



KEY FEATURES

- Precision construction
- 6 continuous groove facing feeds for a gramophone finish (ASME Standard)
- 3 different sized quick set independent bases for improved on-site operation
- Hardened slide ways to maintain long term accuracy
- Swivel tool post for groove details; reduces need for separate accessories

DESCRIPTION

An internally mounted and robust flange facing machine using fixed gears to produce 6 continuous groove gramophone finishes to ASME Standard.

APPLICATIONS

For all types of flange facing, seal grooving, weld preparation and counter boring.

SPECIFICATION

Min Facing Diameter	305mm (12")
Max Facing Diameter	1500mm (60")
Min Clamping Diameter	290mm (11.4")
Max Clamping Diameter	1400mm (55")
Min Swing Diameter	1200mm (47.3")
Tool Post Travel	102mm (4")
Rpm (max)	20
Standard drive type	Air
Hydraulic option available?	Yes
Number of feed settings	6
Output @ 90psi	3kw (4hp)
Air supply needed	2.89m ³ /min 102.4cfm

FACING FEED RATES & GROOVES PER INCH

Direction	Gear	mm/rev	Inches/rev	Grooves/inch
Out	1	0.130	0.005	195
	2	0.203	0.008	125
	3	0.494	0.019	51
In	1	0.155	0.006	164
	2	0.241	0.009	105
	3	0.588	0.023	43

BORING FEED RATES

	3 off up/down	mm/rev	inches/rev
Out		0.02	0.000787
		0.045	0.001772
		0.12	0.004724
In		0.04	0.001575
		0.06	0.002362
		0.13	0.005118

INCLUDED AS STANDARD WITH MACHINE

The machine is supplied complete with the following items;

- ✓ 3 quick set bases
- ✓ All required mounting feet and extensions
- ✓ Toolkit including tools and inserts
- ✓ Air filter lubricator
- ✓ Hose connection
- ✓ Storage / shipping box
- ✓ CE certificate,
- ✓ Packing list and manual

SET UP AND OPERATION

The operator must be:

- Trained and conversant with the product
- Able to identify the correct and incorrect use of static or portable machines.
- Comply with all local and internationally recognised safe use of powered machines.

COMPONENT WEIGHTS

Weight (excl base)	155kg	342lbs
Max Base Assy Weight	67kg	148lbs

SHIPPING WEIGHTS

Box 1 Weight	500kg	1102lbs
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SHIPPING DIMENSIONS

	Length	Width	Height
Box 1	122cm (48")	62cm (24.4")	82cm (32.3")



Above: Exploded view of the 3 base assemblies provided.

IMPORTANT
PLEASE REVIEW OPTIONS, ACCESSORIES
AND SPARE PARTS ON NEXT PAGES



MM1500i FLANGE FACING MACHINE OPTIONS & ACCESSORIES

SPARES KIT

Part number: MM1500i-SK

Recommended for 2 year use. Kit varies by machine, but typically comprises machine bolts, ram bolts, feed nut screw, feed nut bolt, tool holder, spares kit for Modex motor).



HYDRAULIC CONVERSION KIT

Part number: MM1500i-14

Kit for converting the machine to hydraulic drive.



SURFACE COMPARATOR

Part number: RBC0120

A set of roughness specimens in a heavy-duty presentation suited to workshop use.



COMPACT FLANGE MACHINING KIT

Part number: MM1500i-CFM

Add on module to enable the machining of compact flanges.



RTJ MEASURING KIT

Part number: RTJM1500

Kit for measuring RTJ grooves.



HYDRAULIC ORBITAL MILLING KIT

Part number: MM1500i-10

Add-on components used to convert to an orbital milling machine.



HEAT EXCHANGER MOUNTING PLATE KIT

Part number: MM1500i-7

Kit for mounting the machine onto tube sheets.



HEAT EXCHANGER BACK FACING KIT

Module to enable the machining of flange back faces on tube sheets.

