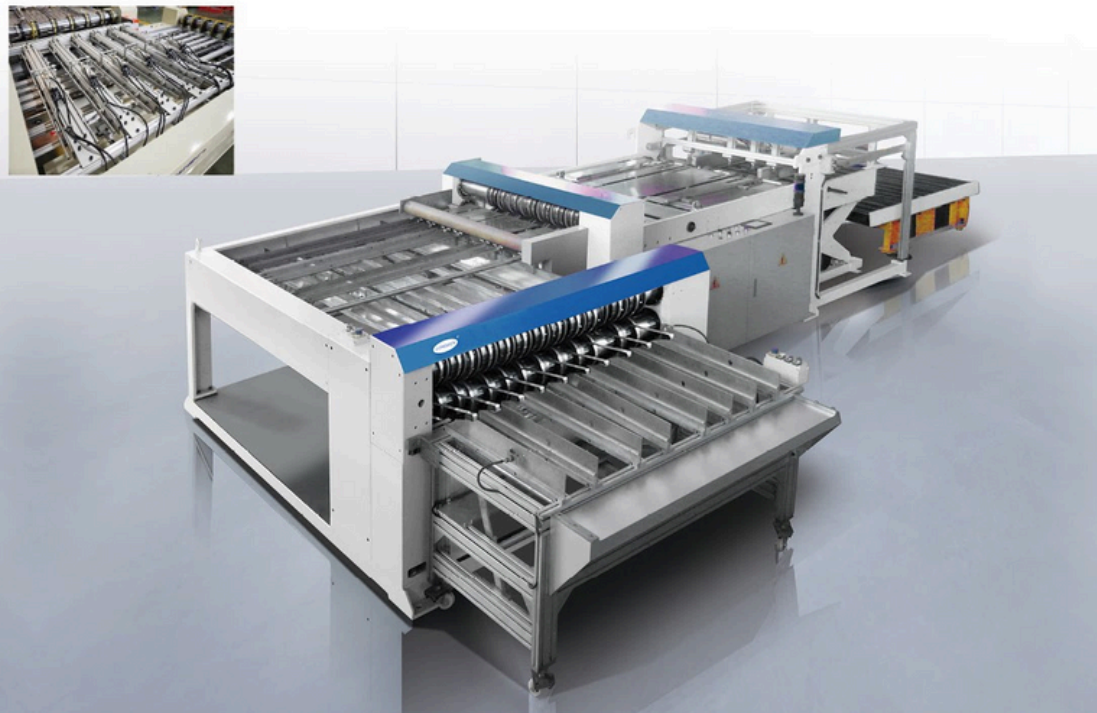
型号 Model	运行及控制方式 Operation and Control	最快速度 Capacity(max)	尺寸公差 Dimension tolerance	对角线误差 Diagonal tolerance	适用规格 Tinplate size	适用厚度 Tinplate thickness
GT10A10G	纵横剪独立变频调速，定位系统 伺服驱动，电子同步 1st and 2ed cutter independent variable frequency speed regulation, positioning system servo drive, electronic synchronization	30 张 / 分钟 (pcs/min)	±0.02mm	±0.05/100mm	600-1200mm	0.12-0.4mm
GT10A10B	纵横剪整体变频调速，定位系统 机械传动，机械同步 Integrated variable frequency speed regulation of 1st and 2ed cutter, mechanical transmission of positioning system, mechanical synchronization	30 张 / 分钟 (pcs/min)				

选配 Optional

磁性料片输送系统
Magnetic sheet moving system

优势 Advantage

一剪和二剪之间铁皮采用磁性方式输送，更好的保护材料的表面
Between the first cut and the second cut, the sheet is transported in a magnetic system to better protect the surface of the material



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AUTOMATIC HIGH SPEED WELDER 高速全自动电阻焊机

特点 ADVANTAGE

- 人机界面控制，最新型可编程控制器；
Equipped with human-computer-interface and PLC;
- 采用数字化控制技术；
Adopt digital control technology;
- 铜线速度自动跟踪控制；
Auto trace for copper string driving speed;
- 最新数字变频电源；
New digital inverter for power supply;
- 设备运行情况可全面监控；
Full control for every operation steps;
- 可配备远程访问控制功能；
Radio control available;
- 可带自动划线装置，
Parting machine available.



技术参数 TECHNICAL SPECIFICATION

机器型号	Model	L500	L600	L800
铜线速度	Wire speed max	50 m/min	65 m/min	80 m/min
搭接宽度	Overlap	0.4-0.5mm		
材料厚度	Tin thickness	0.17-0.3mm		
铜线直径	Copper wire	D1.38/D1.50 mm		
焊接频率	Welding frequency	100-550Hz		
最大功率	Maximun power	90KW		95KW
压缩空气	Compressed air	0.6Mpa 0.7m³/min		
主机尺寸	Machine size	3x2.8m		3.2x3m
主机重量	Machine weight	4500kg		5000kg



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制罐线解决方案 Can making solution

全自动马口铁搬运机 Body blank transfer system

BODY BLANK TRANSFER SYSTEM

全自动马口铁搬运机

本机实现复式纵横裁铁机与自动罐身焊接机的无缝连接，代替人工搬铁的功能，即解放劳力又避免人工搬铁而引起铁皮污染。设备采用全自动智能控制系统；高速，稳定，灵活，满足多种速度要求的设计理念；适应罐径范围大，更换罐径简单快捷。

This transfer system is connected between the slitter and welder, which can realize automatic sheet collecting and feeding. It can replace the manual work and avoid the iron pollution caused by workers. Equipment using automatic intelligent control system, high speed, stable, flexible, meet the demand of various speed design concept. Suit for wide range of can diameter, and easy to change the can diameter.



技术参数 TECHNICAL SPECIFICATION

系列 Product Series	罐径 Can diameter		罐高 Height	速度 (片 / 分钟) Max speed
GT1E18	mm	in	mm	pic/min
奶粉罐 Milk powder can	99-153	401-603	65-265	300
饮料、食品、气雾罐 Beverage&Food&Aerosol Can	52-85	202-307	50-220	1000
18L 花蓝桶 Pail	180-380		100-550	100

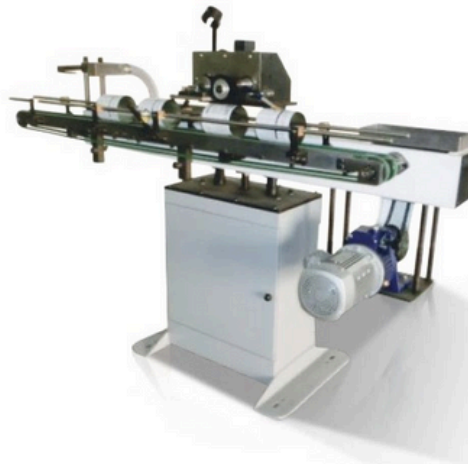
EXTERNAL COATING SYSTEM+TRANSITION MACHINE

外补涂系统 + 过渡机

特点 ADVANTAGE

过渡机通过磁性皮带将罐筒从焊机输送至烘房，并在输送的过程中完成对罐子焊缝外部的补涂。补涂方式可根据客户要求采用滚涂或者喷涂。

This transition machine conveys can cylinder from welder to induction oven, and external coating will be finished in this machine. Customer can choose Rolling Coating or Spraying Coating depends on quality requirement.



