

LDSF Large Diameter Split Frame



Four standard LDSF sizes cover 60-120in (DN1500-3000)



LDSF splits into quadrants for setup, transport & storage

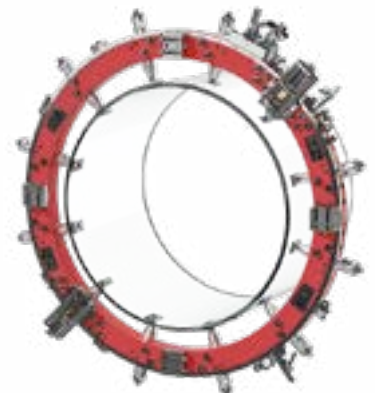


LDSF standard dual hydraulic drive motors & dual pinion housings

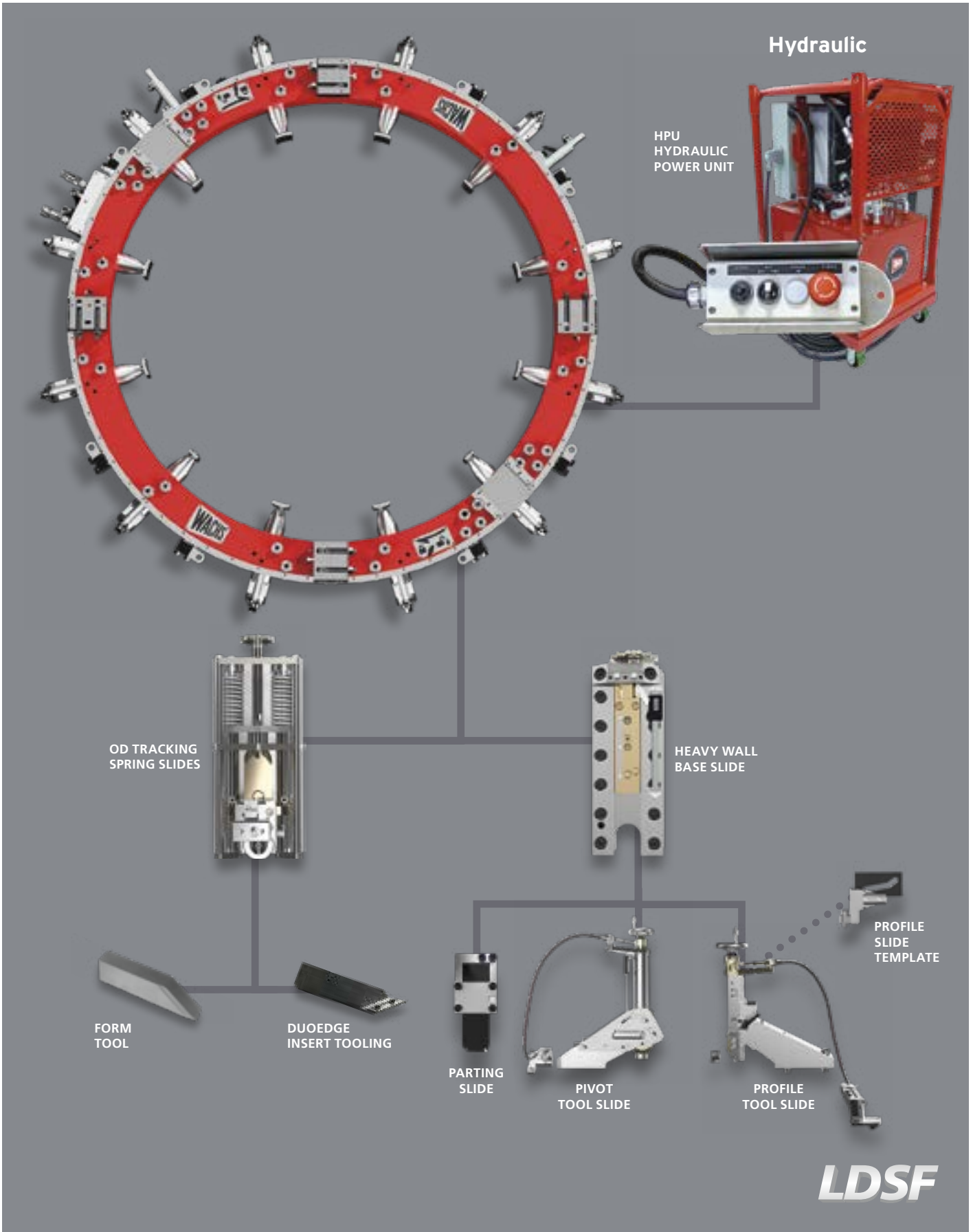
Designed for Large Diameter Pipes & Vessels

E.H. Wachs LDSF Large Diameter Split Frame is designed for cold cutting, beveling, facing and counterboring on large diameter pipes, vessels and flanges. Engineered to incorporate multiple advancements, it's designed to be stronger, faster to set up, faster to operate, and even more versatile than our previous HDSF models.

