

Flange Management Professional Tools



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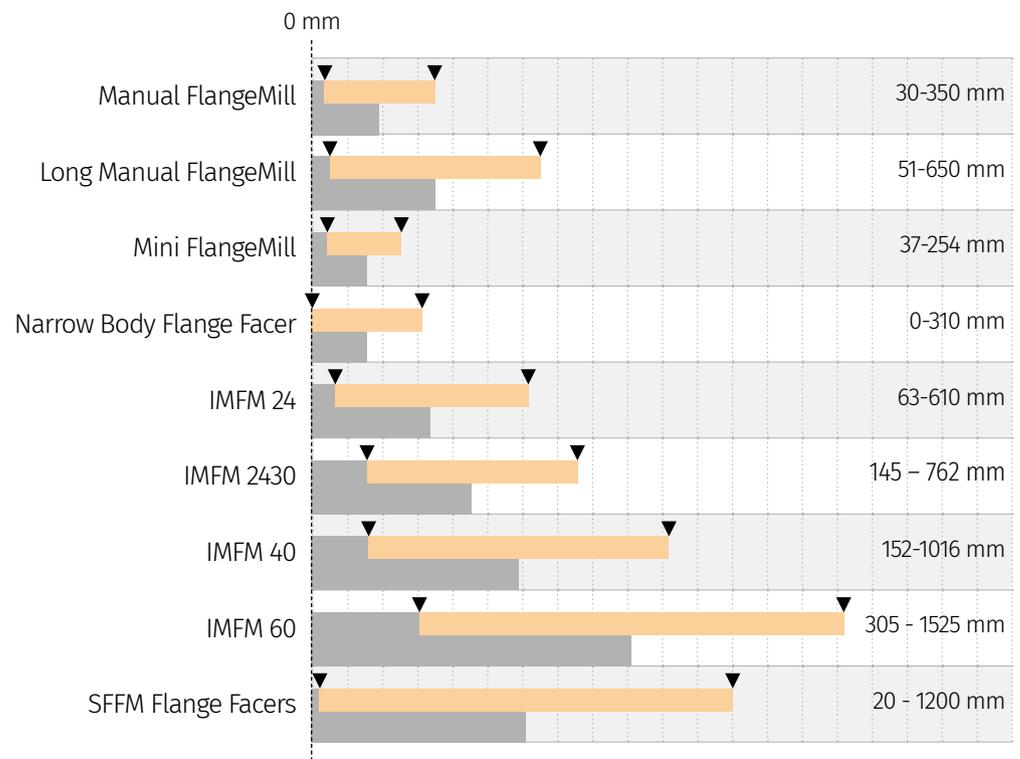
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Flange Management

Professional Tools



MFM – Manual FlangeMill

Basic, simple and cost-effective solution for ID mount flange facing. It is a quick and easy way to reface a damaged flat, grooves in pipe flanges on site. Manual FlangeMill size and body is designed and built to allow quick and convenient processing of small flanges in awkward or dangerous locations.

TOOL SWING DIAMETERS



FACING RANGE

BODY SWING DIAMETER



FACING RANGE	LOCKING RANGE	MAX V TOOL TRAVEL	MAX H TOOL TRAVEL	BODY SWING DIAMETER	
30 – 350 mm	25,4 - 254,0 MM	10 MM	55 MM	457,2 MM	
1,750 – 14,000"	1 - 10"	0,395"	2,165"	18"	
DRIVE	BODY WIDTH		BODY LENGHT		BODY WEIGHT
Manual	6,5"	165 mm	12,8"	325 mm	19,4 Lbs 8,8 kg

MFM TOOL BITS AND HOLDER



Manual Flange Mill uses one just type of holders: MFMH-7-L and MFMH-7-R with carbide insert CI7 (screw MHS-2,7)

	A	B
CI7 mm	7	7

MFM ADVANTAGES



PRECISE DEPTH ADJUSTMENT
The tool depth can be adjusted (10 mm stroke) thru spindle to define cut depth and the correct finish.



EASE OF USE
The tool arm is rotated by hand using a worm-gear mechanism to provide a perfect spiral finish.



SMOOTH OPERATION
Quick adjustment handle to move the cutter to groove position



MACHINING IN EVERY POSITION
Manual FlangeMill can be freely rotated to work in every position. Remachining damaged flat, grooves and raised faced flanges on site is possible in every position.

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
MFMH-7-L	CI7	MHS-2,7	TX-8
MFMH-7-R	CI7	MHS-2,7	TX-8

EXAMPLE TOOL APPLICATION



MFML – Manual FlangeMill Long

Long version of simple and cost-effective solution for ID mount flange facing. It is a quick and easy way to reface a damaged flat, grooves in pipe flanges on site. The L(ong) version FlangeMill size and body is designed and built to allow quick and convenient processing of mid sized flanges in awkward or dangerous locations.



