

NODHA®

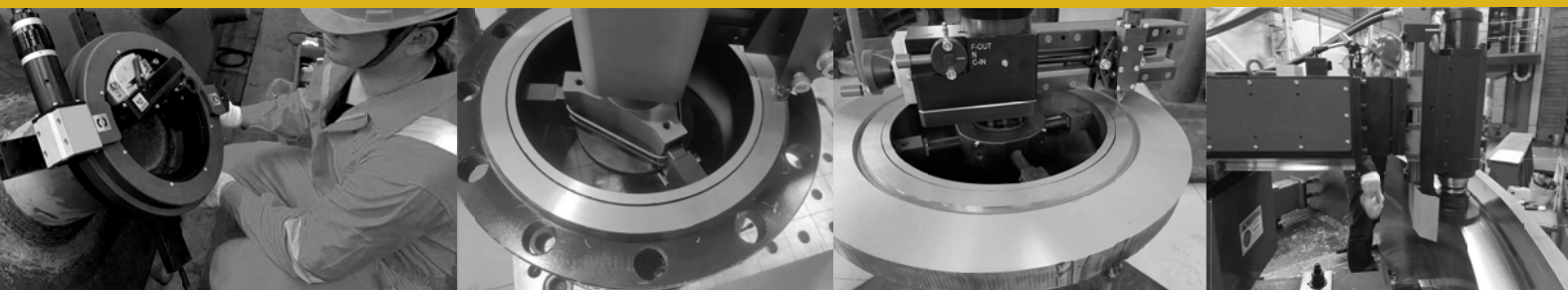
Quality, Your Value, Our Life



NODHA®

Portable Cutting & Machining Tools

Flange Facer - Manually
Flange Facing Machine
Flange Milling Machine



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EN ISO 12100:2010
EN ISO 11148-10:2011
EN ISO 60204-1:2006+A1:2009

ISO9001

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FE12 Flange Facing Machine

0"-12" (0-305mm)

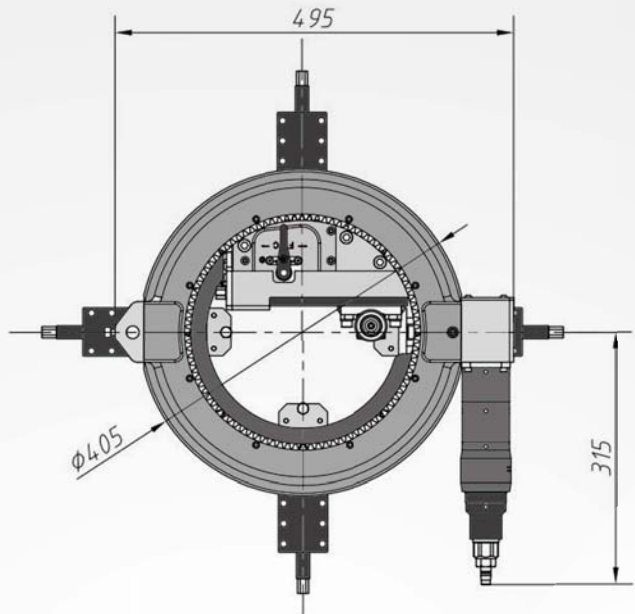
Features

- Externally Mounted
- Light weight & Rigidity Body 7075 Alu.
- Swivel Tool Post
- Portable, durable plastic case



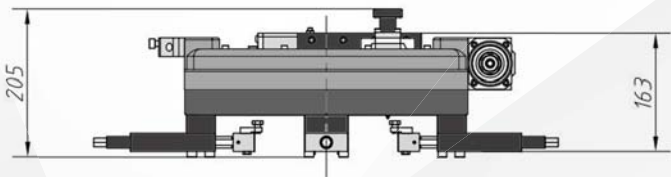
Specifications

Min. Facing Dia.	0mm / 0"
Max. Facing Dia.	305mm / 12"
Min. Clamping Dia.	50mm / 2"
Max. Clamping Dia.	450mm/17.72"
Tool Post Travel	40mm / 1.57"
R.P.M	Max. 45
No. of Feed Setings	2
Driven	Pneumatic
Air Supply	900-1000L/Min @0.6Mpa
Motor Power	1.47HP
Machine Weight	45 Kgs
Shipping Weight	95 kgs
Shipping Dimensions	850x620x580mm



