

Silk FXB630 Flange Facing Machine

Clamping Capacity 6 inches ID to 30 Inches OD (153mm ID to 762 mm OD)

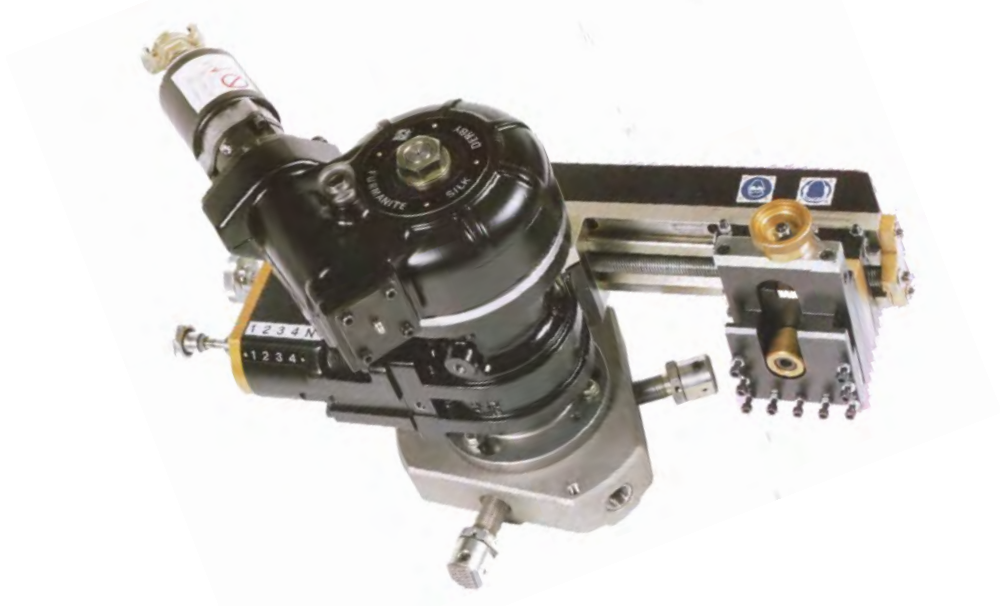
The SILK FXB630 Flange Facer is modular, compact, and of lightweight construction, designed to resurface flanges ranging from 153 mm (6") internal diameter to 762 mm (30") external diameter.

It is internally mounted and comes as standard with three clamping modules. Driven by a 1.7kW (2.3hp) pneumatic motor, this machine is a true workhorse.

Additional versatility is offered by the dovetail slide mounted tool post, which may be swivelled when machining V grooves.

The durable feed gearbox on this machine offers four automatic feed rates to ensure accurate machine settings for a variety of surface finishes.

The versatility of the machine can be expanded via a host of "Bolt-On" extras which are available on request.



Silk FXB630 Features

- Precise and robust
- Compact and portable
- Externally mounted
- Operates in any orientation
- Cuts "O" Ring grooves, RTJ and other V grooves, standard and compact flange facings, weld preparations, etc.
- Achieves surface finishes from 6.3mm Ra to 1.6mm Ra (250min Ra to 63min Ra) when turning and from 1.6mm Ra to 0.8mm Ra (63min Ra to 32min) when polishing
- Pneumatic drive permits use in hazardous areas.
- Optional hydraulic drive is available on request
- Provided in own transportable case



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The SILK FXB 630, as all other machines in the range is constructed from the highest quality materials and will give machine shop accuracy. It consists of the four main assemblies.

Base Assembly

Three separate, hard anodised cast aluminium bases with steel threaded inserts, and adjustable feet enable the machine to be installed perfectly level and central in any flange from 153mm (6") to 762mm (30") in diameter.

Each assembly consists of a flat triangular casting with a radius across each corner, a hole is tapped into these corners along with one on each flat side which enable the bases to be centralised into a variety of bore sizes.

Setting straps are also provided to help in the original positioning of the base to the correct depth.

Drive Hub Assembly

The machine is driven by a 1.2kw (1.5hp) pneumatic motor, mounted directly to the drive hub assembly.

This hub provides the drive input to the gearbox and provides a rigid support for the surfacing arm. The whole hub assembly casting is powder coated after machining for a knock resistant finish.

Drive Gearbox

This is mounted directly to the drive hub assembly and with the use of either leadscrew provided gives specific surface finishes, (see table opposite).

Traverse is selected by a push/ pull rod, which selects traverse IN, traverse OUT and a neutral N position, which is used for manually positioning the tool.

Cutting Arm Assembly

Mounted on the drive hub assembly this provides the rigid structure to which the toolpost is fitted. It can achieve cuts up to a maximum depth of 2mm (0.079") on flanges without boltholes or 0.5mm (0.02") with holes and can achieve a flatness better than 0.04mm (0.0015") at 762mm (30") diameter.

All slideways are coated for rust resistance and 12mm square tooling is supplied as standard.

Typical Applications

- Lens Ring Seat Cutting & Polishing
- 'V' Groove Cutting
- Tube Sheet Machining



Specifications

Principle Dimensions as AX630d 12mm

Table of Surfacing Feeds

	10 TPI .8 RAD	6 TPI .8 RAD
1	40 CLA	55 CLA
2	50 CLA	75 CLA
3	80 CLA	140 CLA
4	175 CLA	325 CLA
	.4 RAD	.4 RAD
1	65 CLA	75 CLA
2	80 CLA	95 CLA
3	100 CLA	175 CLA
4	175 CLA	400 CLA
	.8 RAD	.8 RAD
1	1.0 RA	1.9 RA
2	2.0 RA	2.35 RA
3	2.5 RA	4.37 RA
4	4.37 RA	10.0 RA
	.4 RAD	.4RAD
1	1.67 RA	1.69 RA
2	2.0 RA	2.35 RA
3	2.5 RA	4.37 RA
4	4.37 RA	10.0 RA