TOOL SWING DIAMETERS



FACING RANGE

BODY SWING DIAMETER

FACING RANGE	LOCKING RANGE	MAX V TOOL TRAVEL	MAX H TOOL TRAVEL	BODY SWING DIAMETER	
51 – 650 mm	51 - 550 MM	10 MM	55 MM	757 MM	
2,01 – 25,60”	2,01 - 21,65”	0,395”	2,165”	30”	
DRIVE	BODY WIDTH		BODY HEIGHT		BODY WEIGHT
Manual	6,5”	165 mm	18,7”	475 mm	19,4 Lbs 8,8 kg

MFM TOOL BITS AND HOLDER



Manual Flange Mill uses one just type of holders: MFMH-7-L and MFMH-7-R with carbide insert CI7 (screw MHS-2,7)

CI7	A	B
	mm	7 7

MFM ADVANTAGES



PRECISE DEPTH ADJUSTMENT
The tool depth can be adjusted (10 mm stroke) thru spindle to define cut depth and the correct finish.



EASE OF USE
The tool arm is rotated by hand using a worm-gear mechanism to provide a perfect spiral finish.



SMOOTH OPERATION
Quick adjustment handle to move the cutter to groove position



MACHINING IN EVERY POSITION
Manual FlangeMill can be freely rotated to work in every position. Remachining damaged flat, grooves and raised faced flanges on site is possible in every position.

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
MFMH-7-L	CI7	MHS-2,7	TX-8
MFMH-7-R	CI7	MHS-2,7	TX-8

MMFM – Mini FlangeMill

Compact and light weight flange milling machine – one of the most compact designs on the market today.

- 】 Low clearance.
- 】 Flat and raised face flanges
- 】 Single line, true gramophone groove with 50 grooves per 1" to comply with ASME B46.1 code
- 】 Pneumatic drive 1,3 Hp or 750 W electric with multiple planetary gear box
- 】 Stainless steel body to stiffen the machine base
- 】 Rigid construction aluminium facing head , supported by multiple bearings
- 】 Solid locking mandrel shaft and rigid mounting jaw set
- 】 Hardened and ground tool slides for precision

QUALITY COMPONENTS

- 】 Pneumatic motor comes complete with filter, lubricator and flow control.
- 】 Compact, low-profile drive system engineered for superior power to weight ratio.
- 】 Features rugged main body, heavy-duty bearings, sealed lubrication, and rigid mounting system.



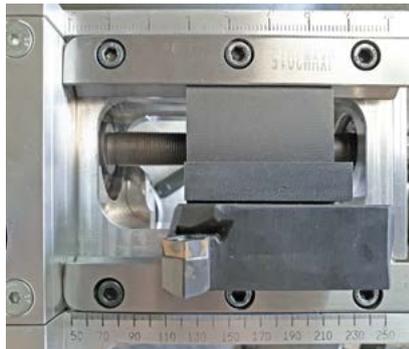
FACING RANGE	RANGE PIPE FACING (SINGLE POINT)	LOCKING RANGE	VERTICAL FEED STROKE	MACHINING FEED RATE	POWER				
37 – 254 mm	51 – 254 mm	26 – 150 mm	13 mm	0,5 mm	1,3 Hp				
1,45 – 10"	2 – 10" OD	1,0 – 5,9"	0,5"	0,019"					
AIR USE		WEIGHT		HEIGHT		LENGTH		SWING DIAMETER	
55 cfm	1,3 m ³ /min	23 Lbs	10,43 kg	19,291"	490 mm	16,338	415 mm	12,204	310 mm

STANDARD FEED SCREW



Machine comes standard with 50 grooves per inch feed screw and nut. Optional feed screw/ nut are available with 68 and 101 grooves per inch.

CONVENIENT SCALE



Convenient and easy to read gauge in metric and imperial scale allowing adjustment of the working range before mounting on the flange.

BASIC FEATURES



Single line gramophone groove (50 grooves per 1 inch)



Graduation of the tool setting to the desired depth of cut.



Handy depth feed locking system to prevent accidental movement of the handle during flange processing.



Hand guard to protect against accidental impact of the rotating head.

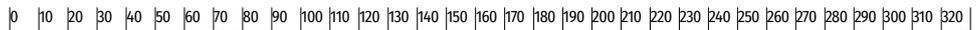
SAFETY FIRST

TOOL HOLDERS RANGES

MMFM is a low clearance flange facing machine. To achieve this multiple tool holders are required to cover full range, below table specifies machining range of each holder.

