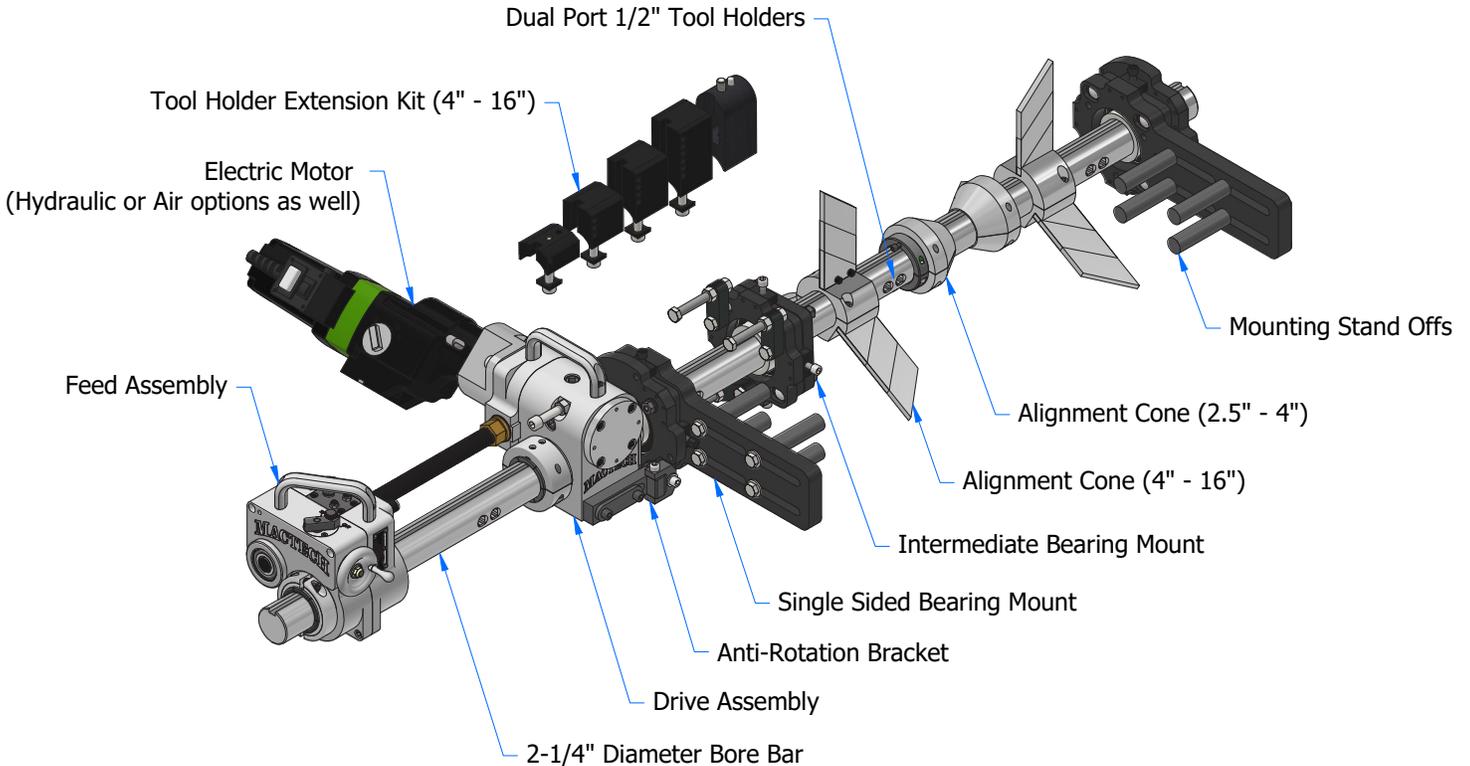


MACTECH

BB2252 BORING BAR SYSTEM

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"
- FEED SCREW BARS AVAILABLE
- HYDRAULIC, AIR, AND ELECTRIC 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
+1-651-388-7117
INFO@MACTECHOFFSHORE.COM

