



# SITU PORTABLE MACHINES

Performance through engineering innovation

## FF842i

Internal Mount Flange Facing Machine

8 - 42" (203 - 1067mm)

### KEY FEATURES

- Heavy duty precision construction
- High torque planetary gear drive
- 3 continuous groove bi-directional facing feeds for a gramophone finish (ASME Standard).
- Auto boring feeds
- Heavy duty adjustable base clamping bolts and extensions for quick set site operation
- Large section hardened slide ways to maintain long term accuracy
- 360 degree swivel tool post for groove details

### DESCRIPTION

An internally mounted flange facing machine capable of producing a continuous groove gramophone finish to ASME Standard along with the capability to auto feed groove details

### SPECIFICATION

Min Facing Diameter	8" (203mm)
Max Facing Diameter	42" (1067mm)
Min standard Clamping Diameter	7.8" (198mm)
Min clamping (optional base)	6" (152mm)
Max Clamping Diameter	34" (864mm)
Min Swing Diameter	33" (838mm)
Tool Post Travel	4" (102mm)
Rpm (max)	30
Standard drive type	Air
Number of feed settings	3 bi-directional
Output	1.6kw (2.1 hp)
Air supply needed @ 90psi	1.9m <sup>3</sup> /min 67cfm

### MACHINE WEIGHT

Weight (inc. base)	115kg	253lbs
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### SHIPPING WEIGHTS

Box 1 Weight	218kg	479lbs
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### SHIPPING DIMENSIONS

	Length	Width	Height
Box 1	34" (87cm)	22" (56cm)	28" (71cm)

### FACING FEED RATES & GROOVES PER INCH

Direction	Gear	mm/rev	Inches/rev	Grooves/inch
FACING In / Out	1	0.32	0.005	76
	2	0.51	0.009	49
	3	0.68	0.021	37
BORING Up / Down	1	0.08	0.006	317
	2	0.12	0.010	211
	3	0.16	0.025	158

### INCLUDED AS STANDARD WITH MACHINE

The machine is supplied complete with the following items;

- ✓ All clamping bases, mounting feet and extensions
- ✓ Toolkit including tools and inserts
- ✓ Air filter lubricator
- ✓ Hose connection
- ✓ Storage / shipping box
- ✓ Packing list and manual

OPTIONAL – 6" mounting base