

.750" to 16.250" (19.1 to 412.8 mm) 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 shop 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. The mandrels are designed to mount in short-radius elbows. The minimum straight depth to mount the model MSF is .500" [12.7 mm], model MTF is 1.000" [25.4 mm] and model MFTF is 1.250" [31.8 mm]).

Centering and squaring devices make accurate machining of gasket surfaces and/or bolt patterns simple and safe.



- **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 Increases Safety and Accuracy**



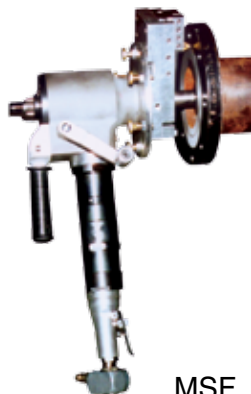
Flange Facing Tools and Accessories

	Model BF	Model MSF	Model MTF	Model MFTF
Working Range*	.750" I.D. to 4.120" O.D. (19.1 to 104.6 mm)	1.250" I.D. to 6.190" O.D. (31.8 to 157.2 mm)	3.250" I.D. to 10.630" O.D. (82.6 to 270.0 mm)	4.250" I.D. to 16.250" O.D. (108.0 to 412.8 mm)
Surface Finish Approx. Finish/Pin	63 to 250 RMS 1 = 63 RMS, 2 = 125RMS 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*	1.500" (38.1 mm)	2.000" (50.8 mm)	3.000" (76.2 mm)	3.000" (76.2 mm)
Axial Feed Rate Per Full Turn	.062" (1.6 mm)	.062" (1.6 mm)	.083" (2.1 mm)	.083" (2.1 mm)
Adjustments				
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	.750" (191. mm)	.500" (12.7 mm)	1.000" (25.4 mm)	1.250" (31.8 mm)
Tooling	Single point replaceable carbide insert in steel tool holder, two machining points per insert.			
Weight				
Power Unit	19.0 lbs. (8.6 kgs.)	27.0 lbs. (12.2 kgs.)	55.0 lbs. (24.9 kgs.)	70.0 lbs. (31.8 kgs.)
Mandrel	N/A	4.0 lbs. (1.8 kgs.)	10.0 lbs. (4.5 kgs.)	13.0 lbs. (5.9 kgs.)
Dimensions				
Mandrel Length	12.500" (317.5 mm)	14.000" (355.6 mm)	15.000" (381.0 mm)	18.000" (457.2 mm)
Radial Clearance*	4.000" (101.6 mm)*	6.000" (152.4 mm)	9.000" (228.6 mm)	11.000" (279.4 mm)
Motor, Pneumatic	.9 HP (0.66 kW)	1.625 HP (1.2 kW)	3.0 HP (2.2 kW)	3.0 HP (2.2 kW)
Air Volume	38 CFM (1.1 M ³ /Min.)	38 CFM (1.1 M ³ /Min.)	65 CFM (1.9 M ³ /Min.)	65 CFM (1.9 M ³ /Min.)
Pressure	90.0 psi (6.1 bar)	90.0 psi (6.1 bar)	90.0 psi (6.1 bar)	90.0 psi (6.1 bar)
Speed, Adjustable	90 RPM, Max.	50 RPM, Max.	22 RPM, Max.	18 RPM, Max

*Model BF has a tight clearance option available. This option reduces the maximum working range to 2.500" (63.5 mm). Tool travel is limited to 1.000" (25.4 mm). Radial clearance is reduced to 2.750" (69.9 mm).



BF



MSF



MTF



MFTF

Model MSF Elbow Mandrel

Size	Pin Length	I.D. Range		Size	Pin Length	I.D. Range	
		Inches	MM			Inches	MM
A	0.594	1.750 – 2.000	44.5 – 50.8	G	1.344	3.250 – 3.500	82.6 – 88.9
B	0.719	2.000 – 2.250	50.8 – 57.2	H	1.469	3.500 – 3.750	88.9 – 95.3
C	0.844	2.250 – 2.500	57.2 – 63.5	I	1.594	3.750 – 4.000	95.3 – 101.6
D	0.969	2.500 – 2.750	63.5 – 69.9	J	1.719	4.000 – 4.250	101.6 – 108.0
E	1.094	2.750 – 3.000	69.9 – 76.2	K	1.844	4.250 – 4.500	108.0 – 114.3
F	1.219	3.000 – 3.250	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	3.250 – 4.000	82.6 – 101.6	MT5	2.750	6.250 – 7.000	158.8 – 177.8
MT2	1.625	4.000 – 4.750	101.6 – 120.7	MT6	3.125	7.000 – 7.750	177.8 – 196.9
MT3	2.000	4.750 – 5.500	120.7 – 139.7	MT7	3.500	7.750 – 8.500	196.9 – 215.9
MT4	2.375	5.500 – 6.250	139.7 – 158.8				

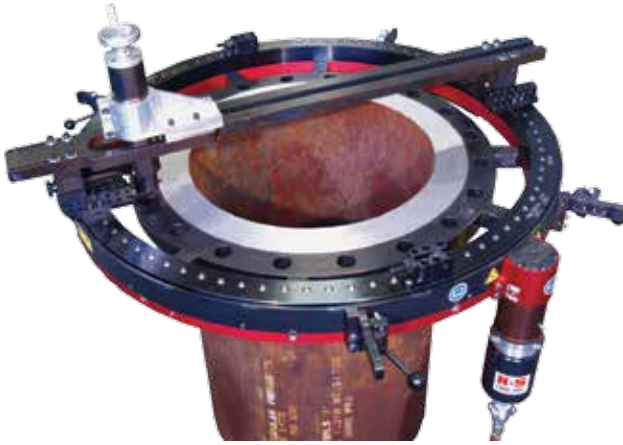
Model MFTF Elbow Mandrel

Size	Pin Length	I.D. Range		Size	Locator Pins For Extended Head		
		Inches	MM		Pin Length	Inches	MM
FT1	1.750	4.250 – 5.000	108.0 – 127.0	FT7	2.375	8.750 – 9.500	222.3 – 241.3
FT2	2.125	5.000 – 5.750	127.0 – 146.1	FT8	2.750	9.500 – 10.250	241.3 – 260.4
FT3	2.500	5.750 – 6.500	146.1 – 165.1	FT9	3.125	10.250 – 11.000	260.4 – 279.4
FT4	2.875	6.500 – 7.250	165.1 – 184.2	FT10	3.500	11.000 – 11.750	279.4 – 298.5
FT5	3.250	7.250 – 8.000	184.2 – 203.2	FT11	3.875	11.750 – 12.500	298.5 – 317.5
FT6	3.625	8.000 – 8.750	203.2 – 222.3	FT12	4.250	12.500 – 13.250	317.5 – 336.6
				FT13	4.625	13.250 – 14.000	336.6 – 355.6
				FT14	5.000	14.000 – 14.750	355.6 – 374.7
				FT15	5.375	14.750 – 15.500	374.7 – 393.7



Specifications are subject to change without notice.

O.D. Mount Flange Facing



Our versatile line of split-frame machines use a counterbore head to quickly and accurately resurface flanges from 4.000" to 86.000" O.D. (101.6 mm to 2184.4 mm).

By altering the number of tripper pins, surface finishes can be machined from 63 to 500 RMS. Contact your H&S representative or our headquarters at the information listed below.

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