WORK HARD

WORK SAFE

WE BEFORE ME

WELCOME CHALLENGES

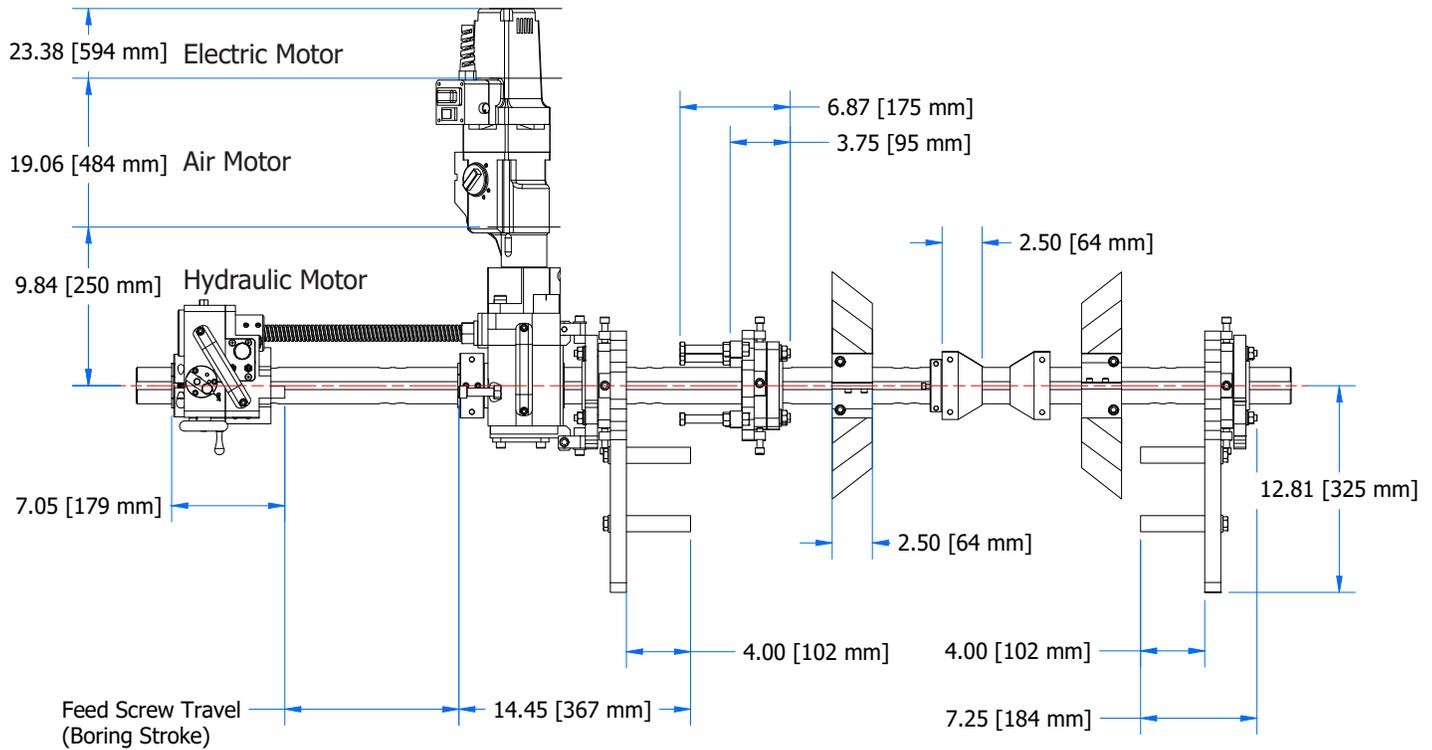
WOW THEM

MACTECH

BB2252 BORING BAR SYSTEM

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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 <i>Included in Base Package</i>
	24", 32", 40" <i>Optional</i> 609, 812, 1016mm

BB2252 BAR OPTIONS

Bar Length (2-1/4", 57mm, dual 1/2" tooling port spaced every 8", chrome plated bar)	<i>No Bar Included in Base Package</i>
	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 <i>Four Speed Variable & Reversible</i>

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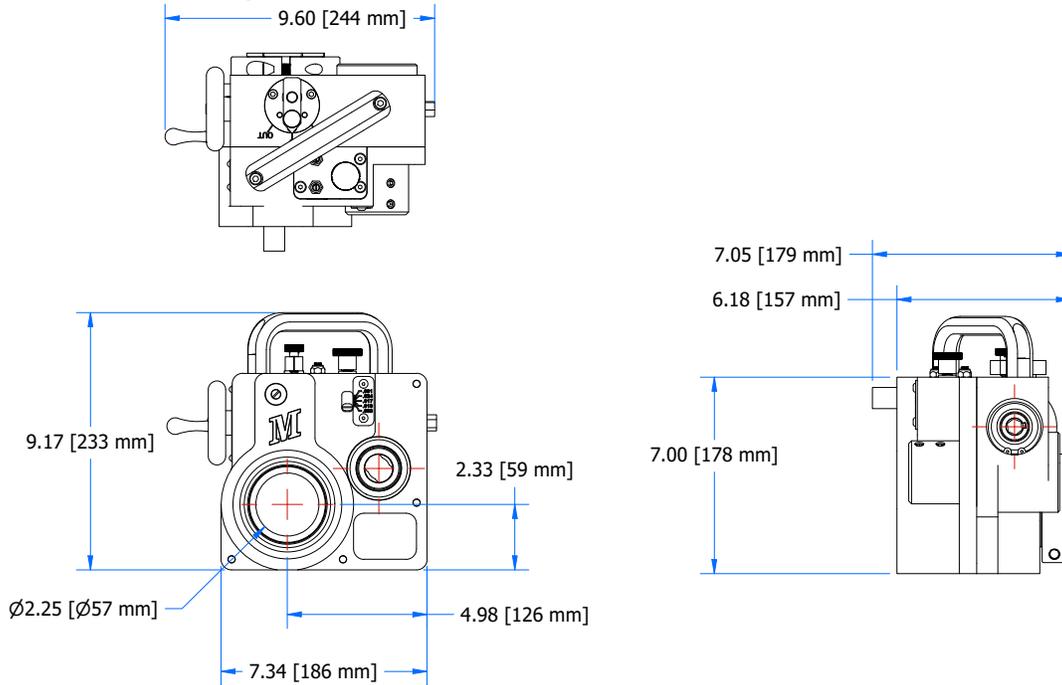
WE BEFORE ME

