ALIGN BORING MEASURING TOOLS

Improving safety *while* increasing production.

Over The Bar Micrometer Range 4.25” to 11.5” **OBM-4510**

The simple solution to large bore measurement. Eliminates the need to remove the boring bar to accurately measure the ID of the bore. Accuracy to one thousands of an inch.

Over The Bar Micrometer Range 8.5” to 29” **OBM-8529**

The over-the-bar-micrometer eliminates the boring bar from the measuring equation. Our model measures the ID of the bore, which is a direct measurement and in turn improves accuracy.

Micro Tool Insert ..... **MTI**

The model MTT micro tool insert fits ~~right~~ into the boring bar or into the boring heads and is designed to facilitate accurate micrometer adjustment of the insert for the finishing cut. The triangular carbide insert is clamped in the valenite E-Z set unit. Using the wrench to adjust the vernier dial provides one tenth of adjustment with a total range of approximately .040”.

Bore Measuring Telescoping Gauge Range 1 3/4” to 6” **TBMT-2300**

The telescoping gauge measures the ID of the bore through an open tool port in the boring bar. It is spring loaded so the operator can get an exact measurement (within .001 per inch) without having to remove the boring bar from the bore.

Bore Measuring Telescoping Gauge **TBMT-2500**

Range is I I /4” to 5”. Designed with hardened measuring tips for rugged durability and consistent accuracy. This superior quality translates into a long-lasting tool and more savings.

Bore Measuring Telescoping Gauge **TBMT-2300-10**

Range is 1 3/4” to 10”. Fits through all makes of boring bars 1/2” and 3/8” tool ports. Variety of range packages to suit your needs.

Dial Tool Adjuster **DTA-2700**

The unique DTA enables you to readjust the tool bit length to within a one hundred of an inch. Using the DTA is easy. Just slip it over the tool bit and rest it against the boring bar. Clamp the tool bit to the DTA by tightening the setscrew. Zero the dial gauge and release the tool bit from the boring bar. Tum the knurled brass nut to pull the tool bit to the desired length. Re-lock the tool bit to the boring bar, release the DTA.

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ALIGN BORING MOUNTING SYSTEMS

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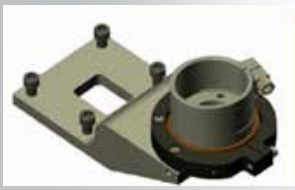
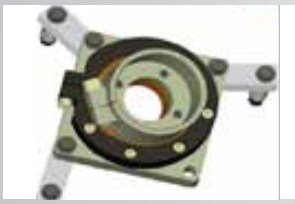


Offset Mount **SCM-2300**

Contains a bronze ball spherical for easy alignment.

Double Bearing Adjustable Mount **DBM-2600**

The machine mount has 3 legs to secure the mount to the work piece. The mount has 2 ball bearings which increase the rigidity of the boring bar. It also has an x & y adjustment.



3-Leg Spherical Mount **SCM-2900**

The machine mount has 3 legs to secure the mount to the work piece. It also has a bronze ball spherical which makes the lining up the boring bar simpler.

Double Bearing Adjustable Support **DBSM-2600**

The support mount has 3 legs to secure the mount to the work piece. It also has 2 ball bearings which increase the rigidity of the boring bar. It also has an x & y adjustment

3-Leg Double Bearing Mount **DBM-2800**

The support mount has 3 legs to secure the mount to the work piece. It also has 2 ball bearings which increase the rigidity of the boring bar. This support does not have an x & y movement.

3-Leg Spherical Bearing Support **TLSM-2900**

The support mount has 3 legs to secure the mount to the work piece. It also has a spherical bearing to help the alignment of the support.

3-Leg Adjustable Spherical Bearing Support **TLASM-2900**

The support mount has 3 legs to secure the mount to the work piece. It also has a spherical bearing to help the alignment of the support. It also has an x & y axis movement for easier bar adjustment.