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
MMFM-12520	CI7	MHS-2,7	TX-8
MMFM-85210	CI7	MHS-2,7	TX-8
MMFM-37160	CI7	MHS-2,7	TX-8



MMFM-12520

125 - 250 mm (4.92" - 9.84")

MMFM-85210

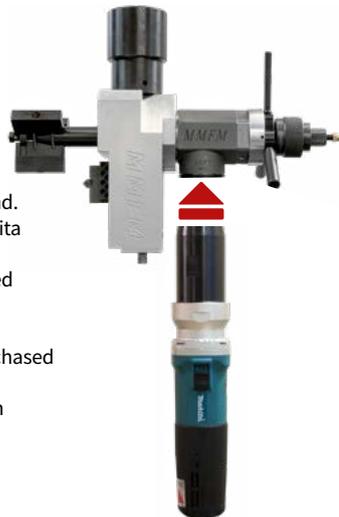
85 - 250 mm (3.35" - 8.27")

MMFM-37160

37 - 160 mm (1.45" - 6.3")

MMFM-E

MMFM-E is electric version of MMFM. A standard machine covers the same flange sizes and comes with the same cutting head. The electric motor, made by Makita with 3 stage planetary gear box made by KRAIS has variable speed control and produce enormous torque. Is interchangeable with pneumatic drive and can be purchased separately at any time. Also available with battery driven motor!



Free Speed 115 RPM
 Power 750 W
 Torque 360 Nm (266 Ft.Lbs)

BATTERY OPTION

The machine is also available with a portable electric drive 18 Volt 5.2 Ah 93.6 Wh Li-Ion battery. The machine can operate up to 15-20 minutes on one battery. Machining itself of one flange takes about 3-4 minutes of motor operation, so the operating time on one battery may suffice on 3-4 flanges. It is possible to have many charged batteries. Comfortable and easy to use in any place where compressed air and electricity is not available or even impossible to use as for example oil refinery.



NBFF – Narrow Body Flange Facer*

*Patent pending

NBFF – the flange facing machine with a slim line gantry profile for mounting in tight spaces. An operator can mount NBFF tool on-site within demanding conditions such as flanges close to walls or pipe racks.

The unique design of NBFF allows the operator to mount the machine and perform a repair in locations that popular, standard equipment could not fit.

The machine conforms to all the necessary standards and is extremely easy to use. Light and robust to quickly mount and repair damaged faces on flanges. NBFF can maximize production and uptime in all flange management jobs.

SUPER NARROW BODY

Thanks to unique, a true narrow design NBFF tool is fully usable within demanding conditions such as flanges close to walls or pipe racks.



MODEL	FACING RANGE	CLAMPING RANGE	MAX SWING DIAMETER	TOOL POST TRAVEL	FEED RATES	FREE SPEED	POWER		
NBFF-115	0 - 125 mm	89 - 170 mm	125 mm	62,5 mm	See table below	100 Rpm	1,3 Hp		
	0 - 4,92"	3,5 - 6,6"	4,92"	2,45"			0,97 kW		
AIR USE		WIDTH		HEIGHT		LENGTH		BODY WEIGHT	
55 cfm	1,3 m ³ /min	65/100 mm	2,55"/3,93"	460 mm	18,11"	260 mm	10,23"	25 kg	55,11 Lbs

MODEL	FACING RANGE	CLAMPING RANGE	MAX SWING DIAMETER	TOOL POST TRAVEL	FEED RATES	FREE SPEED	POWER		
NBFF-160	0 - 185 mm	89 - 280 mm	185 mm	92,5 mm	See table below	115 Rpm	2,2 Hp		
	0 - 7,27"	3,5 - 11"	7,27"	3,6"			1,6 kW		
AIR USE		WIDTH		HEIGHT		LENGTH		BODY WEIGHT	
75 cfm	2,2 m ³ /min	70/100 mm	2,75"/3,93"	510 mm	20,07"	340 mm	13,38"	27 kg	59,52 Lbs

MODEL	FACING RANGE	CLAMPING RANGE	MAX SWING DIAMETER	TOOL POST TRAVEL	FEED RATES	FREE SPEED	POWER		
NBFF-300	0 - 310 mm	108 - 356 mm	310 mm	155 mm	See table below	85 Rpm	2,2 Hp		
	0 - 12,2"	4,25 - 14"	12,2"	6,1"			1,6 kW		
AIR USE		WIDTH		HEIGHT		LENGTH		BODY WEIGHT	
75 cfm	2,2 m ³ /min	70/100 mm	2,75"/3,93"	510 mm	20,07"	470 mm	18,50"	32 kg	70,54 Lbs

CHOICE OF THREE

All versions of NBFF deliver the same advantage over standard flange facers: despite working size all are narrow and fit perfectly in tight spaces.



FEED RATES

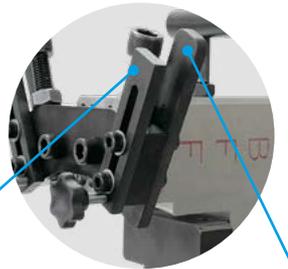
Feed rates pitch mm			
0,5	0,75	1*	1,25
Grooves per inch			
112	75	56	45

* standard feed screw supplied with machine

STANDARD LOCKING SYSTEM



The standard locking system consists of two jaws. One of them is a stabilizing jaw with two adjustable screws to fit the outer diameter of the flange. The second jaw has three clamping screws. Both jaws are equipped with pair top pads for levelling on the sealing surface of the flange. Pads at the bottom, are for tension the machine to the flange surface. Pads help to fix the machine in any position and protect it from falling out of the flange in case of a collision.