WELCOME CHALLENGES

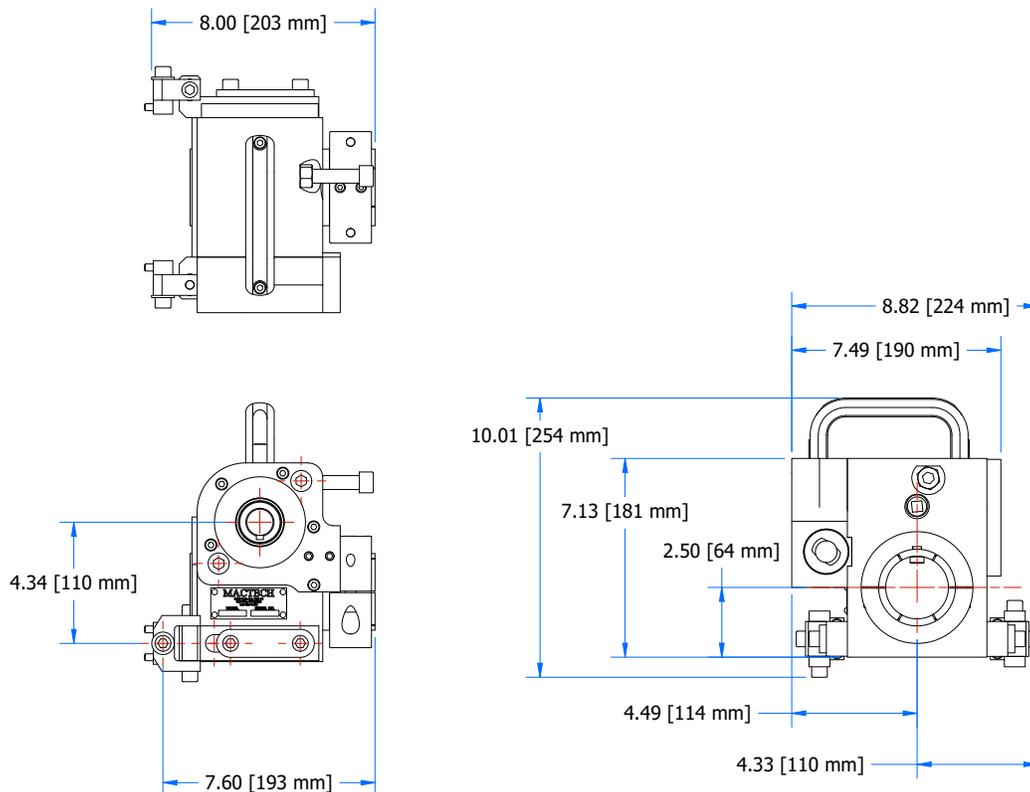
WOW THEM

OPERATIONAL DIMENSIONS - COMPONENTS

600-7038 - BB2252 Feed Assembly



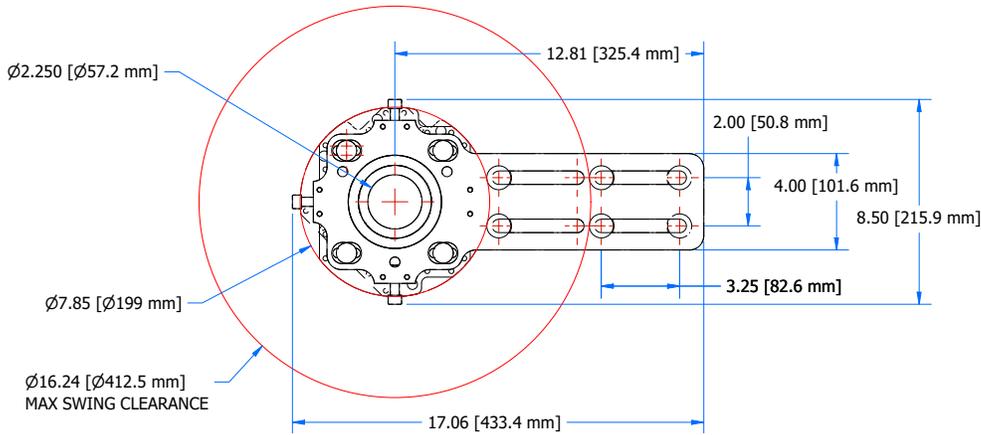
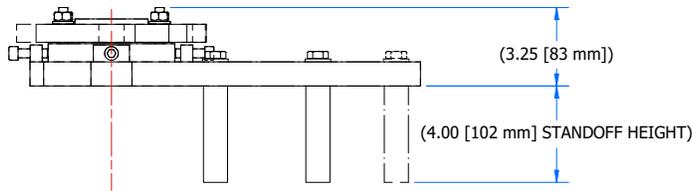
600-7047 - BB2252 4:1 Drive Assembly



