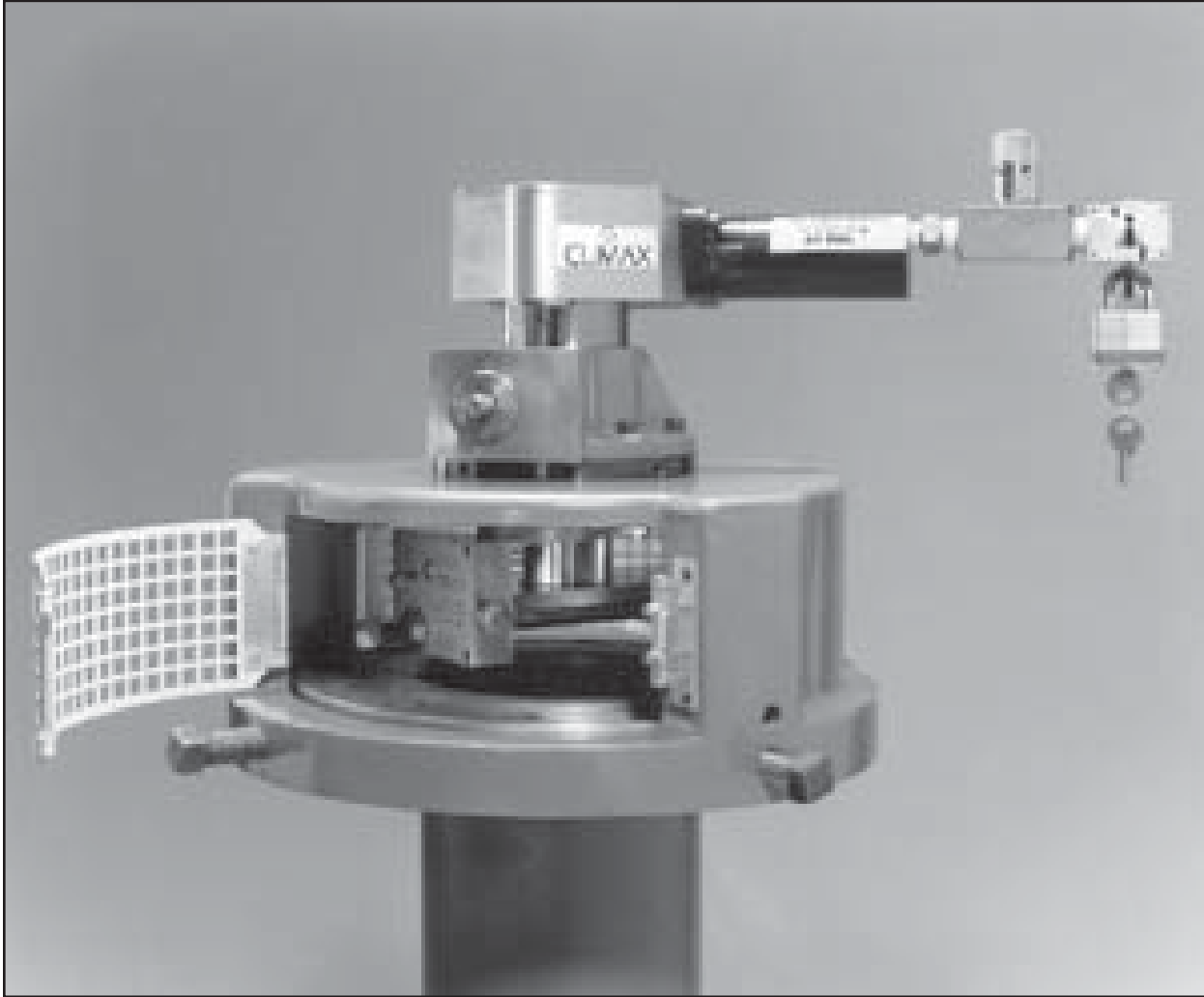


FF1000 FLANGE FACER

FEATURES • SETUP & OPERATION
COMPONENTS & ACCESSORIES • TECHNICAL DATA



- Design Features
- Setup & Operation
- Components & Accessories
- Technical Data



CLIMAX[®]
Portable Machine Tools, Inc.

