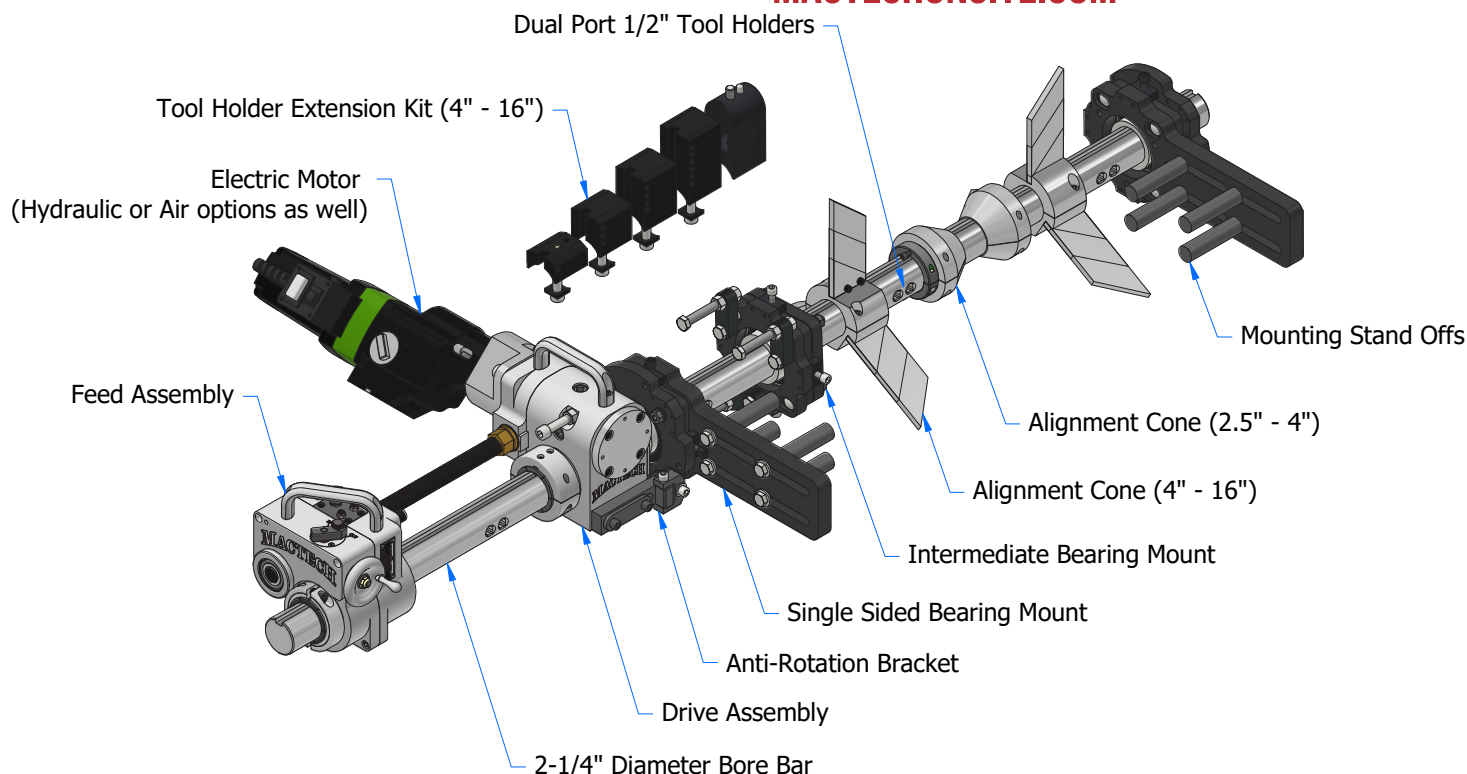


MACTECHONSITE.COM



PRODUCT DESCRIPTION

Save costly shop repairs with fast, accurate, on-site boring, facing, and welding, all with one easy setup. Mactech's simple to operate BB2252 Boring Bar is ready for any bore repair that needs to be done right away. Teamed with our variety of accessories like the Facing Head, 1-1/4" Bar kit, 12-24" Bore kit, Bore Welder, and Tapered Boring Kit; the BB2252 is the versatile solution for many of your on-site repairs. The go-anywhere narrow profile fits in tight work areas. Custom setups are our specialty, give us a call and we will make a system suited just for your application.

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FEATURES

- 4:1 WORM DRIVE FOR QUICK AND POWERFUL CUTTING
- BASE MACHINES 2-1/2" TO 16" DIAMETER BORES
12"-24" KIT EXPANDS TO 24" MAX
1-1/4" BAR ADAPTER KIT EXPANDS TO 1-3/8" MIN
- ADJUSTABLE MECHANICAL FEED RATE
- ADJUSTABLE SWIVEL BEARING MOUNTS
- ALL BARS STRAIGHTENED AND VERIFIED 48" - 144"
- ELECTRIC, HYDRAULIC OR AIR DRIVES
- LIGHT WEIGHT
- TAPERED BORING ACCESSORY AVAILABLE
- FACING HEAD ACCESSORY AVAILABLE

