

S. H. Værktøjsmaskiner ApS

IMPORT * EXPORT * SERVICE

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SHV OILPIPE LATHE

OKA
CNC PIPE THREAD
LATHE SERIES

Ø120 Ø190 Ø260 Ø350



**Model**

QKA1212/19/26/35

Specification**QKA1212/19** | 750/1000/1500/2000/3000**QKA1226/35** | 1500/3000/5000**OKA**
CNC PIPE THREAD
LATHE SERIES

OKA-series CNC pipe thread lathes were developed mainly for the turning of oil-field pipe threads. But now they are also used to the turning of pipe threads of various kinds, e.g. cylindrical and conical threads, threads connected continuously one another, and end face threads as well, and they can also be used as universal CNC lathes for the turning of circumgyration bodies of various curving generatrices. These machines are suitable for varified work-pieces machining in medium and small batches, and are of good flexibility, high efficiency, finishing up with good conformity, and are easy to program, simple to operate. So they ate ideal medium-type mechanical machining equipment.



Structure

Bed with high rigidity for the sturdy body and widened guide-ways and with long life and high precision effectiveness for the twice aging,hardening, and grinding.

Headstock strong enough to support the heavy cutting force in turning for the sturdy structure, quenched and ground gears, large spindle and precision heavy duty bearings.

Centralized auto lubrication.

Guide-ways with TSP coated make the friction reduced and the performance promoted.

Chuck arrangement both at front end and rear end secures the stability and reliability.

Optional

1. Other CNC unit
2. V6 turret
3. Pneumatic/hydraulic chuck (with limited chucking range)
4. Steady rest
5. Higher accuracy than standard.

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| Item | | Unit | QKA1212 | QKA1219 | QKA1226 | QKA1235 |
|----------------------------|---|------|-------------------------|----------|----------------|------------|
| Capacities | | | | | | |
| | Swing over bed | mm | 770 | | 1000 | 1100 |
| | Swing over carriage | mm | 480 | | 630 | 730 |
| External diameter of pipes | Manual chuck | mm | Ø120 | Ø190 | Ø70 – 260 | Ø114 – 340 |
| | | mm | | | | Ø127 – 340 |
| | | mm | | | | |
| | Maximum length of workpiece | mm | 750 1000 1500 2000 3000 | | 1500 3000 5000 | |
| | Maximum turning length | mm | 600 850 1350 1350 2850 | | 1300 2800 4300 | |
| | Span of guideway | mm | 550 | | 755 | |
| Spindle | | | | | | |
| | Spindle nose | | C11 | C11 | A215 | A2'5 |
| Step of spindle speed | three-phase asyn-chronous motor variable frequency variable speed motor | | 16 | 8 | | |
| | | | | | | |
| | | | | | | |
| Range of spindle speed | three-phase asyn-chronous motor variable frequency variable speed motor | | 25 – 800 | 90 – 450 | | |
| | | | | | 6 – 400 | 5 – 320 |
| | | | | | | |
| Power of main motor | three-phase asyn-chronous motor variable frequency variable speed motor | kW | 11 | | | |
| | | | | | 18.5 | |
| | | kW | | | | |
| | Spindle bore | mm | 130 | 200 | 275 | 355 |
| Chuck type | Manual chuck | | ★ Ø380 | ★ Ø500 | ★ Ø630 | ★ Ø780 |
| | | | | | | ▲ Ø760 |
| | | | | | | |
| | Center height from bed | | 385 | | 500 | 550 |
| Feed motion | | | | | | |
| X/Z | Minimum feed increment of X-/Z-axis | mmr | 0.001/0.001 | | | |
| X/Z | Rapid speeds of X-/Z-axis | mmr | 3000/6000 | | | |
| X | Maximum travel of X-axis | mmr | 390 | | 630 | |

QKA

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Turret

| | | |
|------------------------|----------|----------|
| Turret type | V4 □ 240 | V4 □ 300 |
| Section of tool shank | mm □ 32 | □ 40 |
| turret indexing time | s 2.5 | 4 |
| Indexing repeatability | mm 0.008 | 0.01 |

Tailstock

| | | |
|-------------------------------|---------|---------|
| Diameter of tailstock quill | mm 100 | 160 |
| Travel of tailstock quill | mm 250 | 300 |
| Taper hole of tailstock quill | morse 5 | morse 6 |

Accuracy and acceptance conditions

| | |
|-----------------------|--------------------------------|
| Workpiece accuracy | IT6 ~ 7 |
| Surface roughness | Ra1.6 |
| Acceptance conditions | JB/T8324.1-96 JB/T8324.2-96 |

Machine overall dimensions

| | |
|--------------|--|
| Length | mm 2912 3227 3677 4177 5177 4800 6300 8300 |
| Width | mm 1800 2460 |
| Height | mm 1850 2120 |
| Machine mass | kg 3700 3900 4200 4700 5200 9000 10000 13000 |

