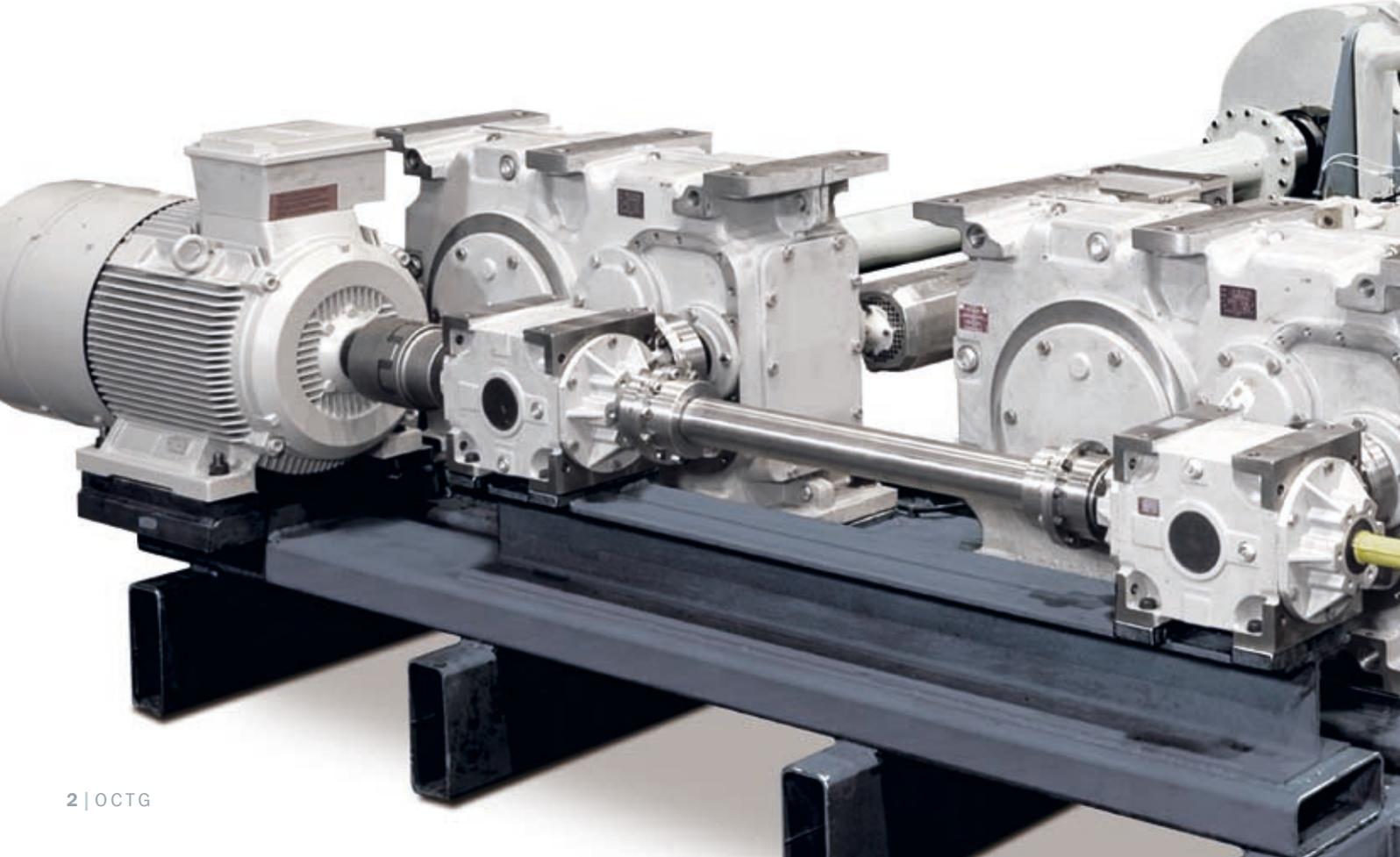
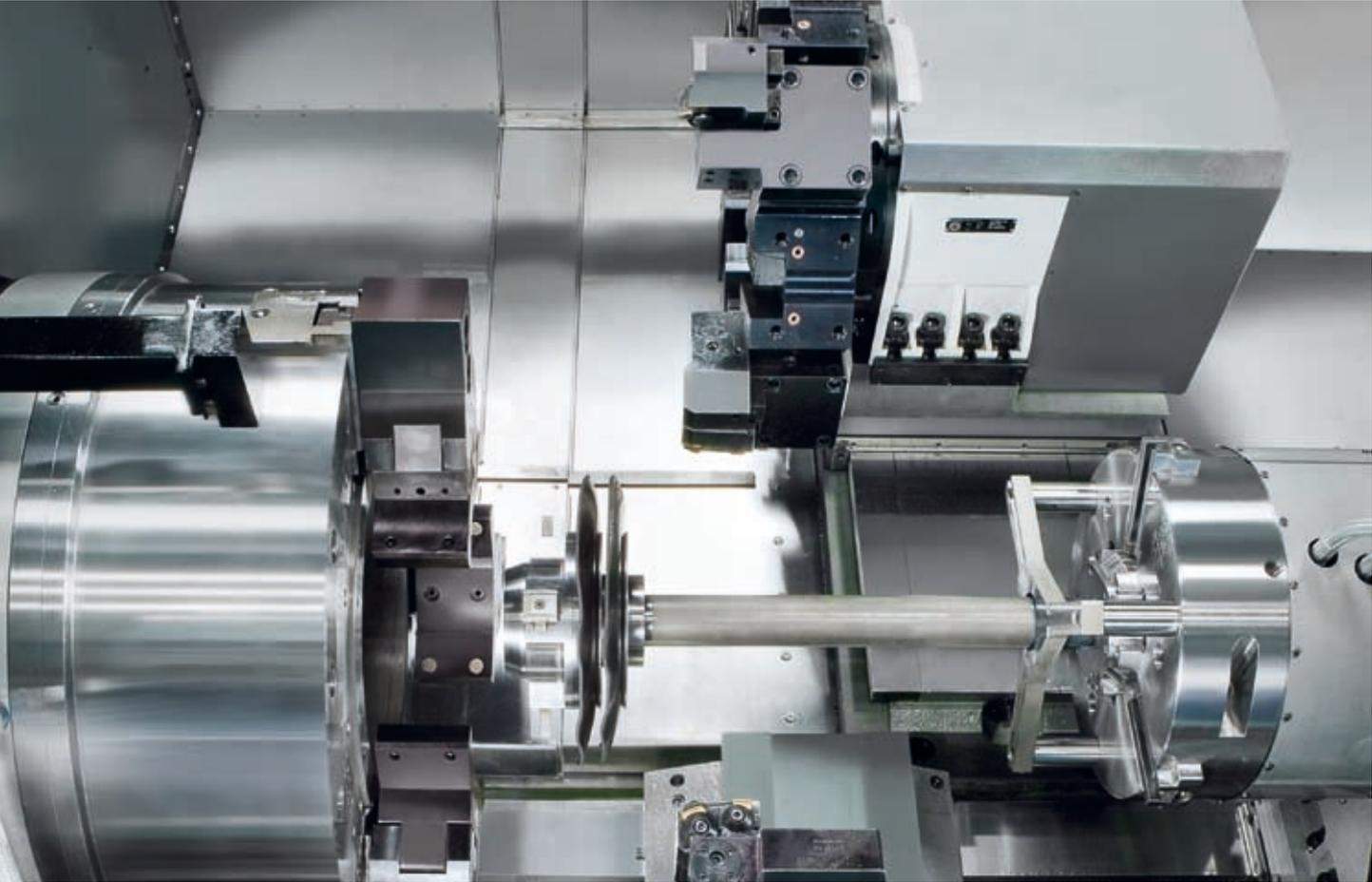




