

FF8000 PORTABLE FLANGE FACER

FEATURES ■ SETUP & OPERATION
COMPONENTS & ACCESSORIES ■ TECHNICAL DATA

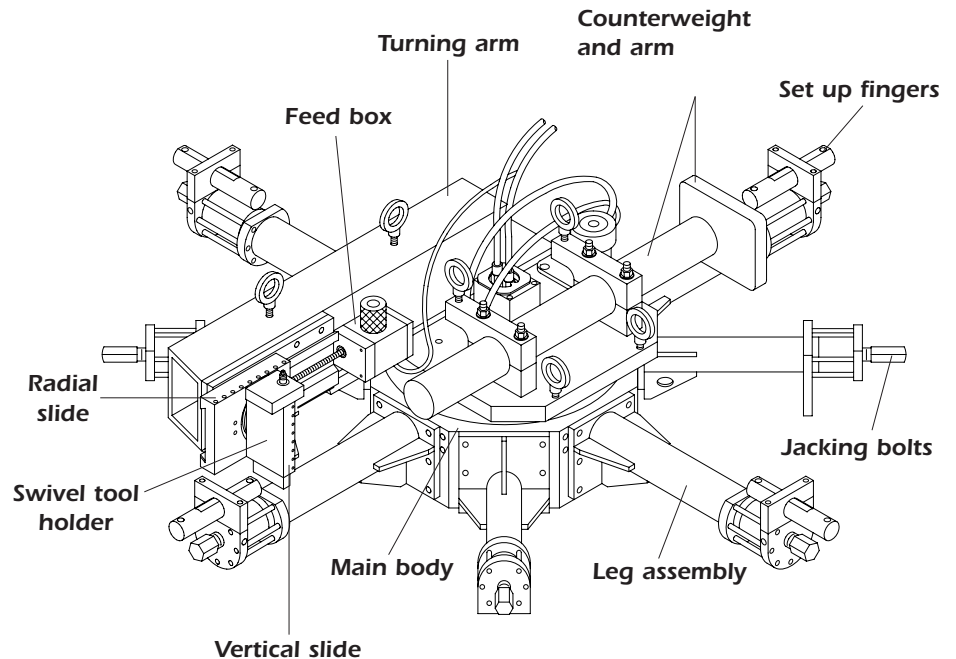
Get big flange faces back in working condition - FAST!

Versatile

- Available in ID or OD mount styles.
- Options include grinding heads, flat surface mounting, and a mounting and facing range of up to 10 feet (3048.0 mm) in diameter.
- Power supply hoses attach to the top or bottom of the machine with a rotary union for operation in horizontal, vertical, or inverted positions.

Rugged and powerful

- Large volume hydraulic motor, or two rotational drive air motors.
- Produces accurate machining even at the maximum turning arm extension.
- Large diameter, heavy-duty Timken bearings support the turntable section. The turning arms are large cross-section tubes that provide rigid, lightweight mounting for the tool head.
- Smooth rotation is ensured by the adjustable counterbalance arm and a set of weights provided with the machine. Properly adjusted, the FF8000 rotates at a uniform rate, even when mounted in vertical flanges.
- Precise finishes with HSS or carbide tool bits, even on stainless steel. Finishes as fine as RMS 16 can be produced with the optional grinding head.
- The turning arms mount on the machine turntable in dovetail ways for easy positioning.
- The 8.0 inch (203.2 mm) travel radial feed is pneumatically actuated.



- The tool head/radial feed mechanism mounts on dovetail ways at the end of the turning arm, to re-face to the edge of flanges that have very little clearance around them, or cut right up to a shoulder. Rotating diameter is easily adjustable in limited clearance applications.
- The four-inch (101.6 mm) travel vertical feed is manually controlled during automatic radial cutting operations, or may be pneumatically controlled when cutting grooves or cutting down vertical surfaces.
- The tool holder also rotates up to 45° in either direction for cutting chamfers or J-weld preps.



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Specifications

All dimensions should be considered reference. Please contact your Climax representative for precision dimensions.

