



**JOYSUNG**  
Portable Machinery tools solutions

# MFM350 Hand Power Flange Facer

## OPERATING MANUAL



## **Important Notice**

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Joysung Portable Machine Tools leads the way in promoting the safe use of portable machine tools. Safety is a joint effort. As the operator of this machine, you are expected to do your part by scrutinizing the job site and closely following the operating procedures outlined in this manual, your own company rules, and local regulations.

JOYSUNG Portable Machine Tools has made every effort to ensure that the Information given in this technical leaflet and other publications relating to this machine is correct and understandable. However it is acknowledged that there may be errors or omissions in this publication.

The company reserves the right to modify its products without notification and consequently to supply machines that may not be in accordance with the descriptions and procedures within this publication.

The company also reserves the right not to provide updates, corrections or amendments to this publication but will endeavor to keep its customers up to date with all changes that may affect the machine operation or safety.

## Health & Safety at Work Act

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Thank you for using Joysung portable machine tools, this manual describes the machine's function, performance, usage and precautions. The following two points must be understood before using:

- To ensure safety, please read and understand this manual before operating this machine.
- Carry this manual for ready reference.

## Operation Instruction

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Please read the manual before using the machine and check the products according to packing list, be aware of safety cautions, performance of the machine and how to use it.


1. The operator must receive safe operation training before starting his/her work.
2. The operator must wear working suit and protection eye glasses.
3. Before starting the machine, please check the voltage and gas requirement on the data plate is same with the one you will use.
4. Please check whether the clamping system is locked or not before starting the machine.
5. You can only adjust the work piece at free position manually or at low speed, adjusting the work piece at high speed is not allowed.
6. Please do not put your hand or other things near the equipment when starting it up to prevent any injury.
7. The electrical wire shall be far away from high temperature, oily or sharp places.
8. When there is malfunction or abnormal sound, the power supply shall be shut down immediately through remote control and then to start checking and repairing.
9. Do not let the machine operating without anyone watching. Operators can only leave after the machine stop and make sure the power supply is switched off and transmission system is in free position.
10. It is prohibited that the machine is used beyond its working scope, any consequences thus caused is not the responsibilities of our company.
11. The machine could not be run beyond its highest cutting capability, to prevent any damage or human injury.
12. Do not attempt to alter the feeds whilst the machine is rotating.
13. Oil stain and iron dust shall be removed after work is done. And anti-corrosive oil shall be put on the cutting arm and main axis.

# Receiving Your Machine

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### Inspect the machine upon receipt

- 1. Inspect the machine for shipping damage
- 2. Ensure you have received the parts listed on the invoice

	<b>IMPORTANT</b>
	Contact JOYSUNG right away at +86-755 33238068 / sales@dthmachines.com, if there are any errors or questions about this equipment.

3. When unpacking the machine, let the machine rest on 4 inch high blocks to prevent damaging the components.


4. The machine has been coated with a waxy preservative to prevent corrosion during shipping. Clean this substance off the machine with solvent to prevent excess accumulation of dirt.


# Labeling Guidelines


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The purpose of product safety signs and labels is to increase the level of awareness to possible dangers.

Safety Alert Symbols indicate **DANGER**, **WARNING** or **CAUTION**. These symbols may be used in conjunction with other symbols or pictographs. Failure to obey safety warnings can result in serious injury. Always follow safety precautions to reduce the risk of hazards and serious injury.

	<b>DANGER</b>
Indicates a hazardous situation that could be fatal or cause serious injury.	

	<b>WARNING</b>
Indicates a potentially hazardous situation that could be fatal or cause serious injury.	

	<b>IMPORTANT</b>
Indicates a potentially hazardous situation that could result in minor to moderate injury, damage to the machine or interruption of an important process.	

	<b>IMPORTANT</b>
Provides critical information for the completion of a task. There is no associated hazard to people or the machine.	

# Warning Labels

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Read and observe all warning labels.