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SIDE STRIPE POWDER COATING SYSTEM

自动焊缝粉末补涂机

特点 ADVANTAGE

- 恒定均匀的涂层;
Steady even application;
- 干净清晰的补涂带;
Clean and clear side stripe;
- 无掉粉、散粉现象;
No powder dropping and splashing;
- 无粉末飞物污染环境、无粉末流失。
No environmental pollution, No powder waste.



技术参数 TECHNICAL SPECIFICATION

速度 Speed	涂布带宽度 Stripe width	罐径 Can size	功率 Power	电源 Power supply	压缩空气 Air
Max.90 m/min	6-12mm	52-400mm	2 kw	380V, 3 phases	6bar 500L/min

INDUCTION DRYING OVEN

电磁感应烘房

利用调制逆变电源变频技术，使交变电流对金属罐焊缝涂层产生特定涡流发热，从而达到烘烤固化效果。适用于饮料罐，食品罐，奶粉罐，化工罐等各种罐型、规格和不同生产速度的制罐线。

It works based on the SPWM technology, generating vortex heating by A/C on the welding seam to get curing. It is suitable for different can sizes, type and different speed of food, beverage, aerosol, milk powder and paint cans production.



技术参数 TECHNICAL SPECIFICATION

生产要求 Production speed	根据要求 Customization
适用罐径 Range of can diameter	
输入电源 Powder supply	AC380V,50Hz



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COMBINATION MACHINE SERIES

组合机系列

浙江龙文精密设备股份有限公司从公司成立之初就开始对各类金属包装的组合机进行研发和生产，具备 20 多年的产品生产经验，产品性能获得国内外高端客户的一致认可。

We works on researching and developing various kinds of Combination machines for metal packaging since company was founded. Over 20 years production experience enables us to produce high quality production. And get into the high-end customers at home and abroad.

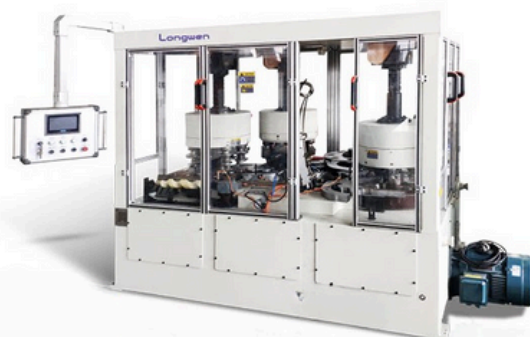
COMBINATION MACHINE FOR FOOD AND BEVERAGE CANS

食品饮料罐组合机

特点 ADVANTAGE

- 采用立式设计，容易和其它设备联接
Vertical design, easy connect with other equipment
- 可再循环的集中润滑系统
Recyclable central lubricating system
- 采用人机界面触摸屏和变频器变频调速
Adopt man-machine interface touchscreen and use frequency conversion motor to control the speed
- 多重安全装置确保人身和设备安全
Multiple safety devices ensure the safety of person and equipment
- 自动流程控制，卡罐自动停止
Flow-control sensors are provided on canpath for safety, if can jam occurs, the machine stops automatically
- 可以选配自动调高功能更快速，准确的调节罐高
It can add automatic height adjust sets, to make the can height adjust more quickly and accurately.

可选功能 Optional	自动调高	Automatic height adjuster
	自动加盖	Automatic end feeder
	安全防护罩	Safety cover



技术参数 TECHNICAL SPECIFICATION

功能 Function	罐径 Diameter		罐高 Height	速度 speed	罐径 Diameter		罐高 Height	速度 speed
	mm	inch			mm	inch		
缩颈 Necking	52-99	202-401	50-160 单面 70-160 双面	200-600	99-153	401-603	110-245 单面	80-200
翻边 Flanging	52-99	202-401	50-160	200-600	99-153	401-603	110-245	80-200
滚筋 Beading	52-99	202-401	50-124	200-600	99-153	401-603	110-245	80-200
封口 Seaming	52-99	202-401	50-160	200-600	99-153	401-603	110-245	80-200

功能 Function	罐径 Diameter range		出罐罐高 Finished can height	出罐速度 Output speed (max)	备注 Note
	mm	inch	mm	CPM	
分切机 Parting machine	52-99	202-401	38-72	600	罐筒需要预先划线 Cylinder should be scored



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COMBINATION MACHINE FOR MILK POWDER CANS

奶粉罐组合机系列

特点 ADVANTAGE

- 采用摇摆翻边，翻边宽度尺寸准确
Swing flange for a more accurate width of flange
- 采用双滚轮式滚筋，滚筋圈数可调，滚筋深度，刚性好
Bead cluster are formed due to pressing between outer beading roller and inner beading roller. With the characteristics of adjustable beading revolution, deeper bead depth and better rigidity.
- 无罐无盖保护系统
No can no end system.
- 三刀分盖系统，不易擦伤罐盖
Triple-blade end separating system for non-scratch end.
- 采用立式设计，容易和其他设备链接
Vertical design easy to connect with other machines.
- 可再循环设计的集中润滑系统
Recyclable central lubricating system.
- 采用变频器变频调速
Inverter for variable speed control.
- 全自动控制系统
Full automatic control system for can making line requirements
- 多重安全装置以保证人身和设备安全
Multi-sensor design for machine and personnel safety.