	<u>US</u>	<u>Metric</u>
General Specifications		
Tool slide:		
Radial travel	10 inches	254.0 mm
Vertical Travel	4 inches	101.6 mm
Swivel	-45° to 0 to 45°	-45° to 0 to 45°
Tool Feed System:		
Automatic feed: pneumatic, reversible	0.003 to 0.20 inches per rev.	0.08 to 0.5 mm per rev.
Manual setup feed (setup only)	0.100 inches per turn of hand wheel	2.5 mm per turn of hand wheel
Tool cutter	¾ inch standard square lathe tool bits	20 mm standard square lathe tool bits
Rotational drive assembly:		
Final drive reduction	8:1 helical gear	8:1 helical gear
Machining speed	13 rpm at 2.9 Hp	13 rpm at 2.18 kW
Power source:		
Pneumatic (standard)	2 motors, 2.9 Hp total Requires 96 ft ³ /min at 90 psi min.	2 motors, 2.18 kW total Requires 2.72 m ³ /min at 620 kPa min.
Hydraulic (optional) (Hydraulic Power Unit information available upon request. Please contact your Climax representative.)	10 Hp hydraulic power unit.	7.46 kW hydraulic power unit
Machine shipping dimensions:		
Main machine (W x D x H)	60 x 34 x 32 inches	1524 x 864 x 813 mm
ID Chuck arm assembly	65 x 43 x 35 inches	1651 x 1092 x 889 mm
(shipped in two crates)	69 x 37 x 32 inches	1753 x 940 x 813 mm
OD chuck arm assembly	65 x 43 x 35 inches	1651 x 1092 x 889 mm
(shipped in two crates)	69 x 37 x 32 inches	1753 x 940 x 813 mm
Hydraulic power unit - 10 Hp	48 x 27 x 36 inches	1219 x 686 x 914 mm
FF8000 Shipping Weights:		
Main machine	2,500 lbs	1,134 kg
ID chuck arm assembly	1,695 lbs	769 kg
OD Chuck arm assembly	2,413 lbs	1,095 kg
Hydraulic power unit - 10 Hp	575 lbs	261 kg
ID Mount Machine Specifications		
Standard ID mounting diameter	30 - 96 inches	762.0 - 2438.4 mm
Optional ID mounting chuck extension kit mounting diameter	96 - 120 inches	2438.4 - 3048.0 mm
Standard facing diameter	30 - 96 inches	762.0 - 2438.4 mm
Optional turning extension kit facing diameter	96 - 120 inches	2438.4 - 3048.0 mm
OD Mount Machine Specifications		
Standard OD mounting diameter	42.5 - 109.5 inches	1079.5 - 2781.3 mm
Optional OD mounting extension kit mounting diameter	96 - 133 inches	2438.4 - 3378.2 mm
Standard facing diameter	30 - 96 inches	762.0 - 2438.4 mm
Optional turning extension kit facing diameter	96 - 105 inches	2438.4 - 2667.0 mm

Specifications subject to change without notice

Tool Configuration:

Basic ID-mount machines

Mounts in 30 - 96 inch (762.0 - 2438.4 mm) ID, faces 30 - 96 inch diameter.

Pneumatic drive/feed **18447** _____
 Hydraulic drive/pneumatic feed **41995** _____

Extensions and Conversions

Extend ID mounting to 120 inches (3048.0 mm) diameter **add 19753** _____
 Extend machining to 120 inches (3048.0 mm) diameter **add 33807** _____
 Convert ID mount to OD mount, 42.5 - 109.5 inch diameter (1079.5 - 2781.3 mm) **add 17801** _____

Basic OD-mount machines

Mounts on 42.5 - 109.5 inch (1079.5 - 2781.3 mm) outside diameter, faces 30 - 96 inches (762.0 - 2438.4 mm) diameter.