Pads at the bottom, are for tension the machine to the flange surface and protect it from falling out of the flange in case of a collision.

Top pads are for levelling on the sealing surface of the flange.

REAL LIFE EXAMPLE



Example of really tight flange – NBFF is the only tool suitable here.

FLANGE2FLANGE LOCKING OPTION



Additional, special flange type locking system is made to suit the application more. NBFF machine is still mounted on the flange outside diameter, but the locking system is equipped with additional studs to be mounted in the flange holes to provide easy operation and perfect centring.

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
NBFF-C17	C17	MHS-2,7	TX-8

NBFF IN ACTION



NBFF-E

NBFF-E is electric version of NBFF. A standard machine covers the same flange sizes and comes with the same cutting head. The electric motor, made by Makita with 3 stage planetary gear box made by KRAIS has variable speed control and produce enormous torque. Is interchangeable with pneumatic drive and can be purchased separately at any time.

Free Speed ... 115 RPM
 Power 750 W
 Torque 360 Nm (266 Ft.Lbs)



BATTERY OPTION

The machine is also available with a portable electric drive 18 Volt 5.2 Ah 93.6 Wh Li-Lon battery. The machine can operate up to 15-20 minutes on one battery. Machining itself of one flange takes about 3-4 minutes of motor operation, so the operating time on one battery may suffice on 3-4 flanges. It is possible to have many charged batteries. Comfortable and easy to use in any place where compressed air and electricity is not available or even impossible to use as for example oil refinery.

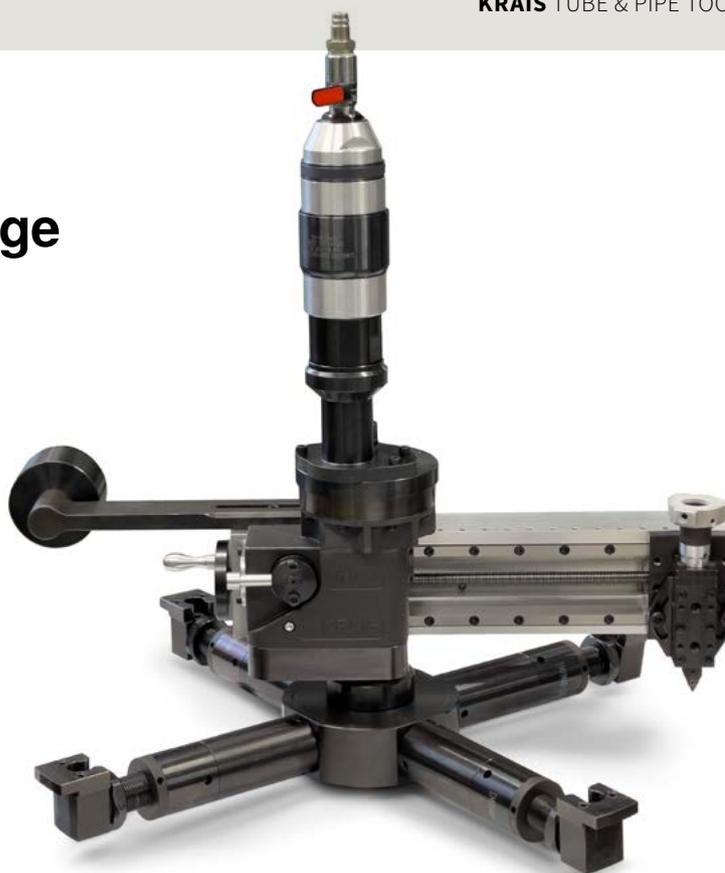


IMFM-24/30

Internal Mounted Flange Facing Machine

Internally mounted, lightweight, super rigid yet super heavy-duty machine tool. Ideal for machining all types of flange faces, seal grooves, weld preparations and counterbores.

- * Heavy-duty steel/aluminium all design.
- * Heavy-duty cast steel body and steel body plate.
- * Solid construction and high rigidity of the machine concerning the dimension and weight.
- * Continuous groove facing feed, 2-speed gearbox.
- * Swivel tool post for grooves, RTJ flanges, and bevels.
- * Quick-set independent bases for improved on-site operation.
- * Fast mounted arm with spindle for the very convenient measure of levelling and centring.
- * Super quick machine fixing to the locking base.
- * Special jaw set for easy and quick levelling and centring machine; jaws are interchangeable with all IMFM series Flange Facers.
- * CE certificate.