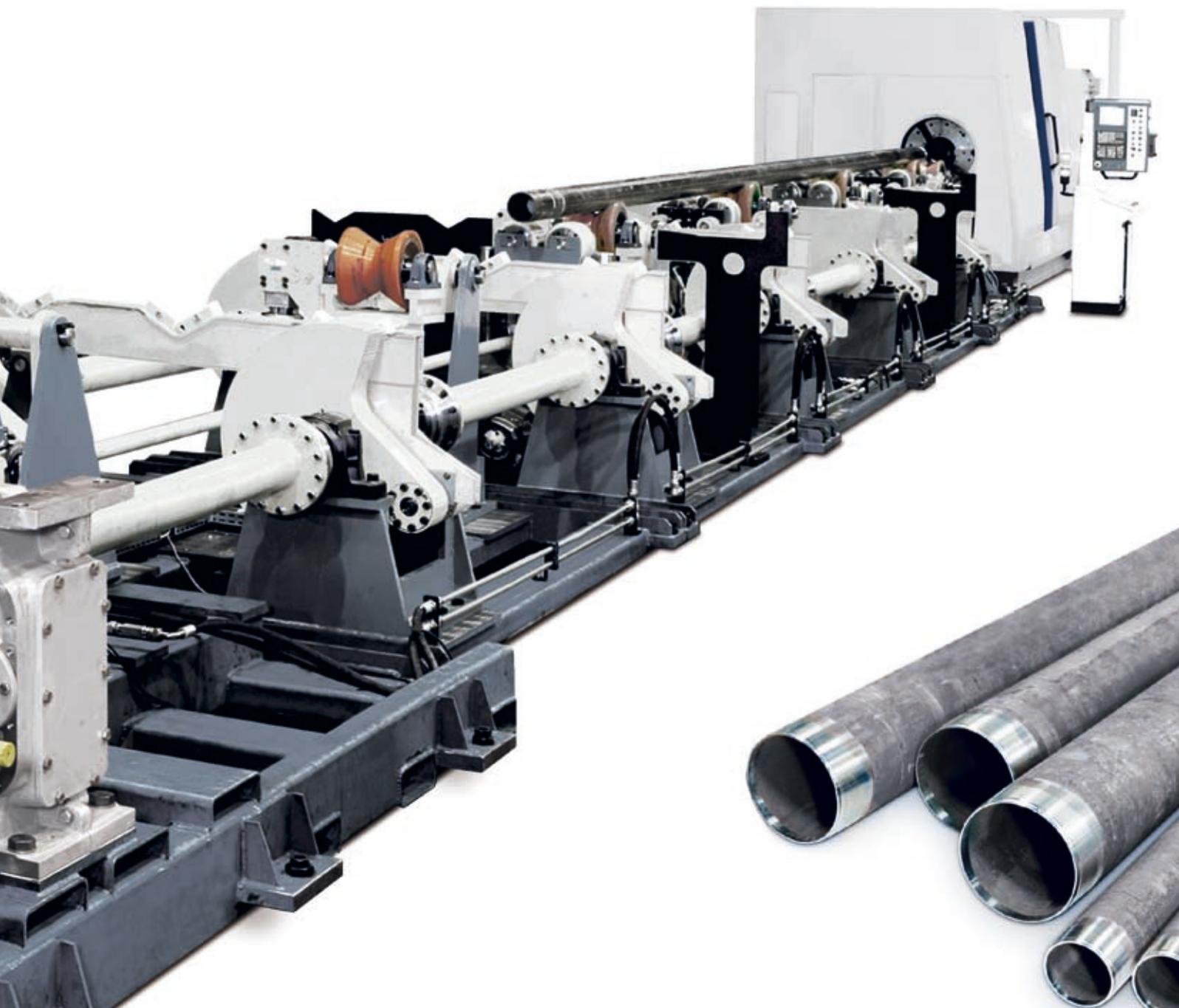
**Machining solutions  
for OCTG**

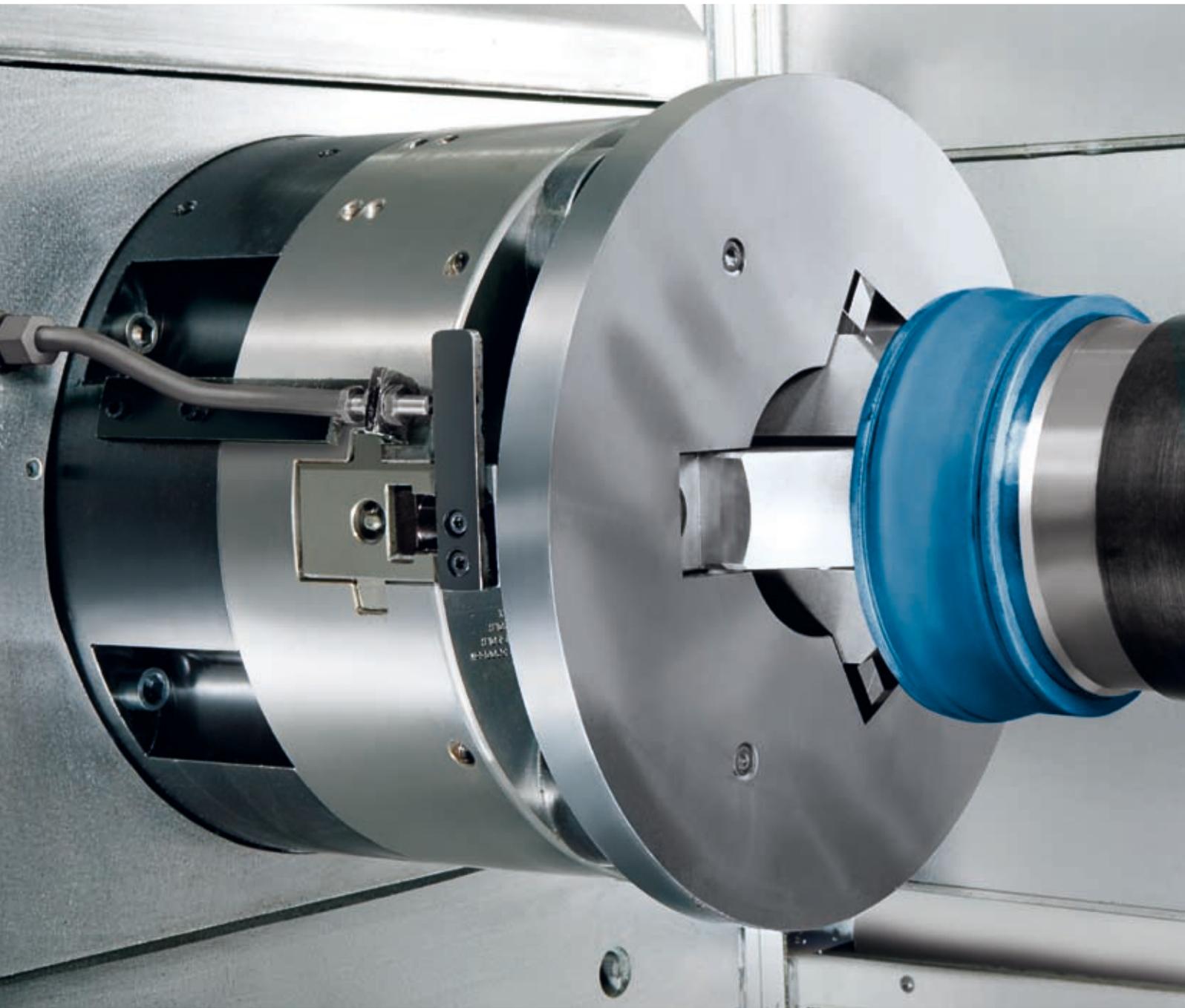


PIPES ENDS MACHINING

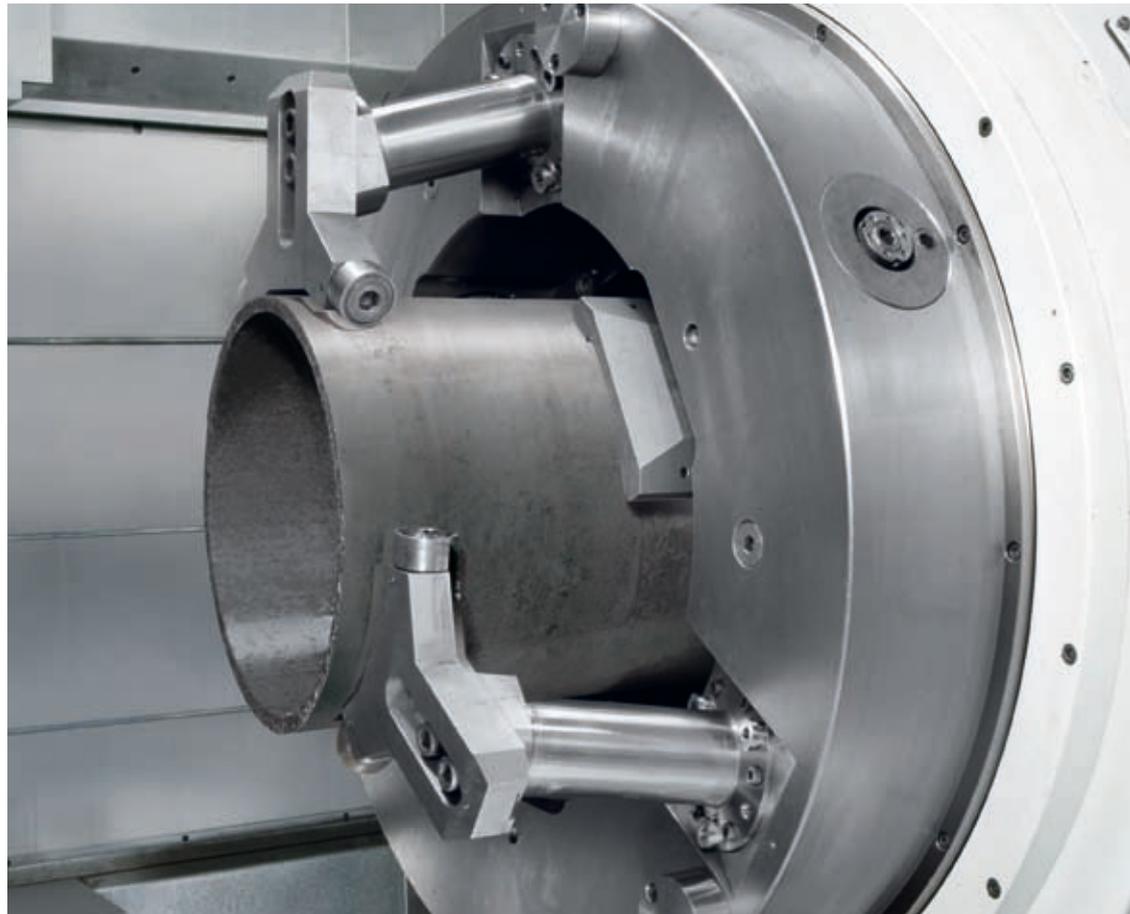


DANOBATGROUP is a leading global solution provider for OCTG pipe finishing and coupling manufacturing. We are a single source supplier for machine, parts handling and or automation, tooling and process development tailored to your production and budgetary needs. We focus on providing the most suitable solution for your API, GOST and PREMIUM thread requirements for medium and high production applications.