可选功能 Optional	自动调高	Automatic height adjuster
	自动加盖	Automatic ends infeder
	安全防护罩	Safety cover



双辊式滚筋
Double rolls beading



轨道式滚筋
Rail beading



设备参数 MACHINE SPECIFICATION

功能 Function	型号 Model	罐径 Diameter range		罐高 Height range	最快速度 Max speed
		mm	inch		
翻边 + 滚筋 (轨道式) + 封口 Flanging+Beading(Rail)+Seaming	GT3B49AI(4H)	83-127	307-502	110-190	120
	GT3B49AI(5H)	99-153	401-603	110-245	130
	GT3B49AI(6H)	99-153	401-603	110-245	160
翻边 + 滚筋 (双辊式) + 封口 Flanging+Beading(Rolls)+Seaming	GT3B49HB(6H)	99-153	401-603	110-245	160
翻边 + 滚筋 (动力双辊) + 封口 Flanging+Beading(Rolls)+Seaming	GT3B49HC(686H)	99-153	401-603	110-245	220



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制罐线解决方案 Can making solution

气雾罐系列组合机 (高配版) Combination machine for aerosol cans (high speed series)

COMBINATION MACHINE FOR AEROSOL CANS (HIGH SPEED SERIES)

气雾罐系列组合机 (高配版)

特点 ADVANTAGE

- 机器采用直线式布局, 占用空间少, 换型维修更方便
Machine layout with linear structure, takes up less space and maintenance more convenient
- 罐身调高系统采用高精度伺服装置, 可通过在屏幕中输入罐高参数, 对设备整体高度进行调整, 也可对每个工位独立调整, 提高换型效率
Machine adopts high precision servo system to change can height. Customer can adjust the height for equipment as a whole, also can be adjusted for each location independence, improve the efficiency of changing can height
- 整机采用变频器变频调速, 具备可再循环的集中润滑系统
adopts frequency inverter to control motor speed, with the centralized lubrication system
- 设备装机配套自动加盖系统
With automatic ends infeder system.



设备参数 MACHINE SPECIFICATION

功能 Station	型号 Model	适应罐径 Diameter range		适应罐高 Height range	最快速度 Max speed
		mm	inch	mm	
5 工位 5 stations	A5450	45-73	113-300	90-320	450
4 工位 4 stations	A4450	45-73	113-300	90-320	400
3 工位 3 stations	A3450	45-73	113-300	90-320	350



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COMBINATION MACHINE FOR AEROSOL CANS (STANDARD SERIES)

气雾罐罐身组合机（标准型）

- 可再循环的集中润滑系统;
Recycleable central lubricating system;
- 采用变频器变频调速;
Use inverter for variable speed control;
- 无罐无盖保护系统;
No can No cover system;
- 配有双刀分盖系统;
Equipped with two separating knives on cone&dome magazine
- 可以选配安全防护罩和电动调高装置;
Optional for safety cover and automatic height adjustment



设备型号 Machine model	罐径 Diameter range		罐高 Height range	最快速度 Max speed
	mm	inch		
GT10C10B(8H)	45-73	113-300	90-320	280
GT10C10B(6H)	45-73	113-300	90-320	200

PAINT CAN COMBINATION MACHINE

油漆罐组合机

功能 Function	罐径 Diameter range		罐高 Height range	最快速度 Max speed
	mm	inch		
翻边 Flanging	52-110	202-405	70-160	180
	99-180	401-700	110-240	100
封底 End seaming	52-110	202-405	70-160	180
	99-180	401-700	110-240	100
封圈 Ring seaming	52-110	202-405	70-160	180
	99-180	401-700	110-240	100



CONTACT US

制罐线解决方案 Can making solution

多次密封罐成型设备 Re-coverable can molding equipment

RE-COVERABLE CAN MAKING EQUIPMENT

多次密封罐成型设备

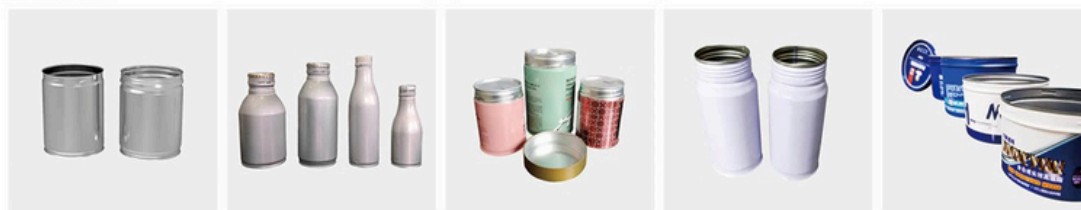
浙江龙文拥有多种自有专利的罐体成型技术，可以通过这些技术的组合，为客户创造出独一无二的罐型。
Zhejiang Longwen own a variety of proprietary can forming technologies, which can be combined to create a unique can for customers

产品优势 ADVANTAGE

- 定制开发罐型，提高产品包装吸引力；
Customized development of can shape to improve packaging attraction
- 拥有多项专利技术，定制罐型不易被仿造，提升防伪能力；
With a number of patented technologies, the customized can shape is not easy to be imitated, improving the anti-counterfeiting ability
- 有助于客户减少市场竞争，增加包装物的附加值；
Help customers to reduce market competition and increase the added value of packaging



多次密封罐 RE-COVERABLE CAN



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DISTINCTIVE CAN MAKING MACHINES

特殊罐型生产设备

浙江龙文拥有多种自有专利的罐体成型技术，可以通过这些技术的组合，为客户创造出独一无二的罐型。
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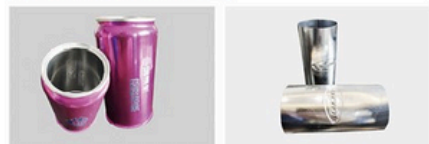
产品优势 ADVANTAGE

- 定制开发罐型，提高产品包装吸引力；
Customized development of can shape to improve packaging attraction
- 拥有多项专利技术，定制罐型不易被仿造，提升防伪能力；
With a number of patented technologies, the customized can shape is not easy to be imitated, improving the anti-counterfeiting ability
- 有助于客户减少市场竞争，增加包装物的附加值；
Help customers to reduce market competition and increase the added value of packaging



奶粉罐定制设备
Milk powder can customization equipment

浮雕罐 EMBOSSED CAN



异型罐 SHAPED CAN



专用罐 SPECIAL PURPOSE CAN



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制罐线解决方案 Can making solution

真空检漏机 Vacuum leaking test machine

VACUUM LEAKING TEST MACHINE

真空检漏机

特点 ADVANTAGE

- 高精密度压力传感器
High precision pressure sensor
- 先进数据分析系统
Advanced system for data analysis
- 智能控制系统
Intelligent control system
- 密封系统可靠、寿命长
High reliable hermetic system and long life
- 无损在线检测
Non-destructive Online inspecting
- 参数化控制
Parameterize control
- 数字化显示
Digital display
- 转盘式调整罐高
Adjustment the can height in rotating disc type
- 操作简单
Easy operation
- 快速更换罐型
Quick to change can size



设备参数 MACHINE SPECIFICATION

适用范围 Test for	型号 Model	罐高 Height range mm	罐径 Diameter range mm	检测精度 Precision mm	速度 Max speed CPM	压缩空气 Compressed air
食品罐、饮料罐 干粉罐、油漆罐 Food & beverage Can Powder can ,Paint can	GT3E98-T-L20H	110-220	99-153	0.15mm	180CPM	50L/6bar
	GT3E98-T-S20H	50-180	52-99	0.1mm	200CPM	
	GT3E98-T-S40H	50-180	52-99		400CPM	
	GT3E98-T-S60H	50-180	52-99		600CPM	



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PRESSURE LEAKING TEST MACHINE 高精度正压检漏机

本产品采用多项高智能核心技术检测工艺，确保机器高速、稳定、可靠地实现无损伤在线检测；适用于各类金属类容器，尤其是易撕盖容器的气密性检测。

This product adopts a number of high intelligent technology testing process, to ensure that the machine can achieve high-speed, stable and reliable on-line detection without end damage; it is suitable for the seaming test of all kinds of cans, especially for the POE ends.