Facing Feed Rate

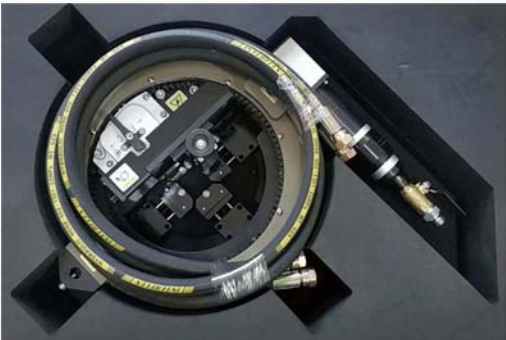
Fine (F-OUT)	0.125mm / 0.005"
Coarse (C-IN)	0.5mm / 0.02"



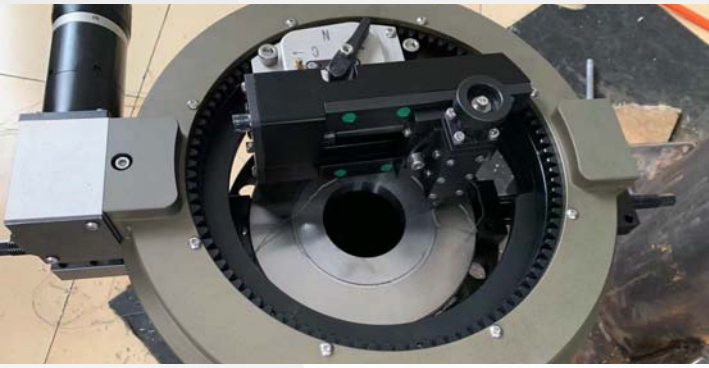
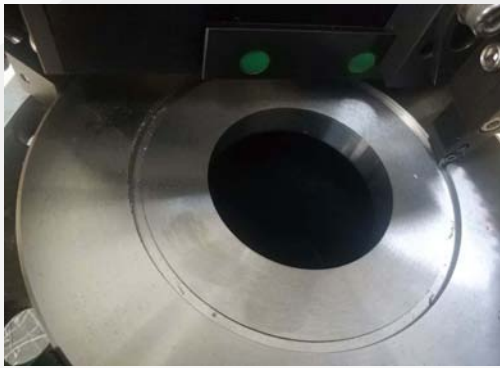
Standard Supply

Main Body-c/w Air motor
Extension Tool holder
90° Tool (RH)
Axial feed mechanism
Cutting tips - 5 pcs
RTJ Tools - 3 pcs
Full set hand tool
Air motor lubricating oil
Air Filter Lubricator-SMC
Hose connection
Full set clamps
Dia Gauge
Stroage / Shipping case
Manual

Package



Application



FI14M Flange Facer

1.07"-14" (27.2-355.6mm)

Features

- Manual operated, No power source
- Explosion-proof
- Quick and easy set up
- Portable, durable trolley case



Specifications

Min. Facing Dia.	27.2mm / 1.07"
Max. Facing Dia.	355.6mm / 14"
Min. Clamping Dia.	27.2mm / 1.07"
Max. Clamping Dia.	270mm / 10.63"
Fine Finish-Feed Screw	0.125mm/r / 0.005"
ASME B16.5-Feed Screw	0.5mm/r /0.02"
Tool Post Travel-Vertical	40mm / 1.57"
Tool Post Travel-Horizontal	57mm / 2.24"
Driven	Manually
Working Weight	9 Kgs
Shipping Weight	29 kgs
Shipping Dimensions	680x510x250mm