## Introduction

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JOYSUNG Portable Machine Tools are highly configurable with many options and accessories. This manual covers the use and operation of all of those possible options.

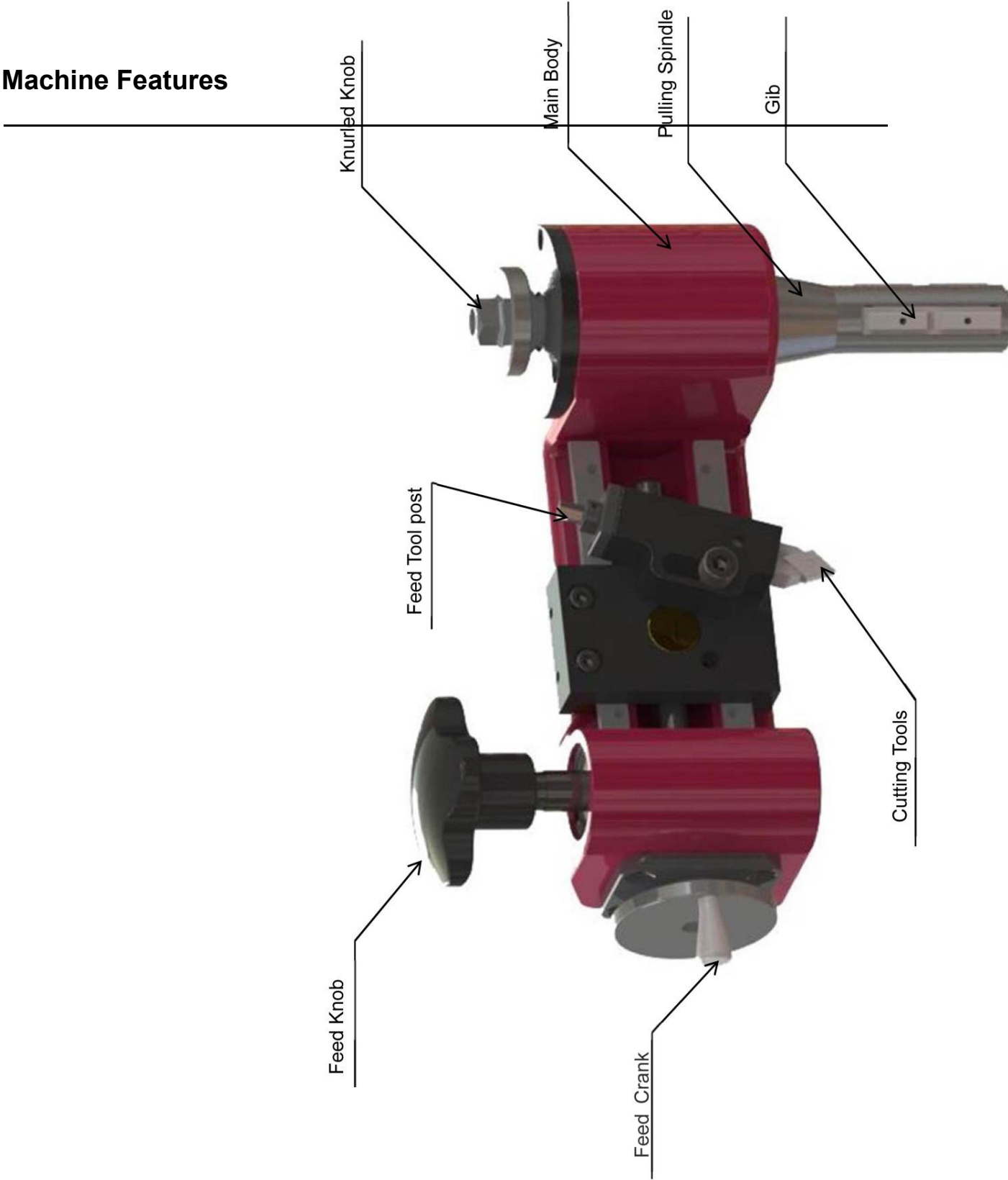
The machine configuration purchased by a customer may not contain all of the options and accessories in this manual. If a specific machine application requires additional options or accessories, please contact a JOYSUNG sales representative at +86-755-33238068 for assistance in obtaining the needed components.