MACTECH INC.
4079 PEPIN AVE UNIT 4
RED WING MN 55066
800-328-1488
INFO@MACTECHONSITE.COM

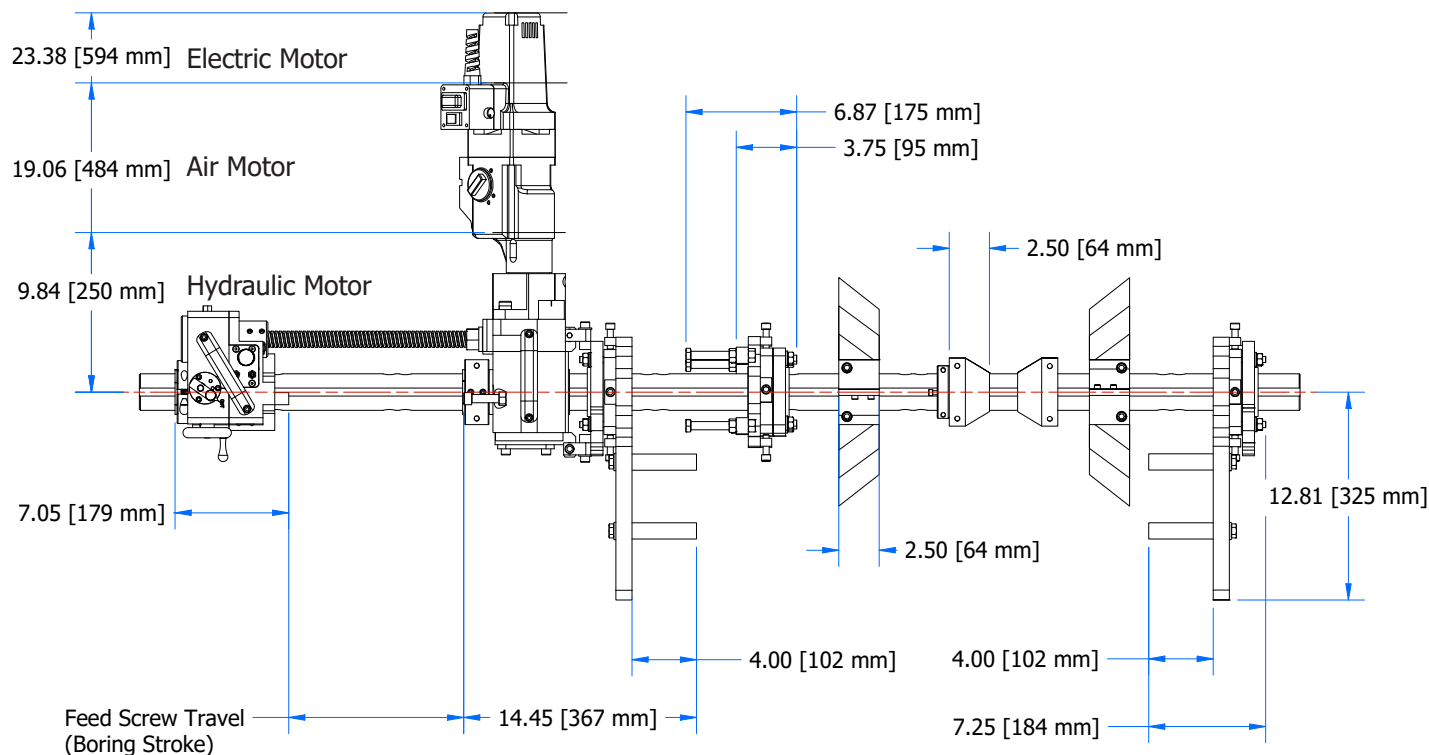
MACTECH OFFSHORE
302 IDA ROAD
BROSSARD LA 70518
337-839-2793
INFO@MACTECHOFFSHORE.COM

MACTECH KENTUCKY
3880 INDUSTRIAL DRIVE
PADUCAH KY 42001
270-442-1559
INFO@MACTECHONSITE.COM

MACTECH WISCONSIN
2515 CLEVELAND AVE
MARINETTE WI 54143
800-328-1488
INFO@MACTECHONSITE.COM

MACTECH INTERNATIONAL
CONTACT US FROM ANYWHERE
AROUND THE WORLD
337-839-2793
INFO@MACTECHOFFSHORE.COM

OPERATIONAL DIMENSIONS



BB2252 SPECIFICATIONS

Cutting Capacity (Base Pkg.)	2.5" - 16" / 64 - 406mm
with 1-1/4" Bar Adapter	1-1/4" - 16" / 32 - 406mm
with 12"-24" Boring Head Package	2.5" - 24" / 64 - 610mm
Tooling	1/2" Sq. Shank
Axial Feed Rate	0-0.031" Rev. / 0-0.7mm

BB2252 FEED SCREW OPTIONS

Boring Stroke (Steel, Acme 1-4 thread double-start feed screw)	12" / 305mm Included in Base Package
	24", 32", 40" Optional 609, 812, 1016mm

BB2252 BAR OPTIONS

Bar Length (2-1/4", 57mm, dual 1/2" tooling port spaced every 8", chrome plated bar)	No Bar Included in Base Package
	48", 72", 96", 120", 144" 1219, 1828, 2438, 3048, 3658mm

BB2252 MOTOR OPTION SPECIFICATIONS

No Motor Included in Base Package

Air Motor	3kW 114-238 bar RPM @ 90psi & 102cfm
Hydraulic Motor(s)	3.6ci, 32-239 bar RPM @ 2-15GPM 5.9ci, 14-147 bar RPM @ 2-15GPM
Electric Motor(s)	21-143 bar RPM, 110v or 220v Four Speed Variable & Reversible