The pipe machining process begins with the cutting of the ends, where we incorporate fully automated lines with two Danobat CP sawing machines that can move along a slide in order to adjust pipe length according to your specifications.



Pipe ends are threaded by rotating the pipe in our Danobat TT model lathes. These machines are designed with a modular concept utilizing Finite Element Analysis. The main features are as follows:

- 4 axes simultaneous threading, reducing cycle time.
- Symmetrical versions available, ie. headstock either on the left or right side, adapting to your plant flow and or floor plan.
- Headstocks prepared for assembly of front and rear chucks, either pneumatic or hydraulic. Integrated into headstock front hydraulic 6 jaws (3 compensating, 3 centering) chucks are also available.
- Main motor power up to 170 kW (230 Hp), depending on model.
- Pipe stopper, optionally with centering features.
- Chatter reducing internal support automatically retractable. Patent pending.
- Tooling solutions for external threads, coupled connections, or internal threads and integral connections.
- Available with Fanuc, Siemens or Fagor CNC.

Different designs of pipe feeding tables may also be integrated along with the lathes for a single source turnkey solution.

	<b>TT-7</b>	<b>TT-10</b>	<b>TT-13</b>	<b>TT-16</b>	<b>TT-20</b>
<b>Pipe size up to</b>	7"	9 5/8"	13 5/8"	16"	20"

