

Flange Facing AX48120

Technical documentation

AX48120

A modular portable machine for flange facing, grooving and weld preparation. The Silk AX48120 is designed to machine full faced, raised face and grooved flanges having a minimum bore of "48 (1219) and a maximum outside diameter of 120" (3048).

The Silk AX48120 Flange Facer is constructed from the highest quality materials. It is designed to give machine shop accuracy combined with portability and ease of handling for on-site machining of flanges form 48" to 120" (1.219mm to 3.048mm). The machine consists of four main modules:

The Mounting Base is an eight-ram radial clamping chuck. Adjustable clamping jaws on four of the rams are adjusted by integral rack and pinion arrangement, operating in similar fashion to a conventional four-jaw chuck. Sectional bolt lengths bolt together for the appropriate I.D. mounting arrangement.

The Turntable provides a rigid support for the slide arm and incorporates two pneumatic motors and right angle feed gearbox. It bolts directly onto the base after the base module has been levelled and radially positioned. Using the two pneumatic motor enables the torque to be evened out and also acts as a backlash eliminator. Air input to the motor units comes via the centre hub manifold.

The Cutting Arm mounted to the turntable, provides a rigid structure to which the tool post is secured. Feed in and out is provided by a leadscrew, driven by the gearbox pick-up gear. Feed is selected at the gearbox. The cutting arm assembly permits cuts to a maximum depth of 0.079" (2mm) without flange holes, and 0.02" (0.5mm) with flange holes. A variety of tools can be fitted to the tool post according to the finish and cut required.

The Drive Gearbox is mounted to the turntable and provides a variety of cutting feeds for different machining applications. Drive input to the gearbox is derived from the hub transfer gear. Four feed rates can be selected by means of a push/pull selector with three positions, traverse IN, traverse OUT and neutral (N).

Optional Accessories:

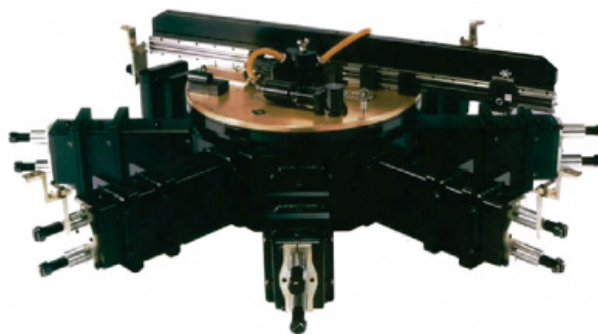
- Tube Sheet Mounting Kit
- Tube Sheet Back Facing Kit
- O.D. Mounting Kit
- Orbital Mounting Kit
- Hydraulic Conversion Kit

Quality

All TEAM Engineering activities are conducted in strict conformance to the ISO9001 quality system.

Silk Design Department

All Silk machines are used by our on-site service technicians and over the years, we have modified and designed attachments to enable the Silk range of machine tools to undertake many specialist applications. Can we help you? Comprehensive CAD facilities operated by qualified design engineers and experienced project engineers are able to meet your exact requirements.



Integrated Solutions to Piping Problems | www.patriot-int.com

The Netherlands

Dordrecht

T: +31 (0) 78 652 41 11

E: info@patriot-int.com

United Kingdom

Aberdeen

T: +44 (0) 1224 724726

E: info@patriot-int.com

Belgium

Antwerp

T: +32 (0)36 00 17 07

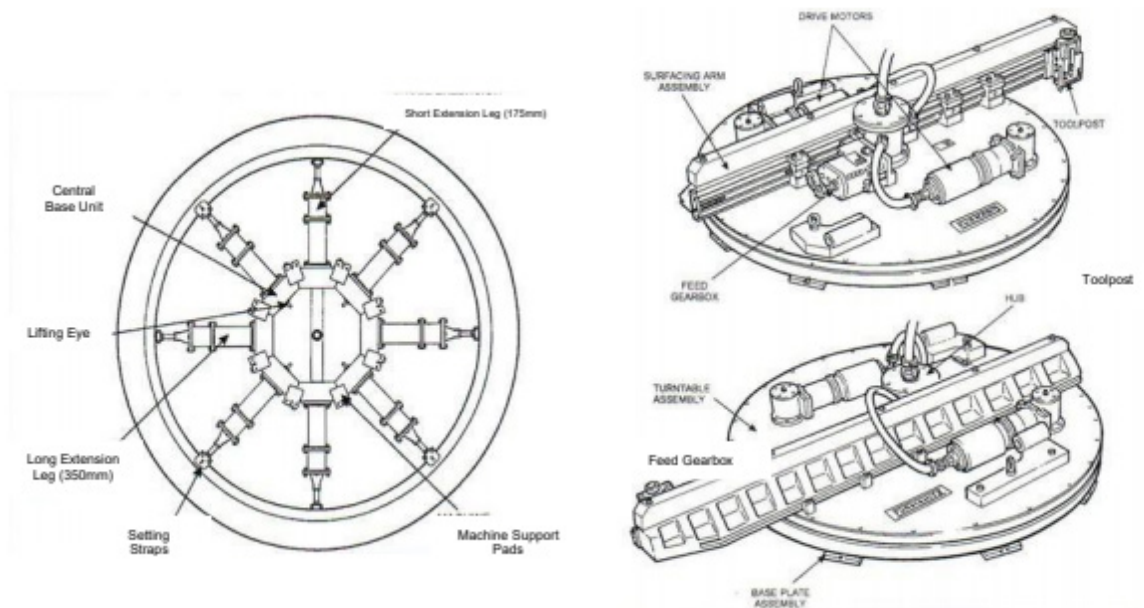
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Weight of turntable (case 1)	2.800lbs. (681kg)
Weight of base (case 2)	1261lbs. (525kg)
Total shipping weight	4.180lbs. (1.445kg)
Case dimensions (1)	96" x 24" x 51"
	2.438 x 610 x 1.295mm
Case dimensions (2)	51" x 13" x 51"
	1.295 x 330 x 1.295mm
Flange range	125" (3.429mm) Max O.D.
	48" (1.219mm) Min bore
	120" (3.048mm) Max bore
Power output	(2) - 3.5hp (2.6kw) motors
Air supply requirements	90PSI @ 140CFM

Features

- Modular construction
- I.D. & O.D. mounting
- Operates in any position
- Cuts all flange types
- Multiple surface finishes
- Pneumatic or Hydraulic drives



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