

➤ HOW DO WE MANUFACTURE ALPHA LATHE MACHINE ?



1. CASTING



2. ROUGH MACHINING
OF PARTS



3. SEASONING
PROCESS OF PARTS



4. BED MACHINING
& HARDNING



5. SEASONING
PROCESS OF BED



6. GRINDING OF BED
(FIRST TIME)



7. SEASONING PROCESS
OF BED (SECOND TIME)



8. FINAL GRINDING OF
BED (SECOND TIME)



9. FINAL MACHINING
OF PARTS



10. SHEET THEORY
PROCESS IN 4 PLACES



11. MACHINE LEVELING
WITH MICRO LEVEL (RSK JAPAN)



12. SHEET THEORY
PROCESS IN 20 VARIOUS
PLACES



13. MACHINE
ASSEMBLY



14. MACHINE TRY &
TESTING



15. PAINTING



16. REFITTING



17. FINAL MACHINE
TRY & TESTING



18. FINAL INSPECTION
LIKE INDIAN STANDARD
IS 1878 (PART 1): 1993



19. PACKING



20. DISPATCH

Our T&C apply.

Must Watch :-

SEASONING PRO.

SHEET THEORY

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1. CASTING

➤ Main Reasons Why Customers Trust Us & Our Manufacturing Keypoints.

1.	We make high quality, micro accuracy and high precision Lathe Machines. (like Indian Standard 1878, P-1)
2.	We make all the machines at micro level (Rsk Japan).
3.	60 days piece to piece exchange (cone pulley lathe machine)
4.	90 days piece to piece exchange (all gear lathe machine)
5.	We do lathe machine manufacturing, leveling and final testing like IS 1878 (Part-1) : 1993 (Indian Standard).
6.	Best price to quality ratio.
7.	After sales support.
8.	Nearly zero % customer complaint rate in Alpha Lathe Machine.
9.	In a 99% Alpha Lathe Machine you don't have to set the headstock and hit the spanner. So 99% Alpha Lathe Machine is ready to use. (without any query)
10.	Alpha Lathe Machine manufacturing process is a special and new technique than normal/regular lathe machine, so Alpha Lathe Machine manufacturing cost is 10% to 15% higher compare to normal/regular lathe machine.
11.	The cost of purchasing high quality spare parts for an Alpha Lathe Machine is 7% to 10% higher than for a normal/regular lathe machine.
12.	We make all lathe machines by seasoning process and we take sheet (lapping) at 24 places so that we can make high quality & high precision lathe machines.
13.	You will get a higher resale value of Alpha Lathe Machine.
14.	We manufacture all Alpha Lathe Machines by balancing the parts. (Like Spindle Pulley with Gear, Counter Pulley with Shaft and Aarapulley).
15.	We have many reputed happy customers who are using Alpha Lathe Machine.

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Rajkot-360002 (Gujarat,India)

➤ “ALPHA” LATHE VS “NORMAL” LATHE MACHINE :-

NO	“ALPHA” LATHE MACHINE	“NORMAL” LATHE MACHINE
1.	<u>45 Days Piece To Piece Exchange* (T&C)</u>	Only 30 Days Manufacturing Defect
2.	<u>Seasoning Process (Our New Technique)</u>	No Seasoning Process
3.	<u>24 Place Sheet In The Machine (Our New Technique)</u>	Only 6 To 7 Place Sheet In The Machine
4.	2 Time Bed Grinding (Our New Technique)	Only One Time Bed Grinding (Urgent)
5.	High Quality Spare Parts	Regular Spare Parts
6.	We Use Micro Level To Make The Alpha Lathe Machine	No Level
7.	High Quality And Best Company Bearing	Regular Quality Or Regular Company Bearing
8.	You Don't Need To Set Taper From The Headstock In 99% Alpha Lathe Machine*	You Need To Set Taper From The Headstock In Normal Lathe Machine
9.	We Balance The Spindle Pulley With Gear, Counter Pulley With Shaft And Aarapully. (Only Our System)	No Balancing
10.	Two Time Try And Testing (Finishing , Small Cut , Big Cut , Fully Machine Testing)	Only One Time Try
11.	Alpha Lathe Machine Is Made With High Precision And Good Inspection (like Indian Standard 1878, P-1)	Only once the worker inspects the machine
12.	You will get a higher resale value of the Alpha Lathe Machine (Know it Yourself in the Market)	You will not get higher resale value
13.	Alpha Lathe build only a limited number of machines so we pay enough attention to each machine	There is no certainty in machine production
14.	30+ Yrs Of Experience & 15000+ Machines Installed	-