Picking up where our DynaPrep MDSF Split Frames leave off, four standard LDSF sizes cover a range from 60-120in OD (DN1500-DN3000). New modules for machining heavy wall up to 6in (152.4mm) and a new, more versatile profile slide kit for single pointing makes the LDSF the most versatile machine in its category.



LDSF Split Frame



LDSF Split Frame Features

LDSF Large Diameter Split Frame

The internal, full bearing construction contributes to the LDSF's smooth operation and long service life. Spring loaded OD tracking slides for irregularly shaped or out-of-round pipe and vessels are standard, and allow the tooling to maintain continuous contact, producing precision weld preps with consistent lands. The LDSF takes corrosion protection to a new level with virtually every surface treated. Its attractive red powder coated finish proudly reflects E.H. Wachs famous red and black corporate colors.

New modules and kits broaden the versatility of the LDSF. Pivot Slide and Profile Slide kits allow for deep counterboring and heavy wall (up to 6in or 152mm) single point machining and profiling. A new flange facing adapter kit allows the LDSF to perform facing on very large diameter flanges. A new double parting kit allows for faster severing on even the heaviest wall or high alloy materials.

- Ideal for vessels & Steam Generator Replacement (SGR)
- Designed for large and very large diameter pipes and vessels
- Four standard LDSF sizes cover a 60in to 120in OD range (DN1500-3000)
- 15in (381mm) clamping diameter range across four standard LDSF models
- 30in (762mm) diametrical machining range including clamping leg and tool slide stroke
- Splits into quadrants for easier storage, transport and set-up
- All steel construction for durability and rigidity
- Common size, fully captivated fasteners used throughout
- Quick release, adjustable height setup legs, 3 per quadrant
- Self squaring mounting system features axially micro adjustable clamping legs
- Rigging blocks with lifting eyes allow horizontal or vertical lifting
- Multiple setup configurations for vertical or horizontal operation
- Includes operating hand tools and manual

Standard Equipment

- Dual hydraulic drive motors
- Heavy duty OD tracking tool slides
- Self re-setting trip assembly
- Lifting eyes for vertical or horizontal mounting
- Ratcheting hinge mechanism for opening & closing
- Self squaring mounting system with axially adjustable clamping legs
- Sealed dual pinion housings
- Custom wood storage case & quadrant end protectors

Additional Features

- Reinforcing stiffener blocks at the split lines offer increased rigidity
- Hinged open/close mechanism to simplify machine mounting
- Frame fastening swing bolts holds ring frames in place during assembly
- Dual hydraulic drive motors require less clearance than one large motor
- Dual drive reduces gear tooth loading for greater durability
- Drive motors utilize Wachs universal quick mount drive assembly
- Fully adjustable mounting legs replace traditional bolt on spacer feet
- Modular leg assemblies offer both ID and OD clamping options
- Designed to use a minimum number of hand tools
- Spring loaded trip design eliminates feed crashes



