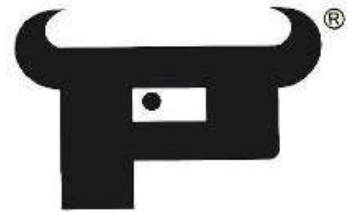


Porta-Tools™



Series II Flange Facer

Mounting Diameters:
4.750" - 24.500"

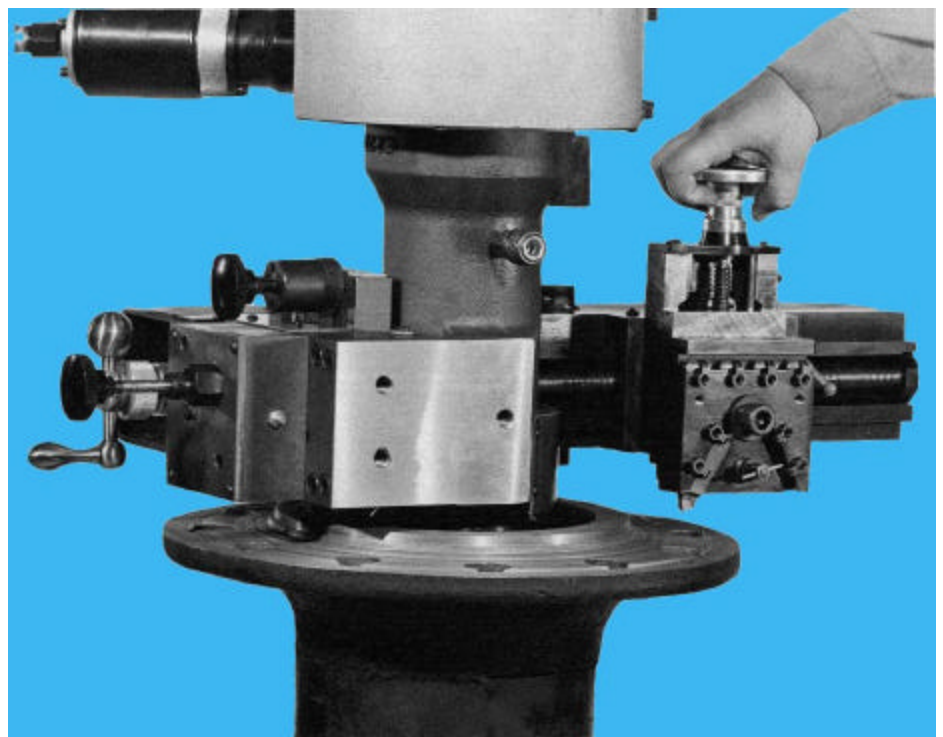
Cutting Diameters:
4.750" - 34.000"

Expandable to 66.000" with Series III and Series IV Options

The Porta-Tools Series II Flange Facer takes machine-shop precision to the field for use on in-line equipment. When down time is critical, or when removal of a flange is impractical, or would require re-normalization of a vessel, this fully transportable machine can save you days or even weeks.

Compact and completely portable, the Flange Facer may ordinarily be set up by one person. It may be mounted on a flange in any orientation, including overhead, and can reface any flange to meet any surface requirement. The tool is strong, rugged, and stable; giving dependable, repeatable accuracy.

Because there is no removal of the flange, there is no transportation lag to and from the shop; and thus, there is no scheduling delay. System integrity is maintained and potentially costly heat treatment eliminated. The easy to operate Porta-Tools Flange Facer provides fast, dependable, precision performance with minimum operator training time.



Learn how this tool is able to operate with such ease and precision; then consider adding the Porta-Tools Flange Facer to your work force.

NON-SLIP POSITIONING

Exclusive 3-point jaw set provides fast, positive, non-slip positioning of the center support mast. The jaw housing and mast assembly are positioned inside the flange and tightened with the

Positive pressure, non-marring clamping units require only two inches depth of clamping surface. Accepted for and used in nuclear applications, these clamping units, when properly set, eliminate tool slippage and resultant scoring of the pipe I.D.

Complete set-up and accurate calibration to no more than .005 inches in any flange positions can be attained.

Using a dial indicator attached to the calibration bar, the operator can measure perpendicularity and concentricity to any referenced surface on the flange body

The mast also may be angled to permit matching of refaced surfaces to correct for angular defects such as those created by field welding stresses.

FAST, SIMPLE ASSEMBLY

Once the Flange-Facer is aligned, the operator slides the main housing over the mast body and attaches the power cap. The main slide assembly, which contains the tool holder, is then positioned and bolted onto the main housing.



SPARK-FREE OPERATION ON FERROUS OR NON-FERROUS METALS

Spark-free operation on any type of metal ensures maximum safety, even when used in highly explosive atmospheres. The three-point mounting provides a full cut that is not displaced by bolt holes



COMPLETE RESURFACING FEATURES IN ONE MACHINE.

The Porta-Tools Flange Facer is the one machine with all the features required for precision flange resurfacing.

A four-speed gear box provides automatic radial feed across the flange face from .007 to .032 inches per revolution, providing the operator flexibility to produce a surface finish on any material type to meet any required specifications, including phonograph needle, any mill standard finish, any configuration of lens ring and ring type joints, or tongue and grooves. Also, with the optional air grinder attachment, even a mirror finish is attainable. This high speed grinder attachment permits quick change-over from machining to grinding or lapping.

Porta-Tools

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1. Individual adjustment for centering and perpendicularity may be calibrated to .005 inch or less.
2. Four-speed gear box provides simple feed rate change from .007 to .032 inches per revolution.
3. Gear-operated feed control with in-feed, out-feed and neutral positions.
4. Variable angle cross slide including fixed stop at 23 degrees for cutting standard ring grooves.
5. Pneumatic or hydraulic drive options.
6. Flow control valve for smooth RPM speed adjustment.
7. All necessary tools are provided for calibration and setup including dial indicator with magnetic base.
8. Rapid setup and takedown by one person without support equipment.

I02-000001-002

Model	Normal Bore Diameters	Facing Diameters
Mini	0.750" - 2.285	0.750 " - 12.000"
Series I	2.285 - 8.000	2.285 - 24.000
Series II	4.750 - 24.500	4.750 - 34.000
Series III	24.000 - 40.500	24.000 - 48.000
Series IV	40.000 - 60.000	40.000 - 66.000