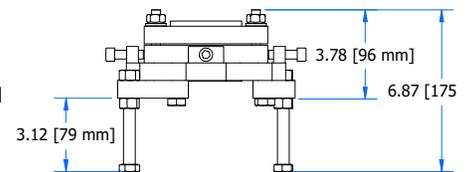
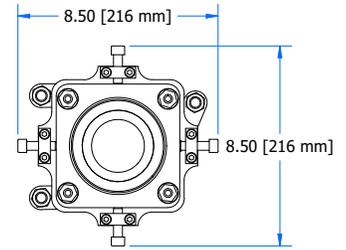
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OPERATIONAL DIMENSIONS - COMPONENTS

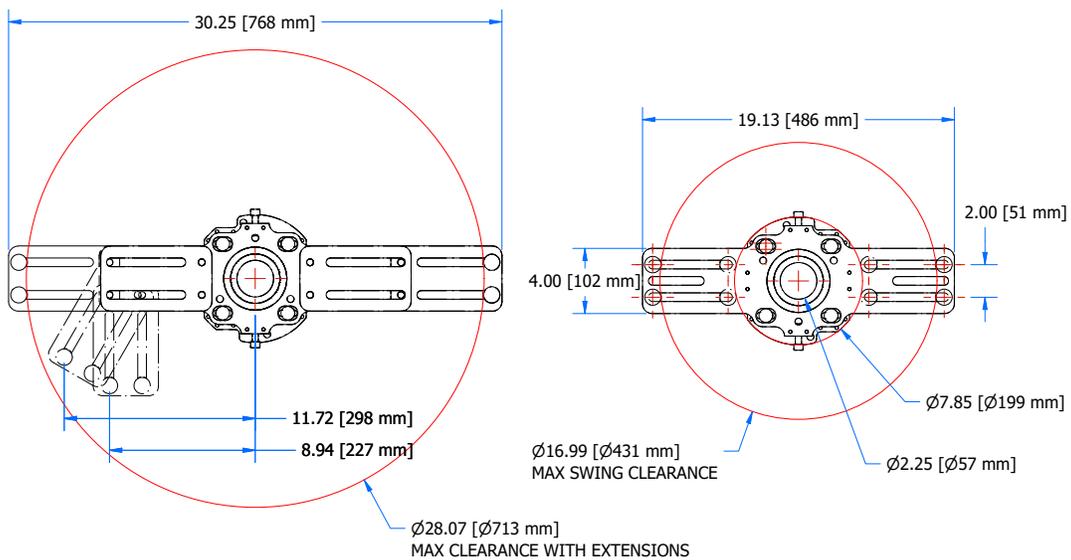
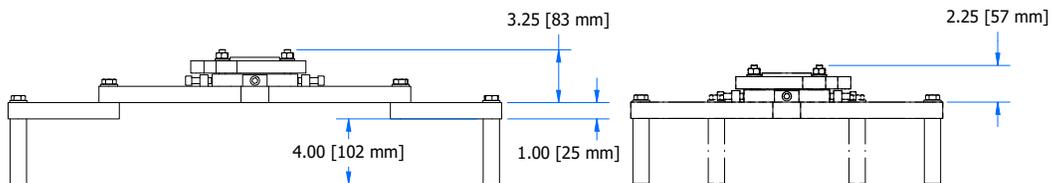
600-7017 - BB252 Single Sided Bearing Mount