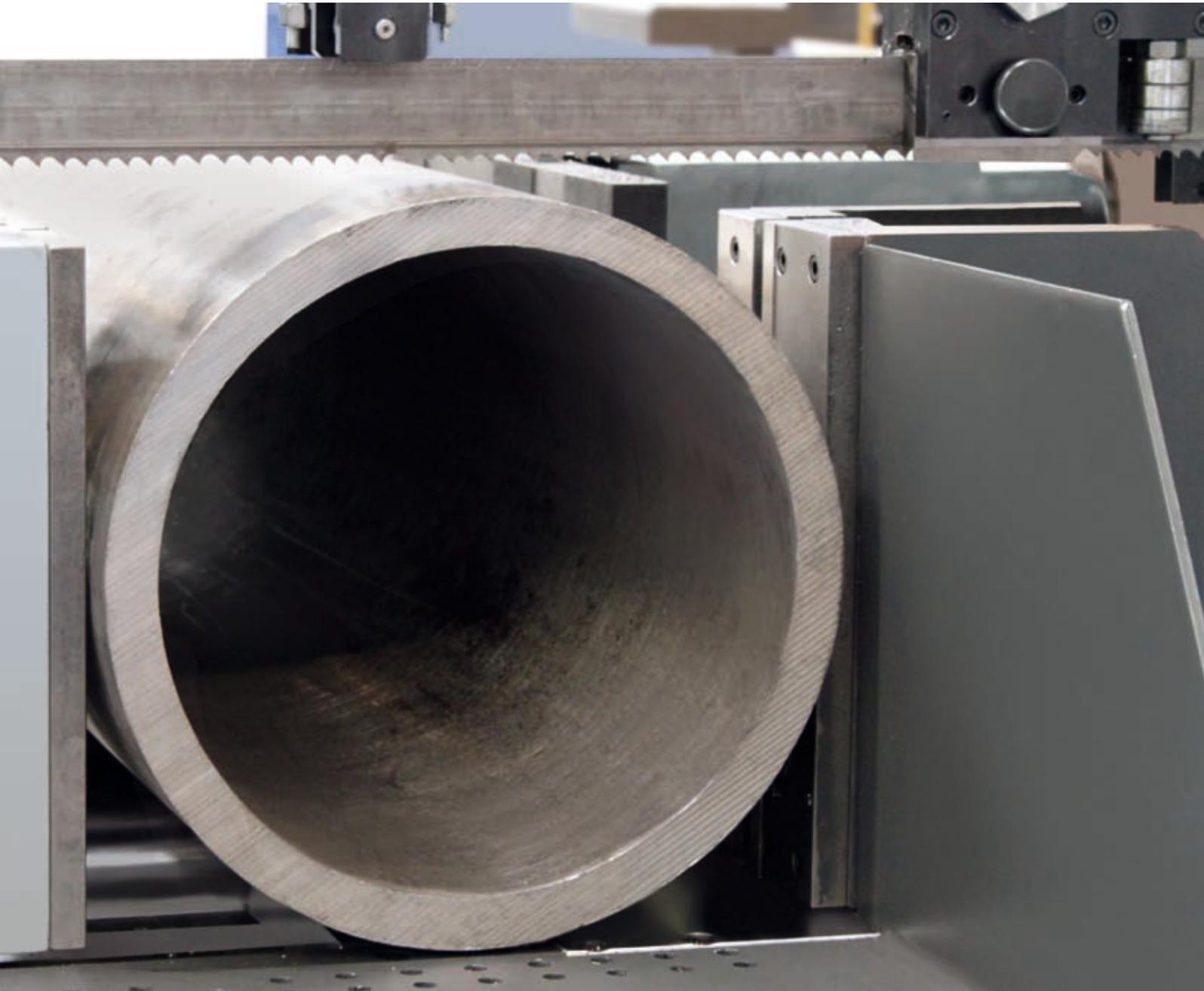
## COUPLING MACHINING

The coupling machining process begins with cutting. DANOBATGROUP can provide high production saw cutting with the Danobat CP range of saws. Powerful software optimizes machining process, it integrates adaptative intelligent cutting and blade deflection control that adjusts automatically the blade speed and downfeed to obtain optimal performance, straightness of the cut, and blade life.

The coupling cut can be integrated in a fully automatic line where in addition to the cutting, OD machining and ID roughing are performed on the TCL range of Danobat lathes. This model is a 4 axes machine where OD and ID machining is performed simultaneously, prior to the cut off of the coupling. The handling is fully automated. With the addition of a welding robot a continuous flow is created, welding the last piece of machined pipe with a new one.

The machining line may be completed with a threading lathe, either a CL or a CIH machine model. This provides a coupling production line from pipe till threading, finishing completely all coupling machining in a fully automatically integrated line. You may machine PREMIUM couplings up to 13 5/8" in diameter.