STANDARD WORKING RANGE		FACING FEEDS			FREE SPEED	POWER					
FACING RANGE	LOCKING RANGE	1,75 MM SCREW	1,25 MM SCREW	1,00 MM SCREW							
145 – 762 mm	140 - 670 mm	0,2 / 0,8 mm	0,14 / 0,57 mm	0,15 / 0,45 mm	20 - 42 Rpm	2,2 Hp					
5" - 30"	5-1/2" - 26"	0,008 / 0,031"	0,006 / 0,022"	0,004 / 0,018"		1,6 kW					
AIR USE		MACHINE WEIGHT		DRIVE WEIGHT		MAX BIG BASE WEIGHT		MAX SMALL BASE WEIGHT		COUNTER WEIGHT	
75 cfm	2,2 m ³ /min	26 kg	57,4 Lbs	5 kg	11,0 Lbs	18 kg	39,7 Lbs	4 kg	8,8 Lbs	6 kg	13,23 Lbs

SHIPPING BOX		SHIPPING WEIGHT	
75 x 55 x 35 cm	30" x 22" x 14"	80 kg	177 Lbs

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
IMFM24-V11	CIV-11-3-1	MHS-4	TX-15

COMPLETE PACKAGE

As standard IMFM is supplied with the complete toolkit, including cutting tool and inserts, an air filter with lubricator and hose connection, required jaws to cover the full range, user manual and storage shipping box. For IMFM, besides standard pneumatic 2,2 Hp drive, we offer a wide choice of pneumatic and electric drives.

UNIQUE RIGIDITY

High rigidity of the machine in relation to the dimension and weight by applying Heavy-duty cast steel body and steel body plate.



WIDE RANGE

Machine is equipped with 2 locking bases
Big 250-700 mm
Small 140 – 290 mm



SWIVEL TOOL

Swivel tool post for grooves, RTJ flanges, and bevels



CONVENIENT JAWS

Special jaw set for easy and quick levelling and centring machine. A special mechanism allows convenient adjustment of the mounting plane relative to the pipe. Jaws are interchangeable with all IMFM series Flange Facers.



PRECISE MOUNTING



Fast mounted arm with spindle for the very convenient measure of levelling and cantering

FAST FIXING

Super fast machine fixing with locking base by means of a taper in the locking base and taper seat in the spindle fastened with a central locking screw



RIGHT ANGLE HEAD



This optional addon allows for fastening drive in alternate positions. The useful option in tight spaces.

ELECTRIC DRIVE

As an option, we can deliver the electric motor, made by Makita. With 3 stage planetary gear box made by KRAIS, the drive has variable speed control and produce enormous torque. Is interchangeable with pneumatic drive and can be purchased separately at any time. Also available with battery driven motor!



Free Speed 115 RPM
 Power 750 W
 Torque 360 Nm (266 Ft.Lbs)

IMFM-24 Internal Mounted FlangeMill

Internally mounted, lightweight and durable machine tool. Ideal for machining all types of flange faces, seal grooves, weld preparations and counterbores.

Features:

- 】 Heavy-duty steel/aluminium design
- 】 High rigidity of the machine in relation to the dimension and weight
- 】 Solid but lightweight construction
- 】 Continuous groove facing feeds
- 】 Swivel tool post for grooves, RTJ flanges and bevels
- 】 Easy levelling and centering system with built-in fast centre feature
- 】 Quick clamping with solid, 50 mm self-centering steel shaft
- 】 CE certificate

As standard IMFM is supplied with the complete toolkit, including cutting tool and inserts, air filter with lubricator and hose connection, required jaws to cover the full range, paper manual and storage/shipping box.

Beside standard pneumatic 2,2 Hp drive, for IMFM we offer a wide choice of pneumatic and electric drives.



STANDARD WORKING RANGE		FACING FEEDS			FREE SPEED	POWER	
FACING RANGE	LOCKING RANGE	1,75 MM SCREW	1,25 MM SCREW	1,00 MM SCREW			
63 – 610 mm	57 - 508 mm	0,2 / 0,8 mm	0,14 / 0,57 mm	0,15 / 0,45 mm	20 - 42 Rpm	2,2 Hp	
2,50 - 24,00"	2,25 - 20,00"	0,008 / 0,031"	0,006 / 0,022"	0,004 / 0,018"		1,6 kW	
AIR USE		BODY WIDTH		BODY HEIGHT		BODY WEIGHT	
75 cfm	2,2 m ³ /min	Depends on motor configuration, see drawing below		99 Lbs	45 kg		

LEVELLING AND CENTERING



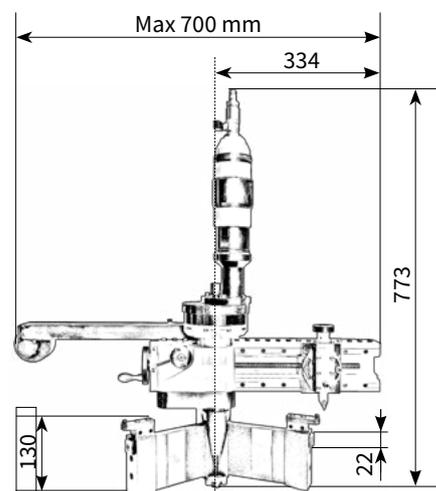
Special jaw set for easy and quick levelling and centering machines on the flange