600-7016 - BB252 Intermediate Bearing Mount



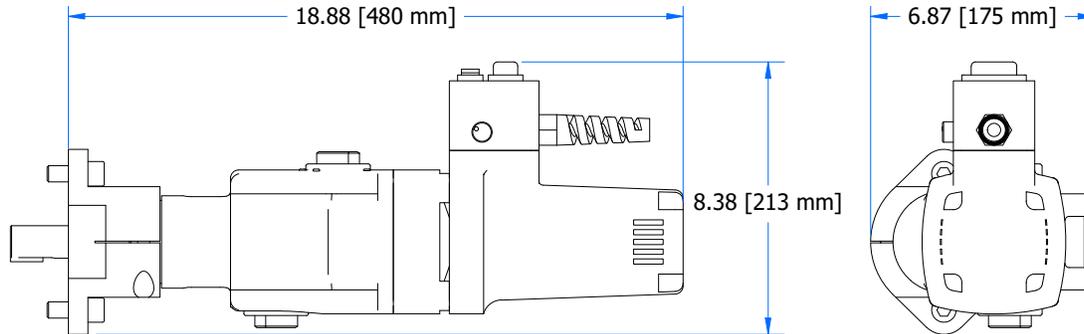
600-7018 - BB252 Double Sided Bearing Mount



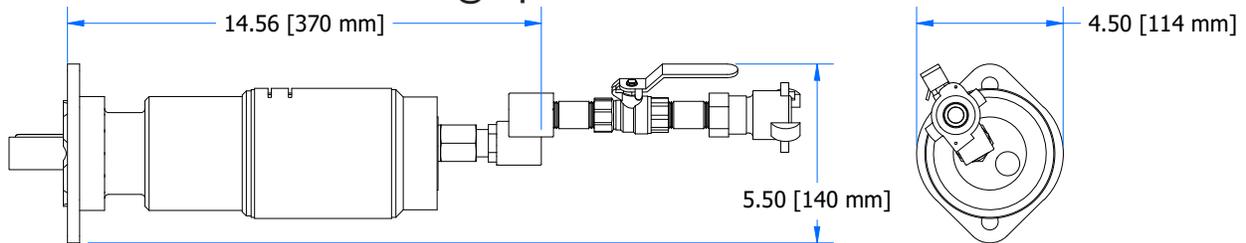
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OPERATIONAL DIMENSIONS - COMPONENTS

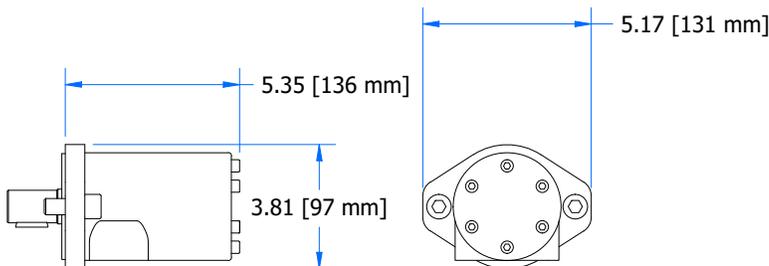
600-6657 / 600-6655 - Electric Motor 21-143 bar RPM, 110v or 220v



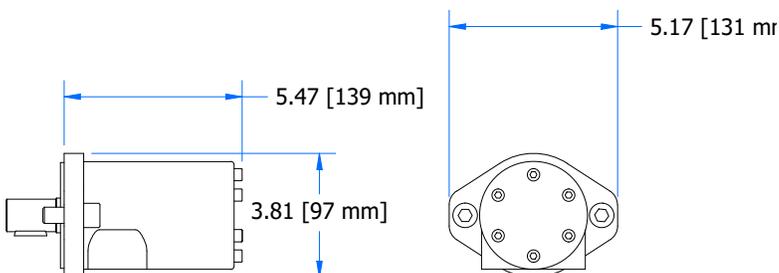
605-6762 - Air Motor 3kw 114-238 bar RPM @ 90psi & 102cfm



