

# **BLIN**<sup>®</sup>

Ideal for machinery solution

# **BLIN MACHINERY**

**CHINESE TECHNOLOGY**

**CNC PIPE THREADING LATHE**



[www.blincnc.com](http://www.blincnc.com)  
**NINGBO BLIN MACHINERY CO.,LTD.**



### A “Versatile Expert” balancing high speed with precision

- **Machining Capacity:** Specifically designed for small-to-medium pipes with diameters from 130mm to 280mm.
- **High-Efficiency Performance:** Maximum spindle speeds up to 720 RPM, significantly boosting mass production efficiency.
- **Loading Stability:** 3 to 4-ton maximum loading capacity ensures stable machining for medium-duty workpieces.
- **Flexible Configuration:** Equipped with dual manual chucks as standard; optional 6 or 8-station turrets for complex multi-process tasks.
- **Application Scenarios:** Widely used in routine oil & gas pipe maintenance, geological drill pipe processing, and general shaft component manufacturing.

### Industry applications

- **Standard Oilfield Tubing & Casing:** Efficient threading specifically for API standard tubing and casing. Its high-speed characteristics are ideal for high-volume production, significantly shortening cycle times.
- **Geological Exploration & Mine Support:** Suitable for processing geological drill pipes and tunnel support pipes. These medium-diameter pipes require higher machine responsiveness and operational convenience.
- **Urban Pipe Networks & Fluid Engineering:** Precision threading for medium-sized pressure steel pipes and flange connections used in water and natural gas transmission.
- **Auxiliary Manufacturing Industry:** Versatile enough to function as a standard CNC lathe for producing long shaft parts, large bushings, or tubular components in architectural structures.

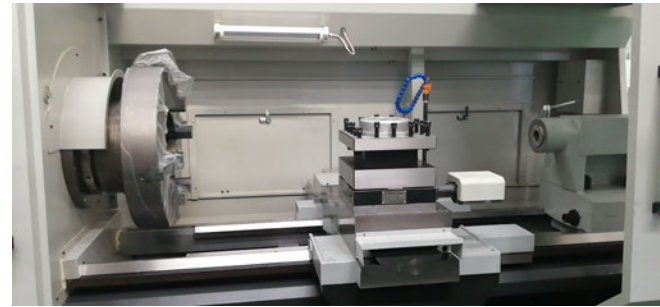
### Machine bed & Structure

Guideway Width: 550 mm

Bed Construction: High-grade resin-sand cast iron, fully stress-relieved via artificial aging treatment for long-term precision retention.

Way Guidelines: Induction-hardened (ultrasonic frequency) and precision-ground guideways.

Saddle Coating: Fluorocarbon resin (PTFE) bonding on mating surfaces to eliminate stick-slip (creeping) and maximize wear resistance.



### Headstock & Spindle System



Spindle Drive: Geared headstock with variable speed ranges (stepless speed regulation within each gear step).

Application Capability: Specifically engineered for high-precision processing of internal and external API pipe threads.

Workholding System: Double manual 3-jaw chuck configuration (front and rear) for secure long-pipe clamping.

### Tooling & Tailstock

Tool Post: Heavy-duty 4-station electric turret (indexing tool post).

Tailstock: High-rigidity manual tailstock with robust manual locking mechanism.



### Controller



Panel: Swivel mounted control enclosure (model dependent)

Standard Control: High-performance GSK 980TC3. Include manual MPG.

Optional Control: FANUC Oi-TF (5). SIEMENS 808D ADVANCED



# CNC PIPE THREADING LATHE QK STANDARD SERIES

BL-QK1313/1319/1322/1325/1327A

550/600MM GUIDEWAY WIDTH, SPINDLE BORE:130/200/225/255/280MM, HIGH QUALITY

## CNC Specifications

Category	Specification	GSK980TC3
Axis Control & Configuration	Controlled Axes	5 axes max.
	Simultaneous Interpolation	3 axes max., linear and circular interpolation
	Processor & Bus	32-bit high-speed processor
	Minimum Command Increment	0.001 mm
	Position Compensation	Bidirectional pitch error compensation and automatic backlash compensation
Feedrates & Motion Control	Max. Rapid Traverse	60.000 mm/min
	Max Cutting Feedrate	30.000 mm/min
	Acceleration/Deceleration	S-curve, T-curve, and exponential ramping for rapid and cutting feeds.
	Manual Overrides	Rapid traverse: F0, 25%, 50%, 100%. Feedrate: 0% to 150% (10% increments)
Spindle & Tool Management	Spindle Support	Max. 2 (analog or digital)
	Spindle Control	Rigid tapping Constant Surface Speed Spindle Orientation C-axis
	Turret Integration	PLC logic, up to 12 station standard
	Tool Offset	32 groups. Tool nose radius compensation
Threading Functions	Thread Profiles	Metric, Inch, straight, tapered, face, variable-pitch, and continuous multi-start threading
	Retraction	Programmable
	Spindle Synchronization	High-resolution encoder feedback
Programming & Canned Cycles	Format	ISO
	Canned Cycles	Turning, grooving, multi-pass threading, drilling/tapping
	Macro Commands	B language
Hardware & Connectivity	Display	8.4" color LCD
	Automation Logic	Dedicated automation interface
	Memory	Flash memory
	I/O Ports	USB 2.0, RS232 and RJ45
	Diagnostics	Real time dual-window PLC and I/O status