Bringing the solution to you.

Easy OD-mount flange facer repairs flanges 2 to 12 inches in diameter.

The Model FF1000 Portable Flange Facer comes complete with all the components you need to get started. It consists of a mounting bell, a power module, and a flange facing module. A 115V power vertical feed module is offered as an option. Individual components and accessories are available for replacement or when required for some applications. See the Components page for the package that's right for you. The Climax FF1000 Flange Facer:

- Sets up and operates easily
- Cuts O-ring grooves
- Uses standard 3/8-inch, square tool bits
- Includes 1.22 hp (.91 kW) pneumatic motor

Two mounting bell sizes:

- **8" module** mounts on flanges 4"-8" (101.6-203.2 mm) diameter
- **12" module** mounts on flanges 8"-12" (203.2-304.8 mm) diameter

Two power modules:

- Use with either mounting bell.
- Variable radial feed rate.
- Manual depth adjustment/longitudinal feed.
- **100 rpm** with a 15:1 gear reduction, 1-inch stroke, 105 ft·lb (142.7 N·m) of torque
- **200 rpm** with a 7.5:1 gear reduction, 1-inch stroke, 52.5 ft·lb (71.4 N·m) of torque

Optional power feed module:

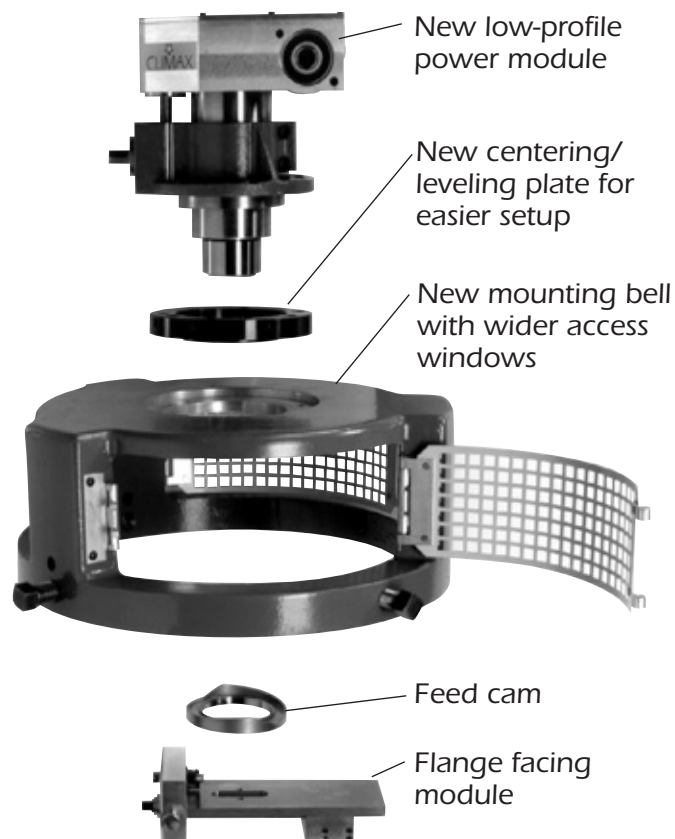
Some applications require a remotely operated power axial feed. This 115V unit attaches to the power module. Axial feed rates are available from .04"-1.60"/minute (1.0 -40.6 mm/min.).

Two facing heads:

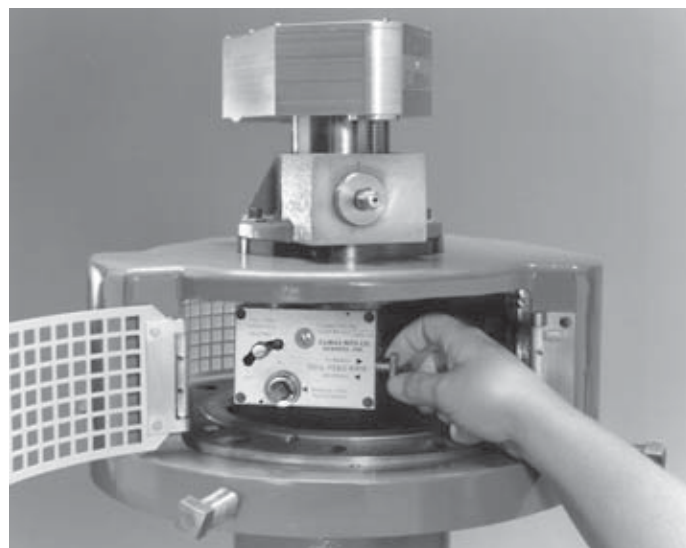
- **8" module** faces 0-8" (0-203.2 mm) diameter
- **12" module** faces 0-12" (0-304.8 mm) diameter

Optional small flange adapter plate:

Attaches to the bottom of the 8" (203.2 mm) diameter mounting bell to allow re-facing flanges from 2"-4" (50-101 mm) in diameter. Unit comes complete with setup fingers to accommodate smaller diameter flanges.



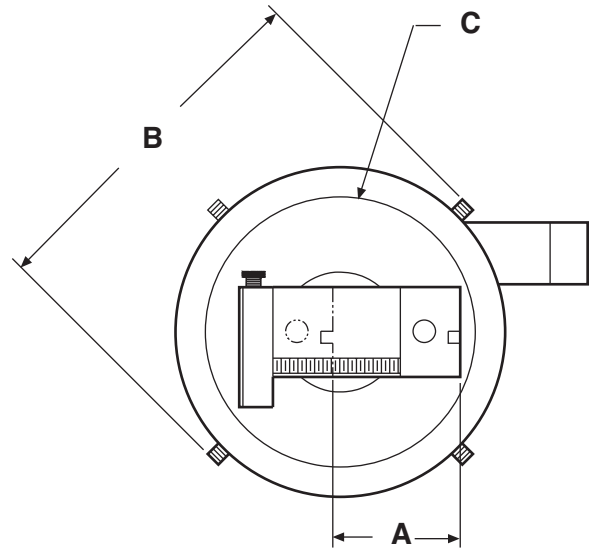
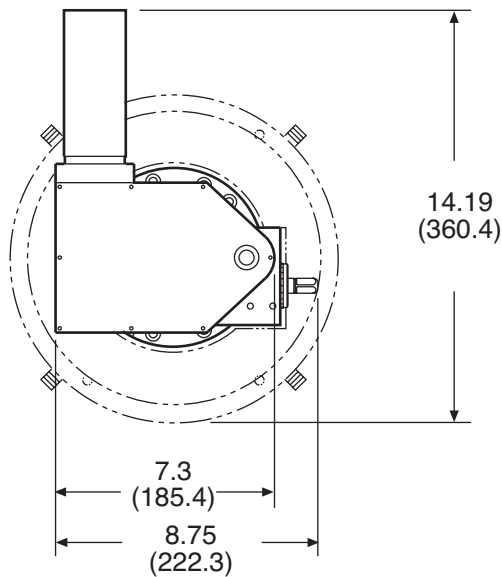
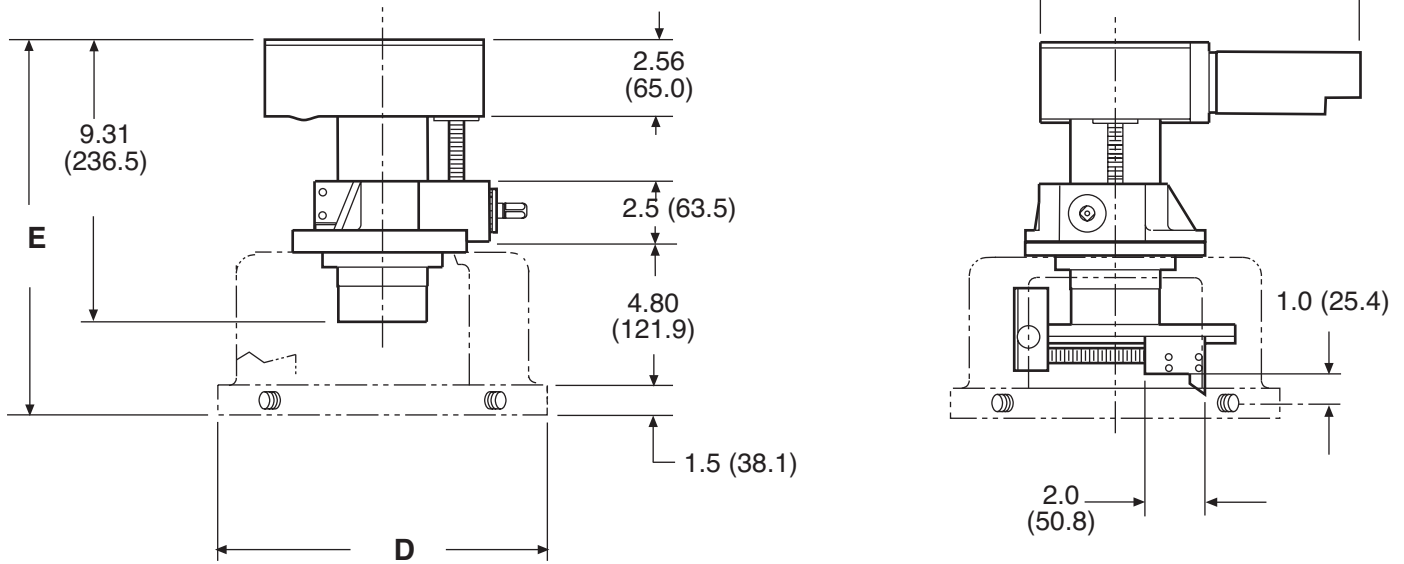
An experienced operator can set up the Model FF1000 Portable Flange Facer in less than half an hour. Once you are familiar with the machine, you could be able to re-face 2 to 3 standard flanges per hour (depending on the size and type of flanges, access and general working conditions).