TOOLING CHART

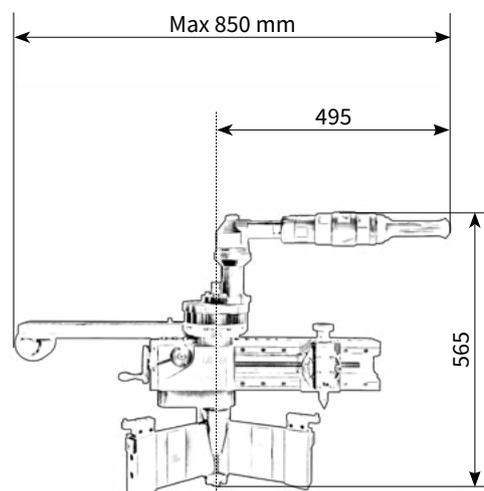
HOLDER	INSERT	SCREW	TORX
IMFM24-V11	CIV-11-3-1	MHS-4	TX-15

DIMENSIONS

INLINE VERSION



RIGHTANGLE VERSION



IMFM-40 Internal Mounted FlangeMill

Internally mounted, lightweight and durable machine tool. Ideal for machining all types of flange faces, seal grooves, weld preparations and counterbores.

- 】 Heavy-duty steel/aluminium design with solid but lightweight construction
- 】 High rigidity of the machine in relation to the dimension and weight
- 】 Continuous groove facing feeds
- 】 Swivel tool post for grooves, RTJ flanges and bevels
- 】 Easy levelling and centering system with built-in self-centre feature
- 】 Quick clamping with solid, 50 mm self-centering steel shaft
- 】 CE certificate

As standard IMFM is supplied with the complete toolkit, including cutting tool and inserts, air filter with lubricator and hose connection, required jaws to cover the full range, paper manual and storage/shipping box. Beside standard pneumatic 2,2 Hp drive, for IMFM we offer a wide choice of pneumatic and electric drives.



STANDARD WORKING RANGE		MAX SWING DIAMETER	TOOL POST TRAVEL	FEED RATES	FREE SPEED	POWER					
FACING RANGE	CLAMPING RANGE										
152 – 1016 mm	120 - 820 mm	1220 mm	102 mm	See table	0 - 24 Rpm	2,2 Hp					
6 - 39,70"	4,72 - 32,20"	32"	4"			1,6 kW					
AIR USE		SHIPPING WIDTH		SHIPPING HEIGHT		SHIPPING LENGTH		BODY WEIGHT		SHIPPING WEIGHT	
75 cfm	2,2 m ³ /min	600 mm	24"	725 mm	28,5"	845 mm	34"	145 kg	319 Lbs	210 kg	462 Lbs

FACING FEED RATES (3 OFF IN/OUT)

Direction	Gear	mm/rev	inch/rev	grooves per cm	grooves per inch
Out	1	0,139	0,005	72	183
	2	0,217	0,009	46	117
	3	0,528	0,021	19	48
In	1	0,165	0,006	61	154
	2	0,258	0,010	39	98
	3	0,628	0,025	16	40

BORING FEED RATES (3 OFF UP/DOWN)

mm/rev	inches/rev
0.05 – 0.10 – 0.20	0.002 – 0.004 – 0.008

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
IMFM40F-V11	CIV-11-3-1	MHS-4	TX-15
IMFM40P-V11	CIV-11-3-1	MHS-4	TX-15
IMFM40L-V11	CIV-11-3-1	MHS-4	TX-15

MACHINE IN ACTION



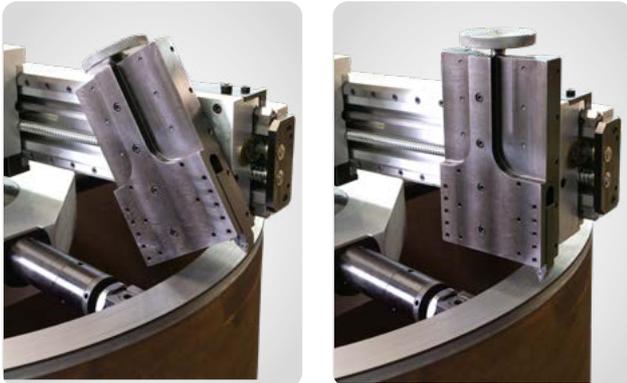
IMFM-40 and IMFM-60 features

LEVELLING AND CENTERING



IMFM40 Special jaw set for easy and quick levelling and centering machine. A special mechanism allows convenient adjustment of the mounting plane relative to the pipe. Built-in self-centering locking system significantly facilitates the coarse setting of the machine.