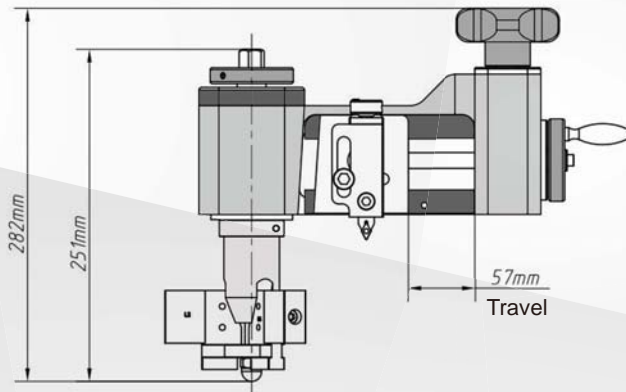
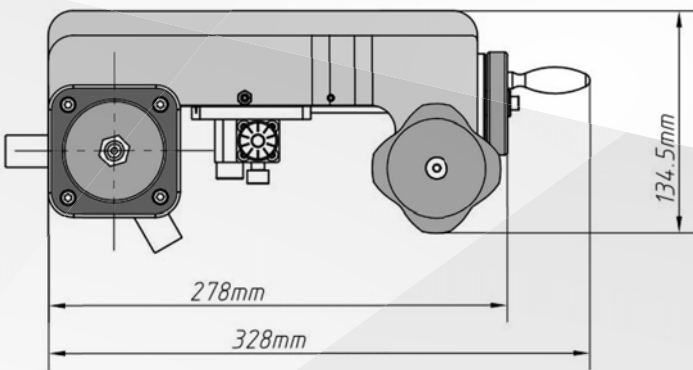
Standard Supply

Facer Body	Extention legs-N1, N2, N3, N4
ASME B16.5 Lead Screw	Extention legs-B1, B2, B3, B4
Straight Tool	Extention Legs-L1, L2, L3, L4
90° Tool (RH)	Spring- L 115mm
90° Tool (LH)	Spring- L 300mm
Cutting tips - 10 pcs	Allen keys, set
Pull Rod -3 Nos	Spanner 17mm
S-Base	Plastic Hammer
M-Base	Dia Gauge
L-Base	Manual

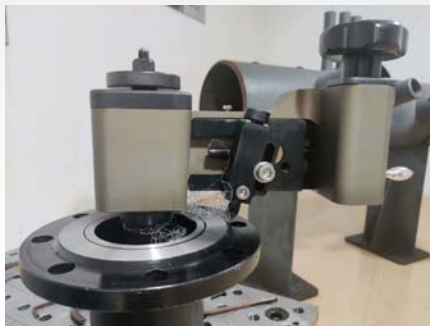
Package



Dimension Figure



Application



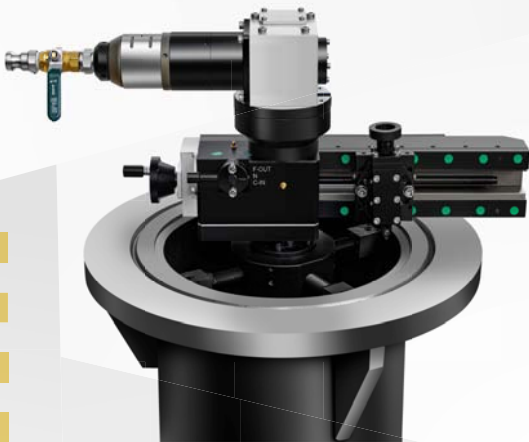
Three sizes of mounting chassis
covering Dia. 27.2-270mm
ensure stability during machining

FI24 Flange Facing Machine

3.15"-24"(80-610mm)

Features

- Internally Mounted
- Light weight & Rigidity Body 7075 Alu.
- Swivel Tool Post
- Portable, durable plastic case