The new, wider access windows make adjustments to the facing head gearbox easier than ever.

FF1000 Dimensions

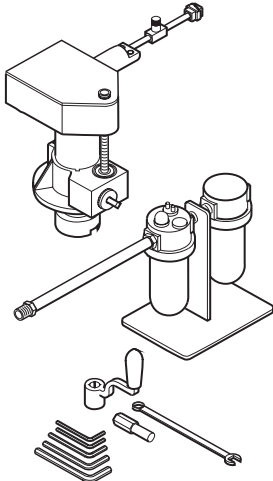
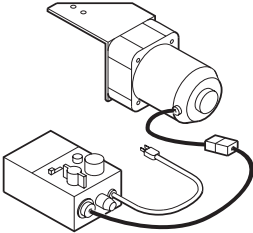
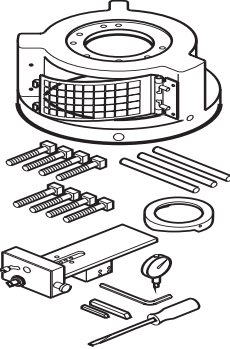
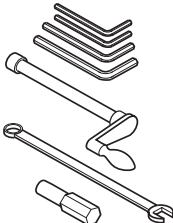
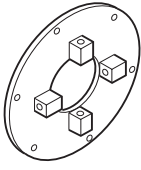
Specifications in inches (mm)
 Specifications are subject to change without notice. Consult a factory representative for precision dimensions.



	A	B		C	D	E	
		min	max			min	max
30717 200 rpm power module	---	---	---	---	---	11.86 (301.2)	13.31 (338.1)
31679 100 rpm power module	---	---	---	---	---	11.86 (301.2)	13.31 (338.1)
30719 8" mounting bell	4.1 (104.1)	12.0 (304.8)	14.25 (361.9)	9.0 (228.6)	11.75 (298.5)	---	---
30990 12" mounting bell	6.1 (154.9)	16.0 (406.4)	18.0 (457.2)	13.0 (330.2)	15.75 (400.0)	---	---

Shipping dimensions:
 19.75 x 30.5 x 22.5

Machine net weight: 74 (33.6 kg)
 (Typical machine including power module 30717 and 8" flange facing module 30718.)

