



V. P. INDUSTRIES

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➤ Quality ➤ Speed ➤ Confidence



V. P. INDUSTRIES

A Complete Tool Manufacturing Company



Complete Holemaking Solution for Automotive & Engineering Industry



Case Transmission



Fuel Pump



Cylinder Block



Gear Box



Cylinder Head

COMPANY PROFILE

V. P. Industries founded in Aug 2009, is today one of the leading Manufacturing Company of a Solid Carbide Tools & expanding its based to all India level.

Our mission is to provide measurable cost savings for our customers.

V. P. Industries is a ISO 9001 : 2008 company having received the scope as Design, Manufacture & Re-conditioning of solid carbide tools for Engineering & Automotive Industries

POINTS OF DIFFERENCE

Machine :

- ◆ To ensure that customers enjoy maximum tool life from original grinding, we utilizes high precision modern 5 Axis CNC grinding machines from ANCA Pty,
- ◆ We have patented license copies for point geometries which helps us to prove wide range of applications.

Materials :

- ◆ Apart from geometries the performance of the tools mainly depend on the quality of raw material being used.
- ◆ We utilizes ultrafine grain carbide rods from pioneer brand in carbide rods , which is absolutely competitive in terms of cutting parameters & tool life.

Quality :

- ◆ From quality pint of view, we have Zoller make inspection cum presetter for measuring profiles & other quality parameters like radius, chamfers. Also for point geometry inspection we have 50X video image magnification system which is PC based.

Edge Preparation

- ◆ We execute Edge Honing & Flute polishing with accuracy to strengthen the cutting edge & assists the chip control.

V. P. INDUSTRIES

Manufacturing Services

- Our mission is to provide measurable cost savings for our customers.
- One such example is our proprietary TOOL manufacturing and reconditioning services.
- To ensure that customers enjoy maximum tool life from original grinding thru multiple regrinds we utilizes the same high precision modern CNC grinding machines as that used at Original Tool Suppliers.

Following Tools we can manufactured from our setup.

1. Drills & Step Drills :

- One to Three (Multiple) Steps.
- Through Coolant Hole Drill
- Left Hand Helix Drill
- Center Drills Single End / Double End.
- Extra Long Drills L/D upto 16.
- Burnishing Drills with hole tolerance IT8,
- Three Fluted Thru / Non Thru Coolant Drills.



2. ENDMILLS :

- Flat / Ball Nose / Corner Radius End mill.
- Step End mill with Multiple steps.
- Hole mills - RH & LH Helix.



3. REAMERS :

- Face Cutting / Chamfer Cutting Reamers.
- Combination Reamers.

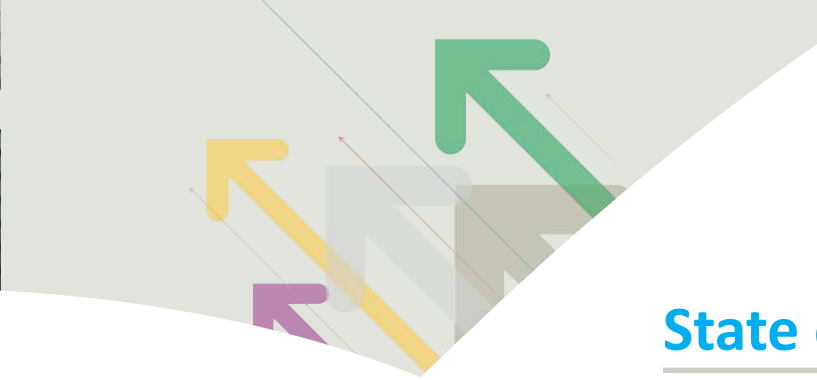
4. PROFILE TOOLS :

- Different Combinations of Radius, Double Chamfers. Port cutter with two chamfers, Radius etc.

5. BRAZED & LUGGED CARBIDE TOOLS

Reconditioning Services

- You can simply send us your worn tools and our reconditioning facility will deliver a tool back to you as good as the original.
- Higher Precision reconditioning delivers longer reground tool life and offer more regrind per tool resulting in significant cost saving.
- The service is fast, convenient & cost - effective.
Returns from reconditioning right from the start.

