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➤ **PRE-DISPATCH INSPECTION AND TRAINING**

- In case of order, the machine will be inspected before dispatch at the premises of the manufacturer. All parameters/accessories/features/functions of the machine will be checked in detail during inspection. It will be the responsibility of the manufacturer to assist in every aspect to facilitate the inspection of the machine. The machine will be rejected if not found conformed to contract clauses without any liability at the buyer side.
- The manufacturer will provide comprehensive training to 02 engineers of the buyer at the manufacturer premises for operation, maintenance (electromechanical) and setup for a period of 07 working days free of cost.

➤ **MANUALS AND DOCUMENTS**

- All manuals and documents must be in English Language.
- Machine parts assembly drawings and technical details, Machine operating manuals and machine maintenance manuals (hard & soft form) should be provided at the time of supply of the machine.
- Detail of complete spare parts list including bought out items if any with full specification like make, size, description/source of supply, quantity required etc. should be given in the manuals.

➤ **MAKE**

- Only **TURKISH & EUROPEAN** made machines are acceptable.
- Country of origin of machine should be clearly mentioned.

➤ **PACKING OF MACHINE**

- Sea worthy packing as per international standard.

➤ **DISPATCH OF MACHINE**

- The supplier shall dispatch the machine duly packed as required. Any transit damage is to be replaced by the supplier at free of cost.

## 2-Roll Thread Forming Machine

### ➤ MACHINE TECHNICAL SPECIFICATIONS

- Material to Thread Form: Mild Steel (MS), Stainless Steel (SS), Aluminum (AL), Alloy Steel.
- Thread Types to Form: ISO, DIN, ACME, Worm Screw threads
- Rolling Force: 10-400 kN
- Die Hardness: Min. 50 HRC
- Die Sliding Speed: 0-6mm/s (Both Die Spindles can slide)
- Spindle Speed Range: 18-60 RPM
- Min./Max. Die Diameter:  $\varnothing$  145-  $\varnothing$  210 mm
- Max. Die Length: 170mm
- Work Piece Diameter:  $\varnothing$  3-  $\varnothing$  48mm
- Max. Pitch to Form : 5mm
- Die Swivel Angle:  $\pm 8^\circ$
- Cylinder Stroke: Min. 0-20mm
- Machine Control: PLC Controller for doing all threading operations.
- Motor Power: Min.11kw
- Electricity: 380V to 440V  $\pm 10V$ , AC supply, 50Hz.

### ➤ THREAD FORM DIE SETS:

Die Type	ISO (Metric Pitch) (mm)								Qty.
	1.0	1.25	1.5	1.75	2.0	2.5	3.0	4.0	
In Feed	1.0	1.25	1.5	1.75	2.0	2.5	3.0	4.0	02 Pair Each
Through Feed	1.0	1.25	1.5	1.75	2.0	2.5	3.0	4.0	02Pair Each

### ➤ MACHINE GENERAL SPECIFICATIONS:

- **Minimum die life must be 1000pcs/die on stainless steel work pieces. (SS304L: UTS 485MPa)**
- Centralized lubrication and Coolant system must be provided with machine.
- Machine Safety Covers must be provided with standard machine.
- Safety switches, sensors and guards must be installed with machine for operator's safety.
- Pneumatic centering equipment should be provided for precisely center the work piece.
- Pitch adjustment gear box is also provided for frequent pitch adjustments.
- Machine should be equipped with hydraulic brake system.

### ➤ SPARES

- Electrical/Mechanical/Electronics spare parts for 05 years trouble free operation. Max spare parts must be offered including circuit breakers/fusing, Servo motors, AC motors, rapid wearing parts as per actual installation on the machine etc. (Cost of each part must be quoted separately).