

FF4000 PORTABLE FLANGE FACER

FEATURES ■ SETUP & OPERATION
COMPONENTS & ACCESSORIES ■ TECHNICAL DATA

Compact, lightweight, and easy to set up.

Compact and Versatile

- Low profile machine is one of the most compact on the market today.
- Lightweight, weighing only 58 lbs (26.3 kg).
- Modular design and versatile setup allows the chuck and main body to be set up separately before placement in the bore.
- Machine raised and flat flanges.
- Bi-directional feed.
- Feed is reversible and infinitely variable for a surface finish of 63 – 500 RMS.
- Optional beveling head connects with “Quick-Lock” system, making changeover quick & easy.

Powerful, Quality Components

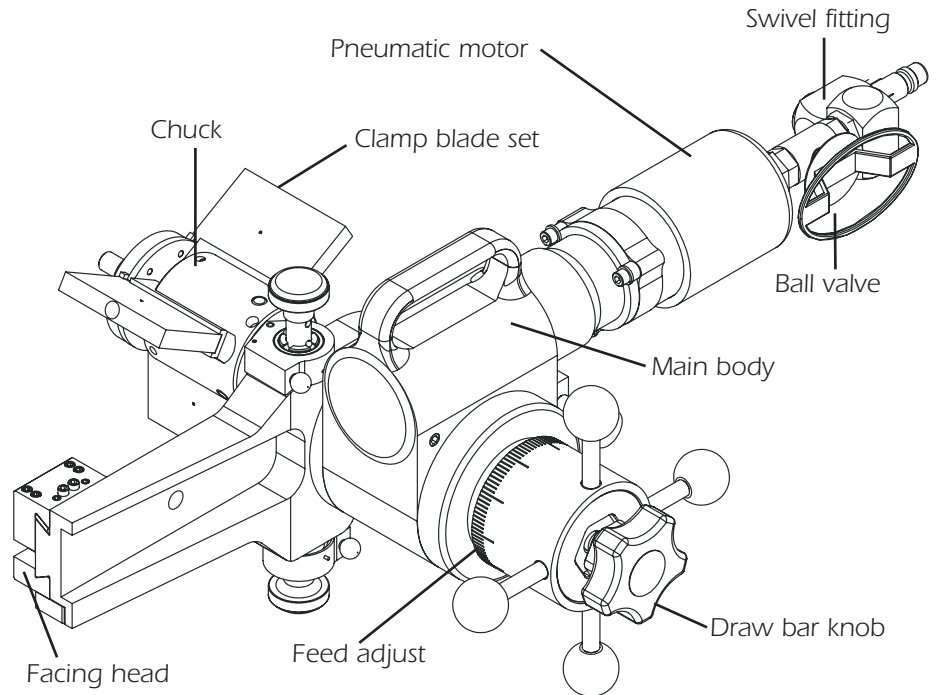
- 1.45Hp (1.08kW) motor allows typical material removal rate of 1 cubic inch (16.4 cm³) per minute.
- Pneumatic motor comes complete with filter, lubricator, and flow control.
- Features rugged main body, heavy-duty bearings, sealed lubrication, and rigid mounting system.

Cost Effective

Cuts costs in four ways:

- Reduces downtime.
- Eliminates off-site machining costs.
- Eliminates leak sealing procedures.
- Reduces stock of replacement flanges.

Recoup the cost of a Climax Flange Facer in the first few flange facing jobs.



Specifications

	US	Metric
Flange Facing Diameter	3.0 - 19.0 inches	76.2 - 482.6 mm
Beveling Diameter (w/ optional beveling head)	3.0 - 12.75 inches	76.2 - 323.9 mm
Pipe Facing Diameter (w/ optional beveling head)	3.0 - 12.75 inches	76.2 - 177.8 mm
ID Mounting Diameter	3.5 - 12.5 inches	88.9 - 317.5 mm
Feed rate (reversible, variable)	0 to 0.025 inches/rev.	0 to 0.635 mm/rev.
Power, Pneumatic	1.45 Hp	1.08 kW
Power Requirement	4 cfm, 90 psi	1.35 m ³ /m, 629 kPa
Operating Weight w/ 19 inch (482.6 mm) facing head	66 lbs	29.9 kg
Operating weight w/ 12 inch (304.8 mm) beveling head	60 lbs	27.2 kg
Shipping Weight	250 lbs	113.4 kg
Shipping Dimensions (2 containers)	33 x 21 x 11 inches	838.2 x 533.4 x 279.4 mm

Tool Configurations

Flange Facing Package includes:

- Basic machine with 1.45 Hp (1.08 kW) pneumatic motor with air conditioning unit
- Three jaw chuck and jaws
- Facing head 19 inches (482.6 mm)
- Two facing bits
- Tool kit with instruction manual
- Unit comes packed in durable molded containers

To order this unit, refer to FF4000.1.00.000.11.20

Pipe Beveling Package includes:

- Basic machine with 1.45 Hp (1.08 kW) pneumatic motor with air conditioning unit
- Three jaw chuck and jaws
- Beveling head 12 inches (304.8 mm)
- Two beveling bits
- Tool kit with instruction manual
- Unit comes packed in durable molded containers

To order this unit, refer to FF4000.1.00.000.11.02

Facing & Beveling Package includes:

- Basic machine with 1.45 Hp (1.08 kW) pneumatic motor with air conditioning unit
- Three jaw chuck and jaws
- Facing head 19 inches (482.6 mm)
- Beveling head 12 inches (304.8 mm)
- Two facing bits
- Two beveling bits
- Tool kit with instruction manual
- Unit comes packed in durable molded containers

To order this unit, refer to FF4000.1.00.000.11.22

Optional Facing/Beveling Bits:

- 33141 facing bit
- 33136 beveling bit 37.5 degrees
- 31867 roughing tool bit
- 31858 finishing tool bit
- 33315 5 degree chamfer tool bit

Small Facing & Beveling Package includes:

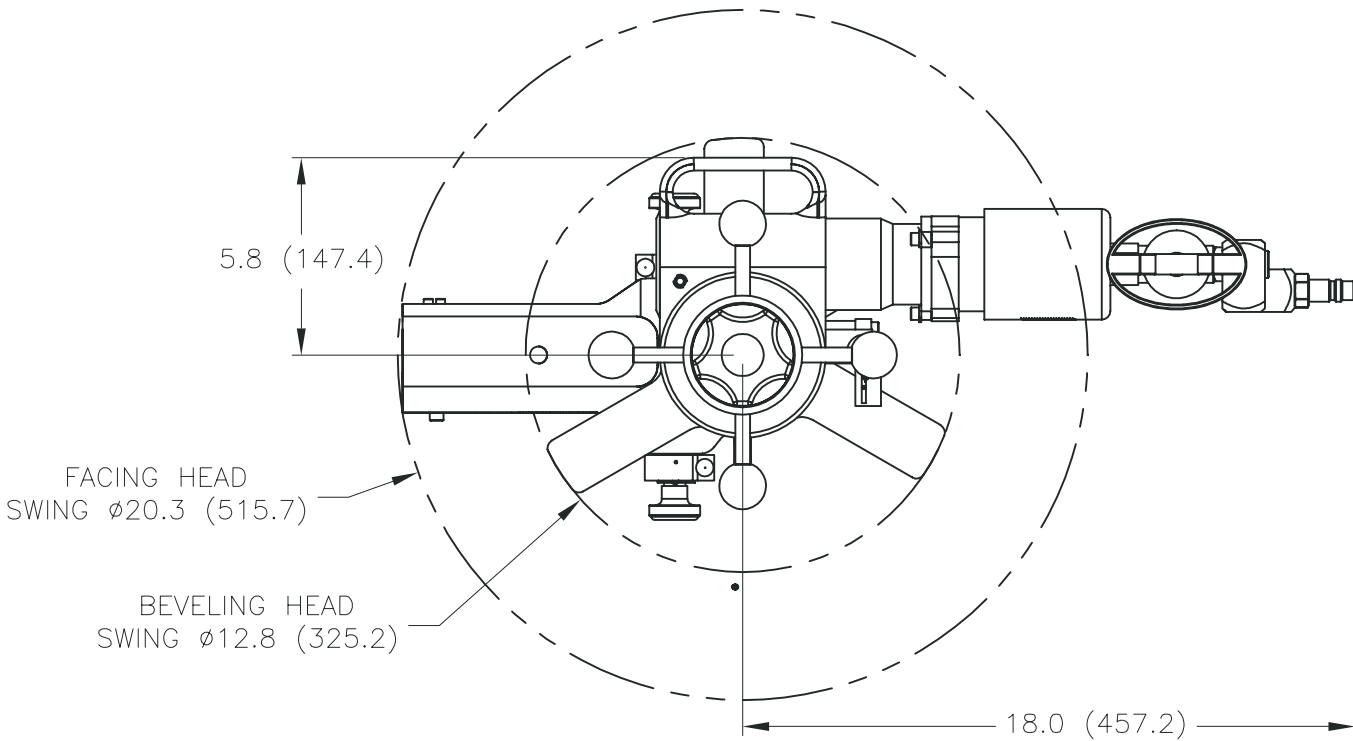
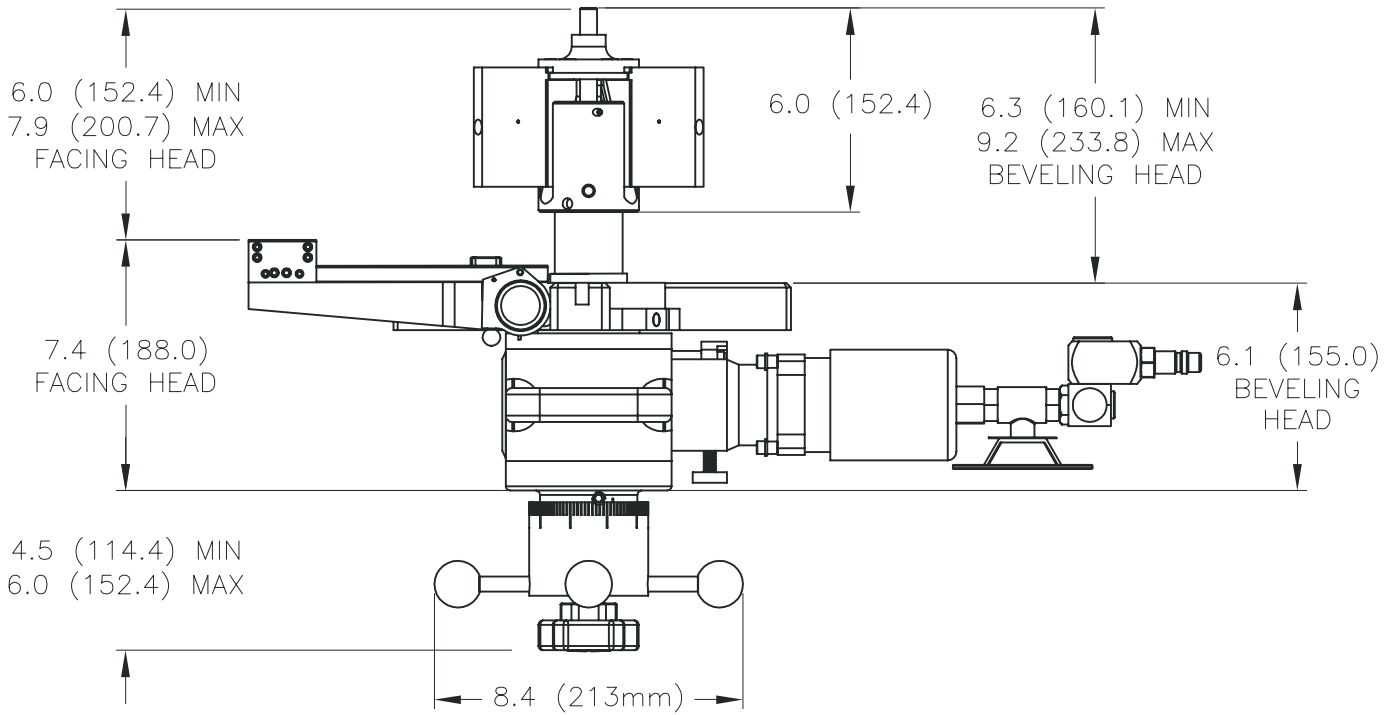
- Basic machine with 1.45 Hp (1.08 kW) pneumatic motor with air conditioning unit
- Three jaw chuck & jaws
- Facing head 12 inches (304.8 mm)
- Beveling head 7 inches (177.8 mm)
- Two facing bits
- Two beveling bits
- Tool kit with instruction manual
- Unit comes packed in durable molded containers