**Specification:**

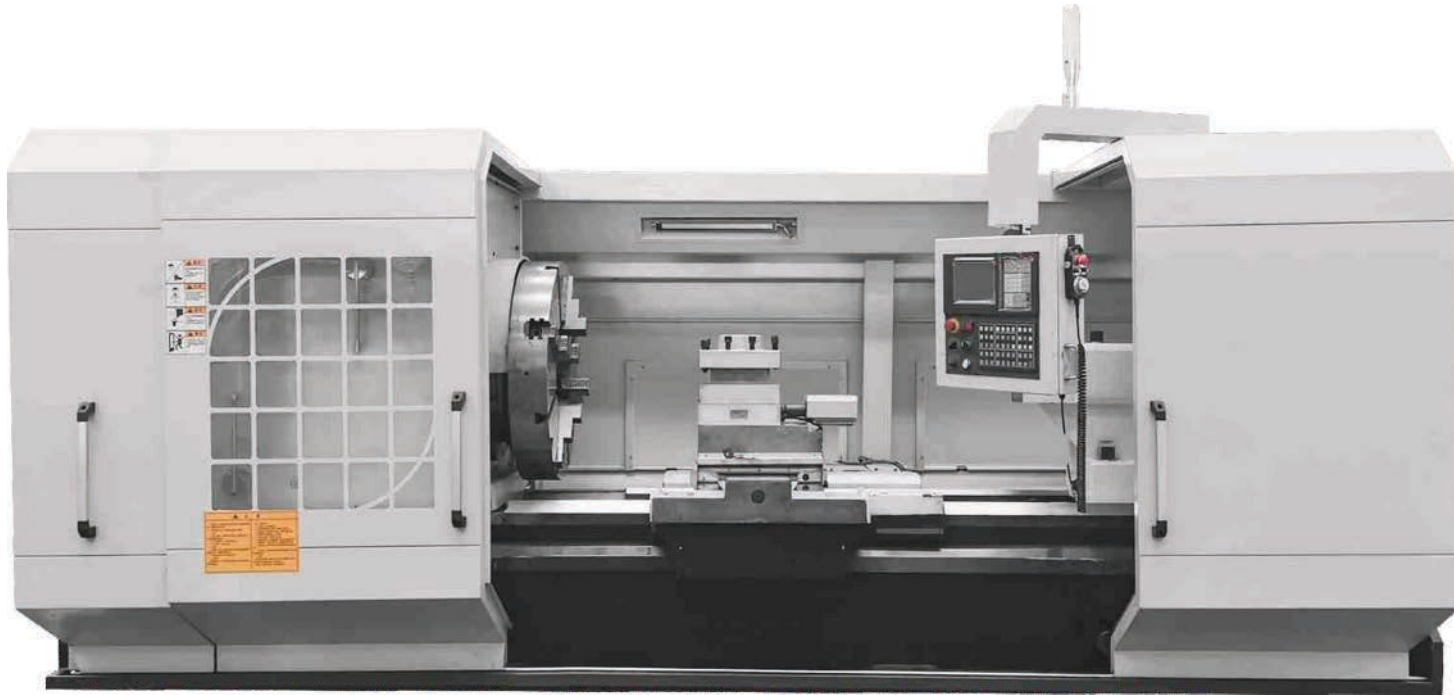
Item	Specification	Unit	BL-QK1313	BL-QK1319	BL-QK1322	BL-QK1325	BL-QK1327
Capacity	Guideway width	mm	550			600	
	Max. swing dia. over bed	mm	∅630/800			∅800	
	Max. swing dia. over slide	mm	∅340/520			∅480	
	Center distance	mm	100/1500/3000				
	Pipe threading range	mm	∅30~126	∅50~193	∅50~220	50~250	50~270
	Max. loading capacity	t	3			4	
Spindle	Spindle bore	mm	∅130	∅200	∅225	∅255	∅280
	Spindle speed steps	/	Manual 3 class, stepless	Manual, 4 class, stepless	Manual, 4 class, stepless	Manual, 4 class, stepless	Manual, 4 class, stepless
	Spindle speed range	rpm	30~720	20~550	20~550	20~420	20~420
	Chuck size	mm	Manual 3-jaw ∅400	Manual 3-jaw ∅500	Manual 3-jaw ∅500	Manual 4-jaw ∅630	Manual 4-jaw ∅800
	Spindle motor	kw	11			15	
Feeding axes	X axes travel	mm	320/420			420	
	Z axes travel	mm	830/1350/2850				
	X/Z axes rapid rate	m/min	4/6				
Tool post	Tool post type	mm	4 station electric tool post				
	Tool shank size	mm	32x32				
Tailstock	Tailstock quill travel	mm	250				
	Tailstock quill diam.	mm	∅100			120	
	Tailstock quill taper	/	MT#5			MT#6	
Other	Overall size	mm	3300/3800/5300×1880×1850			3600/4100/5600×1930×1900	
	N.W.	T	4.5/5/6	4.6/5.1/6.1	4.7/5.2/6.2	6/6.5/7.5	6.2/6.7/7.7