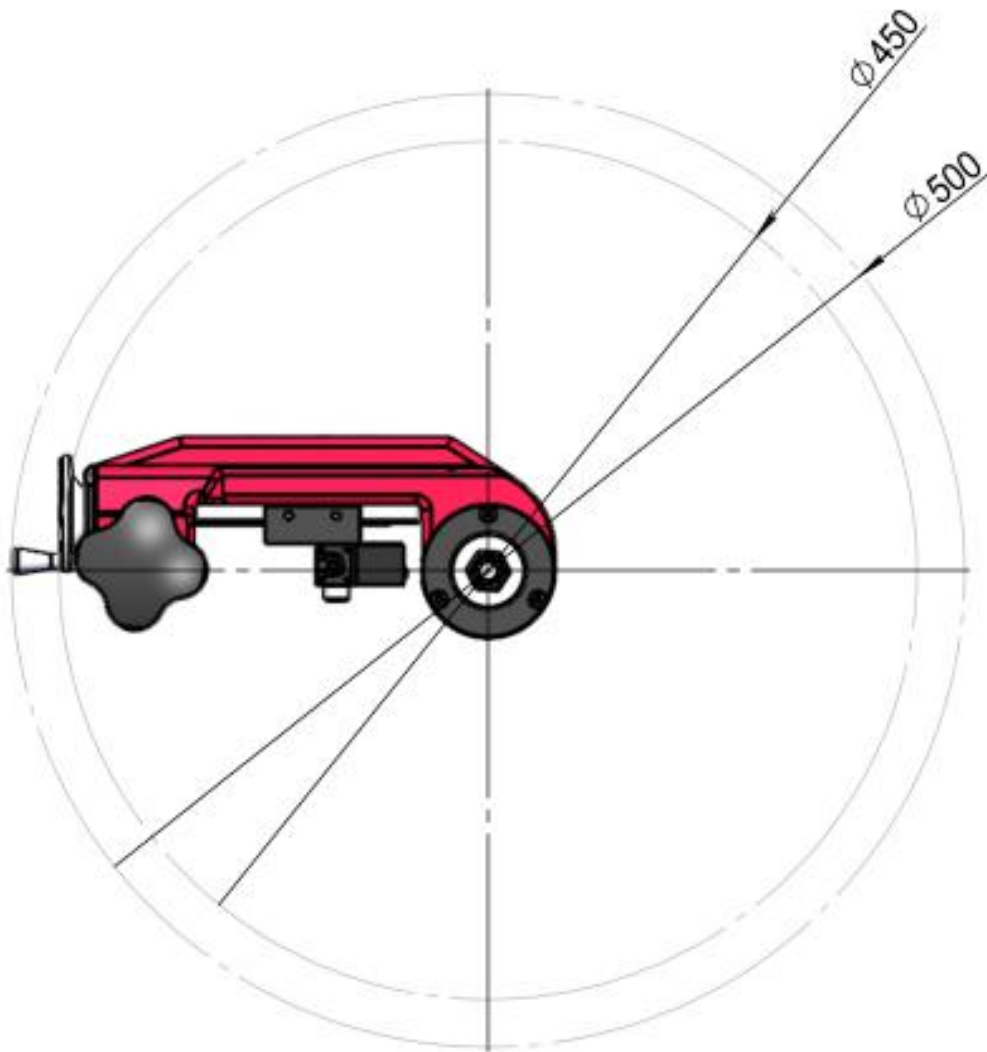
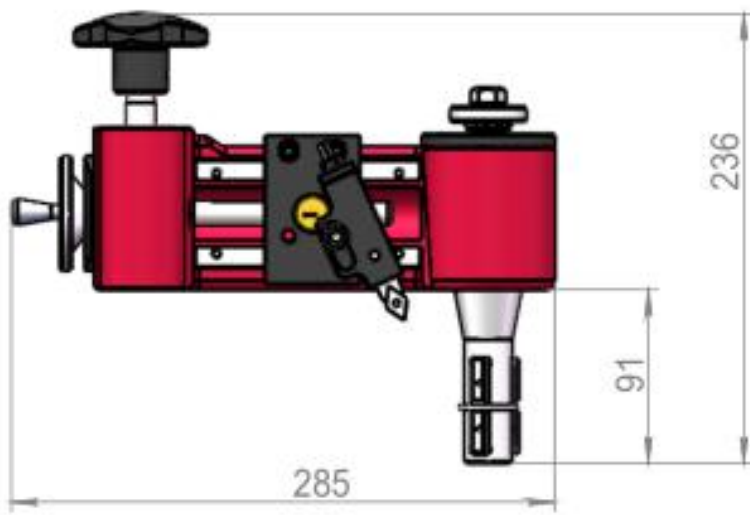
This manual describes the operation and maintenance of your Mini hand power flange facer machine.