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



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

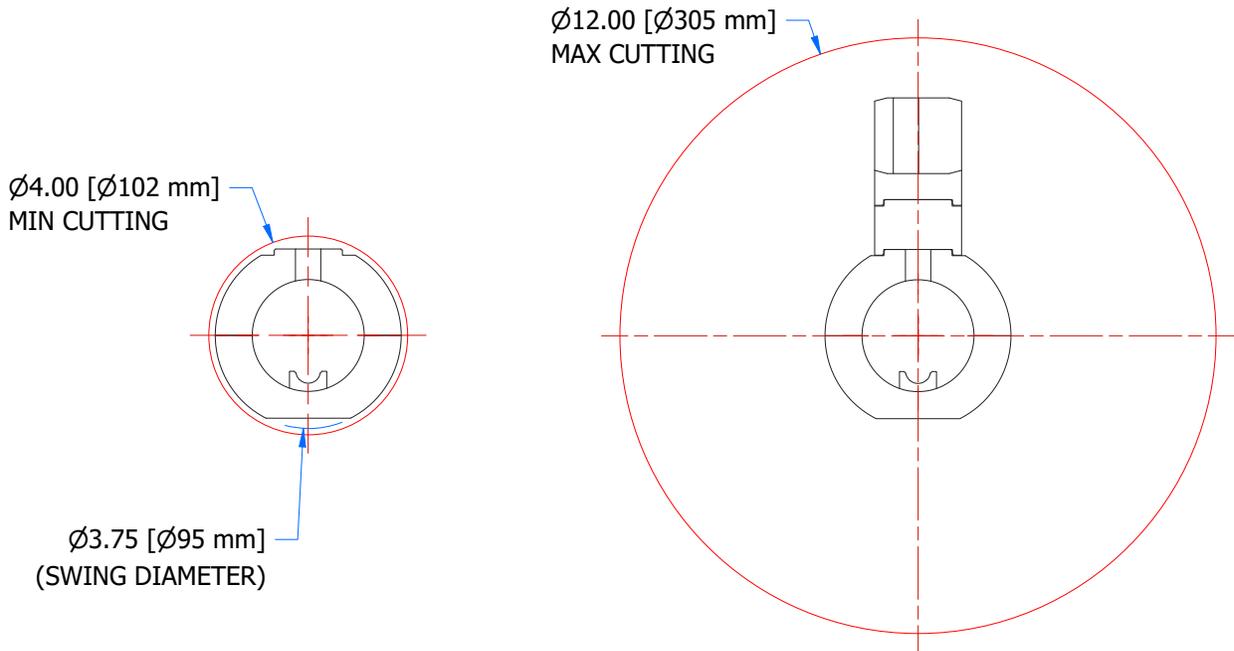
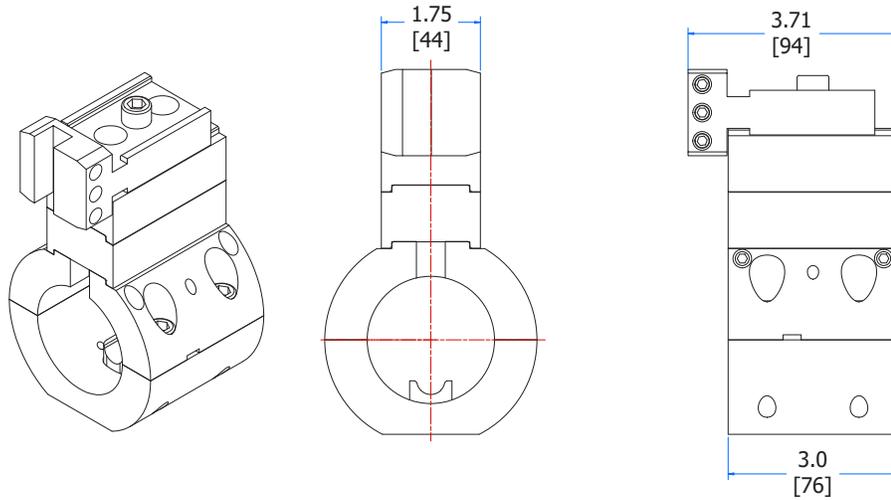


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OPERATIONAL DIMENSIONS - ACCESSORIES

600-7101 - 2-1/4" 4-12" Stackable Cutting Head

(Included with Feed Screw Bars: 605-7085-072FS and 605-7085-096FS)

