

## Operating Recommendations For Model BF Flange Facer

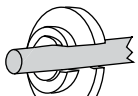


Fig. 1

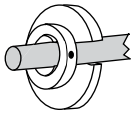


Fig. 2

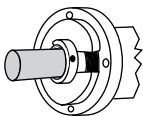
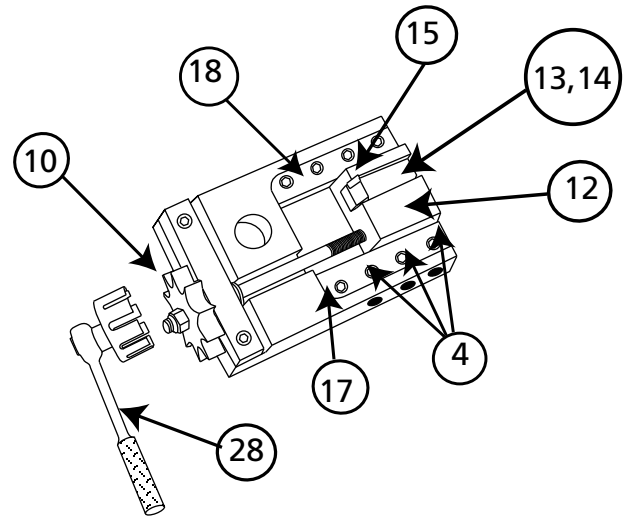
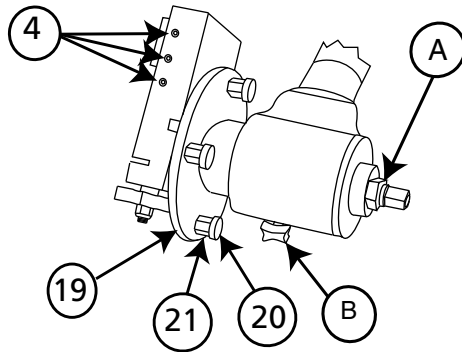


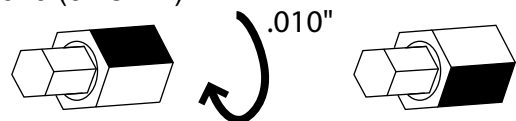
Fig. 3



1. Install the alignment gage near the end of the centershaft allowing enough travel for the collet/wedges. Slide the gage over the shaft (Fig.1). Rotate the collar 180° and lock it in place with set screw (Fig. 2).
2. Mount the model BF machine into the flange tube I.D. using the centershaft collet system or wedge system.
3. Slide the Machine into the flange. Press the gage tightly against the flange surface and tighten in place (Fig. 3).
4. Install cutting insert (15) into holder (13, 14).
5. Install the low range or high range holder (13,14), depending upon the flange size, into the tool slide (12).
6. Rotation of the flange facer body is clockwise when looking at it from the rear of the machine.
7. Ensure that all trip pins are disengaged. Set the tool slide positioning by rotating the trip wheel with the ratchet and socket provided. Allow enough distance for the tool slide to travel the required area of the flange.
8. Position the insert and holder at a place where it will contact the the area to be machined. Start the machine. Slowly feed the insert toward the flange as it rotates by turning the feed nut (A) at the rear of the machine clockwise. Stop the machine as soon as the insert contacts the surface. Retract the insert to a position outside of the surface to be machined by rotating the trip wheel counterclockwise.
9. Once the holder is in position, the trip wheel (10) backlash must be cleared and the timing set. Rotate the trip wheel one full turn clockwise to remove the backlash and position it to point directly at the trip ring (19). **NOTE: Failure to perform this procedure will damage the trip pins.**

**Note: It is important that the gibs (17, 18) are properly adjusted. Correct adjustment maintains proper timing between the trip wheel and the trip screws. The gibs are properly adjusted when the set screws (4) are tightened evenly to apply enough force to the tool slide (12) that it is difficult to turn the trip wheel by hand.**

10. Engage the correct number of trip pins (20) to achieve the required surface finish (see specifications).
11. The depth of the cut is controlled by rotating the feed nut (A) clockwise. One full turn is equal to 0.062" (1.6mm) penetration. Rotating one flat is 0.010 (0.25mm).