All parts meet JOYSUNG Portable Machining Tools strict quality standards. For maximum safety and performance you must read and understand the entire manual before operating the machine.



**Machine Features**





## Set up & Operation

1. Measure the inside diameter of the flange to be machined and ensure this is within the working parameters of the machine.

2. Assemble the appropriate gibs and block as required by the mounting diameter



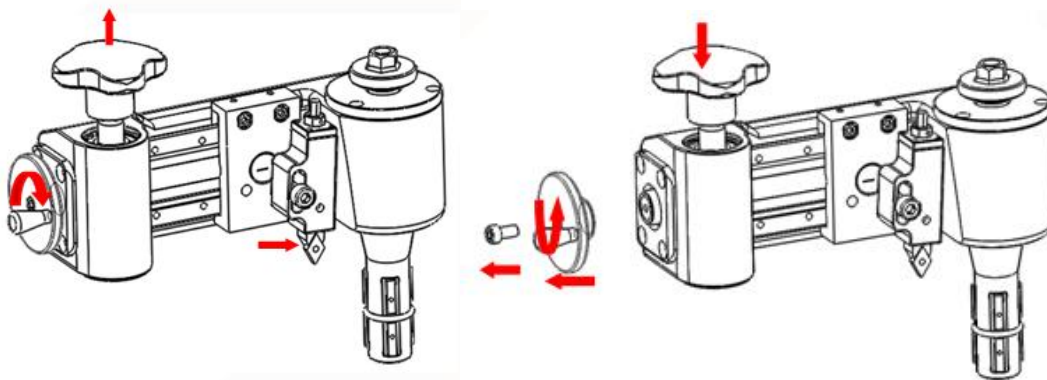
Gib-1 The applicable range is 25.4-30mm, Gib-2 The applicable range is 30-35mm.

5 different size block: 5mm、10mm、20mm、50 mm、100 mm。

Select the desired block of rise depending on the flange diameter。



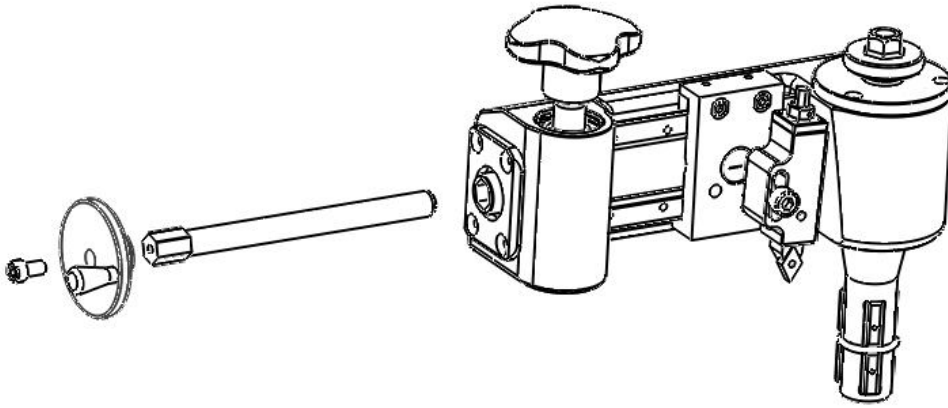
3. According to the processing requirements to select Lead screw, install lead screw.