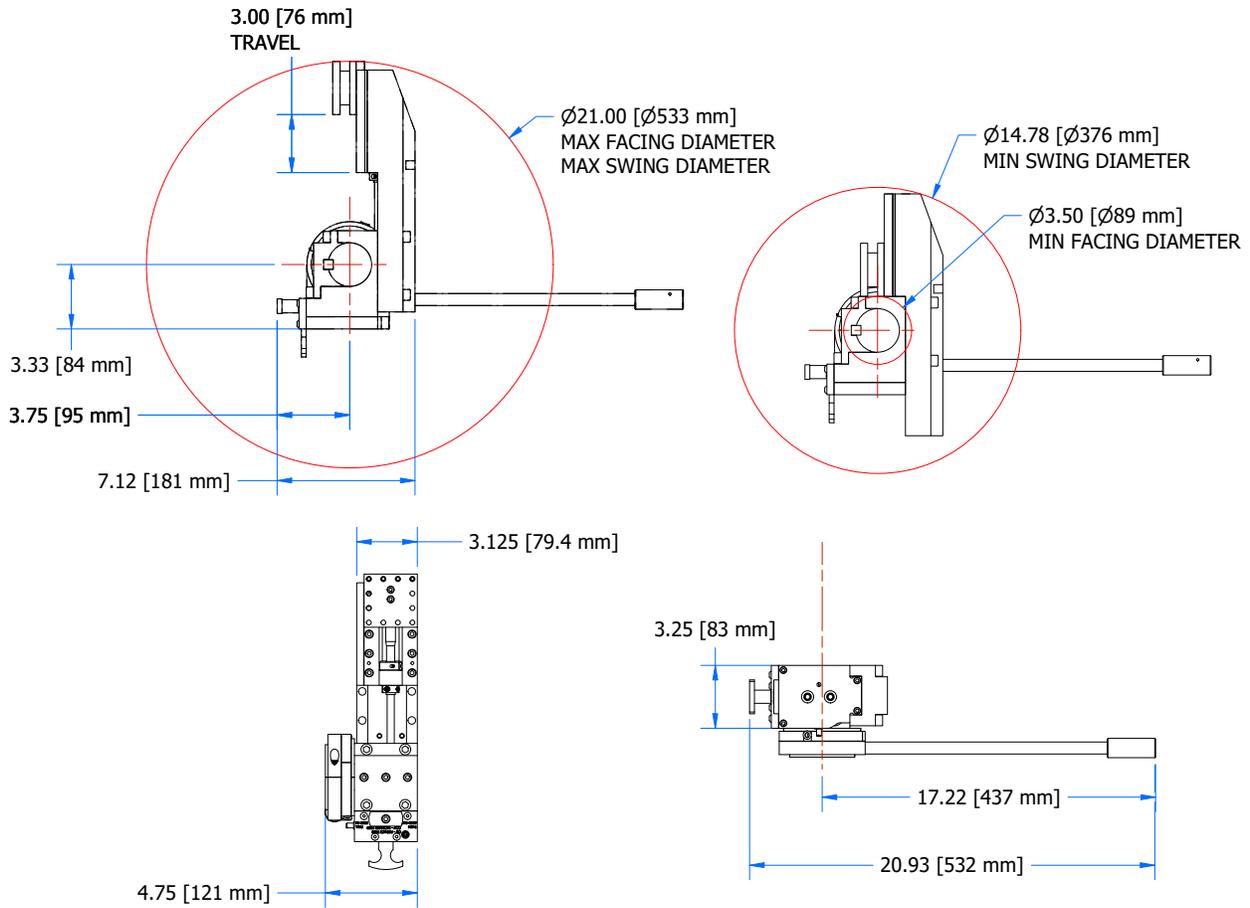


CUTTING HEAD W/ EXTENSIONS

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OPERATIONAL DIMENSIONS - ACCESSORIES

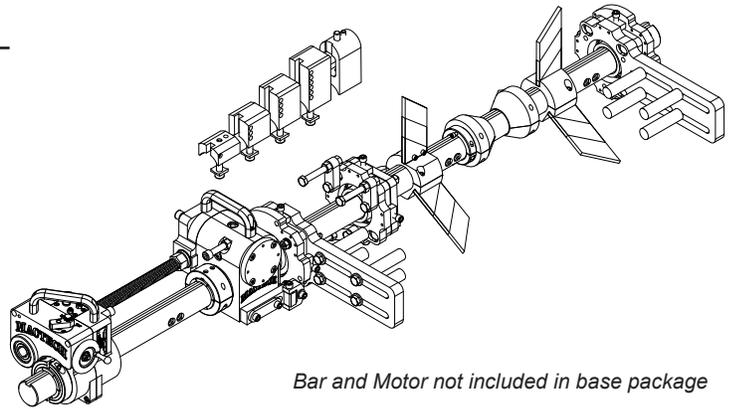
600-7023 - BB2252 Face Head Assembly



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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)

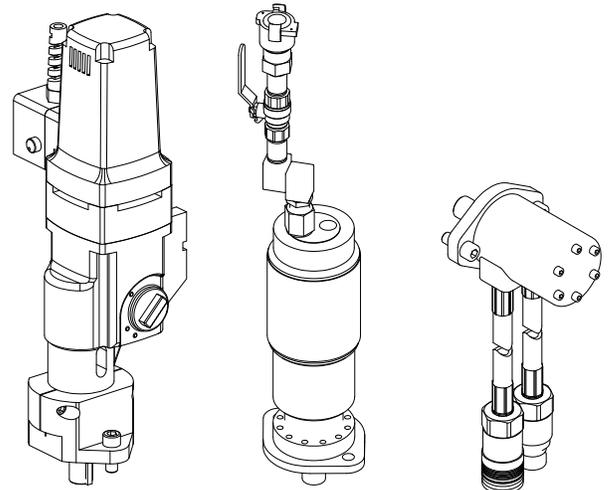
AIR MOTOR OPTIONS

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

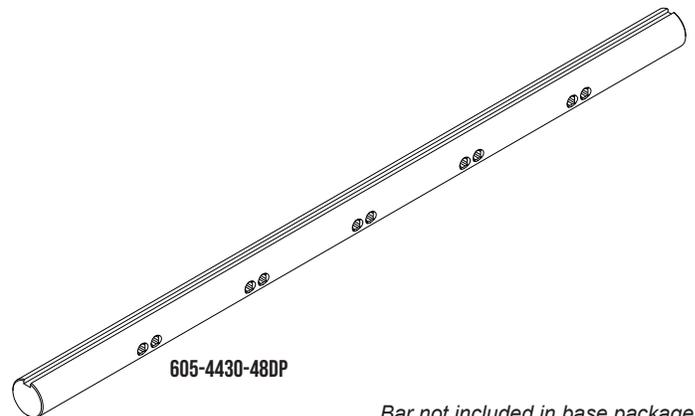
605-4430C-48DP 2-1/4 x 48" Bar Package
(57x1219mm)