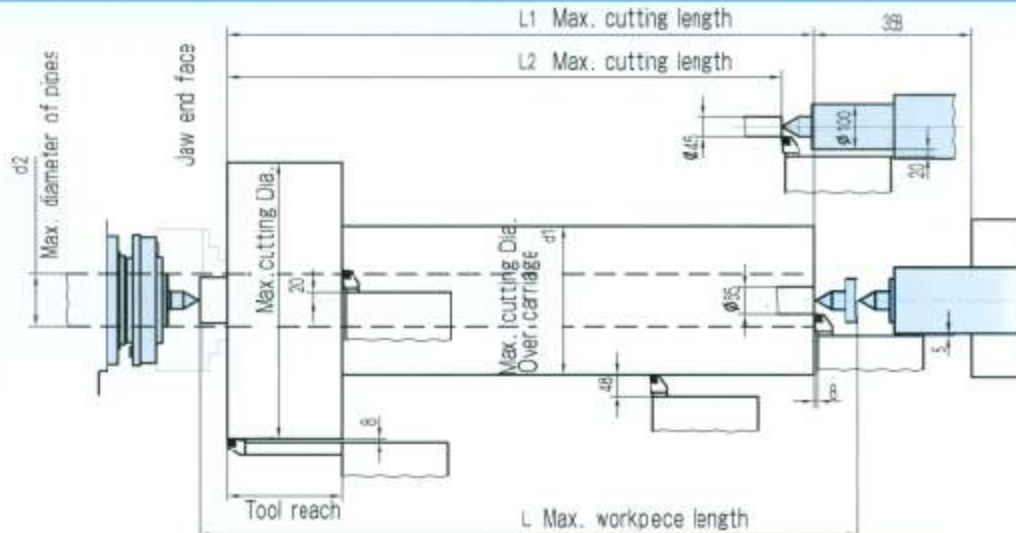
★ Standard

▲ Optional

Data in chart for V4 turret and manual chuck.



Work envelop for V4 turret



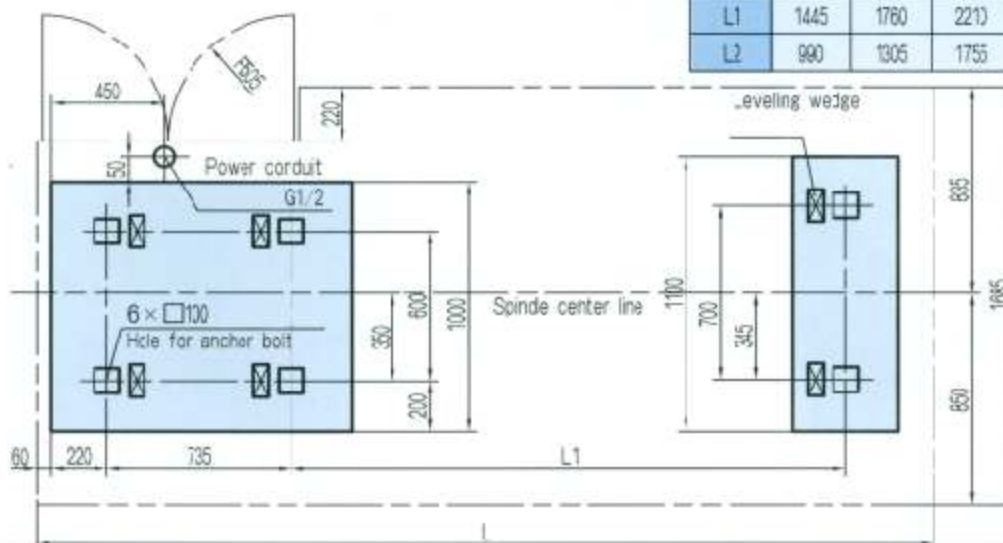
| | OKA1212 | OKA1219 | | OKA1212 | OKA1219 |
|----|---------|---------|----|---------|---------------------|
| D | 330 | 630 | | 750 | 1000 1500 2000 3000 |
| d1 | 480 | 480 | L1 | 600 | 650 1350 1800 2850 |
| d2 | 120 | 190 | L2 | 515 | 765 1265 1765 2765 |