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➤ SEASONING PROCESS THEORY ("ALPHA" VS NORMAL LATHE)

NO	SEASONING PROCESS TYPES	"ALPHA" LATHE MACHINE	"NORMAL" LATHE MACHINE
1.	Bed Roughing And Hardening	→ We Keep 15 TO 180 Days for seasoning. (after process 1.)	Doing direct Bed Grinding.(after process 1.) [Bed was complete]
2.	Bed Grinding (after Roughing & Hardening & Seasoning)	→ We Keep 30 Days To 180 Days for seasoning. (after process 2.)	NA
3.	Final Finishing And Finishing Grinding Of The Bed after two time seasoning process (after 1. & 2.)	→ YES [Bed was Complete]	NA
A.	Headstock Roughing And Boring	→ We Keep 15 Days To 120 Days for seasoning. (after process A.)	Doing direct finishing & boring of headstock. (after process 1.) [Headstock was complete]
B.	Sheet At The Bottom Of The Headstock And Do The Finishing Boring.	→ YES [Headstock was complete]	NA
I.	Sedal, Surface, Compound & Legs Roughing	→ We Keep 30 Days To 60 Days for seasoning. (after process I.)	Doing direct finishing & boring of sedal,surface & compound. (after process I.) [Parts was complete]
II.	Finishing And Boring Of Sedal, Surface And Compound.	→ YES [Various Parts was complete]	NA

➤ **Why are we doing the seasoning process?**

- Increases overall machine life
- Improves machine accuracy
- Micro leveling can be done on machine
- Accuracy lasts longer

- We do all seasoning processes as per our company standard.

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➤ SHEET (SCRAPING) THEORY ("ALPHA" VS NORMAL LATHE)

NO	QUALITY MAINTAIN = SHEET THEORY	"ALPHA"	"NORMAL"
1.	We Take The Sheet At Bottom Of The Bed (From The Surface Plate) (two sheets included)	YES	NO
2.	We Take The Sheet At Above The Face Of The Leg (From The Surface Plate) (two sheets included)	YES	NO
3.	Then We Level The Two Legged Machine With A Horizontal And Vertical Level	YES	NO
4.	WE Take The Sheet Both Between Apron And Saddle. (From The Surface Plate) (two sheets included)	YES	NO
5.	We Take The Sheet At The Sedal Depending On The Bed.	YES	YES
6.	We Take The Sheet At The Bottom Of The Surface. (From The Surface Plate)	YES	NO
7.	We Take The Sheet Between The Sedal And Surface.	YES	YES
8.	We Take The Sheet At The Bottom Of The Compound. (From The Surface Plate)	YES	NO
9.	We Take The Sheet Between The Compound And Surface.	YES	NO
10.	After, We Take The Sheet On Compound Face. (From The Surface Plate)	YES	NO
11.	We Take The Sheet Between Compound Paw And Compound Face.	YES	YES
12.	We Take The Sheet At The Bottom Of The Tool Post.(From The Surface Plate)	YES	NO

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NO	QUALITY MAINTAIN = SHEET THEORY	"ALPHA"	"NORMAL"
13.	We Take The Sheet Between Compound And Toolpost Face.	YES	NO
14.	We Take Sheet At Bottom Of The Headstock. (From The Surface Plate)	YES	NO
15.	We Take The Sheet At The Bed Depending On The Headstock.	YES	YES
16.	We Take The Sheet Counter Breket. (From The Surface Plate)	YES	NO
17.	The Tailstock Patli Depending On The Bed.	YES	YES
18.	Above Tailstock Patli (From The Surface Plate)	YES	NO
19.	Spindle Ring Gear And Kala Sheet (From The Surface Plate) (Two Sheet)	YES	NO
20.	"Bottom Of Tailstock (From The Surface Plate)	YES	NO

TOTAL NUMBER OF SHEET

'ALPHA' LATHE MACHINE

24 places

NORMAL LATHE MACHINE

5-8 places

➤ Why are we doing the sheet theory process?

- Reduce machine vibration,
- Micro accuracy can be achieved,
- Machine running smoothly,
- Precision work can be done,
- Micro leveling can be done
- Precision work can be done,
- Micro leveling can be done,
- Center to center shaft turning and boring can be done

- We do all sheet theory processes as per our company standard.

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Mfg. By
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SEASONING PROCESS



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