



**SHIJIAZHUANG
ZHONGTAI PIPE TECHNOLOGY
DEVELOPMENT CO., LTD**



**China Professional Manufacturer
Of Pipe / Tube Mill**

Shijiazhuang Zhongtai Pipe Technology Development Co., Ltd

Address: Room 1304 Kaiyuan Building, No.322 East Zhongshan Road, Shijiazhuang, China

Phone: +86-311-859506258 Whatsapp: +8615931058620

Fax: +86-311-85956667 Email: sales@ztzg.com

Website: <https://www.ztggsteeltech.com/>

Linkedin: <https://www.linkedin.com/company/chinatubemills/?viewAsMember=true>

Facebook: <https://www.facebook.com/chinatubemills>

Youtube: <https://www.youtube.com/@china-tubemills1533>



CATALOGUE

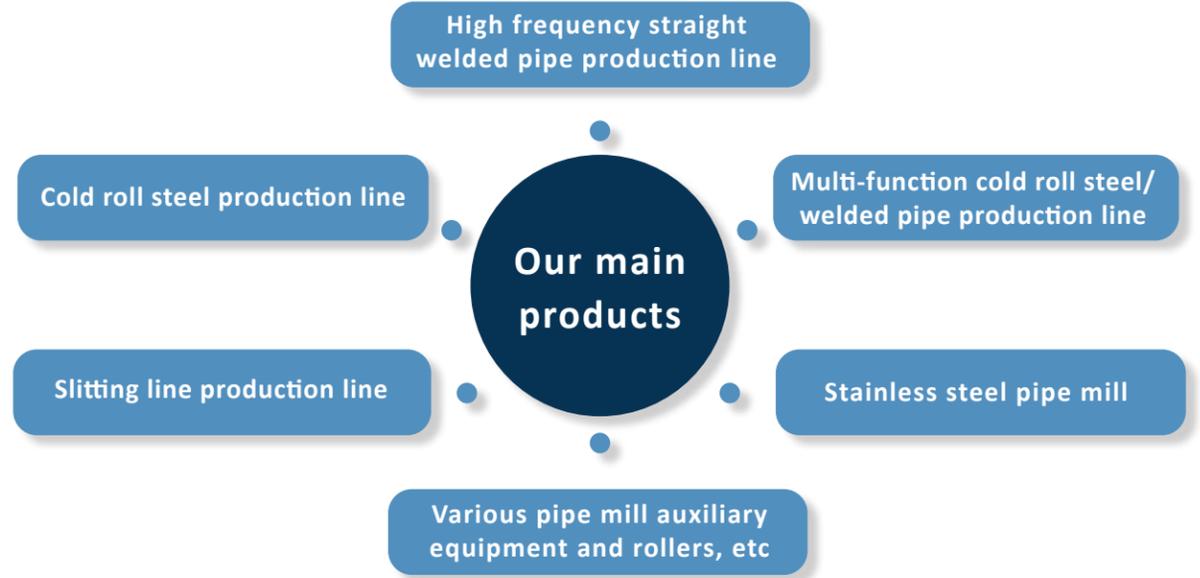
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ABSTRACT ▼



Shijiazhuang Zhongtai Pipe Technology Development Co., Ltd. was established in 2000 locating in Shijiazhuang, the capital city of Hebei Province. Adjacent to Beijing, we are endowed with convenient transportation and many geographical benefits. With the combination of R&D, production, sales, and service, our technicians work stably with precise working style. The factory covers an area of 67,000 square

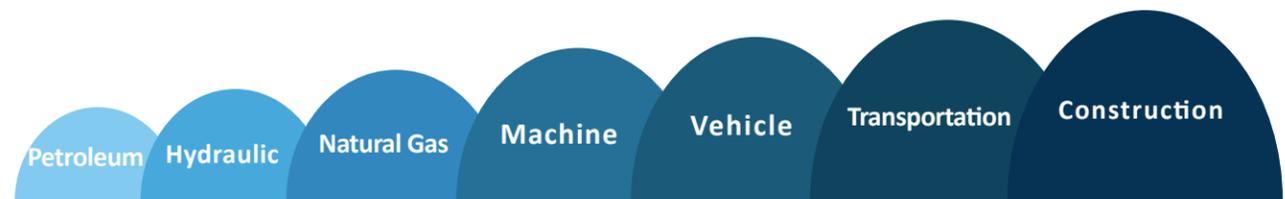
meters, consisting of moulding workshop, machining workshop, assembly workshop, and heat treatment workshop. Based on the principle of high efficiency & people-oriented service, our company scale expands steadily during the past decades. Now with our products sold across the country and around the globe, our company has become a scaled manufacturer in the welded pipeline production field.