Pneumatic drive/feed **19581** _____
 Hydraulic drive/pneumatic feed **41986** _____

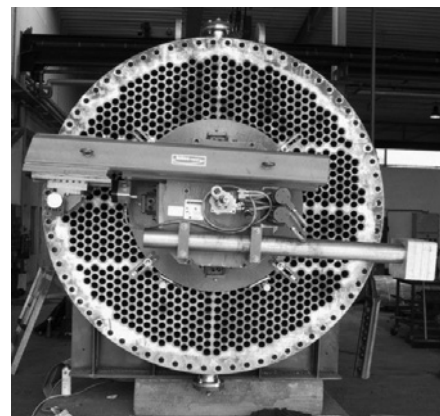
Extensions and Conversions

Extend OD mounting to 133 inches (3378.2 mm) diameter **add 28451** _____
 Extend machining to 120 inches (3048.0 mm) diameter **add 33807** _____
 Convert OD mount to ID mount, 30 - 96 inch diameter (762.0 - 2438.4 mm) **add 17423** _____
 Extend ID mount conversion to 96 - 120 inch diameter (2438.4 - 3048.0 mm) **add 24421** _____
 Extend machining to 120 inches (3048.0 mm) diameter **add 33807** _____

Accessories ID or OD

Grinding head **19060** _____
 Large steel storage boxes **20213** _____
 Tool Kit **17757** _____
 Grinding stones
 4.0 inch (101.6 mm) dia, 16 grit **19498** _____
 4.0 inch (101.6 mm) dia, 60 grit **28295** _____
 Tool holder, RH **33996** _____
 Tool holder, LH **33997** _____
 Carbide insert for tool holder **33998** _____
 HSS tool bit, RH **29067** _____
 HSS tool bit, LH **29066** _____

Application Photos:

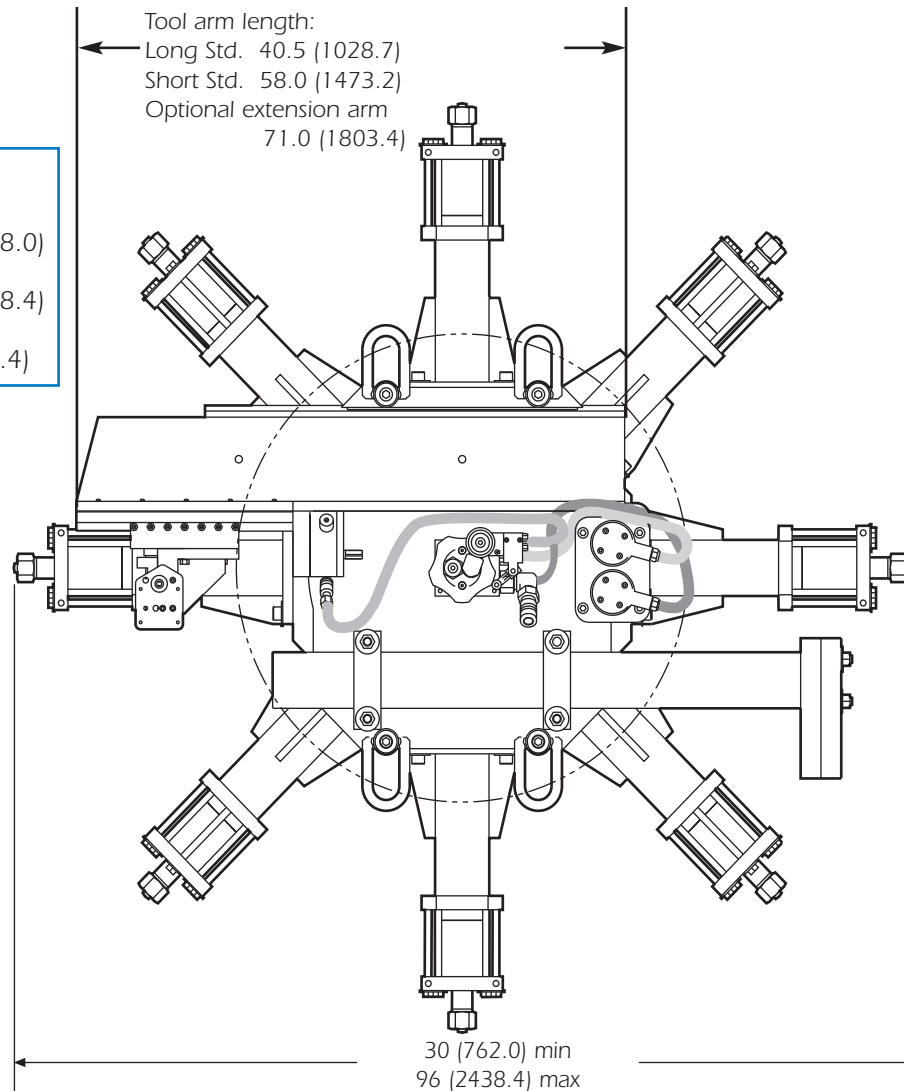


Standard ID-Mount Flange Facer

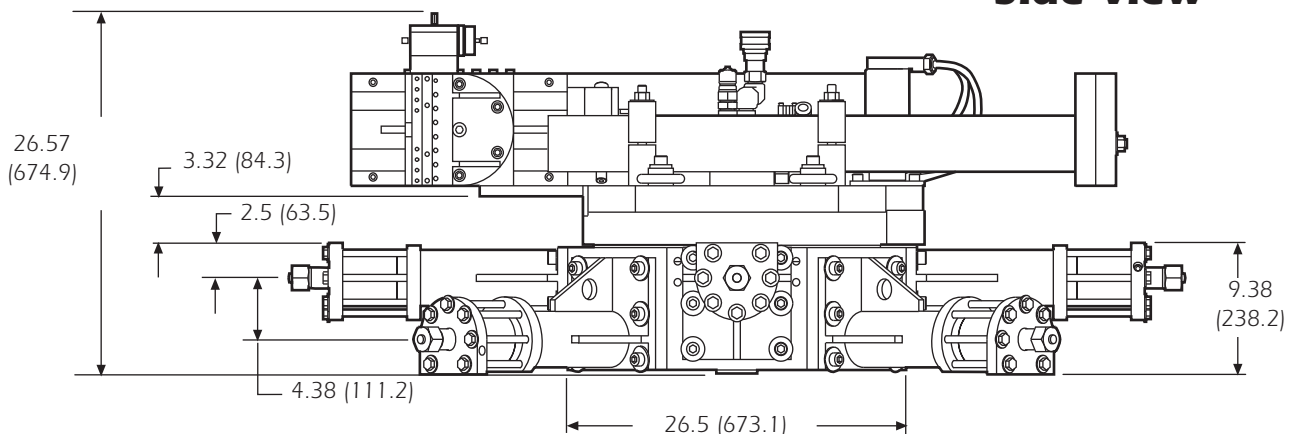
Dimensions in Inch (mm)

Top view

Turning arm facing diameters:	
Optional:	96 - 120 (2038.4 - 3048.0)
Long std.:	47 - 96 (1193.8 - 2438.4)
Short std.:	30 - 61 (762.0 - 1549.4)