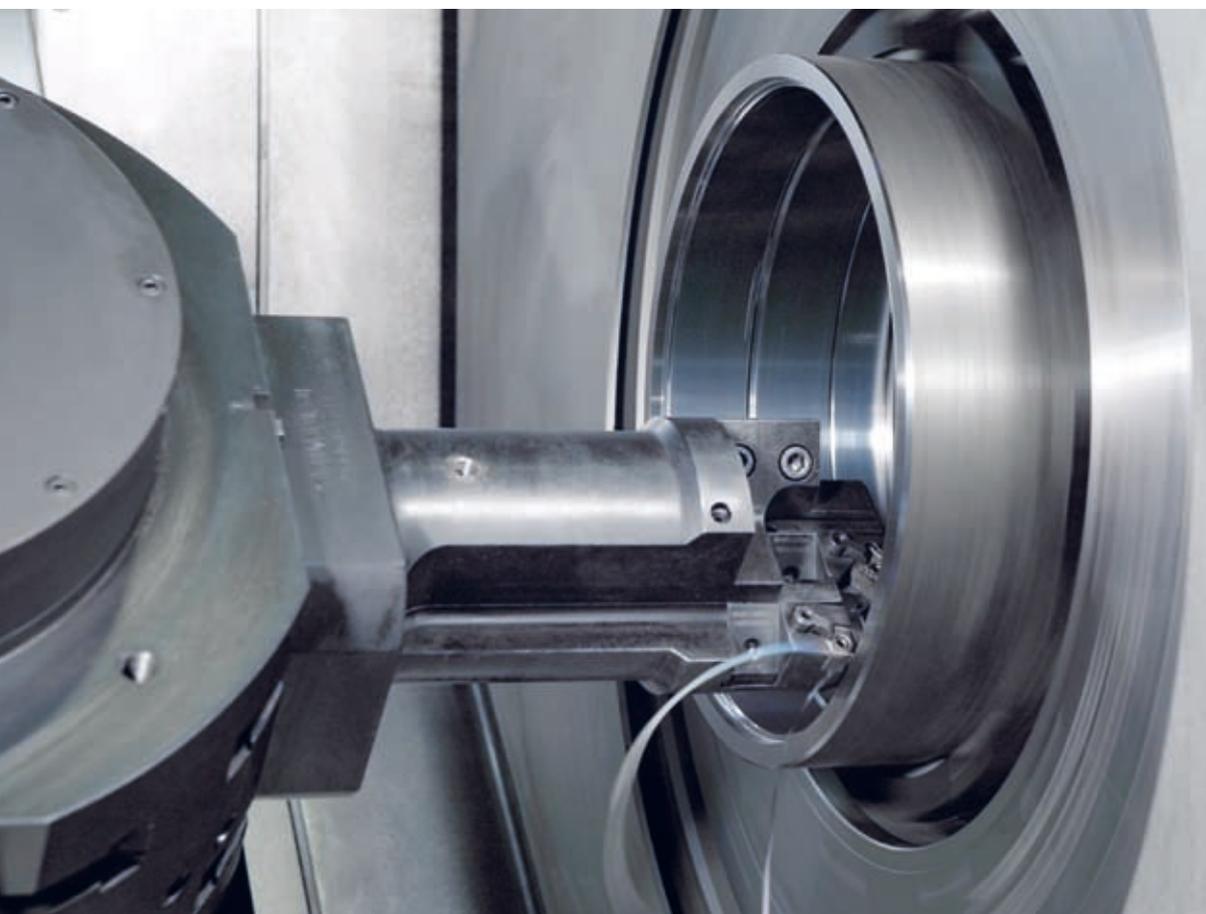


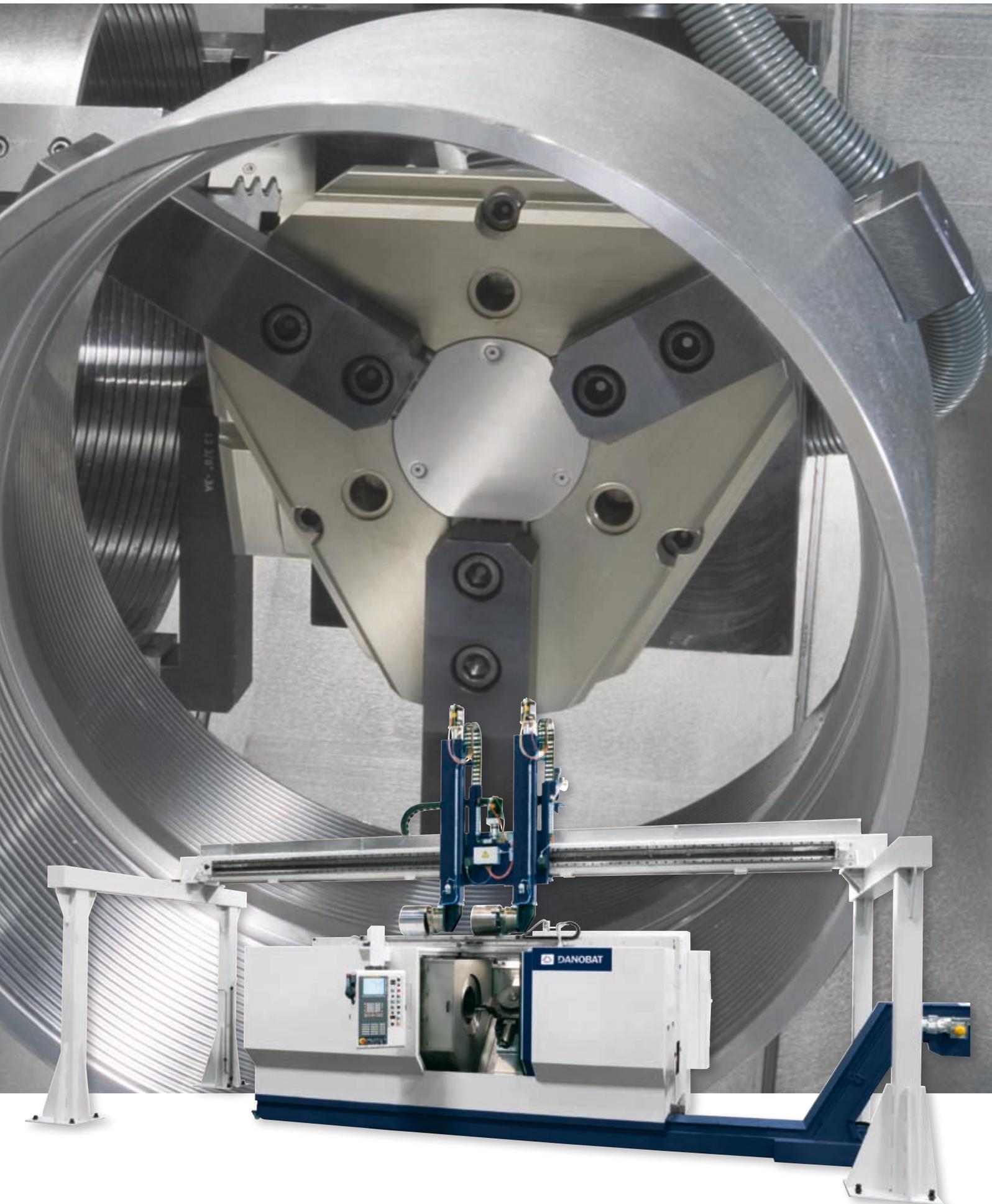
Coupling threading may be done in a single clamping on the CIH range of machines, or in two set ups on the CL range. Main features as follows:

- Rigid design capable of performing not only threading but also the roughing of PREMIUM couplings.
- Heavy duty vertical axis turret prepared for high pressure through tool coolant.
- Symmetrical distribution of guideways balancing cutting forces for higher accuracy.
- Headstocks prepared for assembly of hydraulic indexing chuck (only on CIH model) to finish the coupling in a single set up.
- Main motor power up to 100 kW, (134 Hp) depending on model.
- Tooling solutions for “pushing”, cutting threads inwards, or “pulling”, cutting threads outwards, facilitating optimal chip evacuation and protecting the threaded area.
- Available with Fanuc, Siemens or Fagor CNC.