FINISHED PRODUCT



APPLICATION



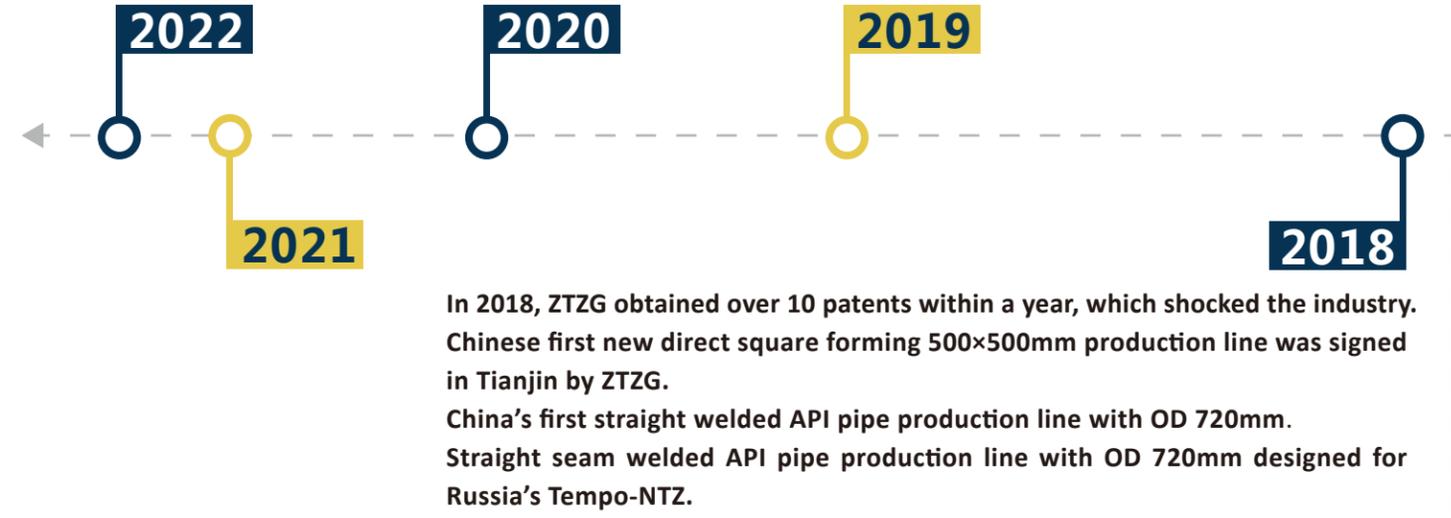
HISTORY ▼



In 2022, China's first advanced version direct square forming pipe line with fully-automatic adjustment.

In 2020, ZTZG signed the largest stainless steel double weld seams 862 pipe production line in China.

In 2019, China's first round-to-square shared roller production line. The F80X8 round-to-square shared roller forming process equipment was put into use in Tangshan Shunjie Cold Roll Forming Steel Co., LTD.



In 2001, a 150×150 tube mill was manufactured for Wuxi HengFa Color Coated Steel Sheets Co.,LTD
China's first directly square straight welded pipe production line.

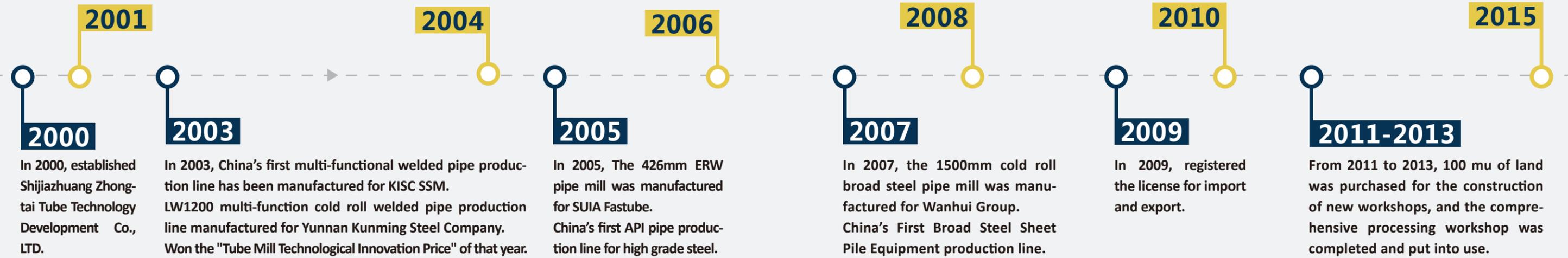
In 2004, the 273mm ZTF (ZhongTai Flexible Forming) -1 pipe mill was manufactured for Tianjin Zhongshun Steel Pipe Factory.
China's first welded pipe production line by using ZTF Technology.