To order this unit, refer to FF4000.1.00.000.11.11

Facing and Beveling Heads:

- 34980 beveling head 7 inches (152.4 mm)
- 35439 beveling head 12 inches (304.8mm)
- 35222 facing head, 3 - 12 inch (76.2 - 304.8 mm) diameter
- 34936 facing head, 3 - 19 inch (76.2 - 482.6 mm) diameter

Dimensions in inch (mm)



Note: Both the Facing and Beveling heads shown for dimensional reference only. They can not be mounted simultaneously.

Setup and Operation

Setup of the FF4000 is quick and easy. The modular design and versatile setup options allows the chuck and main body to be set up separately. An experienced operator can set up the machine in 10 minutes or less.

- 1** Choose from facing or beveling heads. Place tool bit in tool slot and tighten set screw.



- 2** Align the 3 pin "Quick-Lock" system and tap with plastic mallet to seat.



- 3** Select jaw set according to the ID diameter that the machine will chuck into.



- 4** Place the machine in the bore. Hold to good start height, and tighten hand nut to snug. Push down on hand nut. While holding nut down, turn rod handle to tighten chuck.



- 5** Set tool to desired cutting depth, and begin machining.



Training at the Portable Machining Training Institute

Climax has been teaching the fundamentals and fine points of portable machine tool operation for practically as long as we've been inventing and building the tools.

At the Portable Machining Training Institute situated in our corporate headquarters near Portland, Oregon, we provide training for machine tool operators on portable machine tool safety, and machine setup and operation. Trainees also receive technical tips and tools to improve operational efficiencies. With the vast majority of every program devoted to hands-on activities and skill development. The Climax instructional team includes specialists in shipbuilding, power generation, civil engineering, bridge re-building, and other industries.



Whether it's a regularly scheduled course at the Portable Machining Training Institute, or a custom curriculum conducted at your facility, your machinists will benefit from courses developed by some of the most respected authorities in the business.



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Climax has been solving complicated on-site machining problems for our customers since 1964.

On-site Training

Need some refresher courses in setting up and operating your Climax machine tool?

Call us. We'll bring the solution to you.

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