Flange Facer

3. 法兰铣刀盘

TECHNICAL SPECIFICATION

Silk SX 2872 Flange Facer

With more than 15 years' experience, Stork ensures reliable and safe operations through our integrated bolting, on-site and in-shop machining and leak repair packages, coupled with the required expertise and specialist machinery.

The Silk SX 2812 Flange Facer is a lightweight portable, flange facing, grooving and weld preparation machine designed to machine full faced, raised face and grooved flanges from 711mm - 1829mm (28"- 72").

Optional: Extra reach tool post

The Silk SX 2812 is constructed from the highest quantity materials. It is designed to give the machine shop accuracy, combined with ease of handling and portability in the flange range of 711mm (28") to 1829mm (72"). Spur gears engage directly on the drive ring, keeping power requirements and losses to a minimum and allowing maximum torque at the cutting tool. When the machine is used in the vertical plane, balancing is greatly reduced.

Features

- Compact
- Bore mounted
- Operates in any position
- Cuts 'O' ring grooves, vertical grooves, 'V' grooves, lens ring seats and weld preparations
- Achieves finishes from 63 CLA to 250 CLA 'gramophone' finish when turning and 32 CLA to 63 CLA when polishing
- Pneumatic drive permits use in hazardous areas
- Fitted transportable case.

Mounting Base

The mounting base assembly enables the machine to be installed in the center of any flange from 711mm (28") to 1829mm (72") in diameter. It consists of a cruciform body provided with four adjustable clamping jaw assemblies. The mounting base is installed and aligned prior to the turntable installation.

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Turntable Assembly

This provides a ridged support for the air motors, gearbox and surfacing arm assembly. The upper part of the assembly allows rotational movement for surfacing, while the lower part remains stationary, held in position by the mounting base assembly.

Drive Arrangement

The machine is driven by two pneumatic motor units, mounted directly into the ring gear, which is mounted on the main bearing. The use of two motors enables the overall machine height to be reduced, evens out the torque and also acts as a backlash eliminator and cushion drive.

Feed Gearbox

The drive gear box is mounted onto the turntable assembly providing a variety of cutting feeds for different applications.

Drive input to the gearbox is derived from the mast transfer gear. The gearbox provides four different feed rates selected by a push/pull selector, which gives traverse IN, traverse OUT and neutral. The neutral N position is used for manually positioning the toolpost.

Cutting Arm Assembly

This is mounted on the turntable assembly and provides a ridged structure to which the toolpost is fixed. Feed in and out is provided by a lead screw, driven by the gearbox output gear. Feed rate is selected at the gearbox material tooling and with conditions permitting, the cutting arm assembly can achieve cuts to a maximum depth of 2mm (0.079") without flange holes and 0.5mm (.02") with flange holes.

Alternative tools can be fitted to the post depending on the finish and cut required.

Technical specifications

Principle Dimensions	
Machine Height	434mm
Mounting base thickness	167mm
Minimum mounting base diameter	660mm
Toolpost travel standard	1300mm
Toolpost travel option	40mm
Toolpost reach optional	100mm
	130mm
Weights	
Machine Weight (less case)	214kg
Base weight (minimum diameter)	87kg
Net weight (less wooden case)	486kg
Total shipping weight	552kg
Transportable Wooden Case Dimensions	
Length	1400mm
Height	650mm
Weight	840mm
General Information	
Power output	3Kw
Gripping range:	
Minimum recommended bore	711mm
Maximum recommended bore	1727mm
Facing range:	
Minimum diameter	711mm
Maximum recommended diameter	1829mm
Depth of flange required to set the base using standard part	259mm
Final rotational speed	20rpm
Drive motors (2 off)	1.5kw
Recommended air supply requirements	6 bar 2.69m
Drive motor output speed	265rpm

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