Step 1

Step 2

Take up the Feed Knob, turn on the feed crank,  
Put the cutter head at end right side, make lead  
screw out off with nut



Step3

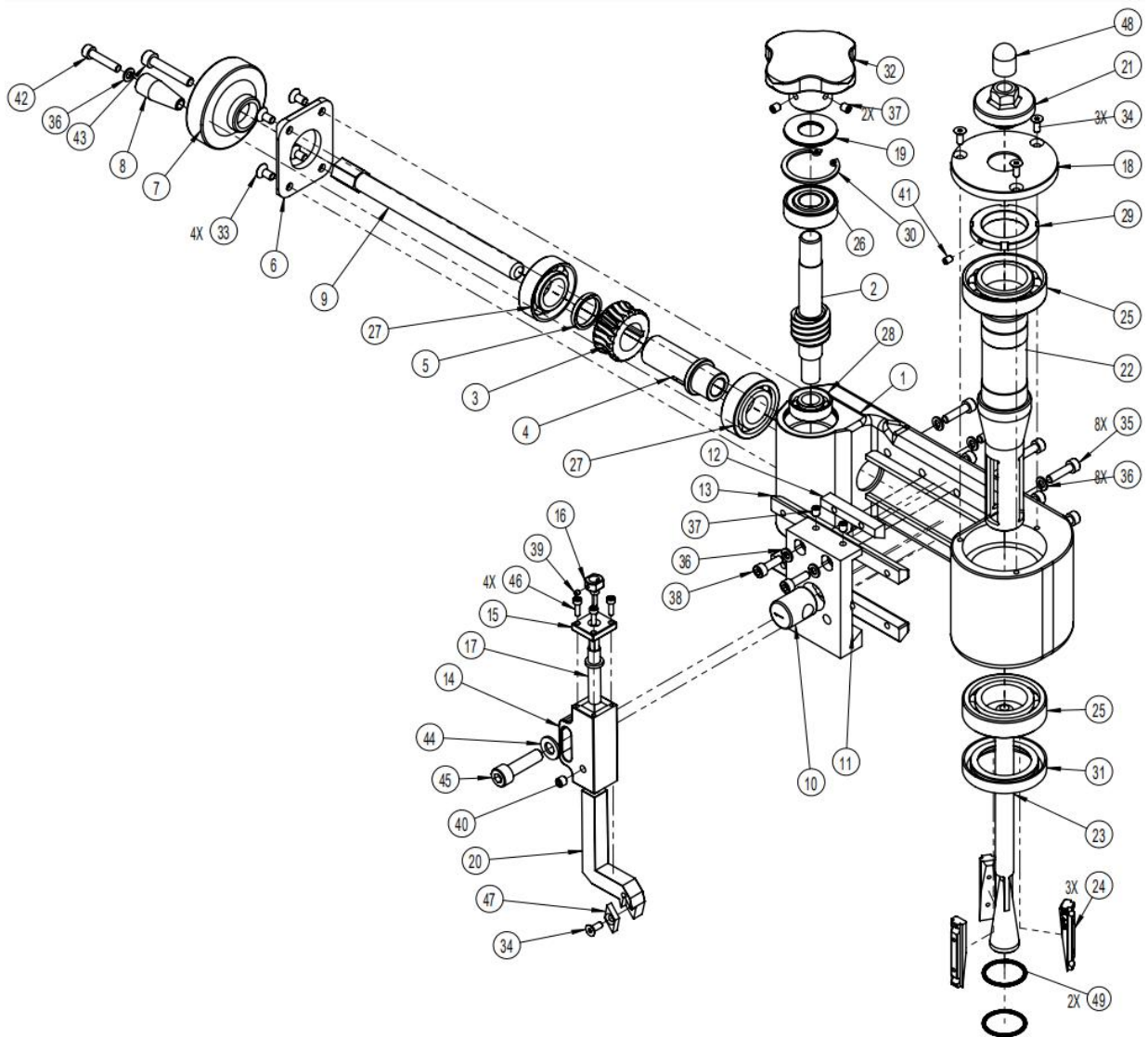
Take out the lead screw and change other one.