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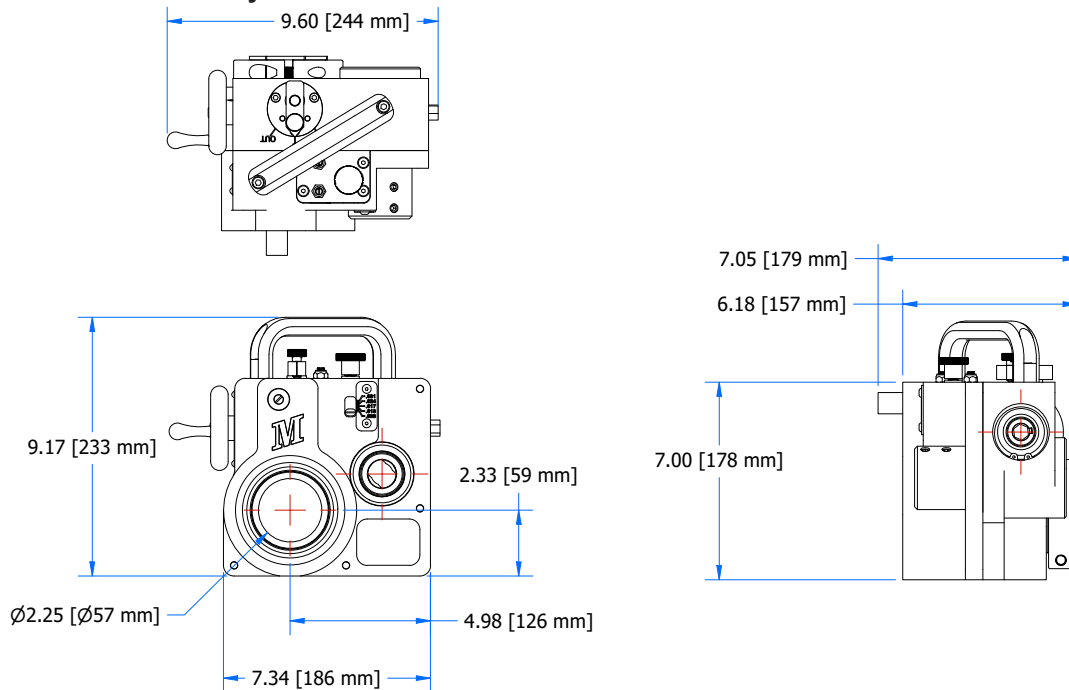
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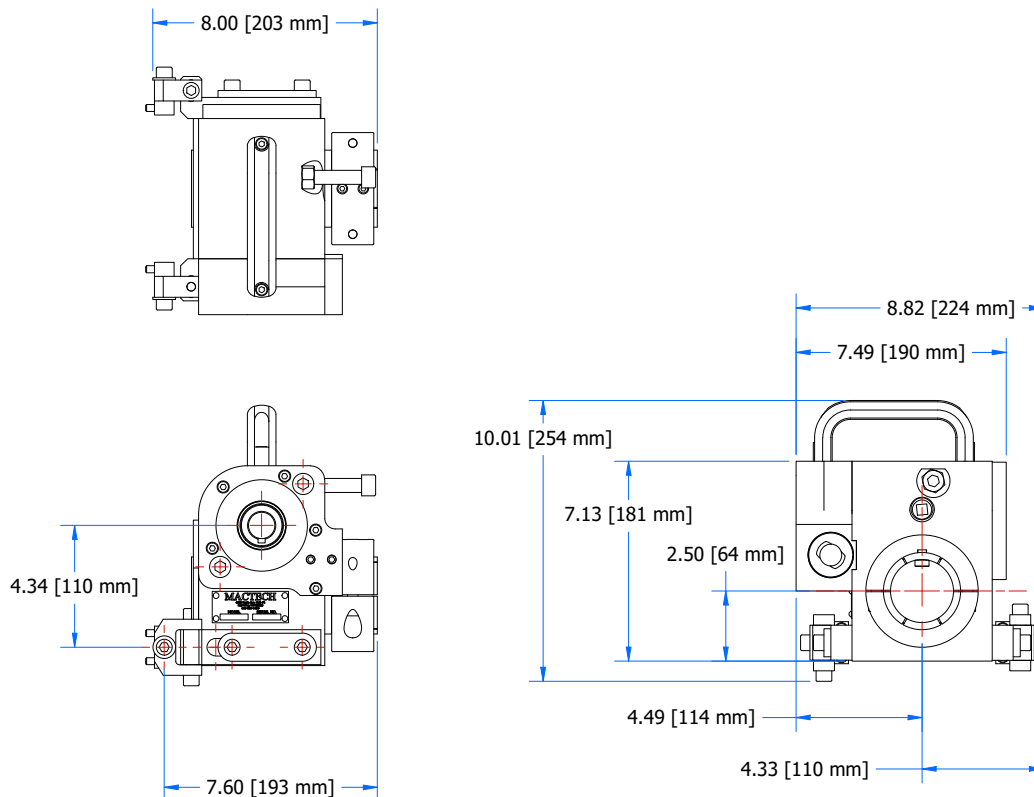
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OPERATIONAL DIMENSIONS - COMPONENTS