In 2006, China's first stainless steel production line specialized for Railway Rail.
The 200×200mm special stainless steel sharp angle steel production line was manufactured for Shanxi Steel Group.

In 2008, ZTZG became an example company of Chinese Credit Rating System.

In 2010, passed ISO9001 Quality System Certification; Participated in the compilation of a number of industry standards.
"XZTF" technology won the China Cold Roll Forming Steel Technology Innovation Award.

In 2015, China's first direct square forming pipe line with fully-automatic adjustment
China's first computer-controlled online roll position adjustment direct square production line (compatible with round tube and square tube) was successfully tested in Turkey.



Business Philosophy



Honesty is the cornerstone

Take customer satisfaction as the criterion

Driven by technological innovation

In the pursuit of casting quality

Service



1.Warranty service

- (1) free timely replacement within the warranty period
- (2) Lifelong responsibility for quality maintenance period

2.Technical services

- (1) Installation and debugging
- (2) Technical support

3.Personnel services

- (1) One to one service
- (2) Uninterrupted website stationing

4.Response time

- (1) Timely response within one hour
- (2) after-sales service users return visit/active contact regular tracking

5.Daily maintenance

Strong Company With Over 20 Years of Experience

1.Subsidiary Company

Hebei Dexu Pipe Machinery Making CO,. LTD

2.Staff Member

With currently over 200 employees including over 30 R&D crew members with minimum of college degree and 25% of them with graduate degree and higher.

3.Sales Achievement

Over 100 million RMB(15.6 mil USD) of sales achievement in 2020 from both domestic and overseas' market.

4.Manufacturing Shop

Our factory covers the land of over 35000 in', consisting of a machining factory, a assembling factory, a heat treatment factory, and a moulding factory. All the factory follows 6S standards and are equipped with modernized machines.

Factory Environment



Machining workshop

Assembly workshop





PRODUCT TECHNIQUE ▼

Technology is the key in maintaining a high efficient and high quality product while minimizing the production cost. With the development of technology, we have entered an era of automation and computerization. Our research team strives for the realization of higher automation of pipe production for stronger, smaller, or bigger pipes.

ZTF Forming Process

ZTF is a forming technique developed by ZTZG in 2005. **It allows the shared-usage of rollers during break-down section when forming pipe**, saving significant mould and labor cost while greatly improving production efficiency.

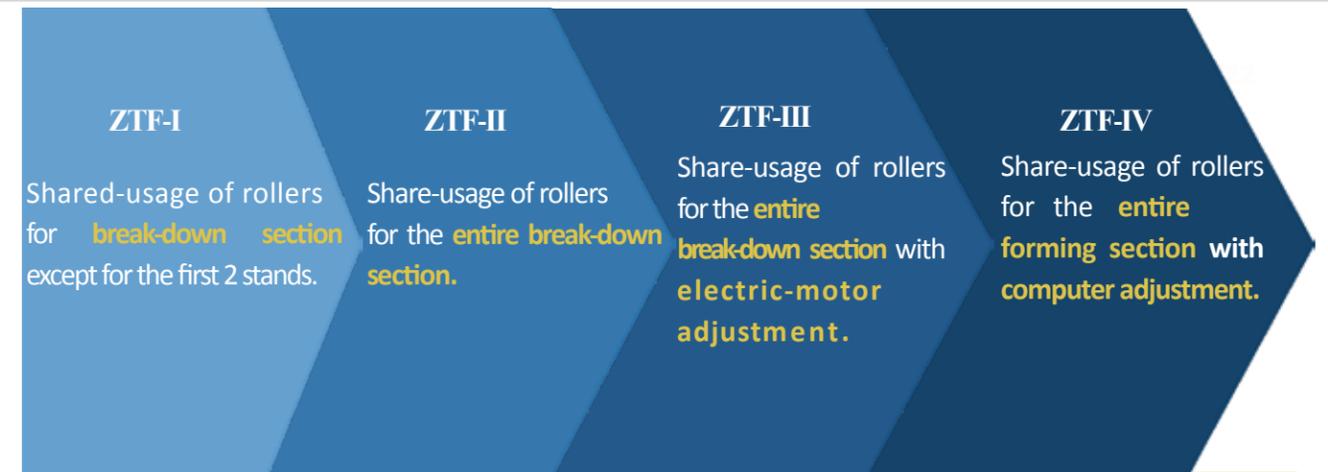
It earns the reward of 'Technology Innovation Award' by 'China Cold Forming Steel Association' in 2010. After absorbing advanced pipe making technology from both abroad and domestic, our innovative designed production line and each single unit of the production line are not only economical but also practical.