LDSF Split Frame

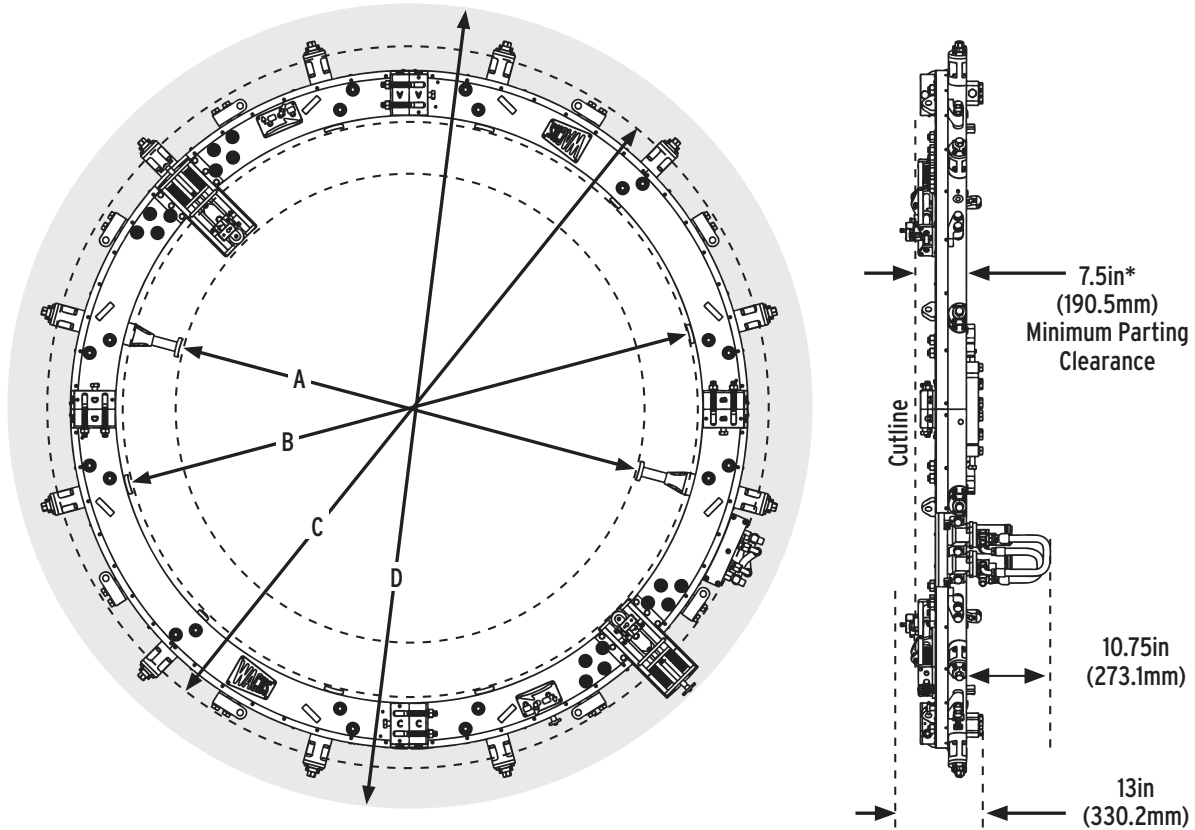


Swing bolts & hinge mechanism speeds assembly & mounting



LDSF includes OD Tracking Slides as standard equipment

LDSF Split Frame Specifications



SPECIFICATIONS	LDSF 75	LDSF 90	LDSF 105	LDSF 120
Dimension "A - B" Machine capacity range (Nominal Pipe Size)	60-75in (1524-1905mm)	75-90in (1905-2286mm)	90-105in (2286-2667mm)	105-120in (2667-3048mm)
Dimension "C" pinion clearance	99in (2515mm)	114in (2896mm)	129in (3277mm)	144in (3658mm)
Dimension "D" Standard OD Tracking slide clearance	111in (2820mm)	126in (3200mm)	141in (3581mm)	156in (3962mm)
Dimension "D" Optional Heavy Wall Base Slide clearance	117in (2972mm)	132in (3353mm)	147in (3734mm)	162in (4115mm)
Machine height	13in* (330.2mm*)			
Hydraulic motor height	10.7** (271.8mm**)			
Cutting tool surface speed	Adjustable, 60 surface ft/min (18.28m/min)			
Hydraulic power requirements	14gpm @ 1800psi (53lpm @ 124BAR)			
Feed Methods	Mechanical Starwheel or Cable feed			
Feed Rates	0.0031in (0.0787mm) per trip w/ OD Tracking Slide			
	0.003846in (0.09769mm) per trip w/ Heavy Wall Base Slide			
	0.001 to 0.006in (0.0254 to 0.1524mm) per trip w/ axial operations (adjustable)			

* MINIMUM CLEARANCE SHOWN IS WITH STIFFENING BLOCKS REMOVED. ** STANDARD DRIVE MOTOR CONFIGURATION. REDUCED CLEARANCE OPTIONS AVAILABLE.