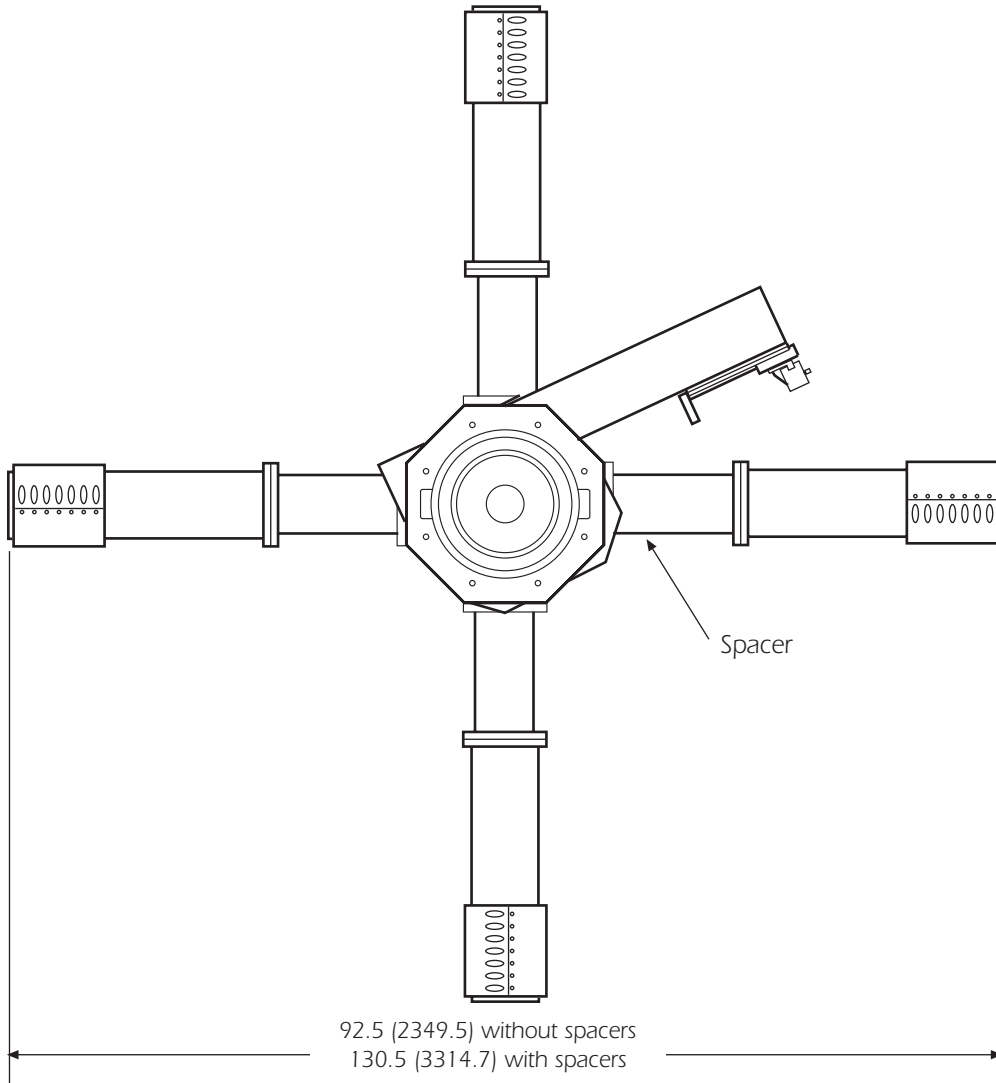
Side view



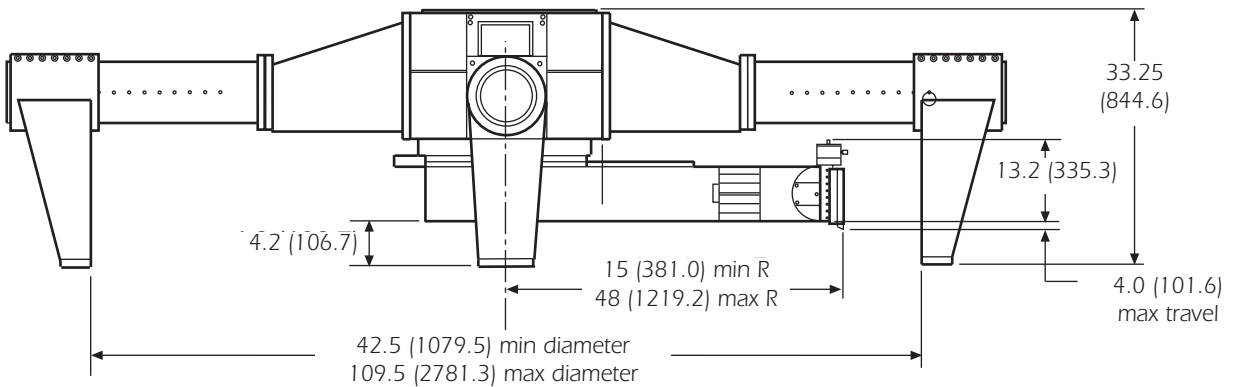
**Standard OD-Mount
Flange Facer**

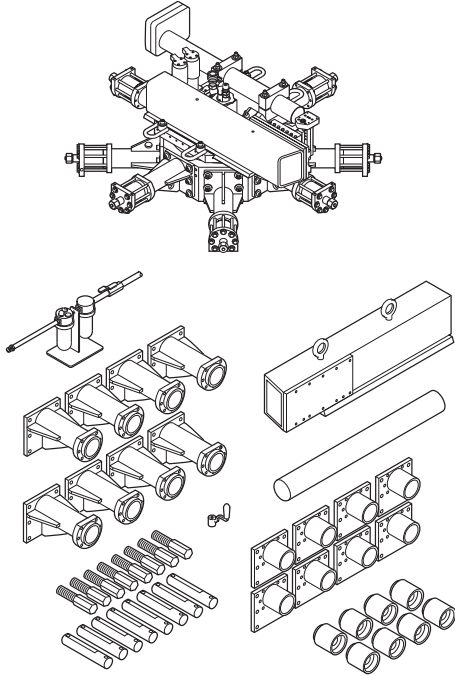
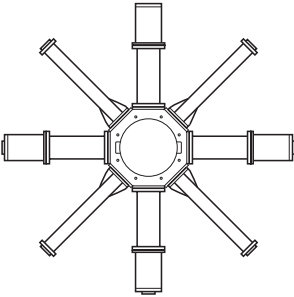
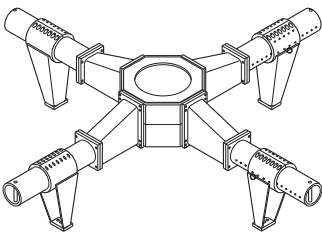
Dimensions in Inch (mm)