600-7038 - BB2252 Feed Assembly



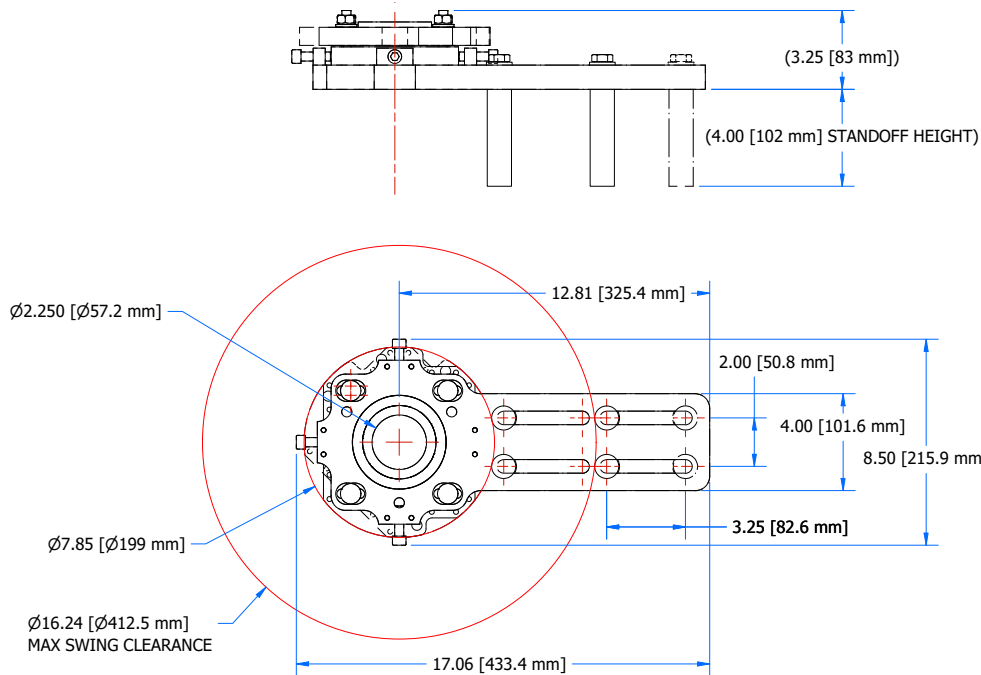
600-7047 - BB2252 4:1 Drive Assembly



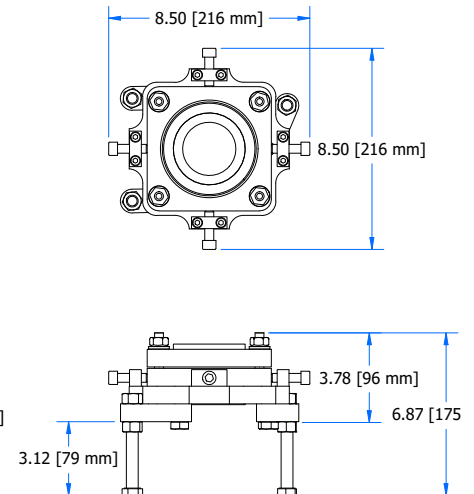
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OPERATIONAL DIMENSIONS - COMPONENTS

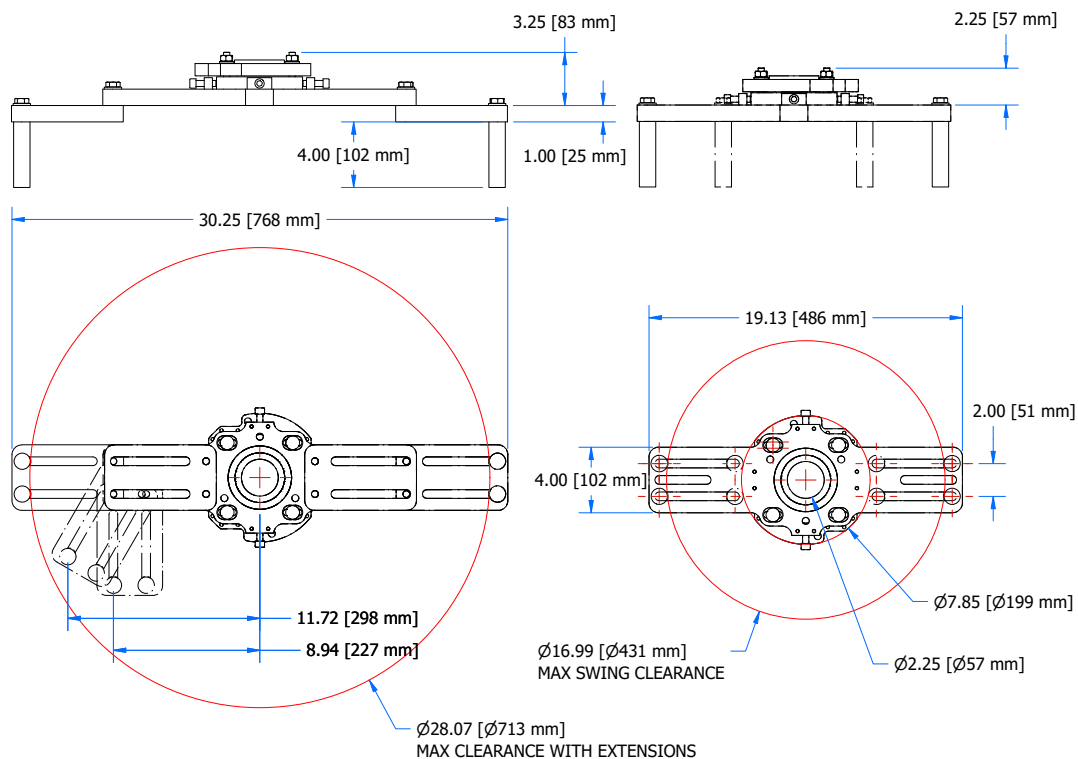
600-7017 - BB2252 Single Sided Bearing Mount



600-7016 - BB2252 Intermediate Bearing Mount



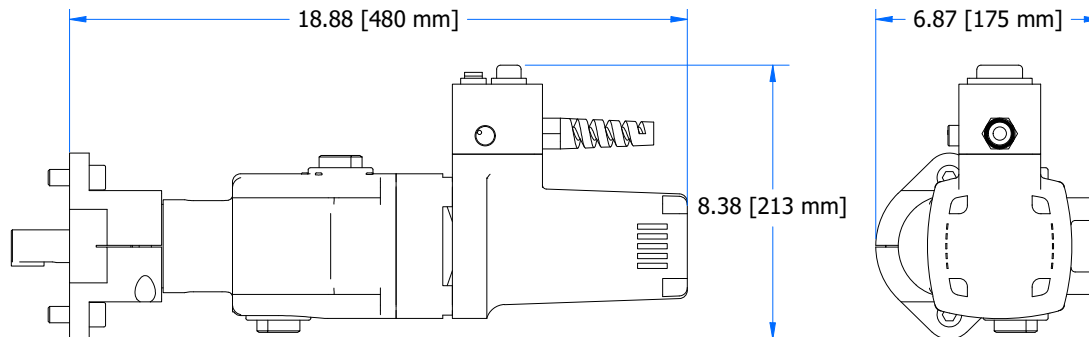
600-7018 - BB2252 Double Sided Bearing Mount



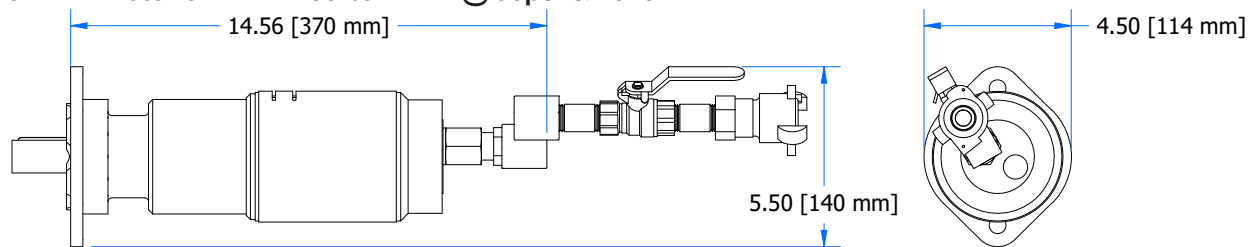
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OPERATIONAL DIMENSIONS - COMPONENTS