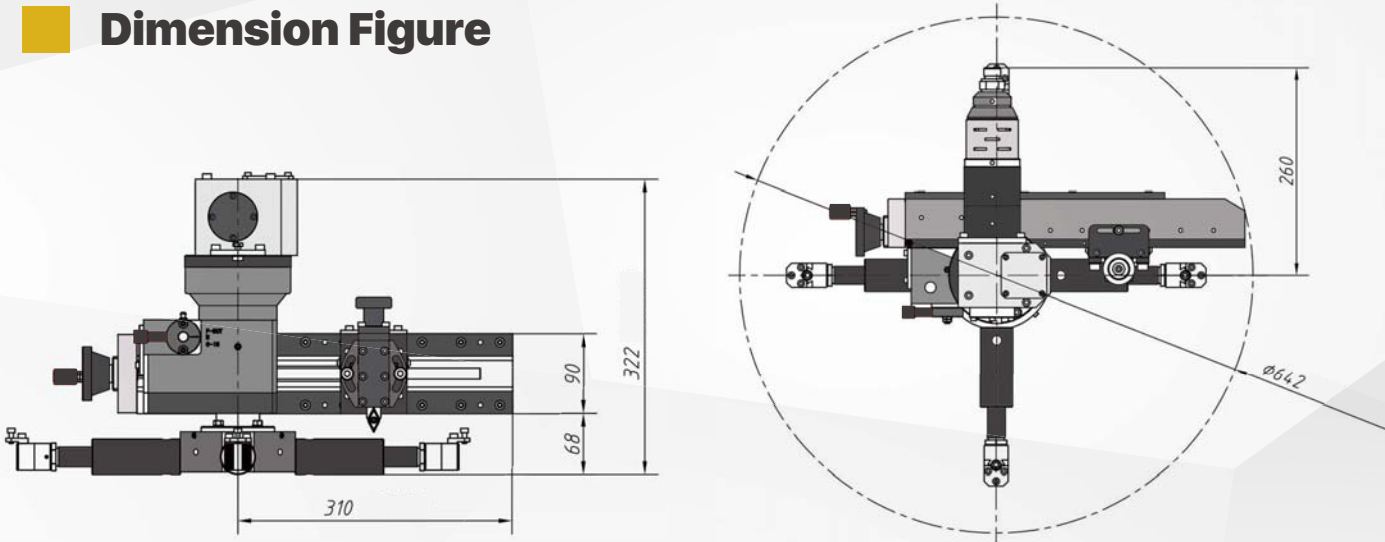
Specifications

Driven	Pneumatic	Electric-Servo
Model	FI24P	FI24E
Min. Facing Dia.	80mm / 3.15"	
Max. Facing Dia.	610mm / 24"	
Min. Clamping Dia.	59mm / 2.32"	
Max. Clamping Dia.	570mm / 22.44"	
Tool Post Travel	40mm / 1.57"	
R.P.M	Max.45	0-57
Driven	Pneumatic	Servo Motor-Panasonic
Air Supply	900-1000L/Min @0.6Mpa	220-240V 1PH 50/60HZ
Motor Power	1.47HP	1.0Kw
Machine Weight	28 Kgs	
Shipping Weight	85 kgs	
Shipping Dimensions	850x620x580mm	

Facing Feed Rate

Fine	0.125mm	0.005"
Coarse	0.5mm	0.02"

Dimension Figure



Standard Supply

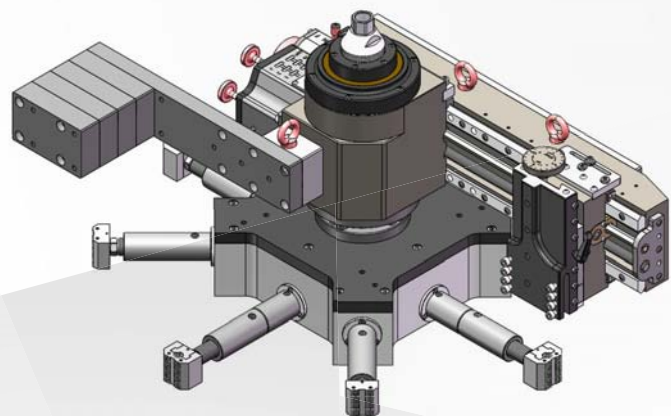
Main Body-c/w Motor	Full set Clamping Screws
Self-Centering Base	Axial feed mechanism
S-Base	Horizontal adjustment set
L-Base	Full set hand tool
Tool	Air motor lubricating oil
Extension Tool holder	Air Filter Lubricator-SMC
Cutting tips - 5 pcs	Hose connection
RTJ Tools - 3 pcs	Full set clamps
Counterweight	Dia Gauge
Counterweight plate	Stroage / Shipping case
Extension nut	Manual