OKA1212/1219

Foundation

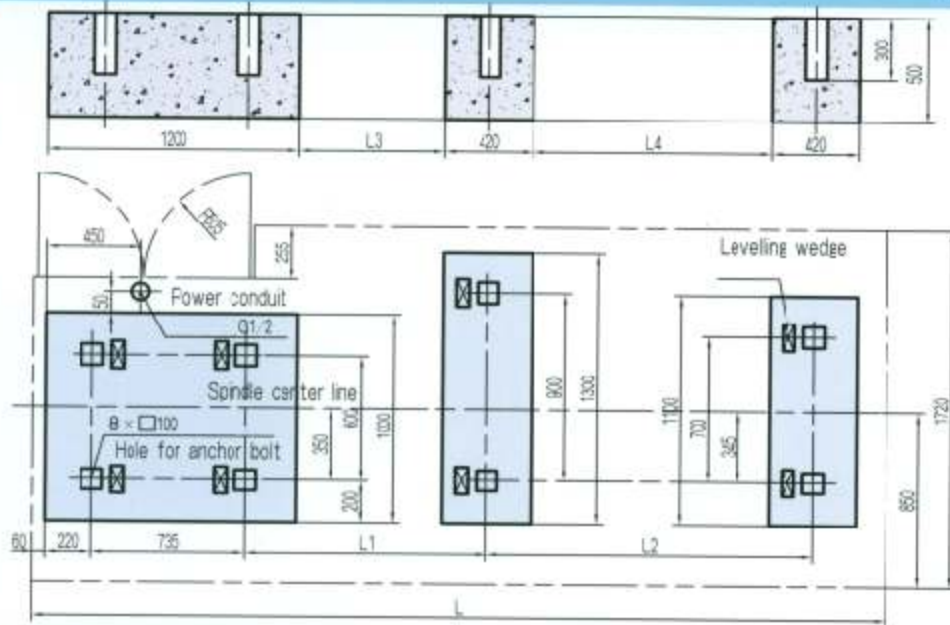


| | 750 | 1000 | 1500 |
|----|------|------|------|
| L | 2810 | 3125 | 3575 |
| L1 | 1445 | 1760 | 2210 |
| L2 | 990 | 1305 | 1755 |



QKA1212/1219

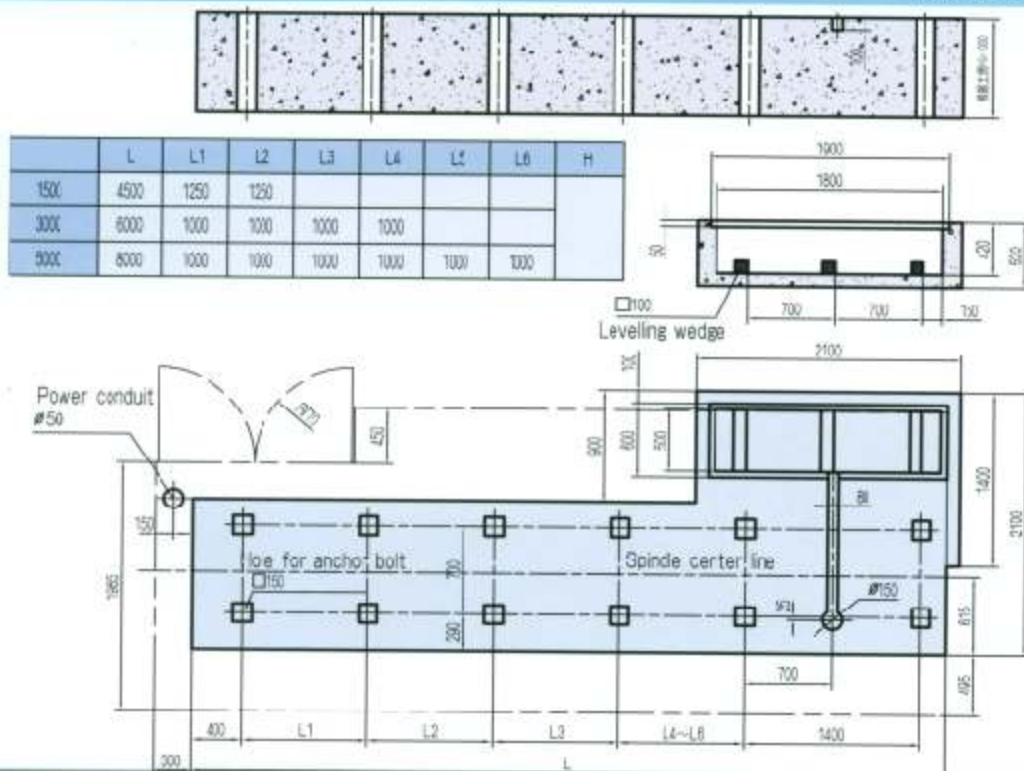
Foundation



| | L | L1 | L2 | L3 | L4 |
|------|-----|------|------|------|------|
| 2000 | 475 | 1152 | 1558 | 605 | 1140 |
| 3000 | 975 | 1802 | 2108 | 1145 | 1690 |

QKA1226/1235

Foundation



| | L | L1 | L2 | L3 | L4 | L5 | L6 | H |
|------|------|------|------|------|------|------|------|---|
| 1500 | 4500 | 1250 | 1250 | | | | | |
| 3000 | 6000 | 1000 | 1000 | 1000 | 1000 | | | |
| 5000 | 8000 | 1000 | 1000 | 1000 | 1000 | 1000 | 1000 | |

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