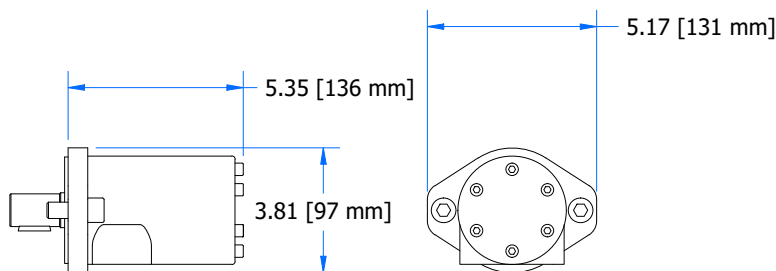
600-6657 / 600-6655 - Electric Motor 21-143 bar RPM, 110v or 220v



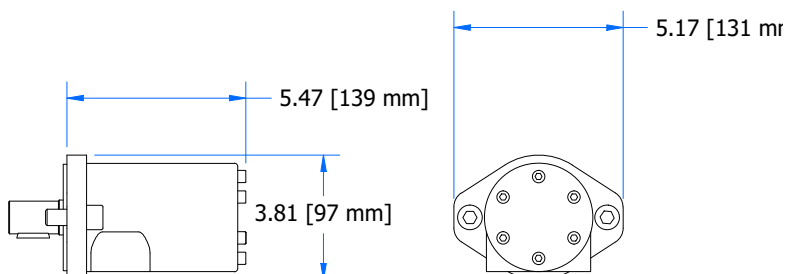
605-6762 - Air Motor 3kw 114-238 bar RPM @ 90psi & 102cfm



600-6763 - Hydraulic Motor 3.6ci, 32-239 bar RPM @ 2-15GPM



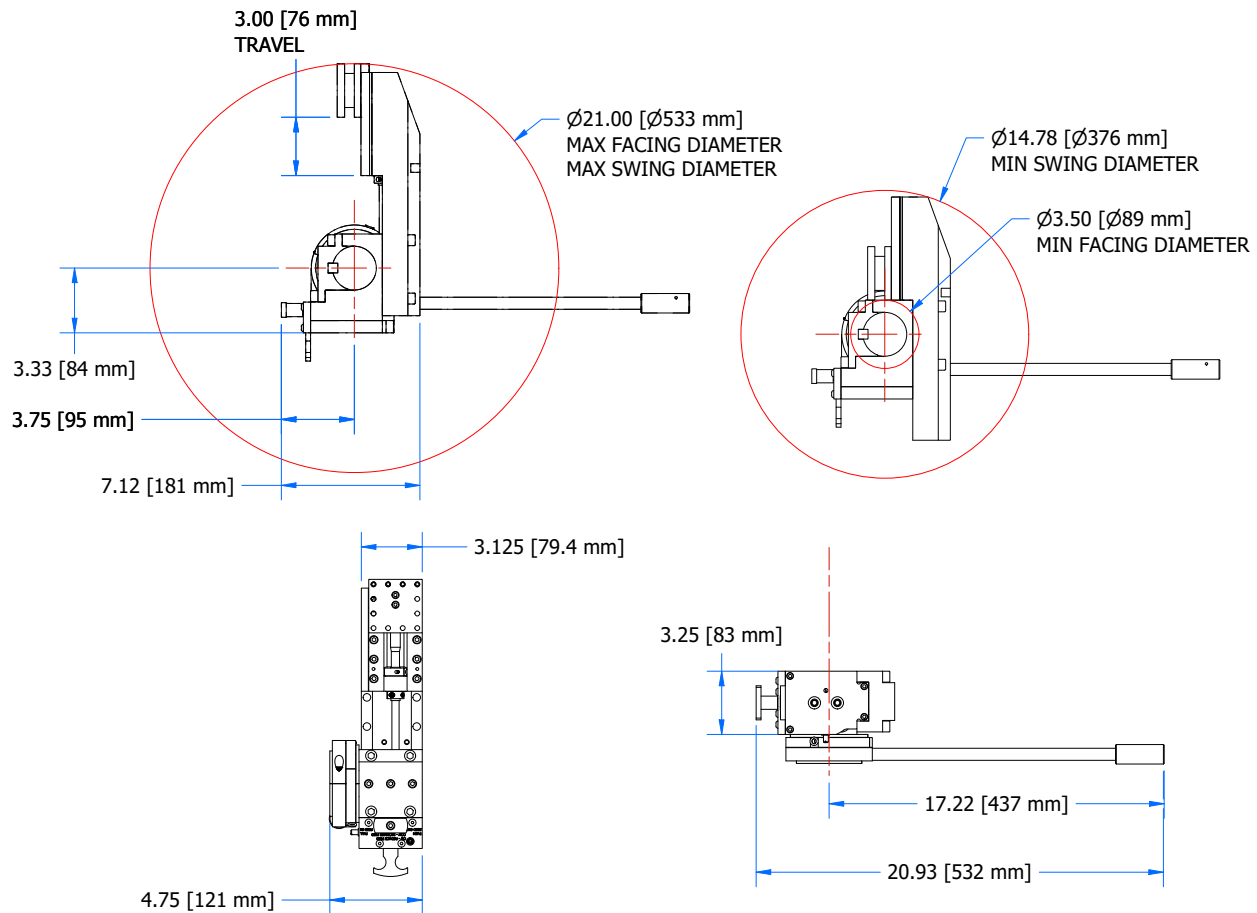
600-6775 - Hydraulic Motor 5.9ci, 14-147 bar RPM @ 2-15GPM



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OPERATIONAL DIMENSIONS - ACCESSORIES

