

FLANGE FACING

4 Models to Resurface Flanges and Bolt Patterns from 3/4" to 24" O.D.

Simple, Safe, Accurate Flange Facing

H&S Tool offers four models of reliable pipe machine tools with premium flange facing conversion accessories. Each is powered by reliable pneumatic or electric motors to accurately meet your job site or factory requirements.

The tools are portable, making them ideal for use in the field. Setup and operation is easily handled by a single worker.

Kits include everything necessary to convert your Model B, MS, MT or MFT beveling tool with illustrated instructions.

Standard wedge plates can be used for internal locking or precision elbow mandrels are available. Centering and squaring devices make accurate machining of gasket surfaces and/or bolt patterns simple and safe.

Rental or purchase, the rugged design and quality construction makes H&S the tool of choice for all types of tube and pipe machining, cutting and expanding tools plus flange facing.

Model BF

Working range: 3/4" to 8" (19.1 mm to 203.2 mm) O.D.

Model MSF

Working range: 1 1/4" to 12" (31.8 mm to 304.8 mm) O.D.

Model MTF

Working range: 3 1/4" to 16" (82.6 to 406 mm) O.D.

Model MFTF

Working range: 4 1/4" to 24" (108.0 to 609.6 mm) O.D.



Single Person Setup And Operation

Field Conversion Between Beveling Machine And Flange Facer Is Quick And Easy

Adjust Between A Wide Range Of Face Surfaces

Internal Locking With Standard Wedge Plates Or Elbow Mandrel For Maximum Accuracy

Mandrel Mounts In Short Radius Elbows — MSF In 1/2" (12.7 mm), MTF In 1" (25.4 mm), MFTF In 1 1/4" (31.8 mm) Minimum Depth



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Flange Facing Tools and Accessories

	Model BF	Model MSF	Model MTF	Model MFTF
Working Range*	3/4" I.D. to 8" O.D. (19.1 to 203.2 mm)	1 1/4" I.D. to 12" O.D. (31.8 to 304.8 mm)	3 1/4" I.D. to 16" O.D. (82.6 to 406.4 mm)	4 1/4" I.D. to 24" O.D. (108.0 to 609.6 mm)
Surface Finish Approx. Finish/Pin	63 to 250 RMS 1 = 63 RMS, 2 = 125 RMS 4 = 250 RMS	63 to 500 RMS 1 = 63 RMS, 3 = 125 RMS, 6 = 500 RMS		
Tool Feed Rate	.005" (0.13 mm) per pin. Pins must be engaged at opposing positions for even resurfacing.			
Max. Tool Travel*	1 1/2" (38.1 mm)	2" (50.8 mm)	3" (76.2 mm)	3" (76.2 mm)
Axial Feed Rate Per Full Turn Adjustments	.062" (1.6 mm)	.062" (1.6 mm)	.083" (2.1 mm)	.083" (2.1 mm)
1/4 turn	.015" (0.38mm)	.015" (0.38 mm)	.021" (0.53 mm)	.021" (0.53 mm)
1/2 turn	.031" (0.79 mm)	.031" (0.79 mm)	.042" (1.1 mm)	.042" (1.1 mm)
3/4 turn	.046" (1.2 mm)	.046" (1.2 mm)	.063" (1.6 mm)	.063" (1.6 mm)
Internal Locking/ Locating	Collet Internal Locking	Precision elbow mandrels with "Z" axis adjustment.		
Alignment	Centering/squaring machined aluminum plate, spoked adapter and dial indicator attachment for use with elbow mandrels.			
Minimum Mounting Depth	3/4" (191. mm)	1/2" (12.7 mm)	1" (25.4 mm)	1 1/4" (31.8 mm)
Tooling	Single point replaceable carbide insert in steel tool holder, two machining points per insert.			
Weight Power Unit Mandrel	19 lbs. (8.6 kgs.) N/A	27 lbs. (12.2 kgs.) 4 lbs. (1.8 kgs.)	55 lbs. (24.9 kgs.) 10 lbs. (4.5 kgs.)	70 lbs. (31.8 kgs.) 13 lbs. (5.9 kgs.)
Dimensions Mandrel Length Radial Clearance*	12 1/2" (317.5 mm) 4" (101.6 mm)*	14" (355.6 mm) 6" (152.4 mm)	15" (381.0 mm) 9" (228.6 mm)	18" (457.2 mm) 11" (279.4 mm)
Motor, Pneumatic Air Volume Pressure Speed, Adjustable	.9 HP (0.66 kW) 38 CFM (1.1 M ³ /Min.) 90 psi (6.1 bar) 90 RPM, Max.	1-5/8 HP (1.2 kW) 38 CFM (1.1 M ³ /Min.) 90 psi (6.1 bar) 50 RPM, Max.	3 HP (2.2 kW) 65 CFM (1.9 M ³ /Min.) 90 psi (6.1 bar) 22 RPM, Max.	3 HP (2.2 kW) 65 CFM (1.9 M ³ /Min.) 90 psi (6.1 bar) 18 RPM, Max