Construction

- Alloy steel stationary and rotating rings
- Alloy mounting legs
- High capacity bearings
- Dual heavy duty pinion housings
- Ratcheting hinge mechanism
- Stainless steel, nickel plating and powder coating for corrosion resistance

Optional Equipment

- Base slide kit
- Pivot slide kit*
- Profile slide kit*
- Flange facing adapter kit
- Genuine Wachs Tooling

*REQUIRES BASE SLIDE KIT

LDSF Split Frame Tool Slides

OD Tracking Slide

Standard equipment and included with the LDSF, the OD Tracking Slide is extremely versatile and suitable for typical applications including parting and beveling, and includes spring loaded trips to eliminate feed crashes. Utilizes standard Legacy and DynaPrep MDSF tooling.

Pivot Slide Kit

The LDSF Pivot Slide Kit is designed for ID or OD turning, facing and beveling. It's ideal for large diameter vessels, including steam generators, used in oil and gas and power generation applications. Used for extra heavy wall applications (up to 6in) with greater metal removal requirements on ID and OD profiles.

Profile Slide Kit

The LDSF Profile Slide Kit is a multipurpose slide that can be configured to bevel heavy wall pipe and vessels and face large diameter flanges. The Profile Slide utilizes standard and custom made interchangeable templates to perform precise compound bevels.

Parting Slide Kit

The LDSF Parting Kit features digital read out (DRO) for precise radial position indication. This module is designed for parting and beveling configurations.

Heavy Wall Base Slide

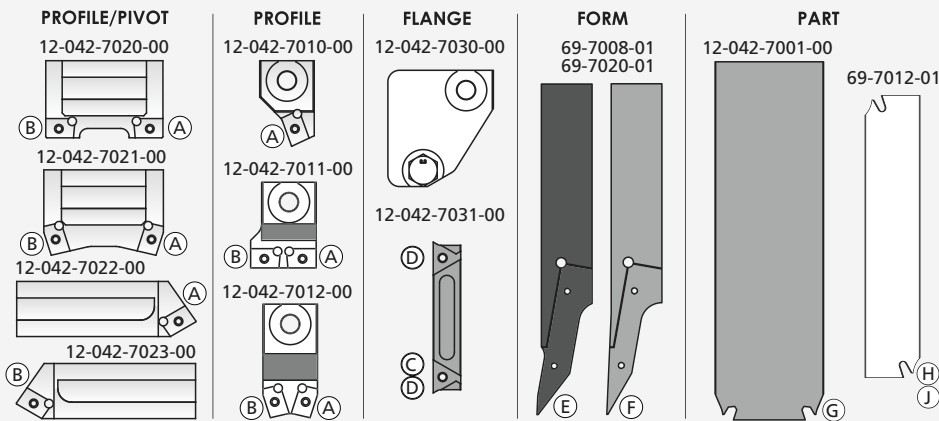
The LDSF Heavy Wall Base Slide serves as the mounting platform for the Parting Kit, Pivot Slide and Profile Slide Kits.

DESCRIPTION	PART #
Pivot Slide Kit*	12-042-4442-00
Profile Slide Kit*	12-042-4443-00
Template for Profile Slide Kit**	12-042-4445-00
Parting Kit*	12-042-4441-01
Heavy Wall Base Slide	12-042-4440-00

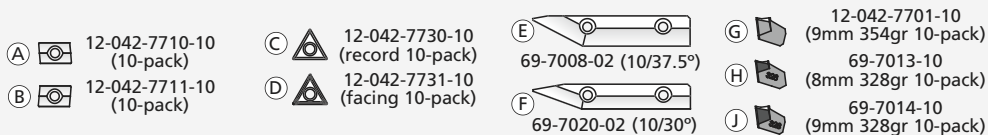
*REQUIRES MOUNTING BASE 12-042-4440-00, SOLD SEPARATELY.