600-7023 - BB2252 Face Head Assembly



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WORK HARD

WORK SAFE

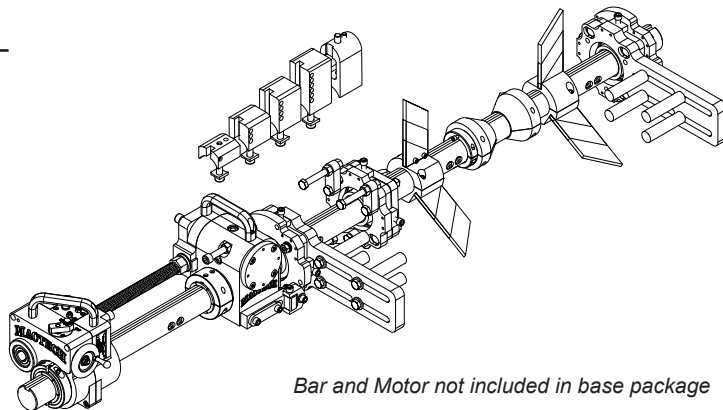
WE BEFORE ME

WELCOME CHALLENGES

WOW THEM

BB2252 BASE PACKAGE

605-7038 Contains: 4:1 Drive Assembly, Feed Assembly, Single Sided Bearing Mount (2), Intermediate Bearing Mount (2), Setup Cone Set (2-1/2" to 16"), Hand Tool Kit, Setup and Operation Manual, Drawing Package, Shipping Crate.



Bar and Motor not included in base package

MOTOR OPTIONS (CHOOSE ONE)

ELECTRIC MOTOR OPTIONS

600-6655 21-143 bar RPM, 220v
(4 Speed, Reversible)

600-6657 21-143 bar RPM, 110v
(4 Speed, Reversible)

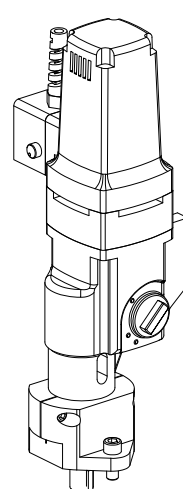
AIR MOTOR OPTIONS

605-6762 3kW 114-238 bar RPM @ 90psi & 102cfm

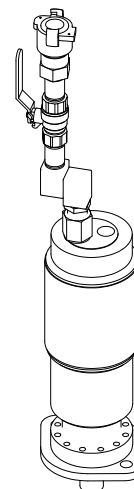
HYDRAULIC MOTOR OPTIONS

600-6763 3.6ci, 32-239 bar RPM @ 2-15GPM

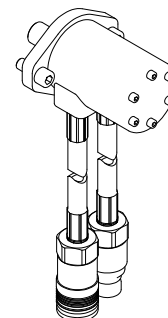
600-6775 5.9ci, 14-147 bar RPM @ 2-15GPM



600-6655 / 600-6657



605-6762



600-6763 / 600-6775

Motor not included in base package

BAR OPTIONS (CHOOSE ONE)

All Bars 2-1/4", 57mm, dual 1/2" tooling port spaced every 8", chrome plated bar

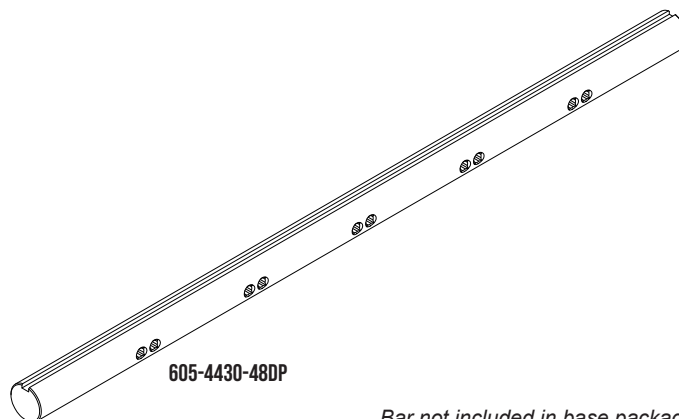
605-4430C-48DP 2-1/4 x 48" Bar Package
(57x1219mm)

605-4430C-72DP 2-1/4 x 72" Bar Package
(57x1828mm)

605-4430C-96DP 2-1/4 x 96" Bar Package
(57x2438mm)

605-4430C120DP 2-1/4 x 120" Bar Package
(57x3048mm)

605-4430C144DP 2-1/4 x 144" Bar Package
(57x3638mm)



605-4430-48DP

Bar not included in base package

ACCESSORIES

620-4456 2-1/4" Boring Bar Coupling
(Couples two bars end to end)

621-1396 Stepped Drive Key for 2-1/4" Bars
with 3/8" keyway

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1-1/4" BAR ADAPTER ACCESSORY

Allows the BB2252 to Utilize 1-1/4" Bars extending boring range to a minimum of 1-3/8" (35mm)

600-7064 BB2252 2-1/4 To 1-1/4 Bar Adapter Set

1-1/4" BARS

605-4454C-48DP 1-1/4" X 48" Bar Package

620-4454C-72DP 1-1/4" X 72" Bar Package

620-4454C-96DP 1-1/4" X 96" Bar Package

TOOLING

TOOL HOLDERS

605-4010 2-1/4" Boring Bar Tool Holder Set 4" To 16"
(Included in 600-7067 / Base Pkg.)

605-7053 BB2252 12" To 24" Boring Head Package

TOOLING

441-AR-8 Brazed Carbide - 1/2 X 1/2 X 3-1/2, RH
(Included in 607-7067 / Base Pkg.)

441-AL-8 Brazed Carbide - 1/2 X 1/2 X 3-1/2, LH

440-0278 Boring / Flange Facing, High Speed Steel, 1/2 SQ RH 90 Degree 4" Long
(Included in 607-7067 / Base Pkg.)