*Model BF has a tight clearance option available. This option reduces the maximum working reach to 5 1/2" (139.7 mm). Tool travel is limited to 1" (25.4 mm). Radial clearance is reduced to 2 3/4" (69.9 mm).

Model MSF Elbow Mandrel

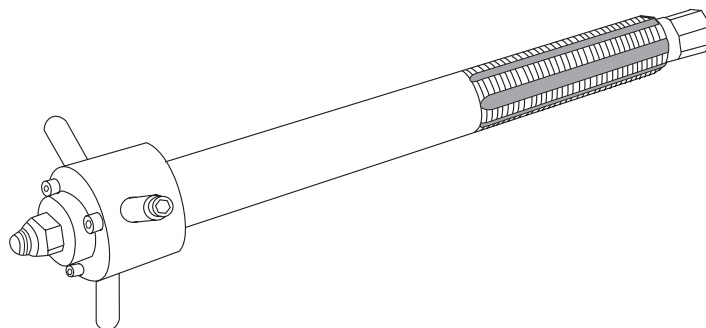
Size	Pin Length	I.D. Range		Size	Pin Length	I.D. Range	
		Inches	MM			Inches	MM
A	0.594	13/4 – 2	44.5 – 50.8	G	1.344	31/4 – 31/2	82.6 – 88.9
B	0.719	2 – 21/4	50.8 – 57.2	H	1.469	31/2 – 33/4	88.9 – 95.3
C	0.844	21/4 – 21/2	57.2 – 63.5	I	1.594	33/4 – 4	95.3 – 101.6
D	0.969	21/2 – 23/4	63.5 – 69.9	J	1.719	4 – 41/4	101.6 – 108.0
E	1.094	23/4 – 3	69.9 – 76.2	K	1.844	41/4 – 41/2	108.0 – 114.3
F	1.219	3 – 31/4	76.2 – 82.6				

Model MTF Elbow Mandrel

Size	Pin Length	I.D. Range		Size	Pin Length	I.D. Range	
		Inches	MM			Inches	MM
MT1	1.250	31/4 – 4	82.6 – 101.6	MT5	2.750	61/4 – 7	158.8 – 177.8
MT2	1.625	4 – 43/4	101.6 – 120.7	MT6	3.125	7 – 73/4	177.8 – 196.9
MT3	2.000	43/4 – 51/2	120.7 – 139.7	MT7	3.500	73/4 – 81/2	196.9 – 215.9
MT4	2.375	51/2 – 61/4	139.7 – 158.8				

Model MFTF Elbow Mandrel

Size	Pin Length	I.D. Range		Locator Pins For Extended Head			
		Inches	MM	Size	Pin Length	I.D. Range Inches	MM
FT1	1.750	41/4 – 5	108.0 – 127.0	FT7	2.375	83/4 – 91/2	222.3 – 241.3
FT2	2.125	5 – 53/4	127.0 – 146.1	FT8	2.750	91/2 – 101/4	241.3 – 260.4
FT3	2.500	53/4 – 61/2	146.1 – 165.1	FT9	3.125	101/4 – 11	260.4 – 279.4
FT4	2.875	61/2 – 71/4	165.1 – 184.2	FT10	3.500	11 – 113/4	279.4 – 298.5
FT5	3.250	71/4 – 8	184.2 – 203.2	FT11	3.875	113/4 – 121/2	298.5 – 317.5
FT6	3.625	8 – 83/4	203.2 – 222.3	FT12	4.250	121/2 – 131/4	317.5 – 336.6
				FT13	4.625	131/4 – 14	336.6 – 355.6
				FT14	5.000	14 – 143/4	355.6 – 374.7
				FT15	5.375	143/4 – 151/2	374.7 – 393.7



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