1. **Save 60% roller cost** per specification of desired product.
2. **Eliminate production down time** for break-down forming section roller replacement (typically 1-2 days per roller replacement).
3. Electric controlled with **high automation level**.
4. **Higher precision** and faster roller change speed.

ZTF CATEGORIZATION

Throughout the years, ZTZG has developed 4 generation for ZTF technique



Multi-functional Tube Production Line

Multi-functional production line combines the latest share-usage roller techniques(ZTF,DSS) in producing round pipe and square tube. **It can produce round pipe, square and rectangular pipe, and some of broach cold rolled section steel all with only one set of mill.**



1. Can produce straight welded round, square, rectangular, and unwelded abroach steel(C,Z,U,etc) within **1 set of production line.**
2. Save significant **roller cost** when producing multiple sizes of tube.
3. Allows share-use rollers in certain section, reduce labor intensity and **production efficiency.**
4. Adopts **advanced** quick-change system.

Quick-change System

- 1.Requires no dismount of flange plate screw.
- 2.Typical roller change period can reduced by 4/5 from standard changing methods.
- 3.Perfectly deal with water back-flow issue.
- 4.Automatically clear the scale cinder and dust while performing.

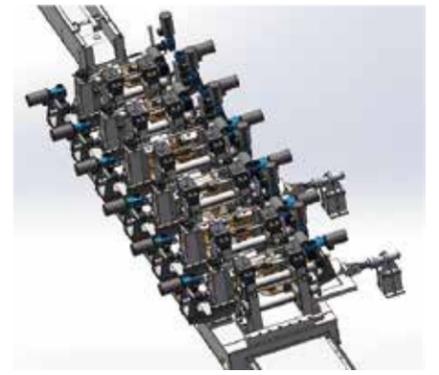
Quick-change Table

Allows the pre-assembly of rollers onto the stands on the quick-change table or quick-change shaft, when producing different size of rollers, load the quick-change system table directly onto the production and switch off the existing line. This system allows the unhalting production process, saving significant time during production.



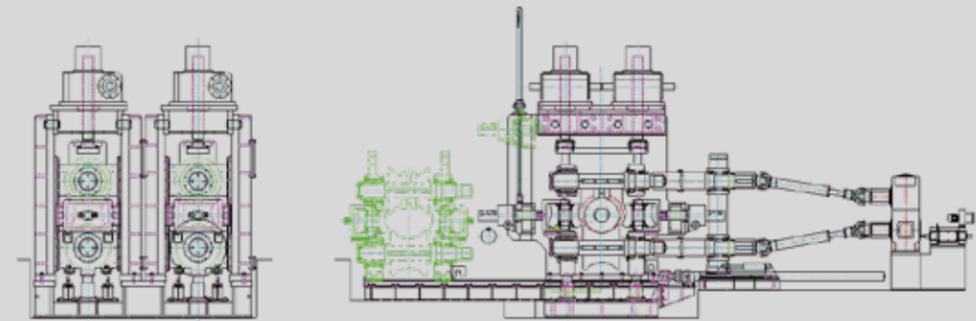
Auto Stands Adjustment System

When a production line has less than three specifications, this new auto-quick change system is recommended. There is no need to replace the mold, just pre-place the corresponding mold on the horizontal roll and vertical roll, and the automatic motor adjusts the roll position without the need of dismantling and roller switching.