**Standard configuration**

- GSK980TC3 CNC controller
- Double Manual chuck
- 4 station tool post
- Manual tailstock

**Optional configuration**

- SIEMENS 808D ADVANCED/FANUC OI TF controller
- 6/8 station tool turret

**For large-bore and extreme-weight challenges.**

- Extra-Large Spindle Bore: Features a massive 280mm to 640mm spindle bore to handle large-scale piping with ease.
- Heavy-Duty Structure: Guideway widths from 755mm to 1100mm with a maximum loading capacity of up to 10 tons.
- Superior Rigidity: Built with premium resin sand cast iron and aged for stability; ultrasonic frequency-hardened guideways ensure long-term precision under heavy loads.
- Powerful Torque: Equipped with high-power spindle motors (22kW to 37kW) to meet the demands of heavy-duty cutting.
- Application Scenarios: Engineered for precision machining of deep-sea drilling tools, large-scale oil/gas trunk lines, and ultra-heavy industrial shaft components.

**Industry applications**

- Deep-Sea & Ultra-Deep Well Drilling Tools: Designed for large-diameter Drill Collars, heavy drill pipes, and marine risers. The ultra-wide guideways (up to 1100mm) provide exceptional cutting rigidity for high-strength alloy steels.
- Large Oil & Gas Trunk Line Projects: Handles end-thread processing for large-diameter, long-distance pipelines, supporting pipe threading up to  $\Phi 630$ mm.
- Nuclear Power & Chemical Pressure Vessels: Ensures vibration-free stability for large-scale heat exchanger tube sheets and extra-large chemical pipelines, utilizing its 10-ton load capacity.
- Extreme-Sized Non-Standard Components: Beyond pipes, this series serves as a heavy-duty CNC lathe for machining large mining machinery spindles, heavy hubs, and other massive castings or forgings.

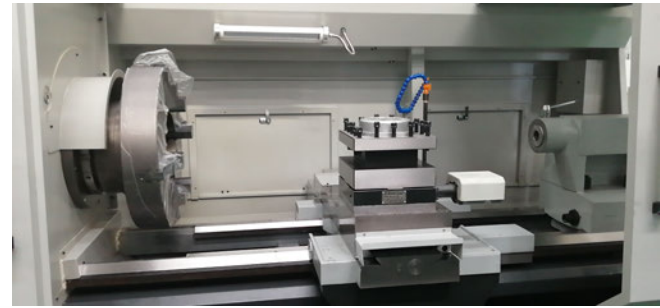
### Machine bed & Structure

Guideway Width: 550 mm

Bed Construction: High-grade resin-sand cast iron, fully stress-relieved via artificial aging treatment for long-term precision retention.

Way Guidelines: Induction-hardened (ultrasonic frequency) and precision-ground guideways.

Saddle Coating: Fluorocarbon resin (PTFE) bonding on mating surfaces to eliminate stick-slip (creeping) and maximize wear resistance.



### Headstock & Spindle System



Spindle Drive: Geared headstock with variable speed ranges (stepless speed regulation within each gear step).

Application Capability: Specifically engineered for high-precision processing of internal and external API pipe threads.

Workholding System: Double manual 3-jaw chuck configuration (front and rear) for secure long-pipe clamping.

### Tooling & Tailstock

Tool Post: Heavy-duty 4-station electric turret (indexing tool post).

Tailstock: High-rigidity manual tailstock with robust manual locking mechanism.



### Controller



Panel: Swivel mounted control enclosure (model dependent)

Standard Control: High-performance GSK 980TC3. Include manual MPG.