SWIVEL TOOL AS A STANDARD



Standard configuration of IMFM is equipped with swivel tool post for grooves, RTJ flanges and bevels

TWO LOCKING PLATES



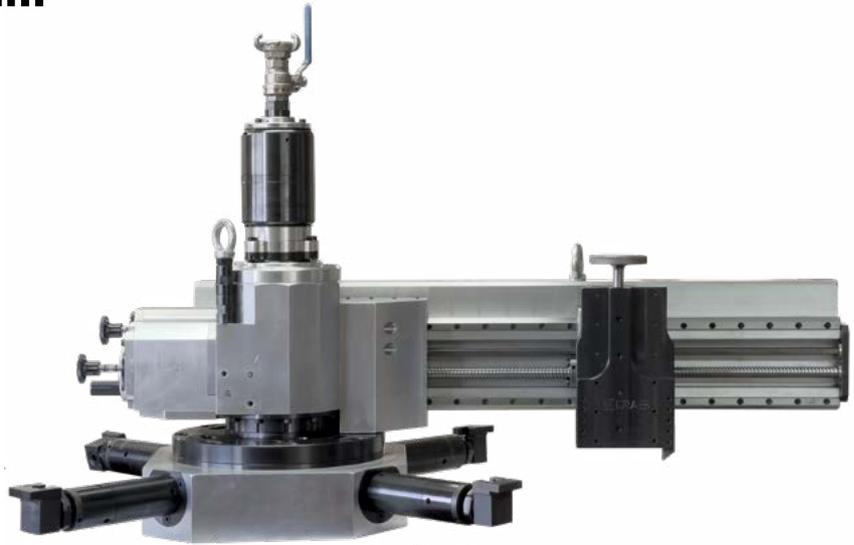
The offer includes two sizes of locking system. Thanks to the matching dimensions of the rigid body, stable mounting and smooth machining of face surfaces and flanges in all pipe sizes is possible.

IMFM-60 Internal Mounted FlangeMill

Internally mounted, lightweight and durable machine tool. Ideal for machining all types of flange faces, seal grooves, weld preparations and counterbores.

- 】 Heavy-duty steel/aluminium design with solid but lightweight construction
- 】 High rigidity of the machine in relation to the dimension and weight
- 】 Continuous groove facing feeds
- 】 Swivel tool post for grooves, RTJ flanges and bevels
- 】 Easy levelling and centering system with built-in self- centre feature
- 】 Quick clamping with solid, 50 mm self-centering steel shaft
- 】 CE certificate

As standard IMFM is supplied with the complete toolkit, including cutting tool and inserts, air filter with lubricator and hose connection, required jaws to cover the full range, paper manual and storage/shipping box. Beside pneumatic 4,0 Hp drive, for IMFM we offer a wide choice of pneumatic and electric drives.



STANDARD WORKING RANGE		MAX SWING DIAMETER	TOOL POST TRAVEL	FEED RATES	FREE SPEED	POWER					
FACING RANGE	CLAMPING RANGE										
305 – 1525 mm	290 - 1400 mm	765 mm	102 mm	See table	0 - 22 Rpm	4,0 Hp					
12" - 60"	11,4" - 55"	30,1"	4"			3,0 kW					
AIR USE		SHIPPING WIDTH		SHIPPING HEIGHT		SHIPPING LENGTH		BODY WEIGHT		SHIPPING WEIGHT	
98 cfm	2,69 m³/min	820 mm	32"	830 mm	33"	1230 mm	48"	412 kg	906 Lbs	499 kg	1010 Lbs

FACING FEED RATES (3 OFF IN/OUT)

Direction	Gear	mm/rev	inch/rev	grooves per cm	grooves per inch
Out	1	0,130	0,005	76	195
	2	0,203	0,008	49	125
	3	0,494	0,019	20	51
In	1	0,155	0,006	65	164
	2	0,241	0,009	41	105
	3	0,588	0,023	17	43

BORING FEED RATES (3 OFF UP/DOWN)

mm/rev	inches/rev
0.05 – 0.10 – 0.20	0.002 – 0.004 – 0.008

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
IMFM60F-V11	CIV-11-3-1	MHS-4	TX-15
IMFM60P-V11	CIV-11-3-1	MHS-4	TX-15
IMFM60L-V11	CIV-11-3-1	MHS-4	TX-15

MACHINE FACING 60" FLANGE RING



SFFM Flange Facer

SFFM series Flange Facing Machines are mounted on the outer diameter of the flange. The precise, synchronized radial and axial feed mechanism allows for a high quality machining, resulting in one continuous groove producing a true gramophone finish.

SFFM Flange Facing Machines are suitable for various flange types:

- 】 Flat Face
- 】 Raised Face
- 】 Ring Type Joints (RTJ)
- 】 Tongue & Groove
- 】 Lens Ring
- 】 Grayloc® (hub profile)
- 】 Compact Flanges

SFFM Flange Facers are suitable for the oil and gas industry, power plants, chemical plants, oil rigs and many others. They are prepared to implement applications complying with ASME standards.