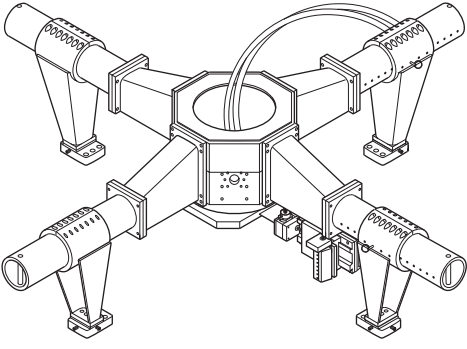
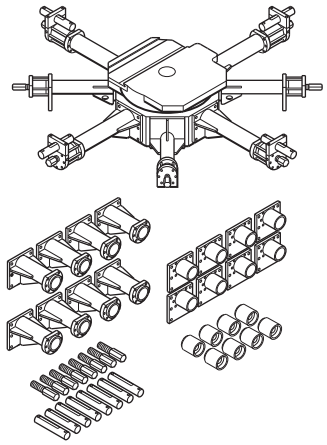
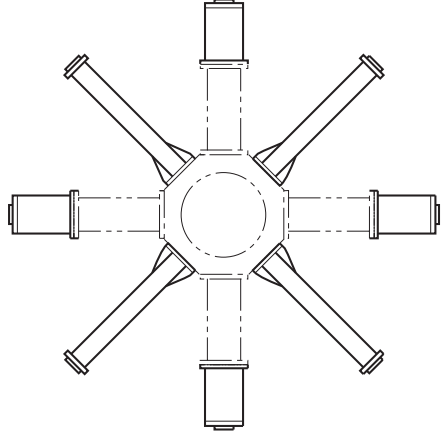
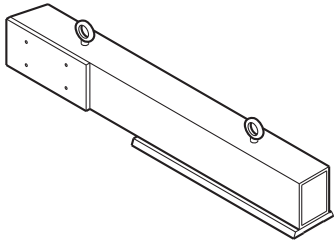
Top View

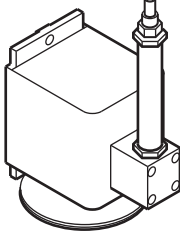
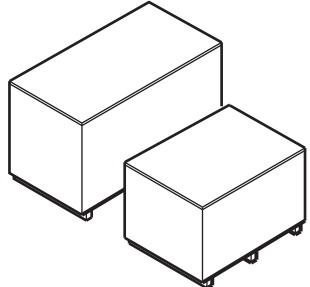