Horizontal Stand Roller Quick-shaft Change System

When changing rollers, pull out the side of the entire shafting unit, lift the shafting unit with the first roller specification from the transport trolley with the crown and put it aside, lift the shafting unit installed with the second roller specification, place it on the transport trolley, and then push the shafting back to the frame. **It reduces roller replacement time for the entire mill from ~6 hours to ≤2 hours.**



Hydraulic Shaft Quick-Change System

Hydraulic transmission shaft removal device: Transmission shaft is designed as quick-disassemble type which requires no dismount of flange plate screw. The disassemble of shaft utilize hydraulic system for easy operation. Roller change period with quick-change system: Appr. 8 hours (typically 1.5-2 days needed without quick-change system)

If equipped with additional set of shaft, the appr. roller change period is < 2 hours

Quick Changing Shaft: When the steel pipe specification needs to be changed, preload the new specification and the quick-change shaft installed with the new roller can be put into production, so as to achieve the effect of quickly changing the steel pipe specification.





Direct Square to Square Pipe Mill

DSS technique directly reel the strip steel into desired sized tube with several distinct advantages. It adapts the multi-point bending method, which avoids the axial force and side abrasion, reduces the forming step, and ensures high quality. Compare to Round-to-Square(RS) forming technique, DSS creates better outer edge and smaller inner are for the cross section of the tube, and the brim is flatter with more regular outlook. With our new DSS-3 technique, **only one set of rollers is needed for the entire mill with no need for any roller or spacer replacement**, which achieves full-automatic adjustment for roller positions, significantly increasing production efficiency and reducing labor cost and risk of hazard.

- 
 Automatic Position Adjustment
- 
 One-button Control
- 
 Intellectualized Material Feeding



- 1. Save 95% roller cost** for square&rectangular sizes.
- 2. Occupies smaller floor space** compare to RS technique.
- 3. Saves raw material consumption** since the width of steel strip required is 2.4%-3% narrower than RS.
- 4. High Automation level**, require minimum to none manual adjustment.



Oblique Roll Stand
 It is used to extrude the R angle and ensure the angle control of forming R angle, solving the problem of uneven R angle in traditional direct square forming.

XZTF Round-to-Square Pipe Mill

Technique Overview:

With the increasing need in stronger structure and better quality square pipe, many more countries and regions are starting to favor the round-to-square cold formed square product due to their better inner R angle and shape. However, the convenience and automation level of round-to-square forming compare to direct square forming is still lacking in some degree due to the forced change of rollers in sizing section when producing different square products.



Details of XZTF Round-to-Square Forming Technique:

This most advanced patented technique developed by ZTZG utilizes round-to-square technique while allowing customer to only use **one set of rollers to produce all square pipe range within the set range, and share-use break-down section rollers when producing round pipe**, saving significant roller cost and increase productivity. The adjusting time when producing a different size of product should ≤ 2 hours.

No manual switching rollers, higher efficiency

	Roller Shareness	Labor Cost Saved	Worker Saved
Round	60%	80%	30%
Square&Rectangular	100%	100%	50%

Advantages

1. Save up to 95% roller cost per one size of desired product.

2. Even inner R angle for square products.

3. No reduced thickness for the R angle compare to direct square forming.

4. Eliminate the incidence of R angle cracking when producing high grade steel tubes.

5. High automation level.



Model List

ERW MODEL LIST

Model	Round pipe mm	Square pipe mm	Thickness mm	Working speed m/min
ERW20	Φ8-Φ20	6x6-15x15	0.3-1.5	120
ERW32	Φ10-Φ32	10x10-25x25	0.5-2.0	120
ERW50	Φ20-Φ50	15x15-40x40	0.8-3.0	120
ERW76	Φ32-Φ76	25x25-60x60	1.2-4.0	120
ERW89	Φ42-Φ89	35x35-70x70	1.5-4.5	110
ERW114	Φ48-Φ114	40x40-90x90	1.5-4.5	65
ERW140	Φ60-Φ140	50x50-110x110	2.0-5.0	60
ERW165	Φ76-Φ165	60x60-130x130	2.0-6.0	50
ERW219	Φ89-Φ219	70x70-170x170	2.0-8.0	50
ERW273	Φ114-Φ273	90x90-210x210	3.0-10.0	45
ERW325	Φ140-Φ325	110x110-250x250	4.0-12.7	40
ERW377	Φ165-Φ377	130x130-280x280	4.0-14.0	35
ERW406	Φ219-Φ406	170x170-330x330	6.0-16.0	30
ERW508	Φ273-Φ508	210x210-400x400	6.0-18.0	25
ERW660	Φ325-Φ660	250x250-500x500	6.0-20.0	20
ERW720	Φ355-Φ720	300x300-600x600	6.0-22.0	20