**REQUIRES MOUNTING BASE 12-042-4440-00 AND 12-042-4443-00 PROFILE SLIDE, SOLD SEPARATELY.

Heavy Wall Insert Holders (includes insert screws and wrench)



Heavy Wall Insert Tooling



OD Tracking Slide



Pivot Slide Kit



Profile Slide Kit



Parting Kit

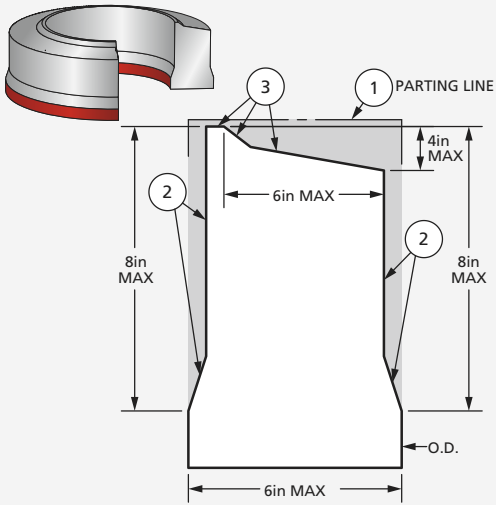


Heavy Wall Base Slide



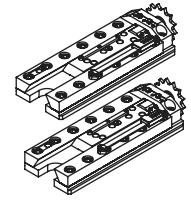
Template for Profile Slide Kit

LDSF Split Frame Heavy Wall Kits

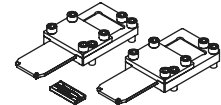


LDSF 6in Wall Tooling Setup 12-042-5701-00 (Rental # R12-042-5701-00)

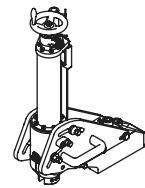
	DESCRIPTION	PART #
ALL	(2) BASE SLIDE KIT	12-042-4500-00
ALL	FEED TRIP KIT	12-042-4506-00
1	PARTING KIT	12-042-4501-00
2	PIVOT SLIDE KIT	12-042-4502-00
3	PROFILE SLIDE KIT	12-042-4503-00



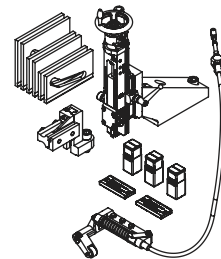
Heavy Wall Base Slide



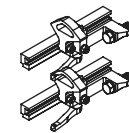
Parting Kit



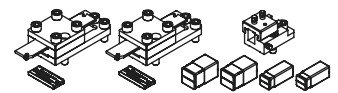
Pivot Slide Kit



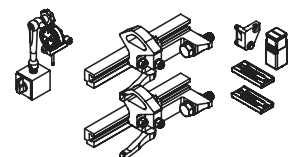
Profile Slide Kit



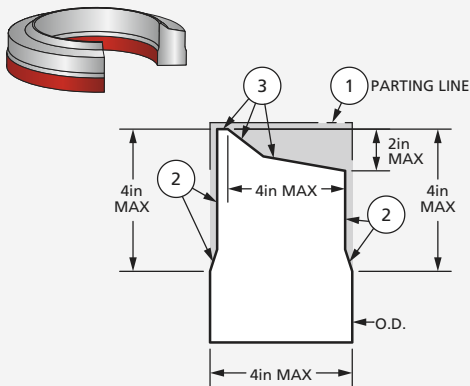
Feed Trip Kit



Form Tool Adapter Kit



Flange Face Adapter Kit



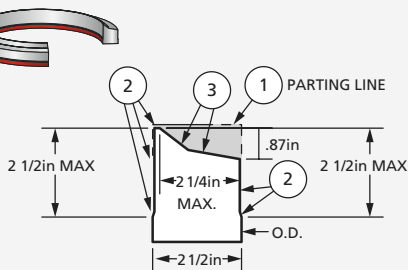
LDSF 4in Wall Tooling Setup 12-042-5702-00 (Rental # R12-042-5702-00)

	DESCRIPTION	PART #
ALL	(2) BASE SLIDE KIT	12-042-4500-00
ALL	FEED TRIP KIT	12-042-4506-00
1	PARTING KIT	12-042-4501-00
2,3	PROFILE SLIDE KIT	12-042-4503-00

LDSF Form Tool Adapter Setup 12-042-5703-00 (Rental # R12-042-5703-00)

	DESCRIPTION	PART #
2	PROFILE SLIDE KIT	12-042-4503-00
1,3	FORM TOOL ADAPTER	12-042-5703-00

* REQUIRES 4IN WALL KIT 12-042-5702-00



LDSF Flange Facing Adapter 12-042-5704-00 (Rental # R12-042-5704-00)

	DESCRIPTION	PART #
ALL	FLANGE FACING ADAPTER KIT	12-042-5704-00

* REQUIRES 4IN WALL KIT 12-042-5702-00