设备特点 ADVANTAGE

- 进口感应器确保检测结果高精度，定制 PLC 系统检测结果可保存；
Using European brand sensors to ensure high accuracy of test results, and customized PLC system can save the test results.
- 在线检测且测试过程对罐体无损伤；
Online inspection and no damage to the canbody during the test.
- 采用凸轮机构对罐体进行升降，确保密封压力且可靠耐用；
Cam mechanism is used to lift the can body to ensure the sealing pressure is reliable and durable.
- 采用不锈钢外罩，确保食品安全；
Using stainless steel cover to prevent pollution and ensure food safety.
- 直接采用车间空气，无需经过任何空压系统，节省能源并避免二次污染；
Recycled using of workshop air to test, saving compress air and avoiding secondary pollution.
- 不锈钢外壳为选配
The stainless cover is for optional



适用范围 Test for	型号 Model	罐高 Height range mm	罐径 Dia range mm	检测精度 Precision	速度 Max speed CPM
干粉罐 Powder can	GT3E98-T-M15H	110-245	99-153	0.05mm	150
干粉罐 Powder can	GT3E98-T-M20H	110-245	99-153		200
干粉罐、食品饮料罐 Powder&Food& Beverage can	GT3E98-T-S30H	110-245	52-99		300
食品饮料罐 Food&Beverage can	GT3E98-T-S48H	70-150	52-65		400



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制罐线解决方案 Can making solution

气雾罐高压检漏机 High pressure leaking test machine(aerosol)

HIGH PRESSURE LEAKING TEST MACHINE

高压罐体检漏机

特点 ADVANTAGE

- 适用于内容物有压力要求的罐体检测
Testing can with high inside pressure
- 检测过程对产品无破坏性
Nondestructive testing;
- 进口高精度传感器，性能可靠
European brand high precision sensors, better reliability
- 具备温度补偿系统，提高检测精度
Temperature compensation system, improve the detection accuracy.
- 设备界面人性化，操作简便
Equipment interface humanization, easy operation.
- 自动调高系统，换型更加简单
Fast changeover and height adjustment.



技术参数 TECHNICAL SPECIFICATION

适用范围 Test for	型号 Model	罐高 Height range mm	罐径 Diameter range mm	检测精度 Precision	速度 Max speed CPM	压缩空气 Compressed air
气雾罐 Aerosol can	GT3E98-T-A24H	80-320	45-70	2cc/min	220CPM	8-12Bar
	GT3E98-T-A36H	80-320	45-70		320CPM	
	GT3E98-T-A48H	80-320	45-70		450CPM	
啤酒罐 Beer can	GT3E98-T-B18H	110-300	52-86	0.05mm	160CPM	8-12Bar
	GT3E98-T-B24H				200CPM	



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PALLETIZER SYSTEM 码垛系统

可以根据客户需要，设计自动化金属罐收集、打包、码垛、上托盘系统。整套系统全机械手设计，最大限度的减少人工成本。
Could design an automatic system according to the customer's demand, including metal cans collection, strap and wrapper, stacking, pallet feeding system. Whole system using palletizing robot, minimize labor costs.

码垛机形式 Stacker	可选功能 Optional features					
	适应罐型 To adapt to the tank type	在线打带 Strap online	在线裹膜 Wrap online	自动上托盘 Auto pallet infeed	自动加衬纸 /PE 垫 Auto intermediary paper infeed	自动加盖板 Auto cover infeed
GT9D90						
半自动码垛机 Semi-auto Palletizer	饮料罐、食品罐、奶粉罐 Food\Beverage\Milk powder can					
磁吸式码垛机 Magnetic Palletizer	奶粉罐、喷雾罐 Milk powder & Aerosol can	★	★	★	★	★
高位码垛机 High Level Palletizer	所有罐型 All can sizes	★	★	★	★	★
全自动机械人码垛机 Full automatic robot Palletizer	所有罐型 All can sizes	★	★	★	★	★



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METAL END MAKING MACHINE AND LINE SOLUTION 金属制盖设备及整线方案

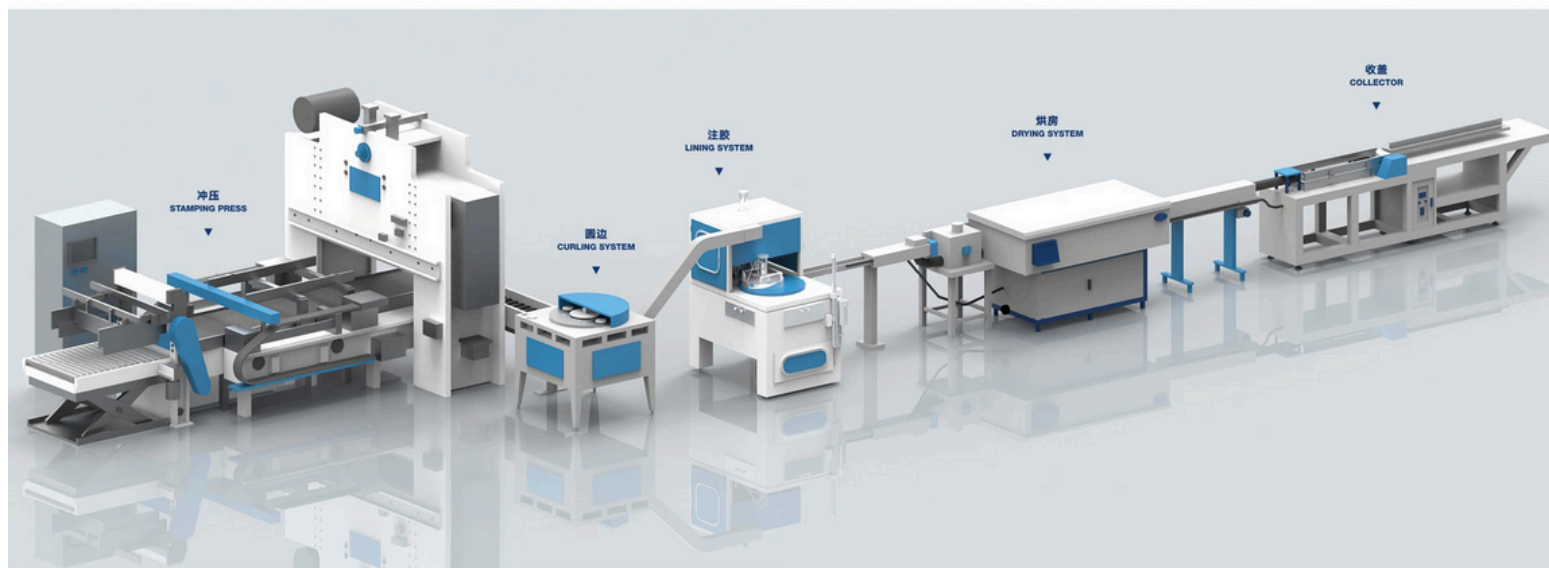
可用于生产 OUR MACHINE CAN PRODUCE:

食品、饮料罐底盖, 顶盖基础盖; 奶粉罐底盖, 圈盖; 喷雾罐底盖, 顶盖; 油漆罐底盖, 圈盖; 各类异形罐底盖和顶盖基础盖。

Our machine can produce: End and shell for food & beverage can. End and ring cover for milk powder can. Cone and dome for aerosol can. End and ring cover for paint can. End and shell for irregular shape cans.



STAMPING PRESS 冲压	单排模冲床 Single row tooling	单机械手进料 Single zigzag		双机械手进料 Double zigzag	
	双排模冲床 Double row tooling	片材进料 Sheet feeder		卷材进料 Coil feeder	
CURLING SYSTEM 圆边	圆盘式 Disc curler				
LINING SYSTEM 注胶	旋转式 Rotary	3 注胶头 3 heads	4 注胶头 4 heads	6 注胶头 6 heads	8 注胶头 8 heads
	直线式 Straight	单通道 Single channel		双通道 Dual channel	
DRYING SYSTEM 烘房	电热立式烘房 Electric heating drying system	单通道 Single channel		双通道 Dual channel	
	电磁感应烘房 Electromagnetic induction drying system	单节 Single section		多节 Multisection	



CONTACT US

金属盖线 End making line

金属盖冲床系列 CNC sheet feed press for metal end making

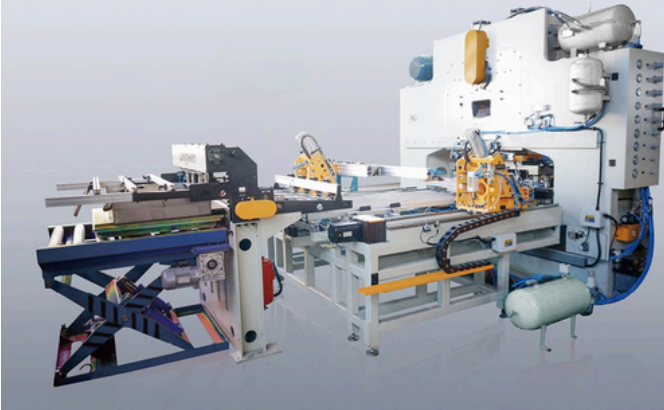
CNC SHEET FEED PRESS FOR METAL END MAKING

金属盖冲床系列

行业领先的自动化机械手进料系统，保证送料顺畅、快速，充分提高产能。相比传统冲床系统，可大幅减少废料率，提高原材料利用率。Industry-leading automation zigzag feeding system, ensure the feeding smooth, fast, fully improve the capacity. Compared with the traditional punching system, can greatly reduce scrap rate, improve the utilization rate of raw materials.

特点 ADVANTAGE

- 公司凭借丰富的模具设计经验，可为客户定制模具，保证在减薄马口铁厚度的同时不降低最终产品强度，为客户节约成本；
With experienced in mold design, we could provide tailor-made to customer's exact need. In order to save the cost, we ensure the thinning of tinplate thickness will not reduce the strength of the final product.
- 公司具备完善的模具加工设备检测体系，模具中关键零件全部采用进口材料；
We have perfect mould processing equipment and testing system, key parts in the mold all adopt imported materials;
- 国际标准的安全防护设置，保证生产安全性
The international standard of safe protection Settings, ensure the safety production
- 全自动控制系统，多语言界面，易于操作
Automatic control system, support in several languages, easy to operate
- 模块化结构设计，便于维修保养
Modular design, easy to maintenance.
- 专业的冲床模具设计
Professional punch die design



金属制盖设备及解决方案
METAL END MAKING MACHINE AND LINE SOLUTION

技术参数 TECHNICAL SPECIFICATION

冲床型号 Model	公称压力 Pressure	冲速 Strokes	适用规格 End dia		模数 Number of tooling	最大产能 Max capacity
	KN	SPM	mm	inch		EPM(max)
GT2A78	630	100-180	47-153	113-603	1-2	300
GT2A48A	800	100-180	47-153	113-603	2-6	1000
GT2A48	1000	100-200	47-153	113-603	3-8	1300
GT2A48D	1000	100-200	47-153	113-603	3-8	1400
GT2A48H	1000	100-200	47-153	113-603	3-8	1500
GT2A125	1250	150-200	47-99	113-401	8-16	3000

各系统适应盖型 Applicable end type

主机型号 Model	食品饮料罐底盖 End for food and beverage	易拉盖基础盖 Shell for easy open end	奶粉罐底盖 End for milk powder	奶粉罐侧盖 Ring for milk powder	气雾罐底盖 Aerosol dome	气雾罐顶盖基础盖 Shell for aerosol cone	油漆罐底盖 End for paint can
GT2A78	▲	▲	▲	▲	▲	▲	▲
GT2A48A	▲	▲	▲	▲	▲	▲	▲
GT2A48	▲	▲	▲	▲	▲	▲	▲
GT2A48D	▲	▲	▲	▲	▲	▲	▲
GT2A48H	▲	▲	▲	▲	▲	▲	▲
GT2A125	▲	▲	▲	▲	▲	▲	▲



食品饮料罐底盖



奶粉罐底盖



气雾罐底盖



油漆罐底盖



易拉盖基础盖



奶粉罐侧盖



气雾罐顶盖基础盖

PROFESSIONAL ZIGZAG FEEDING SYSTEM

专业的机械手进料系统



单机手进料
Single zigzag



双机械手进料
Dual zigzag



CONTACT US

金属罐线 End making line

双排模冲床 GT2A125 系列 High speed press with double-row die GT2A125

HIGH SPEED PRESS WITH DOUBLE-ROW DIE 双排模冲床 GT2A125

设备适用于铝或者铁材质的片料、卷料，可用于高速生产食品、饮料罐底盖和基础盖；
Adapted to the aluminum or tinfoil sheet or coil, can be used in the high-speed production of food cans and beverage cans' bottom end and shell

