MULTI AXES FEED SYSTEM WITH COMMON VFD

PLANO MILLING CONVERSION KIT WITH LATEST, ABB VFD CONTROLLED STEPLESS FEED RANGE, NOW AVAILABLE AT HIGHLY AFFORABLE PRICE!

COMMON VFD CONTROLLED 3 AXES FEED SYSTEM PACKAGE: This package consists of table drive unit, cross feed drive unit and vertical feed drive unit. Table drive unit consists of a motor, worm reduction gear box & the other fittings, bracketories. Table drive unit is to be coupled to the existing main drive shaft of the planing machine. ABB make VFD provides step-less table speeds from about 40 mm per minute to 1200 mm per minute. A panel, secured on the column of the planing machine, accommodates the VFD drive, switch gear elements for the motors of the table drive and the spindle drive. A calibrated digital display in the panel reads the table movement in mm per minute. Controls are provided in the panel, which can be shifted to an operator’s pendant, if required at an extra cost. The cross feed unit and the vertical feed unit too consist of its own motor and gear box. But the variable feeds are provided by the same table drive VFD unit, through a selector switch. At a given time, only one axis is operative, which is a built-in safety feature by itself.

SUPERVISORY ASSISTANCE FOR ERECTION & COMMISSIONING is rendered by us at site at an additional cost. You need to provide us manpower, machining, handling etc facilities. You need to provide us tools, instruments, consumables, small & sundry items like fasteners etc at the time of E&C. You need to keep a cutter, arbor, consumables, job, job clamping etc ready before calling us for commissioning.

SCOPE OF SUPPLY: IF MILLING HEADS ARE ORDERED WITHOUT FEED SYSTEM, PROVIDING CONTROLS FOR THE MILLING HEAD MOTOR IS NOT IN OUR SCOPE. TOOLS, CUTTERS, JOB CLAMPING ELEMENTS ARE NOT IN OUR SCOPE.

FEATURES OF MILLING HEAD:
- Closed grained, high grade, stress-relieved castings
- Taper roller bearings provide rigid support to the spindle
- Drive through ground splines in the spindle
- Gears, spindle, quill etc made of case hardened steel, case hardened & ground
- Bull gear and mating gears, helical for high torque transmission
- Least Count: 1 dvn=0.1 mm of the quill movement
- Gear teeth are ground for noise free rotation
- Spindle bearings are SKF/FAG make; Motor bearings are SKF/FAG make
- Spindle bearings lubricated for life with molybdenum sulfide grease
- Spindle bearings lubricated for life with NGEF/ABBK/KEC/SIEMENS
- Self contained, cam operated automatic lubrication system for gear box
- Spindle run-out on face, ID & OD: within 0.01 mm
-\( \text{Least Count: } 1 \text{ dvn}=0.1 \text{ mm of the quill movement} \)
-\( \text{Spindle run-out on face, ID & OD: within 0.01 mm} \)
-\( \text{Leakage: } 0.01 \text{ mm/meter} \)
-\( \text{Molybdenum} \)
-\( \text{Sulfide grease} \)
-\( \text{Spindle bearings} \)
-\( \text{Lineweights} \)
-\( \text{Gears, spindle, quill etc} \)
-\( \text{Closed grained, high grade, stress-relieved castings} \)
-\( \text{Taper roller bearings} \)
-\( \text{Drive through ground splines in the spindle} \)
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SHENOY ENGG PVT LTD
7, 19th (Old), 16th (new) CROSS, DODDANNA INDL ESTATE, NEAR PEEYNA II STAGE, BANGALOE-560 091
PH: 080-28361767 FAX: 08028361725 CELL: 0-9243437487 EMAIL: info@shenoyengineering.com WEB: www.shenoyengineering.com

PLANO MILLING CONVERSION WITH 4 MILLING HEADS

SPECIFICATIONS
SPINDLE TAPER MHR-5 MHCL-5 MHCL-8
SPINDLE SPEED 5 (205,300 & 630 RPM) 6 (30,120, 250, 350 & 500) 6 (80,122, 158, 260, 335 & 500)
MANUAL QUILL Ø125 mm Ø150 mm Ø165 mm
MAX CUTTER Ø100 mm Ø125 mm Ø150 mm
RECOMMENDED Ø125 mm Ø150 mm Ø165 mm
DRIVE Combination of gears & time belt, pulley All geared (through physically change gear pairs) All geared (through lever shifting mechanism)

OPTIONALS FOR MILLING HEADS:
- a) MANUAL BACK PLATE for 5 HP milling heads for (a) taper machining by manually setting the spindle axis ±45°, (b) optimizing the available quill movement & (c) quick & easy alignment of the spindle with respect to the table
- b) MECHANICAL TILTING BACK PLATE through bearing supported worm shaft & integral sector gear for fatigue free manual tilting of the back plate for both 5 HP & 10 HP milling heads
- c) PLAIN BACK PLATES only for (a) optimizing the available quill movement & (c) quick & easy alignment of the spindle with respect to the table, but with no facilities for tilting the head.
- d) Right angle attachments are suitable for using max. Ø125 mm cutter. With 5 HP milling head, the right angle attachment is provided with ISO-40 input drive arbor; with 10 HP milling head, the right angle attachment is provided with ISO-50 input drive arbor. But the output spindle taper in either case is ISO-40.
- (Different spindle speeds in MHR series heads are through change gear pairs provided. Different spindle speeds in MHCL series heads are through lever operated system)

5 HP MILLING HEAD

10 HP ALL GEARED MILLING HEAD

SPECIFICATIONS
SPINDLE TAPER MHR-10 MHCL-10
SPINDLE SPEED 6 (80,122, 158, 260, 335 & 500) 6 (80,160, 200 & 260)
MANUAL QUILL Ø150 mm Ø150 mm
MAX CUTTER Ø122 mm Ø165 mm
RECOMMENDED Ø150 mm Ø165 mm
DRIVE Combination of gears & time belt, pulley All geared (through physically change gear pairs) All geared (through lever shifting mechanism)

20 HP MILLING HEAD

SPECIFICATIONS
SPINDLE TAPER MHCL-20 MHCL-30
SPINDLE SPEED 6 (50, 80,120, 140, 220 & 350) 6 (50, 85, 120, 285 RPM)
MANUAL QUILL 125 mm
MAX CUTTER Ø125 mm
RECOMMENDED Ø150 mm
DRIVE Combination of gears & time belt, pulley All geared (through physically change gear pairs) All geared (through lever shifting mechanism)

75 HP MILLING HEAD

SPECIFICATIONS
SPINDLE TAPER MHR-20
SPINDLE SPEED 4 (50, 100, 150, 200 & 250)
MANUAL QUILL Ø150 mm
MAX CUTTER Ø150 mm
RECOMMENDED Ø165 mm
DRIVE Combination of gears & time belt, pulley All geared (through physically change gear pairs) All geared (through lever shifting mechanism)

MILLING HEAD, HIGHER CAPACITY MILLING HEAD UPTO 50 HP

OVER 3000 PLANERS CONVERTED INTO PLANO MILLS, ALL OVER INDIA & ABROAD IN THE PAST 25 YEARS.

MULTIPLE REPEAT ORDERS FROM PRESTIGIOUS CLIENTELE LIKE TECMACO, BHEL, SAIL, HMT, L&T ETC.

READY-MADE, CONVERTED PLANO MILLS FOR SALE.

LINEAR PLANO MILLS, ROTARY PLANO MILLS, TRAVELLING COLUMN PLANO MILLS, RAM TYPE PLANO MILLS, SPECIAL PURPOSE PLANO MILLS, CNC PLANO MILLS

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