

# TECHNOLOGICAL SHEET No. 2

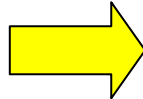
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Machining of valve body for a pipeline

## SOLUTION OF CUSTOMER TECHNOLOGY

**New goals need  
new solutions**

Presentation of WRD 130/150 Q milling machine technological usage with applied LD 650 facing head and HOI 50 milling head by the machining of valve body intended for a pipeline for the Russian customer.



**Weight of the valve:  
20,000 kg**

### The specified machining parameters

Workpiece material	Autrod OK 16.95, P355 NL2+H
Tolerance of dimensions	D1166+0,2/0,5mm, D1291H7, D1192H7
The surface roughness	Ra 1,6

### Machining of holes and faces

#### Rough machining

Speeds <b>S</b> (1/min)	55
Feed <b>F</b> (mm/min)	20
Max. chip (mm)	2

#### Finishing

Speeds <b>S</b> (1/min)	65
Feed <b>F</b> (mm/min)	6
Min. chip (mm)	0,05



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# Horizontal boring mills

## WRD 130/150 (Q)



The machines are intended for precision and high-efficient machining of large, heavy or structurally difficult workpieces made of cast iron or cast steel. They can be extended with a wide range of technological accessories.

### Machine description

WRD 130/150 (Q) are floor type horizontal boring mills with a sliding RAM and sliding spindle which represent a twin type of machines with the same machine concept, but the different headstock parameters.

### Technical specifications

		WRD 130	WRD 150
<b>Working space</b>			
Column transverse travel X	mm	5,000 – 27,000	
Headstock vertical travel Y	mm	2,000 – 4,500	
RAM stroke Z	mm	1,000	
Spindle stroke W	mm	700	800
<b>Headstock</b>			
Spindle diameter	mm	130	150
Spindle speed max.	1/min	3,000 (3,500)	2,500 (2,800)
Main motor power (S1/S6)	kW	37 / 46	51 / 65
RAM size	mm	450 x 450	
<b>Feeds</b>			
Feed range	mm.min <sup>-1</sup>	1 – 8,000	
Rapid traverse – X	mm.min <sup>-1</sup>	20,000	
Rapid traverse – Y	mm.min <sup>-1</sup>	16,000	
Rapid traverse – Z, W	mm.min <sup>-1</sup>	12,000	



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