无空冲
No idle strokes

卷材片料通用
Coil and sheet
available

铝材及铁通用
Tinfoil and
aluminum available



金属罐线设备及其解决方案
METAL END MAKING MACHINE AND LINE SOLUTION

特点 ADVANTAGE

- 采用双排模结构，产能大幅度提高
With double-row multi-die, the capacity is greatly increased.
- 采用液压锁紧，有助于维持机器精度和冲模寿命
With hydraulic lock, the machine precision and the die life can be ensured.
- 六点滑动导向
With six-point slide guide.
- 润滑系统带有监控，确保润滑有效
With lubrication monitoring, the effective lubrication can be ensured.
- 机械式闭合高度，集中调整
With centralized adjustment for the mechanical shut height
- 配有计数器、配备曲轴位置指示
With a counter, a position indicator of crankshaft
- 液压过载保护系统直接装在滑块上，能及时反馈压力过载情况，保护冲模
Hydraulic overload protection system is installed on the ram directly in order to report pressure overload timely and protect the critical dies
- 滑块可快速提升
The ram can be lift quickly



技术参数 TECHNICAL SPECIFICATION

公称压力	Nominal pressure	1250KN
冲压行程	Length of stroke	50mm
最大冲速	Strokes per min	2005PM
适用直径	Can diameter	113-401
最大装模	Tooling max	16
封闭高度调整量	Adjustment of die shut height	10mm
最大封闭高度	Die shut height	385mm
快速提升长度	Ram lift height	100mm
冲压台面尺寸	Punch table dimensions	1220*700mm
主电机功率	Driving power	22KW
外形尺寸	Overall dimensions	2520*1840*3980mm
整机重量	Net weight	21T



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金属罐盖 End making line 级进式冲床 (专业生产气雾顶盖、阀门封杯) Transfer press for aerosol cone & mounting cup

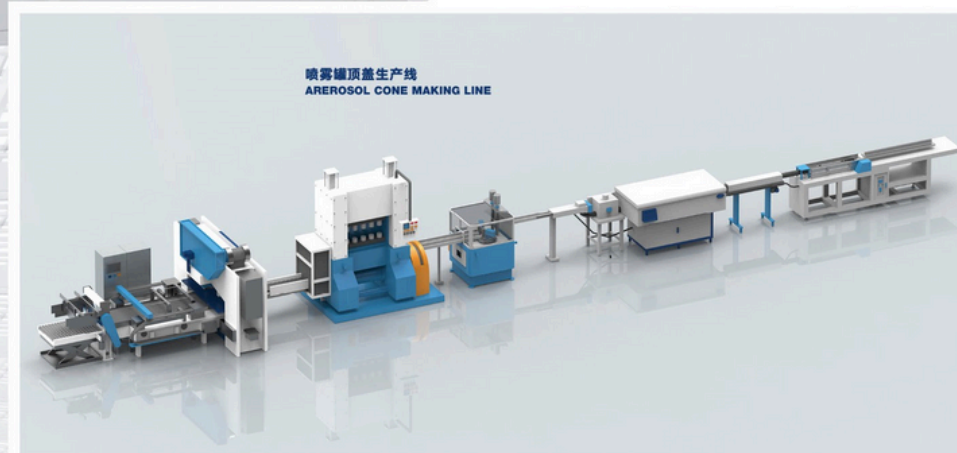
TRANSFER PRESS FOR AEROSOL CONE & MOUNTING CUP

级进式冲床 (专业生产气雾顶盖、阀门封杯)

特点 ADVANTAGE

- 专为制造罐盖设计的级进式系统，生产的产品质量优于普通冲床；
The step transfer system press designed for making cone, the product quality is better than normal press.
- 双通道冲床拥有自主研发产权，生产速度行业领先；
Dual channel press with independent research and development of patent rights, the speed is leading in industry level.
- 独特的动平衡设计及精密的模具加工确保设备高速运转；
Unique dynamic balance design and precise tooling processing ensure high-speed operation of the equipment.





技术参数 TECHNICAL SPECIFICATION

型号 Press type	GT2A88	GT2A88DH
公称压力 Pressure	400KN	800KN
冲速 Stroke max	180SPM	180SPM
适用规格 End size	41-73mm	41-65mm
工位 Tooling	8-9	8-9
最大产能 Max. capacity	180EPM	360EPM



气雾罐顶盖
Aerosol Cone



气雾罐及卡式炉阀门封杯
Mounting Cup



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TWIST-OFF CAP FORMING AND LINING MACHINE

旋开盖成型注胶一体机

特点 ADVANTAGE

- 采用四导柱式机构，确保工作稳定性和精度。
Ram guide by four guide pillars for higher precision and stability.
- 采用缓冲气缸，确保更稳定的冲压和成型尺寸。
With buffer cylinder for steady punching and forming size.
- 自带集中润滑系统设备寿命更长。
With automatic lubrication system for long service life of machine.
- 内置式电器柜使得设备占用空间更少。
Built-in electrical cabinet for small floor area and simple appearance.
- 自带曲轴平衡系统，工作时震动更小并有效延长机器寿命。
With balanced crankshaft for lower vibration and longer service life of machine.
- 采用进口品牌凸轮分度器确保机器精度和速度。
With imported cam indexer for high positioning precision.
- 带流程控制系统卡盖自动停机。
With flow control for auto-stop in case of failure.



- 四导柱设计，成型精度更高，机器更耐用。
Four guide column design, higher molding accuracy, more durable machine.