4. Insert the conical sleeve into the flange, pull the anchor by pulling the bolt.
5. Rotate the handle to lift the worm and worm gear, shake the Feed rod hand wheel, Place the tool holder in the machining area and adjust the turning angle.
6. Return the rotary lever to start the work.
7. After processing, loosen the tightening bolts, remove the chuck and angle, clean up the iron filings, Into the toolbox.

## Packing List

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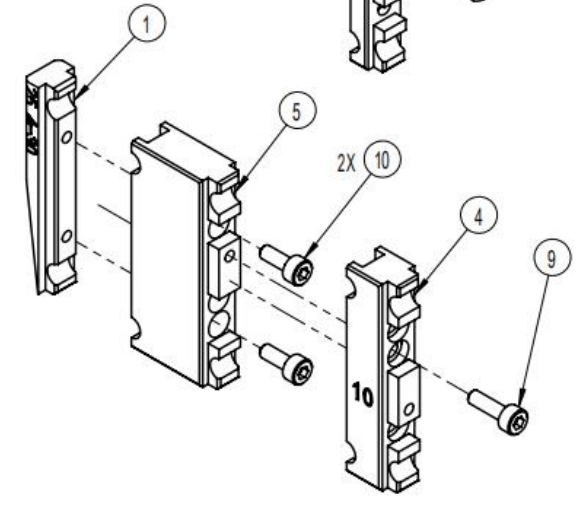
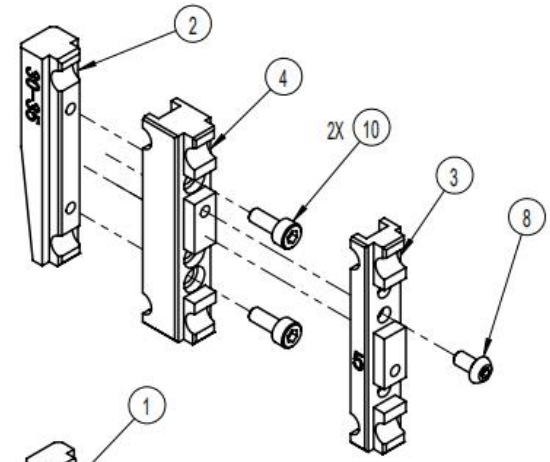
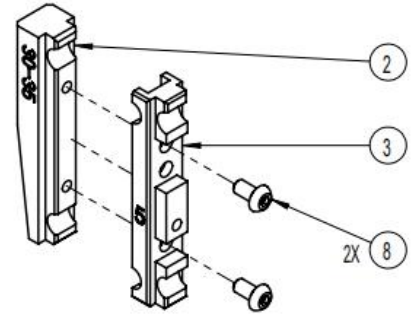
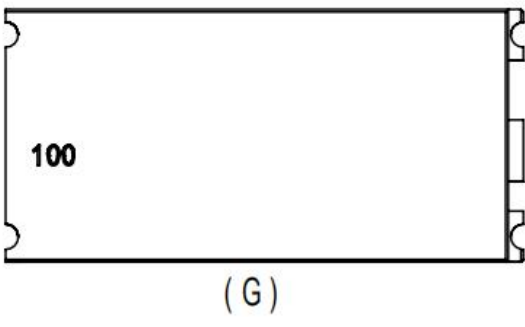
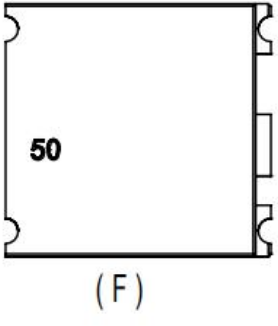
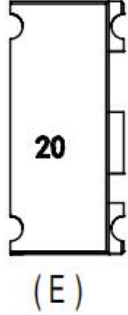
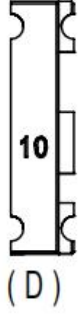
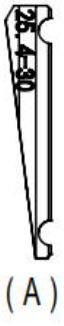
No.	Items	Qty
1	Main body	1 set
2	Lead screw and nut	2 set
3	Gib 1	3 pcs
4	Gib 2	3 pcs
5	5mm Block	3 pcs
6	10mm Block	3 pcs
7	20mm Block	6 pcs
8	50mm Block	3 pcs
9	100mm Block	3 pcs
10	Cutter head	1 set
11	Cutter	1 pcs
12	Tools	1 set
13	tension spring	2 pcs
14	Packing Box	1 set