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ALIGN BORING FACING HEADS

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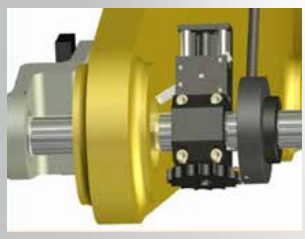

The facing heads are used to machine the outer surface 90 degrees to the bore. Using the same cutting tools for cutting the bores, place them in the tool holder of the saddle. To advance the tool bit along the work face, use the star wheel and the striker ring shown at the bottom of the page. Each time the star wheel hits the striker the tool bit advances approximately three thousands of an inch.

Special Facing Attachment ..... **TM-F-SP, AM-F-SP**

Facing range is from 2” to 10” (50mm to 250mm). The swing diameter is approximately 11”.

Facing Attachment ..... **AM-F, TM-F**

Facing range is from 4” to 12” (IOOmm to 305mm). The swing diameter is approximately 14 1/4”.

22” Facing Attachment **AM-F-422, TM-F-422**

Facing range is from 4” to 22” (IOOmm to 559mm). The swing diameter is approximately 22 1/2”.

Striker Ring **TM-SP-30**

The striker ring is used with the star wheel to advance the tool bit automatically. To advance the tool bit, place the rod into the striker ring and securing it to the work piece. Once the machining is complete, remove the rod and the striker ring will rotate with the facing head. The tool bit will not advance any farther.

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ALIGN BORING OPTIONS

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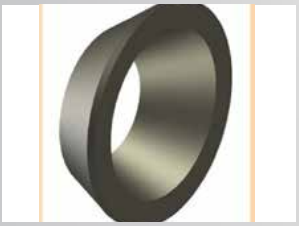
Variable Feed Gear Box VF-2800

The variable feed gear box can be adapted to any electric or hydraulic unit. The feed rate of the gear box is .002, .004 and .006 per revolution. The variable feed will decrease the cutting time for each cut pass.

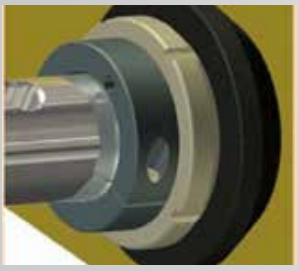
7/8” Boring Bar Kit ..... SE-Kit

The SE-kit reduces the align boring machine to receive a 7/8” boring bar. Available in various packages depending on bar length required. The boring range for SE-kit is from 1” to 2 1/2”. Complete with adapters, set-up cones and chromed boring bar.



Centering Cone Extension LACC-685

Cones are used to center the boring bar to the bores. The LACC-685 extends the cone range from 6” to 8 1/2” diameter.



Cone Tightener LACC-2900, TCC-2900

The cone tightener consists of 3 parts: locking collar, threaded ring and lock nut. To tighten the cones to the bore, place the threaded ring which has the lock nut on it and a locking collar on each side of the cones. Tighten the locking collars in place. Using the supplied spanner wrench, tighten the lock nut onto the cone, which in turn tightens the cones into the bores.

Spider 4 1/2” to 22” IBS-4625

The spider is used when it is impossible to use a bar support. For example, when the bore you are machining is 3’ to 4’ long, you need some type of support, so you would insert a spider in the bore to support the bar.

Follower Rest FR-2600

The follower rest is used when a spider cannot be used because the bore is too small, or when you need a continuous cut for an extended length and you cannot put a support along the bore.

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BoreWelder BOA-408I

The BOA portable bore welder system saves welding time and machining time, with smooth, high quality welding on internal and external diameters. Welding systems range from 1 1/4" to 37" depending on the package required, combined with B&D Manufacturing's mounting systems allow for quick and easy set up.

Grooving Tool

The grooving tool is used to make snap ring grooves in bores. The groove diameter ranges from 2 1/4" to 5 1/4" with a 1 3/4" boring bar. The minimum groove width dimension is 3/32".

Cam Variable Feed

The cam variable feed is a 2-feed system with feed rates of .002 and .004 thousand per revolution. The cam feed system can be adapted to any EV, TM, LM or AM models.

Boring Bar Couplers LAC-200, TC-175, XC-125

Boring bar couplers couple 2 bars together when one bar is not long enough to fit between the bores, thus eliminating a longer, heavier boring bar.

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