型号 Model	工序 Stations	最快速度 Capacity max	适应盖规格 Cap Diameter	总功率 Power	压缩空气 Air consumption	外形尺寸 Overall Dimensions
TOC-250	预卷; 卷圆; 成爪; 注胶 Pre-curling, Curling, Forming, Lining	220 Caps/ Min	ø38mm-ø82mm	8.5KW	0.3M³/Min, ≥0.6MPa	1500×1100×1880mm



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PEEL-OFF END(POE)SEALING MACHINE

易撕盖覆膜机

特点 ADVANTAGE

- 该产品自动完成下盖、冲孔、拉伸、卷边、冲膜(箔)预封、封口、压花、输出等功能

The machine combines including feeding, punching, drawing, curling, foil punching pre-sealing, sealing, embossing, transporting and other functions

- 独立伺服控制的各功能模块，可单独调节参数，并可实现高速响应及同步动作，斜冲排列的方式可使封口材料浪费最少

Each function module under independent servo control, which can adjust parameters alone. And it can realize high speed response and synchronous movement. oblique shock arrangement can make the sealing material waste to a minimum



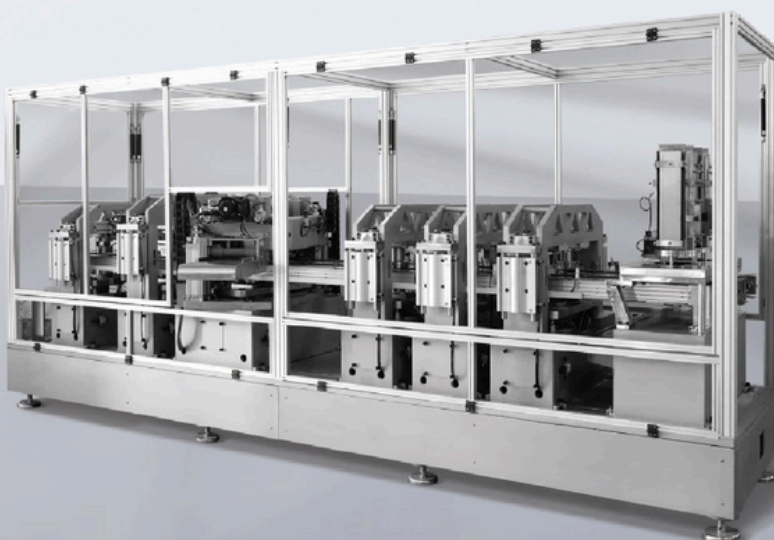
可使用的基础盖材料 SHELL MATERIAL

镀锡薄板、镀铬薄板、铝材、涂层钢板
Tin plate, TFS, aluminum, coated steel plate.

可使用的封口膜材料 SEALING FOIL MATERIAL

涂层铝箔、PP复合铝箔、塑料复合膜、纸复合膜

Coated aluminum foil, PP-Aluminum composite foil, plastic composite film, paper composite film



技术参数 TECHNICAL SPECIFICATION

型号 Model	SKM-Y	SKM-B-1	SKM-B-2	SKM-B-3
通道数 Channles	1	1	2	3
适合盖型 End size[mm/in]	46-77/113-300	127-178/502-701	52-153/202-603	52-65/202-211
产能 Capacity (EPM)	100-200	100-200	200-400	300-600



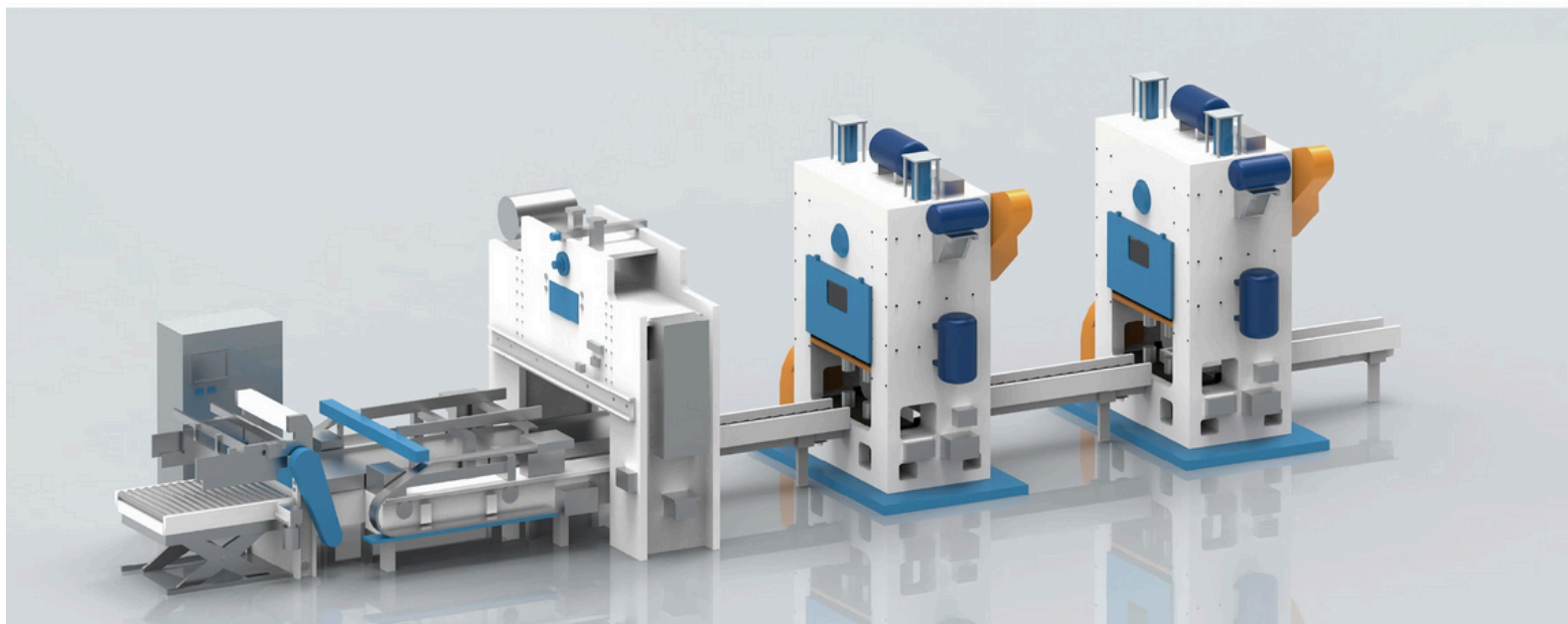
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DRD CAN MAKING LINE SOLUTION

二片罐设备及生产线方案

可根据客户要求定制各类标准和异型两片罐生产线。
Can design normal or irregular shape DRD can making line for customer's requirements
可以根据客户的需要配置不同的生产速度（100CPM, 200CPM, 400CPM）
The line speed can be different to match customer's requirement.



CONTACT US

PUNCH PRESS 落料冲床

特点 ADVANTAGE

- 专为金属包装设计生产的冲床系统，机架用料更厚、刚性更好。
Punch press system designed for metal packaging production, material for frame is thicker and more rigid.

型号 Model	冲压行程 Length of stroke mm	公称压力 Nominal pressure KN	冲速 Number of strokes/min SPM	模数 Number of tooling
GT2A78	120	630	100-180	1
GT2A48A-B	140	800	70-130	1-4
GT2A48A	120	800	90-130	1-2

拉伸
Redrawing

成型
Panelling

修边
Trimming



DRD PRESS 深拉伸冲床

特点 ADVANTAGE

- 专为 DRD 罐定制的冲床，拉伸长度深，导向精度高。
A punch press specially designed for DRD can, deep redraw length and better fix position.
- 级进式冲床可容纳三个工位，大幅节约场地空间。
The double lane transfer press can set 3 stations in one machine, saving space and energy.