MFM350 Hand Power Flange Facer Explosive View

Item	Description	Drawing No.	Qty
1	Main body	MFM350-01	1 pcs
2	Worm	MFM350-02	1 pcs
3	Worm Gear	MFM350-03	1 pcs
4	Turbine sleeve	MFM350-04	1 pcs
5	Washer	MFM350-05	1 pcs
6	Side-cap	MFM350-06	1 pcs
7	Handwheel	MFM350-07	1 pcs
8	Handle	MFM350-08	3 pcs
9	Leadcrew	MFM350-09	3 pcs
10	Leadscrew Nut	MFM350-10	1 pcs
11	Sliding plate	MFM350-13	1 pcs

Item	Description	Drawing No.	Qty
12	Swallowtail	MFM350-14	1 pcs
13	Rail	MFM350-15	2 pcs
14	Rotation holder	MFM350-16	1 pcs
15	Rotation holder plate	MFM350-17	1 pcs
16	Nut	MFM350-18	1 pcs
17	Screw	MFM350-19	1 pcs
18	Cover	MFM350-21	1 pcs
19	Dust cover	MFM350-32	1 pcs
20	Holder	MFM350-33	1 pcs
21	Bolt	MFM350-20	1 pcs
22	Spindle Sleeve	MFM350-22	1 pcs
23	Spindle	MFM350-23	1 pcs
24	Gib 1	MFM350-24	3 pcs
25	Bearing	7006AC	2 pcs
26	Bearing	6202-2Z	1 pcs
27	Bearing	7004AC	2 pcs
28	Bearing	7001AC	1 pcs
29	Nut	KM06	1 pcs
30	Retaining ring	A- $\phi$ 35	1 pcs
31	Seal Ring	$\phi$ 35	1 pcs
32	Feed Handle		1 pcs
33	Screw(Flat)	M5-L10	4 pcs
34	Screw(Flat)	M4-L10	4 pcs
35	Screw	M5-L20	8 pcs
36	Washer	$\phi$ 5	11 pcs
37	Set screw(Flat)	M5-L6	4 pcs
38	Screw	M5-L16	2 pcs
39	Set screw(Flat)	M3-L3	1 pcs
40	Set screw(Flat)	M6-L6	1 pcs
41	Set screw(Flat)	M4-L6	1 pcs
42	Screw	M5-L25	1 pcs
43	Screw	M6-L35	1 pcs
44	Washer	$\Phi$ 8	1 pcs
45	Screw	M8-L30	1 pcs
46	Screw	M3-L10	4 pcs
47	Cutter		1 set
48	Protective glue set	M12	1 pcs
49	Ring type spring	$\phi$ 2 x $\phi$ 0.2	2 pcs