Side View

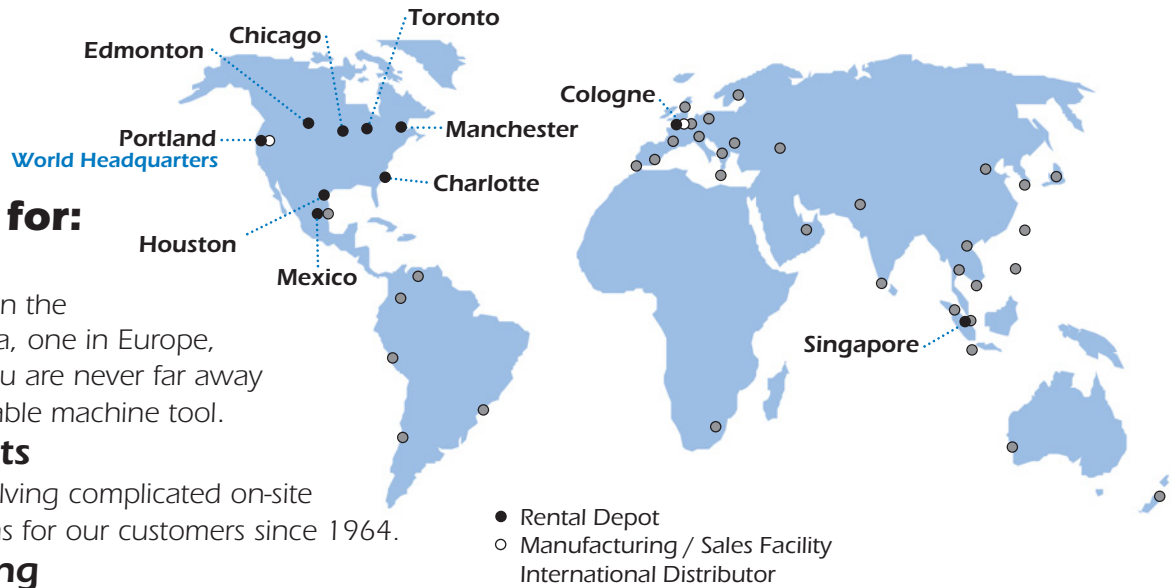


	No. Description
	<p>18447 FF8000 pneumatic ID-mount flange facer Complete flange facing machine. Mounts inside 30 - 96 inch (762.0 - 2438.4 mm) diameter bores. Faces 30 - 96 inch (762.0 - 2438.4 mm) diameter flanges. Machine comes complete with main body, two air motors (2.9 hp/2.18 kW total), pneumatic conditioning unit, chuck arms for 30 - 96 inch (762.0 - 2438.4 mm) diameter bores, short and long tool arm supports, swivel tool holder, radial and vertical slide assemblies, short and long counterweight arms with weights, tool kit, instruction manual, and wooden storage crate.</p> <p>41995 FF8000 230V hydraulic/pneumatic ID-mount flange facer Complete flange facing machine. Mounts inside 30 - 96 inch (762.0 - 2438.4 mm) diameter bores. Faces 30 - 96 inch (762.0 - 2438.4 mm) diameter flanges. Machine comes complete with main body, hydraulic motor, pneumatic feed box, chuck arms for 30 - 96 inch (762.0 - 2438.4 mm) diameter bores, short and long tool arm supports, swivel tool holder, radial and vertical slide assemblies, short and long counterweight arms with weights, tool kit, instruction manual, and wooden storage crate.</p> <p>Hydraulic power unit available separately. Contact your Climax representative for details.</p>
	<p>19753 Extended range ID-mount chuck assembly for 96 - 120 inch (2438.4 to 3048.0 mm) diameters Includes hub, upper, lower, and formed leg assemblies.</p> <p>Use with p/n 18447 or 41995 (FF8000 ID-mount flange facers) to extend its mounting range to bore diameters from 96 - 120 inches (2438.4 - 3048.0 mm).</p> <p>Turning extension kit (33807) must be purchased separately to face diameters up to 120 inches (3048.4 mm).</p>
 <p>NOTE: Drawings are for reference only, are not to scale, and may not represent actual product.</p>	<p>17801 OD-mount chuck assembly (OD-mount conversion kit) Includes OD hub, formed legs, leg tubes, leg clamps and instructions. Convert part number 18447 or 41995 ID-mount machines to OD mounting for outside diameters of 42.5 - 109.5 inches (1079.5 - 2781.3 mm). Machine faces 30 - 96 inch (762.0 - 2438.4 mm) diameter flanges.</p> <p>28451 OD chuck extension kit (OD-mount extension kit) for 96 - 133 inch (2438.4 - 3378.2 mm) diameters (not shown) Kit includes leg extensions and mounting hardware only. Use with part numbers 17801 or 19581 to extend OD mounting range to 96 - 133 inches (2438.4 to 3378.2 mm) in diameter.</p> <p>Turning extension kit (p/n 33807) must be purchased separately to face diameters up to 120 inches (3048.4 mm).</p>