Optional Control: FANUC Oi-TF (5). SIEMENS 808D ADVANCED

**Specification:**

Item	Specification	Unit	BL-QK1327B	BL-QK1332	BL-QK1338	BL-QK1343	BL-QK1350	BL-QK1363
Capacity	Guideway width	mm	<b>755</b>	<b>755</b>	<b>755</b>	<b>755</b>	<b>755</b>	<b>1100</b>
	Max. swing dia. over bed	mm	Φ1000	Φ1000	Φ1000	Φ1000	Φ1200	Φ1400
	Max. swing dia. over slide	mm	Φ610	Φ610	Φ610	Φ610	Φ710	Φ800
	Center distance	mm	1500/3000(can be especially ordered for other length)					
	Pipe threading range	mm	Φ130~Φ270	Φ190~Φ320	Φ190~Φ380	Φ270~Φ430	Φ330~Φ510	Φ330~Φ630
	Max. loading capacity	t	6	6	6	6	6	10
Spindle	Spindle bore	mm	<b>Φ280</b>	<b>Φ330</b>	<b>Φ390</b>	<b>Φ440</b>	<b>Φ520</b>	<b>Φ640</b>
	Spindle speed steps	/	Manual 4 class, stepless	Manual 3 class, stepless	Manual 3 class, stepless	Manual 3 class, stepless	Manual 3 class, stepless	Manual 3 class, stepless
	Spindle speed range	rpm	10~320	10~280	8~205	8~205	8~190	2~120
	Chuck size	mm	Manual 4-jaw Φ800	Electric 4-jaw Φ780	Electric 4-jaw Φ800	Electric 4-jaw Φ1000	Electric 4-jaw Φ1000	Manual 4-jaw Φ1250
	Spindle motor	kw	22	22	22	22	22	37
Feeding axes	X axes travel	mm	520	520	520	520	520	750
	Z axes travel	mm	1250/2750					
	X/Z axes rapid rate	m/min	4/4					
Tool post	Tool post type	mm	4 station electric tool post					
	Toolshank size	mm	40×40	40×40	40×40	40×40	50×50	50×50
Tailstock	Tailstock quill travel	mm	300					
	Tailstock quill dia.	mm	Φ160	Φ160	Φ160	Φ160	Φ160	Φ220
	Tailstock quill taper	/	MT6#	MT6#	MT6#	MT6#	MT6#	Metric 80
Others	Overall size	mm	4950/6450×2050×2050	5000/6500×2080×2080	5000/6500×2220×2120	5000/6500×2220×2120	5000/6500×2300×2200	5600/7100×2500×2500
	N.W.	T	10.5/12.2	11.5/12.5	12/13	13/14	15/16	18/19.3

**Standard configuration:**

- GSK980TDi controller
- Dual Manual chuck
- 4 station tool post
- Manual tailstock

**Optional configuration:**

- SIEMENS 808D ADVANCED/FANUC 0I TF controller

# Our Journey & Milestones

*A History of Growth and Innovation*

- 2004 - 2005  
**CNC Transformation**  
Launched Flat Bed CNC Lathes;  
Established Quzhou Plant for VMCs & Milling Machines.
- 2009 - 2010  
**Global Launch**  
Established HK Branch;  
Entered Alibaba & Made-in-China for global export.
- 2013 - 2018  
**Expansion**  
Established Shanghai & Foshan Plants  
focusing on S & H Series Precision Slant Bed Lathes.
- 2022  
**Grinding Solutions**  
Established Xi'an Plant for High-Precision CNC Grinders  
& full grinding category export.
- 2024.6  
**Gear Division**  
Founded Gear Machining Division to expand specialized export lines.
- 2025.8  
**Global Footprint**  
Planned establishment of Japan Production  
Base for localized manufacturing.
- 1979 - 1987  
**Foundation**  
Started production of Instrument,  
Conventional, and Conventional Pipe Threading lathes.
- 2007 - 2010  
**Product Diversification**  
Added CAM Auto Lathes & Drilling Tapping  
Centers to the portfolio.
- 2011 - 2012  
**Global Deepening**  
Produced Swiss-type Lathes; Opened Ningbo Int'l Center;  
Debuted at overseas exhibitions.
- 2020 - 2021  
**Automation Era**  
Launched Micro Swiss Lathes;  
Founded Automation Division for integrated solutions.
- 2023 - 2024.3  
**High-End Mfg.**  
Launched Vertical Lathes;  
Quzhou Plant expanded to 20,000m<sup>2</sup> for 5-Axis & Gantry production.
- 2025.5 - 2025.7  
**Strategic Partnership**  
Collab with Japanese brand for Broaching Machines;  
Expanded into Boring Machines.

# History

## Our advantages:

[www.blincnc.com](http://www.blincnc.com)





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