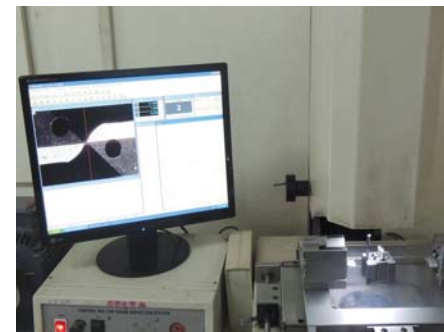


State of Art Facility



A. Complete Tool Manufacturing & Reconditioning on 5 Axis CNC Tool & Cutter Grinder (ANCA RX7 & ANCA Fastgrind)

- "ANCA" CNC TOOL & CUTTER GRINDERS to meet the demands of the industry in terms of quality, accuracy & speed.
- Software options of ANCA enables us to provide you optimal drill point geometry, special profile tools.
- And all this with Precision in terms of accuracy & surface finish.



B. Hi-Resolution Video Image Magnification & Precision Inspection.

- Every tool is checked real time during the process as well as after completion.
- This is accomplished by the use of high-resolution optics built into our PC Based inspection machine.
- All the important geometry points are easy to check & can be record as a library.



C. Zoller Presetter & Measuring Machines

The image processing software "pilot 3 "useful for selective measurement of tool contours & intricate cutting edge shapes.

Alongwith this we have drawing generator" sinope " software which can create a dxf document of measured profile & can be given to our customer as an inspection report.



E. Blank preparation

Rotating tool performance is inherently depends on the quality of blank. To fulfill the need we have excellent cylindrical grinding setup to ensure minimum runout & lapping finish.

F. Laser marking machine to provide identification marking with total description on tools shank

This makes identification of the tools much easier, faster & easy to track specially for reconditioning.

Solid Carbide Drills



Solid Carbide Endmills



Solid Carbide Reamers & Profile Tools



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CUTTING DATA

ISO	Material	Hardness Brinell HB	Cutting Speed Vc (m/min.)	Drill Diameter, mm			
				3 to 6	6.1 to 10	10.1 to 14	14.1 to 20
				Feed mm/rev			
P	Unalloy Steel						
	C = 0.1 to 0.25%	125	60 to 70	0.05 to 0.1	0.1 to 0.2	0.15 to 0.25	0.25 to 0.3
	C = 0.55 to 0.8%	170	50 to 60	0.05 to 0.1	0.1 to 0.2	0.15 to 0.25	0.25 to 0.3
	High Carbon Steel	210	50 to 60	0.05 to 0.1	0.1 to 0.2	0.15 to 0.25	0.25 to 0.3
	Steel Castings	200	50 to 60	0.05 to 0.1	0.1 to 0.2	0.15 to 0.25	0.25 to 0.3
M	Stainless Steel						
	Non-hardened & Austenitic Castings	200	30 to 45	0.04 to 0.8	0.4 to 0.8	0.04 to 0.08	0.12 to 0.15
	Austenitic	180	30 to 45	0.04 to 0.8	0.4 to 0.8	0.04 to 0.08	0.12 to 0.15
K	Grey Cast Iron						
	Low Tensile Strength	180	90 to 120	0.1 to 0.2	0.2 to 0.35	0.25 to 0.4	0.35 to 0.45
	High Tensile Strength	260	60 to 90	0.1 to 0.2	0.2 to 0.35	0.25 to 0.4	0.35 to 0.45
	SG Iron						
	Ferritic	160	70 to 90	0.1 to 0.2	0.2 to 0.35	0.25 to 0.4	0.35 to 0.45
	Pearlitic	250	60 to 80	0.1 to 0.2	0.2 to 0.35	0.25 to 0.4	0.35 to 0.45
N	Alluminium Alloys	60	90 to 180	0.1 to 0.2	0.2 to 0.35	0.25 to 0.4	0.35 to 0.45