Application



FI40 Flange Facing Machine

6"-40" (153-1000mm)



Features

- Internally Mounted
- Light weight & Rigidity Body 7075 Alu.
- Swivel tool post
- Panasonic Servo motor and air motor interchangeable
- 6 continuous groove facing feed
- For flange facing/seal grooving/ counterboring
- Apply to ASME Standard

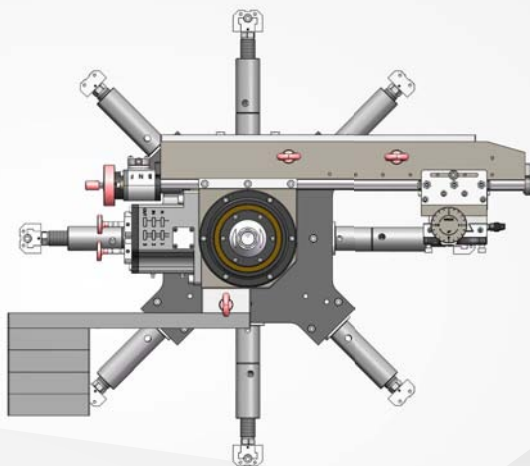
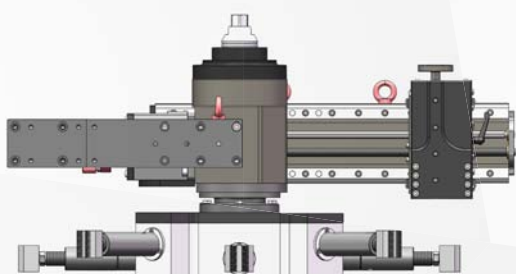
Specifications

Min. Facing Dia.	153mm /6"
Max. Facing Dia.	1000mm / 40"
Min. Clamping Dia.	145mm / 5.71"
Max. Clamping Dia.	910mm /35.82"
Tool Post Travel	102mm /4"
R.P.M	10-33 Air Operated 40 Electric Operated
No. of Feed Setings	6
Driven	MODEC-Pneumatic Panasonic-Electric
Power Supply	1.8m³/min (65CFM) @0.6Mpa (90psi) 220-240V 1PH 50/60HZ
Motor Power	2.3HP-Pneumatic 1500W-Electric
Machine Weight	68Kgs (W/o base)
Shipping Weight	330 Kgs-Pneumatic 350 Kgs-Electric
Shipping Dimensions	1250*650*610mm-Pneumati 1250*650*780mm-Electric

Standard Supply

Main Body-c/w Motor	Full set Clamping Screws
S- Base	Full set extensions
M-Base	Full set hand tool
L-Base	Air motor lubricating oil
Tool Post	Air Filter Lubricator-SMC
Extension Tool holder	Hose connection
Cutting tips - 5 pcs	Dia Gauge
Counterweight	Stroage / Shipping case-steel
Counterweight plate	Manual
Extension nut	

View



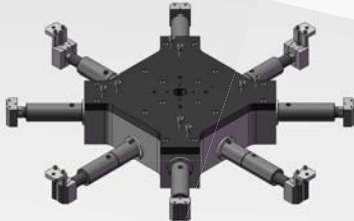
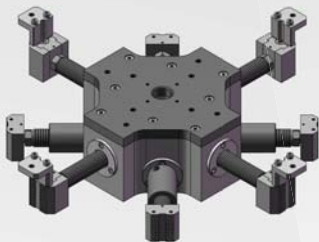
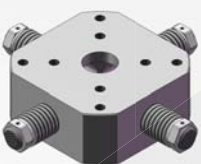
Facing Feed Rates & Grooves per Inch