Gib - Block Explosive View



Item	Description	Drawing No.	Qty
1	Gib 1	MFM350-24	3 pcs
2	Gib 2	MFM350-25	3 pcs
3	5mm Block	MFM350-26	3 pcs
4	10mm Block	MFM350-27	3 pcs
5	20mm Block	MFM350-28	6 pcs
6	50mm Block	MFM350-29	3 pcs
7	100mm Block	MFM350-30	3 pcs
8	Screw	M3-L6	6 pcs
9	Screw	M3-L10	3 pcs
10	Screw	M3-L8	30 pcs

MFM350 Hand Power Flange Facer Aperture clamping range size specification table		A Gib1	B Gib2	C 5mm Block	D 10mm Block	E 20mm Block	E 20mm Block	F 50mm Block	G 100mm Block
Hole Diameter (mm)	Parts								
25.4 ~ 30	A								
>30 ~ 35	B								
>35 ~ 40	A、C								
>40 ~ 45	B、C								
>45 ~ 50	A、D								
>50 ~ 55	B、D								
>55 ~ 60	A、C、D								
>60 ~ 65	B、C、D								
>65 ~ 70	A、E								
>70 ~ 75	B、E								
>75 ~ 80	A、C、E								
>80 ~ 85	B、C、E								
>85 ~ 90	A、D、E								
>90 ~ 95	B、D、E								
>95 ~ 100	A、C、D、E								
>100 ~ 105	B、C、D、E								
>105 ~ 110	A、E、E								
>110 ~ 115	B、E、E								
>115 ~ 120	A、C、E、E								
>120 ~ 125	B、C、E、E								
>125 ~ 130	A、F								
>130 ~ 135	B、F								
>135 ~ 140	A、C、F								
>140 ~ 145	B、C、F								
>145 ~ 150	A、D、F								
>150 ~ 155	B、D、F								
>155 ~ 160	A、C、D、F								
>160 ~ 165	B、C、D、F								
>165 ~ 170	A、E、F								
>170 ~ 175	B、E、F								
>175 ~ 180	A、C、E、F								
>180 ~ 185	B、C、E、F								
>185 ~ 190	A、D、E、F								
>190 ~ 195	B、D、E、F								
>195 ~ 200	A、C、D、E、F								
>200 ~ 205	B、C、D、E、F								

MFM350 Hand Power Flange Facer Aperture clamping range size specification table		A Gib1	B Gib2	C 5mm Block	D 10mm Block	E 20mm Block	E 20mm Block	F 50mm Block	G 100mm Block
Hole Diameter (mm)	Parts								
>205 ~ 210	A、E、E、F								
>210 ~ 215	B、E、E、F								
>215 ~ 220	A、C、E、E、F								
>220 ~ 225	B、C、E、E、F								
>225 ~ 230	A、G								
>230 ~ 235	B、G								
>235 ~ 240	A、C、G								
>240 ~ 245	B、C、G								
>245 ~ 250	A、D、G								
>250 ~ 255	B、D、G								
>255 ~ 260	A、C、D、G								
>260 ~ 265	B、C、D、G								
>265 ~ 270	A、E、G								
>270 ~ 275	B、E、G								
>275 ~ 280	A、C、E、G								
>280 ~ 285	B、C、E、G								
>285 ~ 290	A、D、E、G								
>290 ~ 295	B、D、E、G								
>295 ~ 300	A、C、D、E、G								
>300 ~ 305	B、C、D、E、G								
>305 ~ 310	A、E、E、G								
>310 ~ 315	B、E、E、G								
>315 ~ 320	A、C、E、E、G								
>320 ~ 325	B、C、E、E、G								
>325 ~ 330	A、F、G								
>330 ~ 335	B、F、G								
>335 ~ 340	A、C、F、G								
>340 ~ 345	B、C、F、G								
>345 ~ 350	A、D、F、G								



# JOYSUNG

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