Stainless Steel Pipe Mill Model List

Model	Round pipe mm	Square pipe mm	Thickness mm	Working speed m/min
SS25	Φ6-Φ25	5x5-20x20	0.2-0.8	10
SS32	Φ6-Φ32	5x5-25x25	0.2-1.0	10
SS51	Φ9-Φ51	7x7-40x40	0.2-1.5	10
SS64	Φ12-Φ64	10x10-50x50	0.3-2.0	10
SS76	Φ25-Φ76	20x20-60x60	0.3-2.0	10
SS114	Φ38-Φ114	30x30-90x90	0.4-2.5	10
SS168	Φ76-Φ168	60x60-130x130	1.0-3.5	10
SS219	Φ114-Φ219	90x90-170x170	1.0-4.0	10
SS325	Φ219-Φ325	170x170-250x250	2.0-8.0	3
SS426	Φ219-Φ426	170x170-330x330	3.0-10.0	3
SS508	Φ273-Φ508	210x210-400x400	4.0-12.0	3
SS862	Φ508-Φ862	400x400-600x600	6.0-16.0	2

Service Advantage

One Hour Fast Response
One-To-One Exclusive Service
One Year Warranty & Life-Long Technical Service



Product Advantage

Sales Network All Over The World
Strict Quality Inspection Standards
With CE,BV,ISO 9001 Qualification

Our advantage

Technology Advantage

29 Invention Patents
Executive Member & Technical Support of Industry Association



R&D Advantage

Over One Hundred R & D Team
More Than 10 Senior Engineers
More Than 30 Intermediate Engineers

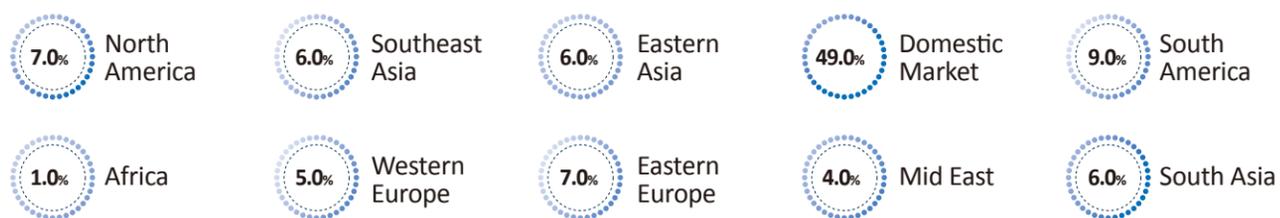
OUR SALES ▼



ZTZG has established long-term and stable cooperative relations with many large enterprises at home and abroad, including: Kunming Steel Holding Co., LTD., Russia Tempo-NTZ Company, India D.P. Jindal Group, Cambodia ISI Steel Company and other well-known domestic and foreign enterprises. Our company's turnover in 2021 reached \$60 million, and our products are exported to Southeast Asia, Europe, South America, Japan, Turkey and other countries and regions. ZTZG support customization according to international standards in each region, and provide excellent equipment for many large enterprises at home and abroad, and our products are all over the world!

Our export percentage is comprised of a number of major markets in which we have been leading since our establishment.

The export percentage can be broken down as:



Country: Iraq
 Company Name: Nojoom Alsuha
 Time: 2010
 Product Name: Φ 254 ZTF-2 API Pipe Production Line
 (Cooperated with the U.S government)



Country: Columbia
 Company Name: Acerias de Colombia ACESCO S.A.S
 Time: 2012
 Product Name: 300X300X12 Direct Square Forming Tube Production Line



Country: Turkey
 Company Name: BASATLI BORU PROFIL SANAYI VE TICARET A.S
 Time: 2015
 Product Name: Φ 273 Multi-functional Pipe Production Line



Country: Russia
 Company Name: Tempo-NTZ
 Time: 2018
 Product Name: Φ 720x22 API Pipe Production Line
 (Largest straight welded API production line exported by China)



Country: Japan
 Company Name: Confidential
 Time: 2021
 Product Name: ERW60X5 High Precision Vehicle Pipe Production Line



Certificate