MODEL	WORKING RANGE			DIMENSIONS					WEIGHT	JAWS
	UNIT	MIN OD	MAX OD	UNIT	FRAME OD	FRAME ID	FRAME WIDTH	HEIGHT		
SFFM-0410	NPS	2,00	10,00	[inch]	16,22	11,24	2,50	17,3"	57	4
	Metric	50,00	250,00	[mm]	412,00	285,40	63,50	440		
SFFM-1016	NPS	2,00	15,00	[inch]	21,46	16,48	2,50	17,3"	68	6
	Metric	50,00	370,00	[mm]	545,00	418,70	63,50	440		
SFFM-1624	NPS	4,00	23,00	[inch]	29,49	24,41	2,50	17,3"	103	10
	Metric	100,00	580,00	[mm]	749,00	619,90	63,50	440		
SFFM-2836	NPS	8,00	35,00	[inch]	42,15	37,00	2,76	17,3"	180	10
	Metric	200,00	890,00	[mm]	1070,60	939,80	65,40	440		
SFFM-4048	NPS	10,00	47,00	[inch]	54,40	49,53	2,76	17,3"	260	12
	Metric	250,00	1200,00	[mm]	1381,80	1251,00	65,40	440		

FEATURES OF MACHINE



CUTTING GROOVES

The machine offers a simple way of execution of the RTJ grooves by using the single point swivel head or formed tools



GRAMOPHONE GROOVE

The design of the feed attachment assures the automatic and variable feed rate on radial axe producing proper gramophone groove.



STRONG DRIVES

Machine can be driven with a wide range of motors, pneumatic, hydraulic and electrical, including servo drives - all made by KRAIS.



AVAILABLE AS MODULE

For owners of our regular SFSF machines we offer special module, allowing to convert the standard SFSF into regular flange facing module

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
SFFM-V11	CIV-11-3-1	MHS-4	TX-15

SFFM Module

SFFM Module can be mounted on all our SFSF clamshells and convert the regular Clamshell into OD mount flange facing machine SFSF clamshell combined with the module widen the scope of its application and still providing the same functionality as the machine SFFM.

Purchasing the SFFM Module allows to save a lot of money by avoiding the purchase of two separate machine tools. Time needed for the machine changeover is only 20 minutes.



SFSF MODEL	WORKING RANGE WITH MODULE			DIMENSIONS					WEIGHT*	JAWS
	UNIT	MIN OD	MAX OD	UNIT.	FRAME OD	FRAME ID	FRAME WIDTH	BOTH HEIGHT		
SFSF-0410	NPS	0,80	8,80	[inch]	16,22	11,24	2,50	16,25	57,00	4
	Metric	20,00	224,00	[mm]	412,00	285,40	63,50	412,5		
SFSF-0612	NPS	1,60	10,50	[inch]	18,15	13,24	2,50	16,25	59,00	4
	Metric	40,00	270,00	[mm]	461,00	336,20	63,50	412,5		
SFSF-0814	NPS	1,60	12,00	[inch]	19,49	14,48	2,50	16,25	61,00	6
	Metric	40,00	305,00	[mm]	495,00	367,90	63,50	412,5		
SFSF-1016	NPS	1,60	14,00	[inch]	21,46	16,48	2,50	16,29	68,00	6
	Metric	40,00	356,00	[mm]	545,00	418,70	63,50	413,5		
SFSF-1218	NPS	2,00	16,80	[inch]	23,50	18,48	2,50	16,29	83,00	6
	Metric	50,00	427,00	[mm]	597,00	469,50	63,50	413,5		
SFSF-1420	NPS	2,00	20,00	[inch]	25,47	20,85	2,50	16,29	90,00	6
	Metric	50,00	508,00	[mm]	647,00	520,30	63,50	413,5		
SFSF-1624	NPS	2,00	22,70	[inch]	29,49	24,41	2,50	16,29	103,00	10
	Metric	50,00	578,00	[mm]	749,00	619,90	63,50	413,5		
SFSF-2028	NPS	4,00	26,80	[inch]	33,90	28,75	2,76	17,48	145,00	10
	Metric	100,00	681,00	[mm]	861,10	730,30	65,40	443,7		
SFSF-2432	NPS	8,00	30,70	[inch]	38,15	33,00	2,76	17,48	158,00	10
	Metric	200,00	782,00	[mm]	969,00	838,20	65,40	443,7		
SFSF-2836	NPS	8,00	34,80	[inch]	42,15	37,00	2,76	17,48	180,00	10
	Metric	200,00	884,00	[mm]	1070,60	939,80	65,40	443,7		
SFSF-3442	NPS	10,00	40,70	[inch]	48,15	43,00	2,76	17,48	202,00	10
	Metric	250,00	1036,00	[mm]	1223,00	1092,20	65,40	443,7		
SFSF-4048	NPS	10,00	46,80	[inch]	54,40	49,53	2,76	17,48	260,00	12
	Metric	250,00	1189,00	[mm]	1381,80	1251,00	65,40	443,7		

*depends on machine configuration

SURFACE FINISH



The Modul is equipped as standard with feed gearbox in order to generate both, fine or coarse surface finish by simple switch on the gear box.

TOOLING CHART

HOLDER	INSERT	SCREW	TORX
SFFM-V11	CIV-11-3-1	MHS-4	TX-15



KRAIS Tube&Pipe Tools
Poland, 55-106 Zawonia, Czachowo 15
tel. +48 71 312 05 96, fax +48 71 387 03 32
email: export@krais.com
web: www.krais.com

 facebook.com/KraisTubeExpanders/
 linkedin.com/company/krais/