NO. DESCRIPTION	NO. DESCRIPTION
 <p>35178 FF1000 flange facer 8" bell, 100 rpm includes spindle, quill, alignment plate, quill clamp, drive gear box, 1.22 hp (.91 kW) air motor, air conditioning unit, 8" OD mounting bell (p/n 30718, also sold separately below) with setup hardware, facing head assembly, dial indicator, 3/8" HSS tool bits, tool kit, and wooden storage crate. Air motor requires: 90 psi (620 kPa) at 30 ft³/min (.85 m³/min) at maximum power. Vertical feed is manual. Spindle free speed 96 rpm max. Spindle provides 42.5 rpm and 105 ft.-lb (142.7 N•m) torque at rated hp. 1" travel.</p> <p>35179 FF1000 flange facer 12" bell, 100 rpm Same as p/n 35178 above with 12" bell (p/n 30996, also sold separately below).</p> <p>35180 FF1000 flange facer 8" bell, 200 rpm Same p/n 35178 above except spindle free speed is 192 rpm max. Spindle provides 98.4 rpm and 52.5 ft.-lb (71.4 N•m) torque at rated hp. 1" travel.</p> <p>35181 FF1000 flange facer 12" bell, 200 rpm Same as p/n 35180 above with 12" bell.</p>	<p>30996 FF1000 flange facing module, 12" (304.8 mm) dia. Mounts onto flanges 8" to 12" (203.2 to 304.8 mm) in diameter. Faces 0 to 12" (0 to 304.8 mm) diameters. Radial feed is manual or automatic. Radial feed speed is variable, up to .035"/rev. (.89 mm/rev.) Net wt. 29 lb (13.2 kg).</p> <p>Replacement tool bits One of each tool listed below is included with each flange facing module.</p> <p>31863 Tool bit, roughing 3/8" sq. x 1.3" long</p> <p>31854 Tool bit, finishing 3/8" sq. x 1.3" long</p>  <p>11863 Power feed module Module mounts securely to the quill support shaft to automatically feed the machine axially. Feed rate is adjustable from .04" to 1.6" (1.0 to 40.6 mm) per minute. Values are theoretical and may vary in actual use.</p>
 <p>FF1000 Flange facing module includes OD mounting bell with setup hardware, facing head assembly, 1/4" and 3/8" HSS tool bits.</p> <p>30718 FF1000 flange facing module, 8" (203.2 mm) diameter. Mounts onto flanges 4" to 8" (101.6 to 203.4 mm) in diameter. Faces 0 to 8" (0 to 203.2 mm) diameters. Radial feed is manual or automatic. Radial feed speed is variable, up to .035"/rev. (.89 mm/rev.) Net wt. 23 lb (10.5 kg).</p>  <p>10993 Tool kit Complete set of tools for the FF1000 Flange Facer. Tool kit is included with complete machine packages.</p>  <p>10991 Small flange adapter plate Attaches to bottom of 8" (203.2 mm) dia. mounting bell. Allows attachment of mounting bell to 2" to 4" (50 to 101 mm) dia. flanges. Net wt. 11 lb (5.0 kg).</p>	

Please note: drawings may not represent actual product.

F1-.5M1004

Corporate Headquarters

Climax Portable Machine Tools, Inc.
2712 E. Second Street, P.O. Box 1210
Newberg, Oregon 97132 USA
Worldwide Telephone: 503.538.2185
USA Toll-Free: 800.333.8311
Fax: 503.538.7600
Email: info@cpmt.com

European Headquarters

Climax GmbH
Willi - Bleicher - Strasse 11
52353 Düren, Germany
Telephone: (+49) (0) 2421.9177.0
Fax: (+49) (0) 2421.9177.29
Email: info.de@cpmt.com

Houston Sales Office

Climax Portable Machine Tools, Inc.
16823 Highway 35
Pearland, TX 77581 USA
Telephone: 281.469.0429



CLIMAX[®]
Portable Machine Tools, Inc.

www.cpmt.com