

ESSENTIAL SPECIAL ACCESSORIES

- Self-opening diehead with fine adjustment RH/LH (To be specified).
- Lead screw—RH/LH (To be specified) for PD4, PD4H, PD6H, PD8H and PD12H only.
- Coolant system including pump, tank, piping, guards.
- Low voltage machine lamp.
- Change gears—for machines with leadscrew.
- Chaser holder (1 set = 4 nos.) — RH/LH (To be specified)

N.B. Sizes of threads to be specified, so that suitable change gears and chaser holders can be recommended.

- Cutting Tool—6 : 5 : 2 HSS Tangential chasers, 62-65 HRC Lanco Type

$$4'' / 3'' \text{ lg.} \times 1 \frac{3''}{64} \text{ W} \times 10.7 \text{ mm thick (1 set = 4 nos.)}$$

- Chaser setting gauge with setting discs and dial gauge.
- Vice Jaws 6-40mm and 40—150mm.

OPTIONAL EQUIPEMNT

- Slitting Device and Chamfering Device except for PD3L and PD4L
- Chaser grinding fixture
- Tapping attachment (i) M6—M24 and (ii) M24—M36
- Nipple chuck and adaptors (N.B. Specify sizes of Nipples)
- Special diehead for self taper generation (Receding type diehead)
- Pneumatically operated self-centering vice for clamping of jobs
- Roller support for long pipes/bars.

TECHNICAL DATA SPECIFICATIONS

MODELS

	PD3L	PD4L	PD4	PD4H	PD6H	PD8H	PD12H
Threading range							
Pipe	$\frac{1}{4}''-1\frac{1}{2}''$	$\frac{1}{4}''-2''$	$\frac{1}{4}''-2''$	$\frac{1}{4}''-4''$	$\frac{1}{4}''-4''$	$\frac{1}{2}''-4\frac{1}{2}''$	$\frac{1}{2}''-6''$
Bolt	$\frac{1}{4}''-1''$	$\frac{1}{4}''-1\frac{1}{2}''$	$\frac{1}{4}''-2''$	$\frac{1}{4}''-2''$	$\frac{1}{4}''-3''$	$\frac{1}{2}''-4''$	$\frac{1}{2}''-6''$
Max. Thread Length	200mm	300mm	400mm	600mm	600mm	600mm	600mm
Spindle speeds (no. of steps)	a.	20-100(6)	15-75(6)	15-75(6)	14-144(6)	10-106(8)	8-80(9)
	b.	30-150(6)	30-150(6)	22-110(6)	30-180(6)	15-160(8)	12-119(9)
	c.	—	—	—	30-225(9)	—	6-37(4)
Power/	a.	2HP	3HP	3HP	5HP	7.5HP	10HP
	b.	2HP	4HP	4HP	7.5HP	7.5HP	10HP
	c.	—	—	—	7.5HP	—	7.5HP
Supply	415 Volts, 3 Phase, 50Hz., A.C.						

OTHER PRODUCTS FROM VIKRANT

- Production type Pipe Threading Machine — OPD Series
- Portable type Pipe Threading Machine (for site work) — PPT Series
- Special Threading Machines
- Complete range of COIL WINDING MACHINES and other special machines for Electrical Industries
- Machinery for TRACTION MOTOR INDUSTRY
- Welding and Assembly manipulators
- SPM's

VIKRANT SPECIAL MACHINES
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VIBRANT

SPECIAL MACHINES

PD SERIES

UNIVERSAL HEAVY DUTY TANGENTIAL TYPE THREADING MACHINES
for bolts and pipes—BSW, Metric, BSP, BSPT, NPT, Knuckle, Acme etc.



Principle of Threading : Diehead rotating - job stationary

Technical Features

- Close grained CI ribbed bed, headstock, carriage, vice guide and slides.
- Heat treated alloy/medium carbon steel gears and shafts.
- Speed change by shifting gears.
- All gears have generated tooth profile and ground bore.
- All shafts and main spindle are toughened, ground, run on antifriction bearings.
- Diehead of precision type, made of alloy steel, heat treated and ground.
- Vice jaws are hardened and ground.
- Vice travels right upto diehead for threading short and irregular shaped components.
- Long and bent pipes can be threaded.
- Hammer vices (except for PD3L and PD4L).
- Bolted bases and bed with rectangular guideways for Models PD4H, PD6H, PD8H and PD12H.
- Cylindrical ground guideways for Models PD3L and PD4L.
- Automatic halfnut dis-engagement.
- Model PD4 is equipped with cantilever type bed with rectangular guideways.
- Manual movement of carriage is by rack and pinion for PD4, PD4H, PD6H, PD8H and PD12H.
In case of PD3L and PD4L carriage movement is by lever system.
- Centralised control panel.
- Pre-set length of threading.