Direction	Gear	mm/rev.	Inches/rev.	Grooves/Inch
In	1	0.1428	0.0056	178
In	2	0.2298	0.0090	111
In	3	0.4959	0.0195	51
Out	1	0.1055	0.0042	241
Out	2	0.1698	0.0067	150
Out	3	0.3664	0.0144	69

Boring Feed Rates

3 off up/down	Gear	mm/rev.	Inches/rev.
In	1	0.0397	0.0016
In	2	0.0638	0.0025
In	3	0.1377	0.0054
Out	1	0.0293	0.0012
Out	2	0.0472	0.0019
Out	3	0.1018	0.0040

3 sized quick set independent bases for improved on-site operation
View of the 3 bases assemblies provided

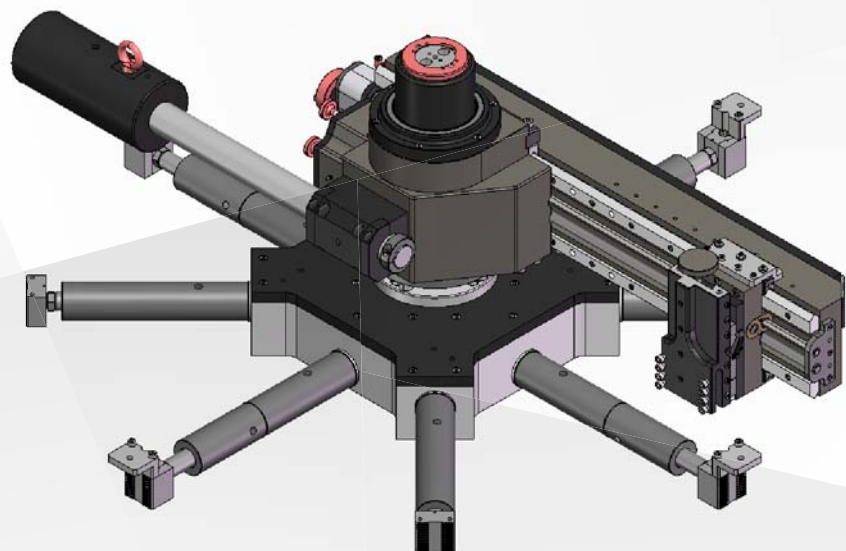


Application



FI60 Flange Facing Machine

12.6"-60" (320-1500mm)



Features

- Internally Mounted
- Light weight & Rigidity Body 7075 Alu.
- Swivel tool post
- 6 continuous groove facing feed
- For flange facing/seal grooving/ counterboring
- Apply to ASME Standard