445-8520 Insert Holder – 1/2 SQ Shank, Right Hand, 6" Length, CCMT 09T3 (32.5) Insert (3/8 IC screw-on style insert)

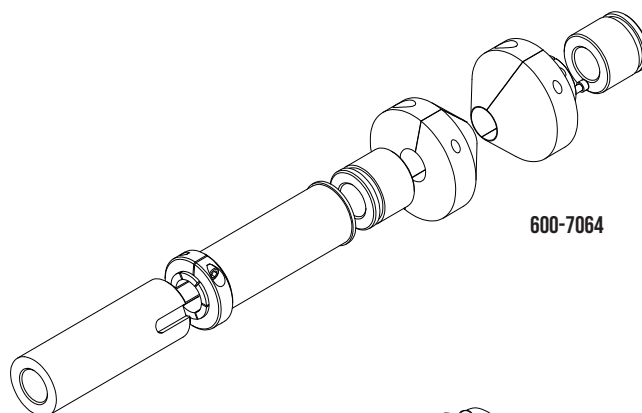
445-8517 Insert Holder - 1/2 Sq Shank, Left Hand, 6" Length, Ccmt 09T3 (32.5) Insert (3/8 IC screw-on style insert)

445-2012 Insert - CCMT32.52 ESU, AC530U (General Purpose Steel Grade)

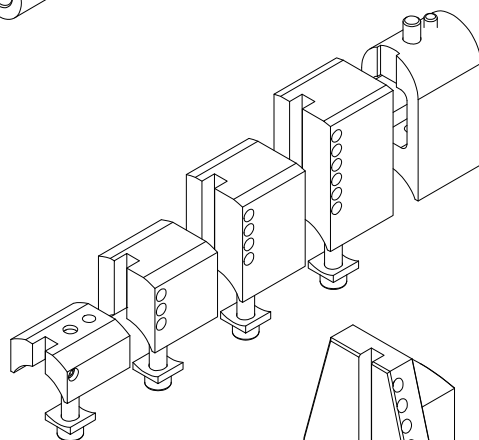
HAND TOOL KIT

Includes: Tool Box, L-Allen Key Set, T-Handle Allen Key Set, Combination Wrenches, Boring Bar Tool Holder Set, 1/2 x 1/2 HSS RH Boring Facing Bit, 1/2 x 1/2 RH Brazed Carbide tool Bit

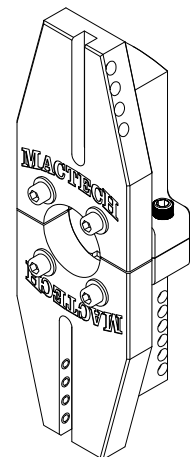
600-7067 BB2252 Hand Tool Kit
(Included In Base Package)



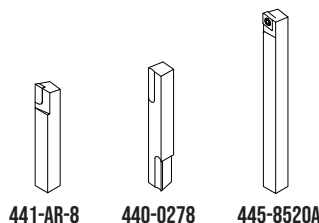
600-7064



600-4010



600-7053



441-AR-8

440-0278

445-8520A

BEARING MOUNTS

Single and double sided bearing mount use 1" steel plates. 4" standoff bars included. Intermediate bearing has 4" adjustable bolt standoffs.

600-7016	BB2252 Intermediate Bearing Mount (Included in Base Package)
600-7017	BB2252 Single Sided Bearing Mount (Included in Base Package)
600-7018	BB2252 Double Sided Bearing Mount

STAND-OFFS

621-1265	2" Weld-On Bar
621-1266	4" Weld-On Bar
621-1267	4" Weld-on Stand-off (Included with Single and Double Sided Bearing Mounts)
621-1353-06	6" Weld-on Stand-off (Longer than 4" req. for Facing Head)
621-1353-08	8" Weld-on Stand-off (Longer than 4" req. for Facing Head)

INTERNAL BEARING MOUNTS

600-6749	2-1/4" Boring Bar Internal Bearing - 5.2" to 16"
626-07-501	2-1/4" Boring Bar Front Adjustable Internal Bearing - 6" To 16"

BAR ALIGNMENT OPTIONS

2-1/2 - 16" Boring Range

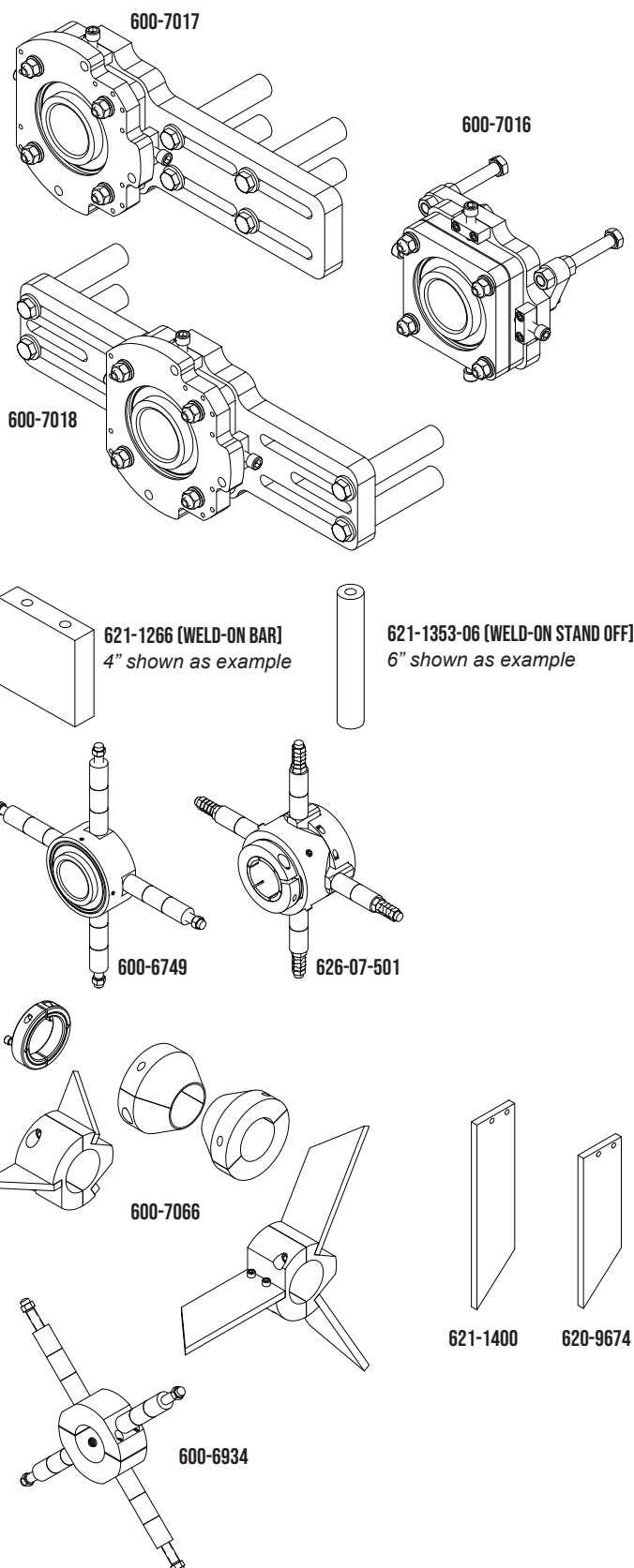
600-7066	BB2252 Setup Cone Set - 2-1/2" To 16" (Included In Base Package)
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16" To 24" Boring Range (Used with 605-7053)