	No. Description
	<p>19581 FF8000 pneumatic OD-mount flange facer Complete flange facing machine. Mounts on work pieces with outside diameters from 42.5 - 109.5 inches (1079.5 - 2781.3 mm). Faces 30 - 96 inch (762.0 to 2438.4 mm) diameter flanges. Machine comes complete with main body, two air motors (2.9 hp/2.18 kW total), pneumatic conditioning unit, chuck arms for 42.5 - 109.5 inches (1079.5 to 2781.3 mm) ODs, short and long tool arm supports, swivel tool holder, radial and vertical slide assemblies, short and long counterweight arms with weights, tool kit, instruction manual, and wooden storage crate.</p> <p>41986 FF8000 hydraulic/pneumatic flange facer As above with hydraulic drive/pneumatic feed.</p>
	<p>17423 Chuck leg assembly (ID-mount conversion kit) Includes short, medium, and long leg assemblies, leg end spacers, short and long setup fingers, short and long jacking bolts, and instructions.</p> <p>Convert p/n 19581 & 41986 (FF8000 OD-mount flange facer assembly) to an ID-mount machine for bore diameters from 30 - 96 inches (762.0 to 2438.4 mm).</p> <p>This assembly is included with ID-mount machines (p/n 18447 or 41995).</p> <p>39947 OD mount small diameter kit Allows mounting down to 24.0 inch (609.6 mm) diameter. OD mount only.</p>
	<p>24421 ID chuck extension kit (ID-mount conversion extension kit) for 96 - 120 inch (2438.4 to 3048.0 mm) diameters (not shown) Includes upper and lower leg assemblies only.</p> <p>Use with part number 17423 (ID-mount conversion kit) to extend its mounting range to 96 - 120 inches (2438.4 to 3048.0 mm).</p> <p>Turning extension kit (p/n 33807) must be purchased separately to face diameters up to 120 inches (3048.4 mm).</p>
 <p>NOTE: Drawings are for reference only, are not to scale, and may not represent actual product.</p>	<p>33807 Turning extension kit for 96 - 120 inches (2438.4 to 3048.0 mm) diameters. Extension kit allows the flange facer to machine larger diameter.</p> <p>Mounting chuck extension must be purchased separately to mount inside 120 inch (3048.0 mm) diameter bores.</p>

	No. Description
	<p>19060 Grinding and polishing head assembly</p> <p>Grinding attachment mounts to the vertical slide to smooth the flange face to a fine finish after machining. Assembly includes mounting bracket, air grinder, hose for connection to the main machine air supply, disk pad, and disks.</p> <p>19498 4.0 inch (101.6 mm) diameter, 16 grit grinding cup 28295 4.0 inch (101.6 mm) diameter, 60 grit grinding cup</p>
	<p>20213 Large steel storage container set</p> <p>For the ID-mount flange facer only.</p> <p>Large steel storage containers to ship or store the extended-reach ID-mount flange facer. Set includes one container for the main machine and one container for accessories. Both containers have steel construction. lids with full-length piano hinges, latches, and handles.</p>

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