Different designs of coupling handling systems may also be integrated along with the lathes for single source delivery on a turnkey basis.

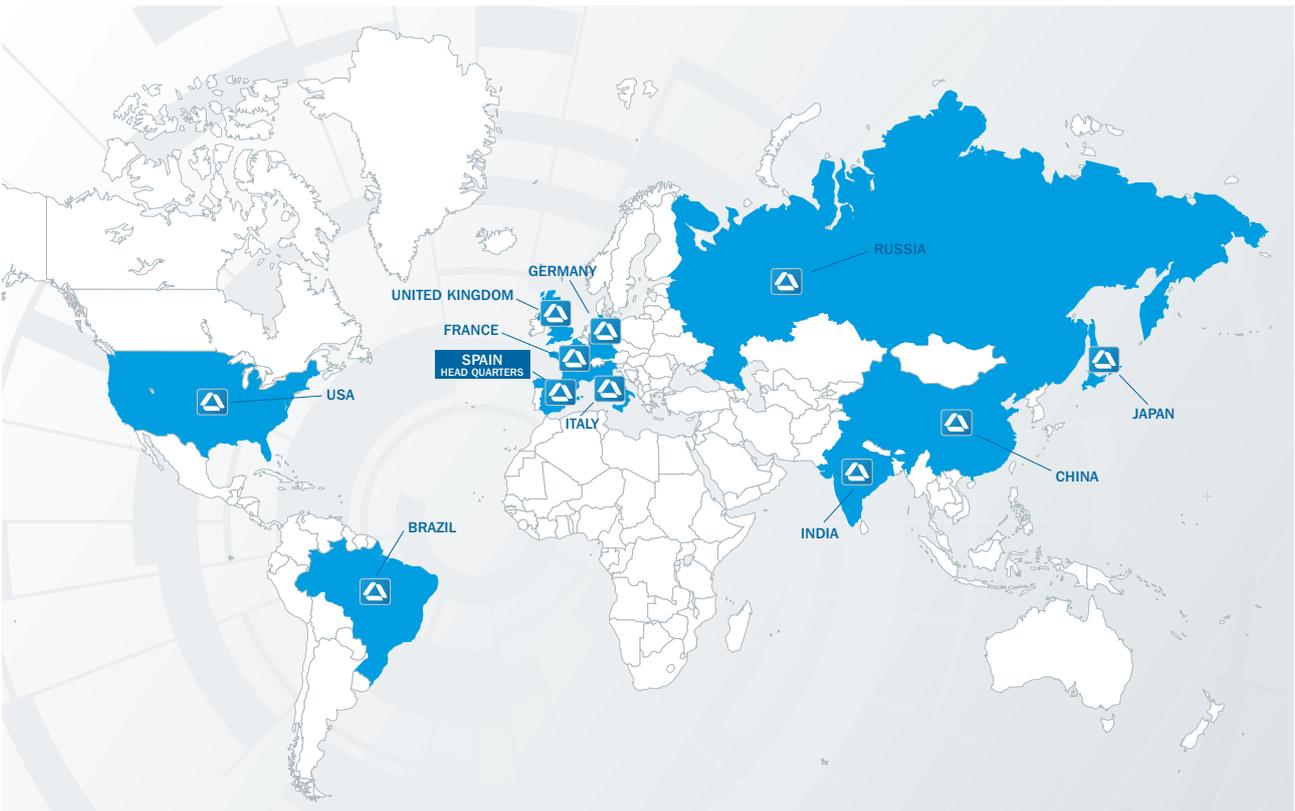
	CIH Range				CL Range		
	CIH-7	CIH-9	CIH-13	CIH-16	CL-7	CL-13	CL-20
<b>Coupling size up to</b>	7”	9 5/8”	13 5/8”	16”	7”	13 5/8”	20”





DANOBTGROUP is one of the largest machine tools manufacturers in Europe. For more than half of a century we have supplied machines to highly reputable customers establishing a worldwide presence.

DANOBTGROUP is the machine tool division of one of the most prestigious Spanish industrial holdings, Mondragon Corporation with a workforce of nearly 100,000 people, and more than 15 billion Euros in turnover.



DANOBTGROUP has offices in 10 countries and our professional representation network completes our presence worldwide.



The technological heart of the company relies on IDEKO IK4 Research and Development Center. Its major activities consist on optimizing traditional processes, developing new ones, and designing the machines capable of working with these demanding processes.

World leaders in pipe manufacturing such as TENARIS, TPCO and VALLOUREC, among others,

have placed their trust in us throughout the world in Europe, South and North America, Africa and Asia.

DANOBATGROUP is always next to its customer, providing the best attention and offering a customised service in local language and timetable.



# OTHER **DANO**BAT SOLUTIONS FOR **OIL & GAS**



Turning centers for valves



Vertical turning centers



Vertical lathes



Internal & radii grinding machines

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