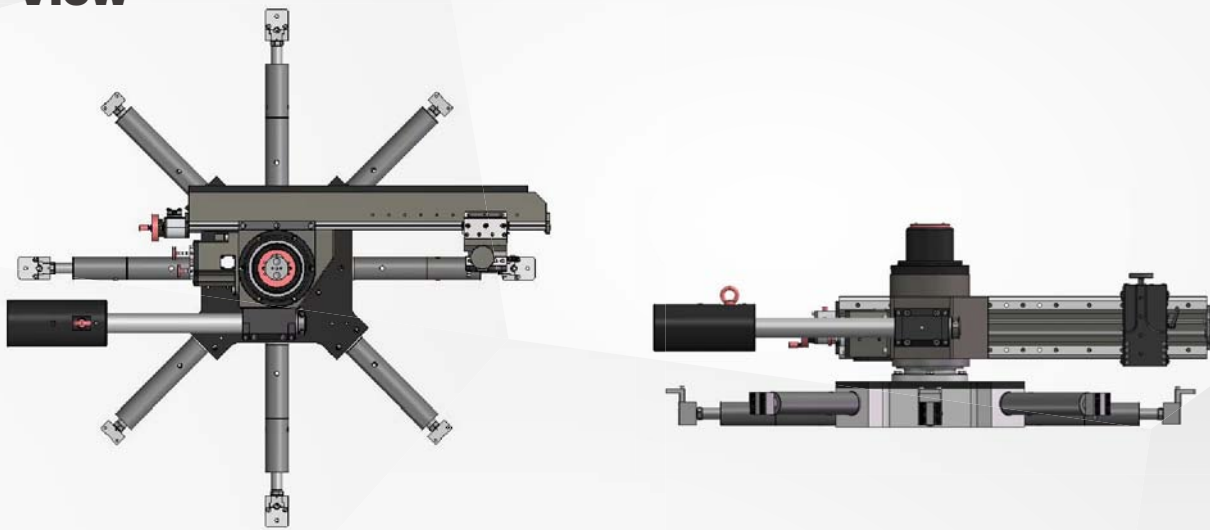
Specifications

Min. Facing Dia.	320mm / 12.60"
Max. Facing Dia.	1500mm / 60"
Min. Clamping Dia.	290mm / 11.40"
Max. Clamping Dia.	1450mm / 57.08"
Tool Post Travel	40mm / 1.57"
R.P.M	Max. 20
No. of Feed Setings	6
Driven	MODEC-Pneumatic
Air Supply	3000L/Min@0.6Mpa
Motor Power	4HP
Machine Weight	220 Kgs (With one base)
Shipping Weight	500 Kgs
Shipping Dimensions	1480*750*880mm

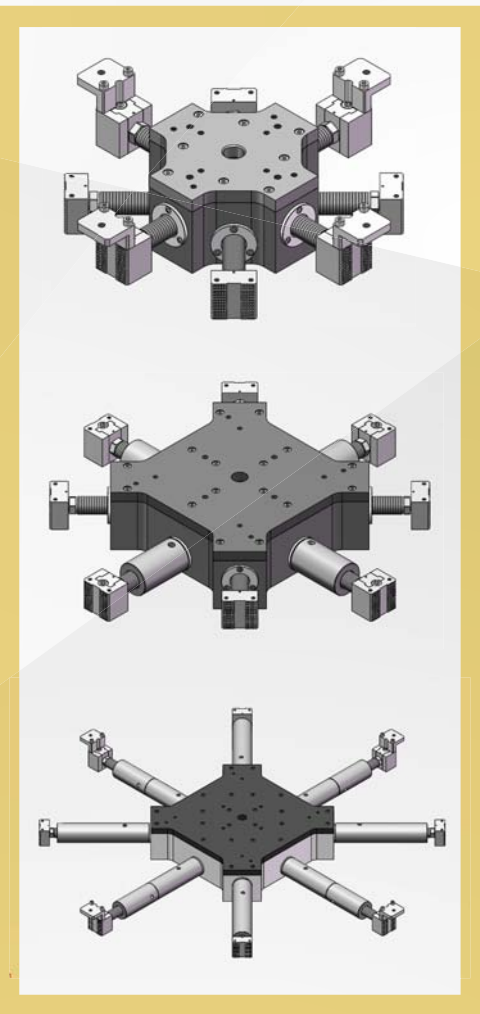
Standard Supply

Main Body-c/w Motor	Full set Clamping Screws
S- Base	Full set extensions
M-Base	Full set hand tool
L-Base	Air motor lubricating oil
Tool Post	Air Filter Lubricator-SMC
Extension Tool holder	Hose connection
Cutting tips - 5 pcs	Dia Gauge
Counterweight	Stroage / Shipping case
Counterweight plate	Manual
Extension nut	

View



3 sized quick set independent bases for improved on-site operation
View of the 3 bases assemblies provided



