Inverted Boring Bar Setup

- Drive Motor 115 or 240 volt
- Drive Gearbox
- Clamp Bar
- Dual-port chrome plated Boring Bar
- Clamping Screw with Captive Nut; reversible for best access to socket head
- Inverting support moves it closer to bore to be machined providing more rigid support and better machining
- (3) Side Adjustment Screw
- (4) Leveling Screw
- (2) Universal Support #K94.30 (inverted)
- (2) Adjustable Sub-Plate #K94.21 (optional)
Bore Welder Center Support

**Typical Repair Sequence**
1. Align Boring Bar using cones for centering
2. Attach Bearing Supports
3. "Skin cut" bores to clean and make round
4. Remove Boring Bar leaving Supports in-place
5. Plug-in BoreWelder to Universal Support
6. Build up bores using BoreWelder
7. Remove BoreWelder
8. Reinstall Boring Bar
9. Machine bores to desired size
BarDrill Setup

- Drive Motor 115 or 240 volt
- Pilot Hole Drill w/ #3 Morse Taper
- Manual Feed Wheel
- Automatic Feed Rate Control
- Drive Gearbox
- Dual-port chrome plated Boring Bar w/number 3 Morse Taper for inserting Drills or Drill Chucks
- Dual Support #K94.32; Typical uses: BarDrill as shown - Blind holes - Extra bar support
- Adjustable Sub-Plate #K94.21
Universal Support Kits K94.30 & K94.32
Mount Configurations

K94.30
Standard Support Setup
- Outer Mounting Surface
- Universal Offset Body
- Captive Clamp Nut
- Reversible Clamp Bolt
- Hold-Down Stud
- Clamping Surface
- Inner Mounting Surface
- (4) Leveling Screws

TYPICAL USES/FEATURES
- Standard Single Support
  - Most outboard locations
  - Where bore is near mounting surface
  - Mount drive on either Outer or Inner Mounting Surface
  - Supports Spherical Bearing

Inverted Single Support
- Use when bore is inboard from mounting surface
- Mount drive on either Outer or Inner Mounting Surface
- Supports Spherical Bearing

Double Support
- Use when extra bar stiffness is needed, such as blind holes or bores located far from support
- Can be used as a drill press with special Morse Taper Bar
- Mount drive or bearing at either clamping location

Reversible Clamp and Joining Bolts
- Allows access to bolt head from either side
- Clamp Nut captive on either side so second wrench not needed

(3) Joining Bolt

K94.32
Dual Support Setup
- Spherical Bearing
- (4) Leveling Screws
- (3) Captive Joining Nut

Anchor Point (normally weld or use #K94.21 adjustable support)
Spider Support K94.51
Mount Configurations

Attachment Radius
2.9”(73mm)

Clamp Lock Bolt allows
very rigid support

Clamp Surface for
Spherical Plain Bearing
or Drive Gearbox

Tack Weld surface

Level Lock Nut

Leg - Pivot
as needed

Cone Nut Receiver Bevel

Leveling Screw

Max. attachment radius
5.4”(137mm)

Max. attachment radius
6.5”(165mm)

Attachment radius
4.0”(102mm)