型号 Model	冲压行程 Length of stroke mm	公称压力 Nominal pressure KN	冲速 Strokes(max) SPM	装模数量 Number of tooling(max)
GT2A80	170	800	100-120	2
GT2A80i	240	800	80-100	2
GT2A100	180	800	100-120	2x3
GT2A160	280	1600	80	2x3
GT2A200	380	2000	60	2x3

以上参数仅供参考，具体数据需根据实际罐型及生产要求确定。
The above parameters are for reference only, the specific data should be determined according to the actual can type and production requirements.



CONTACT US

SERVO DRAWING PRESS

伺服拉伸冲床

伺服冲床的冲压速度和拉伸位置可以任意设定，并可以依据冲压材料的特性定制加工曲线。适用于长行程和特殊材料的拉伸变形。

该设备可以将加工条件数控化，可以将每条冲压曲线的相关参数记录，对应使用模具搭配资料库记录功能，可于每次更换模具时取出之前记录的参数使用，大幅提升换模和换型效率；

该设备待机时为静止状态，伺服马达仅在启动冲压时才会工作并提供工件成型所需的力，相比于普通冲床更加高效节能。

The press speed and tensile position of the servo punch can be arbitrarily set, and the machining curve can be customized according to the characteristics of the stamping material. Suitable for long travel and tensile deformation of special materials.

The equipment can numerically control the processing conditions, can record the relevant parameters of each stamping curve, corresponding to the use of the mold matching database recording function, can be used in each mold replacement before the recorded parameters, greatly improve the efficiency of mold change and mold change;

The machine is in a static state when standby, and the servo motor only works when the stamping is started and provides the force required for the workpiece forming, which is more efficient and energy efficient than the ordinary press.



设备内部可以安装不同种模具，一次冲压完成多道工序。
Inside the equipment can be according to different kinds of molds, a stamping to complete multiple processes.

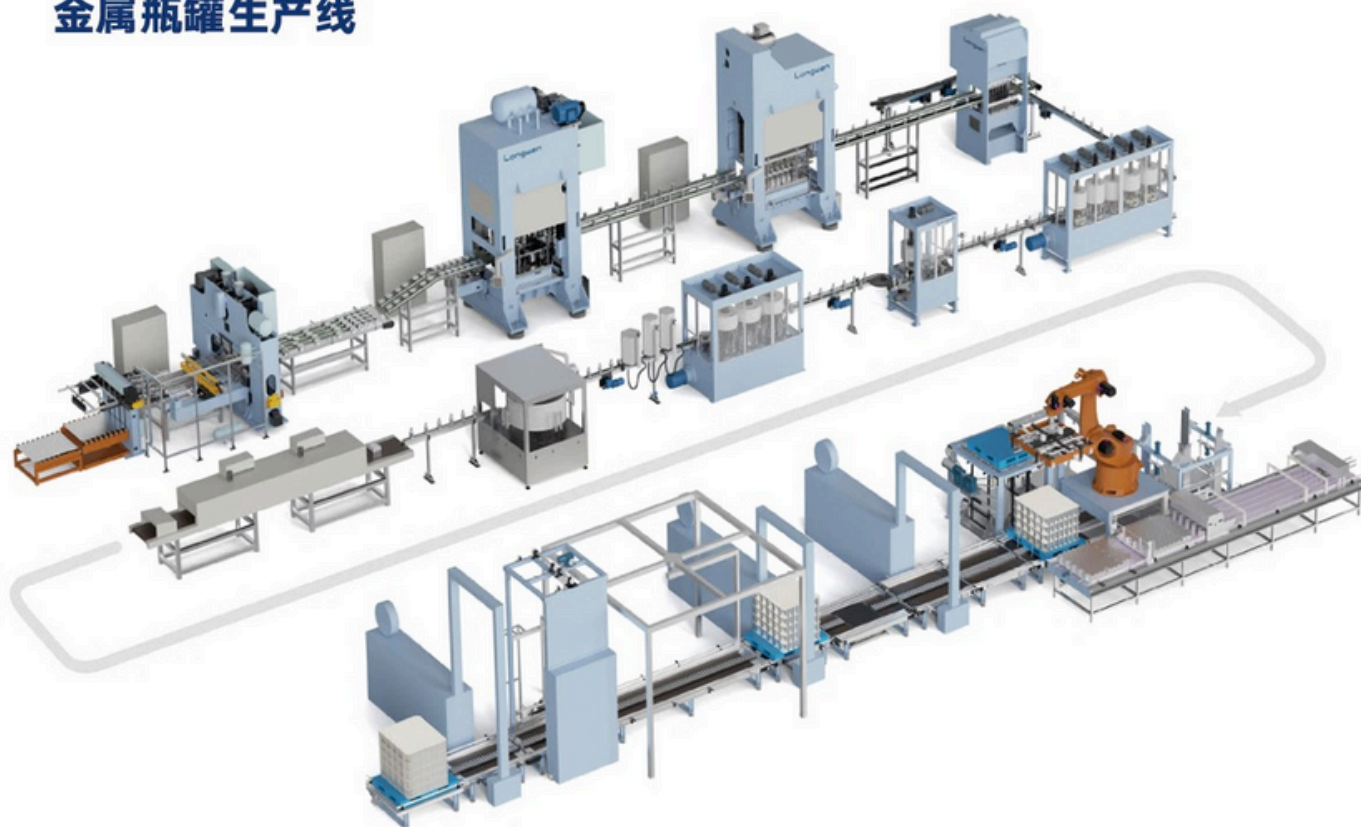


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METAL BOTTLE CAN PRODUCTION LINE

金属瓶罐生产线



浙江龙文综合设备和技术优势，将公司特色的：多工位级进冲床、伺服深拉伸冲床、金属瓶口螺纹成型机等设备融合到一条生产线中，使得该生产线可以满足：DRD(不减薄)深拉伸、瓶口缩颈工艺、螺纹成型工艺、底盖防爆等多种特殊制罐工艺的需求，生产出创新的金属包装产品。

Zhejiang Longwen comprehensive equipment and technical advantages, the company's characteristics: multi-station progressive punching machine, servo deep drawing punching machine, metal bottle screw forming machine and other equipment into a production line, so that the production line can meet: DRD(non-thinning) deep drawing, bottle necking process, screw forming process, bottom lid explosion-proof and other special canning process needs to produce innovative metal packaging products.



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