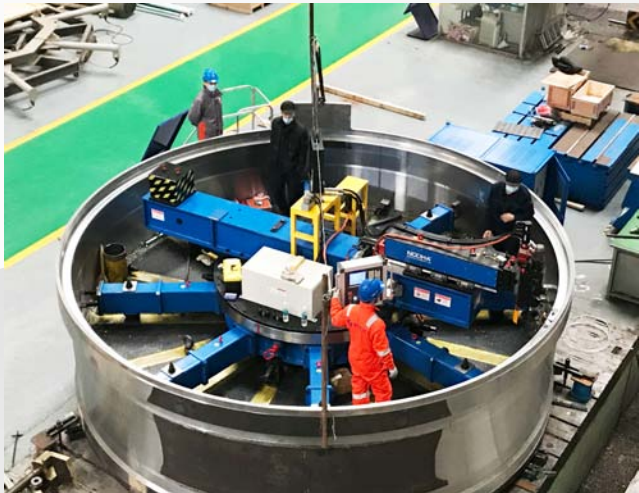
Facing Feed Rates & Grooves per Inch				
Direction	Gear	mm/rev.	Inches/rev.	Grooves/Inch
In	1	0.1935	0.0076	131
In	2	0.3113	0.0123	82
In	3	0.6718	0.0264	38
Out	1	0.1430	0.0056	178
Out	2	0.2300	0.0091	110
Out	3	0.4964	0.0195	51

Boring Feed Rates			
3 off up/down	Gear	mm/rev.	Inches/rev.
In	1	0.0538	0.0021
In	2	0.0865	0.0034
In	3	0.1866	0.0073
Out	1	0.0397	0.0016
Out	2	0.0639	0.0025
Out	3	0.1379	0.0054

FM-CNC8000 Flange Milling Machine

Three-axis linkage
Ultra-high precision

Some large hydropower project, the nuclear power project, oil engineering and offshore engineering projects always require large structure welding assembly on site, because the welding deformation will directly affect the fit precision of key parts. This FM-CNC8000 is customized by CFHI for the large flange plane milling at the scene. The equipment using three axis CNC system control, hydraulic drive main shaft, can complete the plane milling, seal groove processing, counterboring, etc



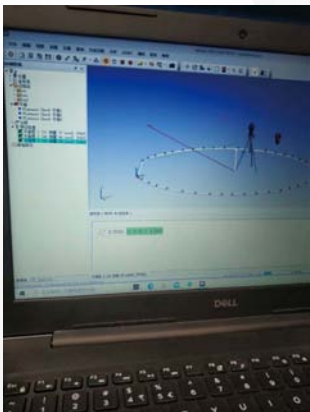
Characteristic

- Adopt modular design, support legs and tool arm detachable, convenient storage and transportation, can be quickly assembled on site
- High precision preloading bearing, high rotation precision, ensure smooth processing process
- The chassis and support legs are equipped with radial and axial fine-tuning functions for accurate correction
- Can be installed horizontally, vertically and upside-down.
- Has mechanical and electrical safety locking function and is suitable for a variety of working conditions
- With the function of plane milling, counterboring, convex processing and seal groove machining
- Three-axis CNC feed system, can realize programming linkage, can accurately control the feed, precision 0.005mm
- The milling spindle is hydraulically driven and can work continuously for days
- Hydraulic station remote control and CNC panel control, more flexible and reliable

Machining Results- By API Laser tracker



Measured at 30 locations



Flatness: 0.08mm



Cylindrical Roughness: Ra1.4



Plane Roughness: Ra1.1

Specifications

Model	FM-CNC8000
Fixed Type	ID Mounted
Clamping Range	Dia. 3800-7800mm
Working Range	Dia. 4000-8000mm
X-axis Rotation Speed	RPM 0-1, Stepless
X-axis Rotation Power	3.0Kw Servo Motor
X-axis Feed	Automatically & Manually, CNC System
Y-axis Travel Stroke	550mm
Y-axis Feed	Automatically & Manually, CNC System, Can be fixed
Z-axis Travel Stroke	Single position: 220mm
Z-axis Rotation Power	1.0Kw
Z-axis Feed	Automatically & Manually, CNC System, Can be fixed
Hydraulic Station Power	11.0Kw
Cutter Dia.	200mm
Milling Depth	1mm
Repeated Positioning Accuracy	Y-axis ≤0.01mm
	Z-axis ≤0.01mm
Machining Linear Speed	500mm/Min
Roughness	Ra1.2
Flatness	Dia. 4000mm, 0.05mm
	Dia. 6000mm, 0.08mm

Nuclear Project Site - South-East China