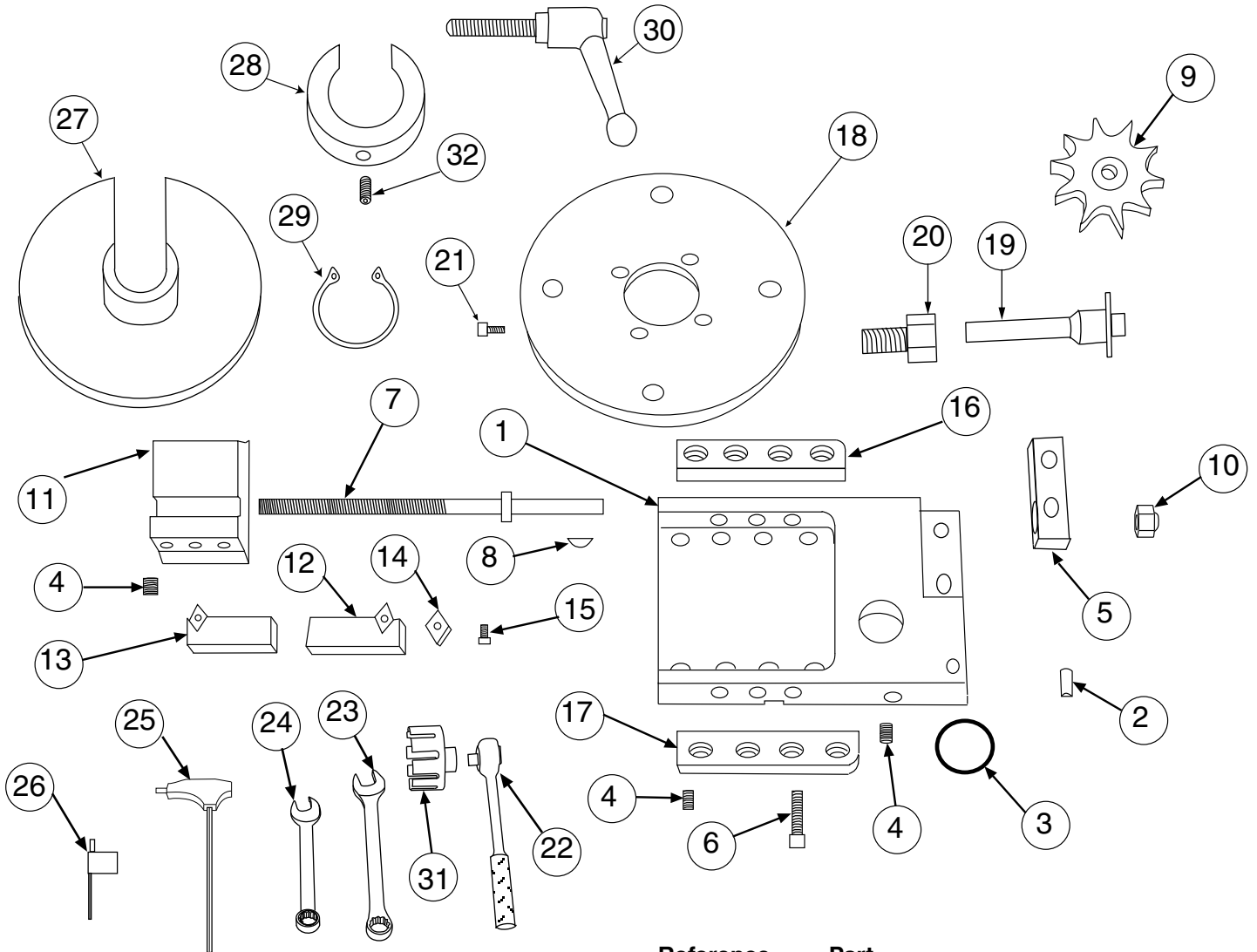


12. Once the depth is set, tighten the locking knob to prevent the machine from moving.
13. Activate the machine by operating the air motor and allow the insert to face across the raised flange area.

### Specifications

Working Range: .75" - 4.12" (19mm to 104.6mm)  
 Radial Tool Clearance: - 4" (101.6mm)  
 Tight-Clearance Version Working Range: .75" - 2.50"  
 (19mm to 63.5mm)-  
 Tight-Clearance Radial Tool Clearance: 2.75" (70mm)-  
 Radial Feed Rate: .005" (0.13mm) per pin; All 4 pins .020"  
 (.51mm) per revolution  
 Axial Feed Rate: .062" (1.6mm) Per Full Feed Nut Turn  
 Approximate Feed Depth Adjustments: 1/4 turn, .015"  
 (0.38mm); 1/2 turn, .031" (0.79mm); 3/4 turn, .046"  
 (1.2mm); One flat, .010" (.25mm)

## Parts List Model BF Flange Facer Part No. 005209



Reference No.	Part No.	Description
1	BF-005210	Body
2	BF-005211	Keystock
3	BF-005212	O-Ring
4	BF-005213	(11) Socket Head Set Screw
5	BF-005214	Feed Screw Bracket
6	BF-005215	(10) Socket Head Cap Screw
7	BF-005216	Feed Screw
8	BF-005217	Woodruff Key
9	BF-005218	Trip Wheel
10	BF-005219	Hex Nut
11	BF-005220	Tool Slide
12	BF-005221	Low Range Holder
13	BF-005222	High Range Holder
14	BF-005223	Insert
15	BF-005224	Torx Screw

Reference No.	Part No.	Description
16	BF-005225	Left Gib
17	BF-005226	Right Gib
18	BF-005227	Trip Ring
19	BF-005228	(4) Trip Pin
20	BF-005229	(4) Trip Receptacle
21	BF-005230	(4) Socket Head Cap Screw
22	BF-005231	3/8" Ratchet
23	BF-005232	5/8" Combination Wrench
24	BF-005233	9/16" Combination Wrench
25	BF-005234	5/32" T-Handle Hex Key
26	BF-005236	T15 Torx Driver
27	BF-005237	Alignment Gage
28	BF-005238	Alignment Gage Collar
29	BF-005239	Alignment Gage Spring Clip
30	BF-005240	Locking Handle
31	BF-005241	Trip Wheel Socket
32	BF-005242	Set Screw