

ANNEXURE-B40350
FULL BORE GATE & PARALLEL SLIDE Valve
Grinding and Lapping Machine
Model TYPE GHF-B40350 Size 40mm to 350mm



You can do lapping of 2 valves of different size in this range.

FLUIDCHEM make PORTABLE Parallel Slide & Gate valve grinding & lapping machine for the refurbishing on site of:

- sealing surface [body seat ring] in parallel Slide & Gate valve of various makes & size
- sealing surface [body seat ring] in swing check valves [with extra Adaptor]
- flanges
- wedges and wedge disk

Design:

- modern construction, handy, light, and robust
- one-man-operation !
- suitable for on-site service as well as for overhaul in the workshop
- machine, tools, and accessories are corrosion-protected by galvanic finish of surface

ASSEMBLY NO.1 :

- 1) Valve size 40mm – 150mm
- 2) Having Submergable depth D -380mm
- 3) Minimum distance between two Valve's Body's seat Ring:
 - a) With Flat Holding plates: 27mm
 - b) With Rotating Grinding Heads disc 33mm
 - c) WEIGHT OF ASSEMBLY 7.6KG + 1.5KG

ASSEMBLY NO.2 :

- 1) Valve size 150mm – 350mm
- 2) Having Submergable depth D -800mm
- 3) Minimum distance between two Valve's Body's seat Ring:
 - a) With Flat Holding plates: 46mm
 - b) With Rotating Grinding Heads disc 48 mm
 - c) WEIGHT OF ASSEMBLY 16KG + 1.5KG

Electrically Operated PERLESS ELCTRIC TYPE SRE4-713 Or Equivalent 230V /50Hz-60Hz, continuous Rotation

Speed 250-600 RPM

Weight 1.75kg.

With Gear Assembly 3.2kg

Or

Pneumatically Operated : Ingersoll rand Air Motor or Equivalent

Air Flow 15cfm




0.8 HP

Free Speed of Air motor 150-240 RPM

Grinding System: Flat Grinding Plates for Working Range DN 40 – 150 (NB 1 1/2” -6”) made up of Stainless Steel

PLATE SIZE- [VALVE SEAT RING OUTER DIA SIZE]	VALVE SEAT RING OPENING (ID) SIZE	QTY.	SUITABLE FOR PRESSURE CLASS #
50mm dia	40mm dia	 1 no.	150# Class & Above
55mm dia	-	 1 no.	150# Class & Above
60mm dia	50mm dia	 1 no.	150# Class & Above
65mm dia		 1 no.	150# Class & Above
73mm dia	65mm dia	 1 no.	150# Class & Above
80mm dia		 1 no.	150# Class & Above
85mm dia	-	 1 no.	150# Class & Above
90mm dia	-	 1 no.	150# Class & Above
95mm dia	80mm dia	 1 no.	150# Class & above
100mm dia	-	 1 no.	150# Class & above
105mm dia	-	 1 no.	150# Class & above
120mm dia	100mm dia	 1 no.	150# Class & above
145mm dia	125mm dia	 1 no.	150# Class & above
165mm dia	150mm dia	 1 no.	150# Class & above
180mm dia	150mm dia aluminium plate	 1 no.	150# Class & above




Grinding system: Variable Planetary grinding disks [made up of Solid Aluminium Plates] for working range DN 175–350 (NB 7”-14”), radial adjustable to the required seat Diameter.

OD of plate	Working Range		Central Grinding Diameter PCD of Rotating Head	Minimum outer dia of planet plates with Rotating Head	Maximum outer dia of planet plates with Rotating Head	
	Mini I.D.	Maxi O.D.			50mm Dia	80mm Dia
130mm O.D. 	185	265	180	230	235	265
180mm O.D. 	285	355	230	280	325	355
230 mm O.D. 	335	460	280	330	430	460

Please note that the Lapping Machine works smoothly and perfectly if the Rotating Grinding Heads Centre is a little smaller [5mm] than the Inner Diameter of Valves Seat Ring.

Rotating Grinding Heads of SS

Size	Quantity
25mm diameter 	5 Nos.
35mm diameter 	5 Nos.
50mm diameter 	5 Nos.
80mm diameter 	5 Nos.

Arms Length	Quantity
32mm 	3 Nos.
55mm 	5 Nos.
85mm 	5 Nos.

Self Adhesive Abrasive Papers:-ALUMINIUM OXIDE upto 220 grit and above 220 grit we will supply Self Adhesive Abrasive Papers in SILICON CARBIDE

SIZE	80 GRIT	120 GRIT	220 GRIT	400 GRIT	TOTAL
25mm dia	100	100	100	100	400 pcs
35mm dia	100	100	100	100	400 pcs
50mm dia	100	100	100	100	400 pcs
80mm dia	100	100	100	100	400 pcs.



CASE NO.1



CASE NO.2



CASE NO.3

EXTRA Accessories on chargeable basis

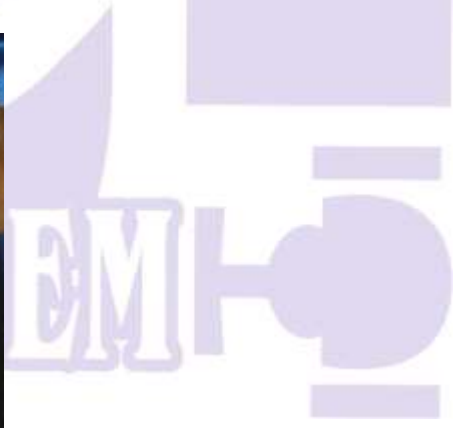
ASSEMBLY NO.3 :

- 1) Valve size 150mm – 350mm
- 2) Having Submergable depth D -1200mm
- 3) Minimum distance between two Valve's Body's seat Ring:
 - A) With Rotating Grinding Heads disc 68 mm
 - B) WEIGHT OF ASSEMBLY 18KG + 1.5KG
2. Mounting assembly for WELDED BONNET JOINT [FLANGELESS BONNET] with 5 meter Belt.
3. CBN [CUBICLE BORON NITRIDE] GRINDING DISC- 5 nos. per set.
4. LAPPING ATTACHEMNT [ROTATING HEADS]
 1. LAPPING ARMS WITH ROTATING HEADS of 50mm dia having 3mm CAST IRON plate on top- 5 NOS.
 2. LAPPING ARMS WITH ROTATING HEADS of 80mm dia having 3mm CAST IRON plate on top- 5 NOS.
 3. ROTATING HEADS of 25mm dia having 3mm CAST IRON plate on top- 5 NOS.
 4. ROTATING HEADS of 35mm dia having 3mm CAST IRON plate on top- 5 NOS.
 5. 500 gms Lapping Paste grit 120
 6. 500 gms Lapping Paste grit 400
 7. 500 gms Lapping Paste grit 800
- 6 Adaptor attachment for Radial drill Machines
7. Electric Drive motor
8. Pneumatic Drive motor
- 9.. Wedge Clamping System

MULTIPLE USES OF IN-SITU VALVE GRINDING AND LAPPING MACHINE



Body Flange Lapping



Wedge Lapping



Bonnet Lapping



Body Seat Lapping