620-9674	16-20 Alignment blade
621-1400	20-24 Alignment blade

Setup Mount (Optional)

600-6934	2-1/4" Boring Bar Setup Spider - 5" To 17-3/16" ID (Setup only, no bearing)
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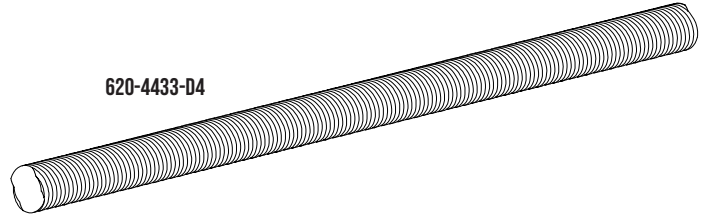


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FEED SCREWS

Axial Feed Rate 0.031" Rev. / 0.7mm

620-4433-D4	1"-4 Double Start Acme Feed Screw, .5 Pitch - 12" Travel / Stroke (305mm) (Included with Feed Assembly / Base Package)
620-4433-D4-24	1"-4 Double Start Acme Feed Screw, .5 Pitch - 24" Travel / Stroke (609mm)
620-4433-D4-32	1"-4 Double Start Acme Feed Screw, .5 Pitch - 32" Travel / Stroke (812mm)
620-4433-D4-40	1"-4 Double Start Acme Feed Screw, .5 Pitch - 40" Travel / Stroke (1219mm)



620-4433-D4

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WORK HARD

WORK SAFE

WE BEFORE ME

WELCOME CHALLENGES

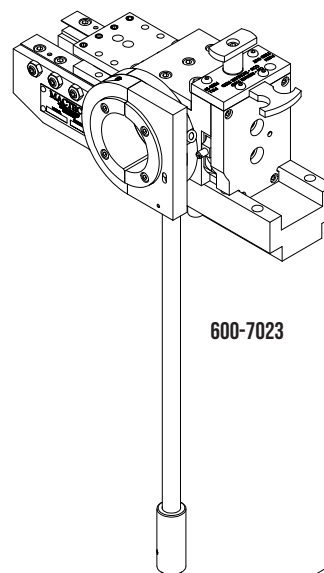
WOW THEM

FACING HEAD ACCESSORY

Facing Range 3.5" - 21" (89-533mm), Variable Feed Rate

605-7023

BB2252 Facing Head Assembly



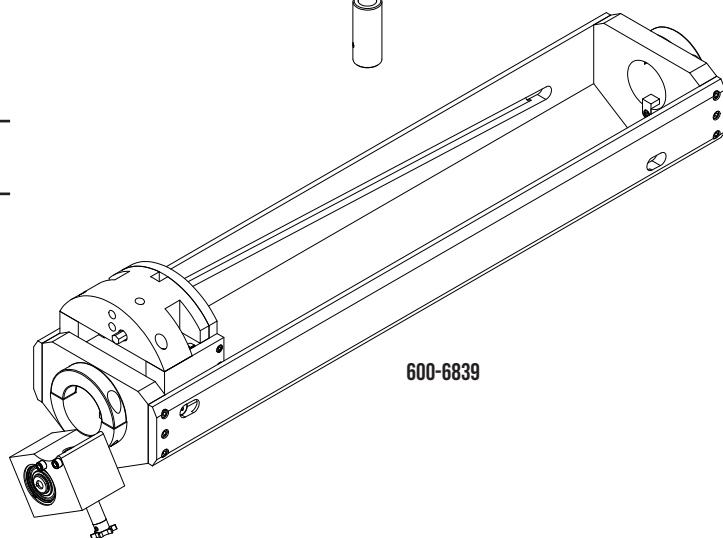
600-7023

TAPERED BORING ATTACHMENT ACCESSORY

7.5"-16.2" (191-410mm) ID Range, 28" (711mm) Travel, Variable Feed Rates

600-6839

Tapered Boring Attachment 2-1/4x28"



600-6839

CONTACT MACTECH FOR MORE DETAILS

BORE WELDER ACCESSORY

Automatic Bore Welding System

600-7057

Bore welder mounting assembly

661-0001

Bore Welder ID Range 0.8-14"
BOA-408i S1

661-0002

Bore Welder ID Range 0.8-21"
BOA-408i S2

661-0003

Bore Welder ID Range 0.8-31"
BOA-408i S3

661-0004

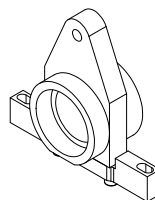
Bore Welder ID Range 0.8-48"
BOA-408i S4

661-0005

Bore Welder ID Range 0.8-48"
BOA-408i S5 w/ Auto-Skip



661-0005



600-7057

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