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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FEED SCREW BAR OPTIONS (CHOOSE ONE)

All Bars 2-1/4", 57mm, Chrome Plated bar, 2-1/4" 15:1 Axial Feed Assembly, 2-1/4" 4-12" Stackable Cutting Head

- 605-7085-072FS** 2-1/4 x 72" Feed Screw Bar Package (57x1828mm)
- 605-7085-096FS** 2-1/4 x 96" Feed Screw Bar Package (57x2438mm)

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

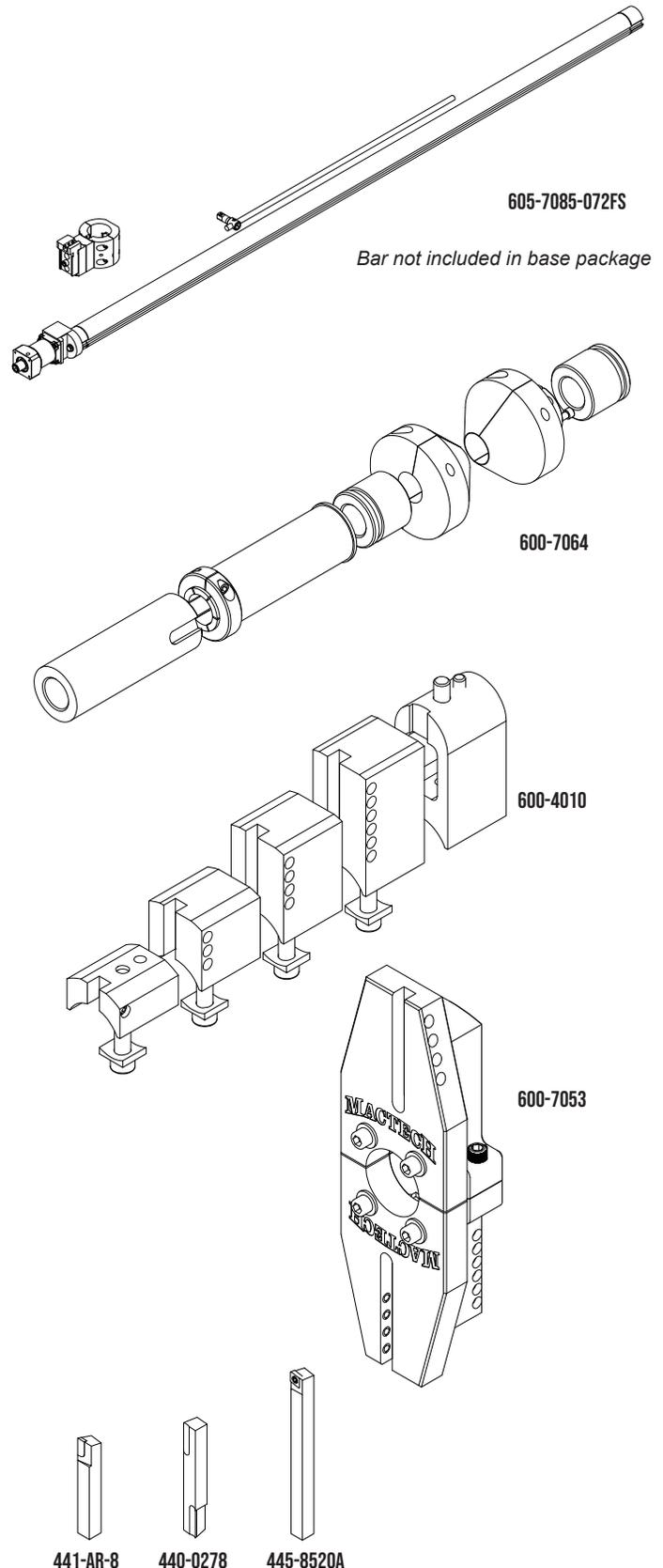
TOOLING

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)



605-7085-072FS
Bar not included in base package

600-7064

605-4010

600-7053

441-AR-8

440-0278

445-8520A

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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 BB252 Hand Tool Kit
(Included In Base Package)

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 BB252 Intermediate Bearing Mount
(Included in Base Package)

600-7017 BB252 Single Sided Bearing Mount
(Included in Base Package)

600-7018 BB252 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)

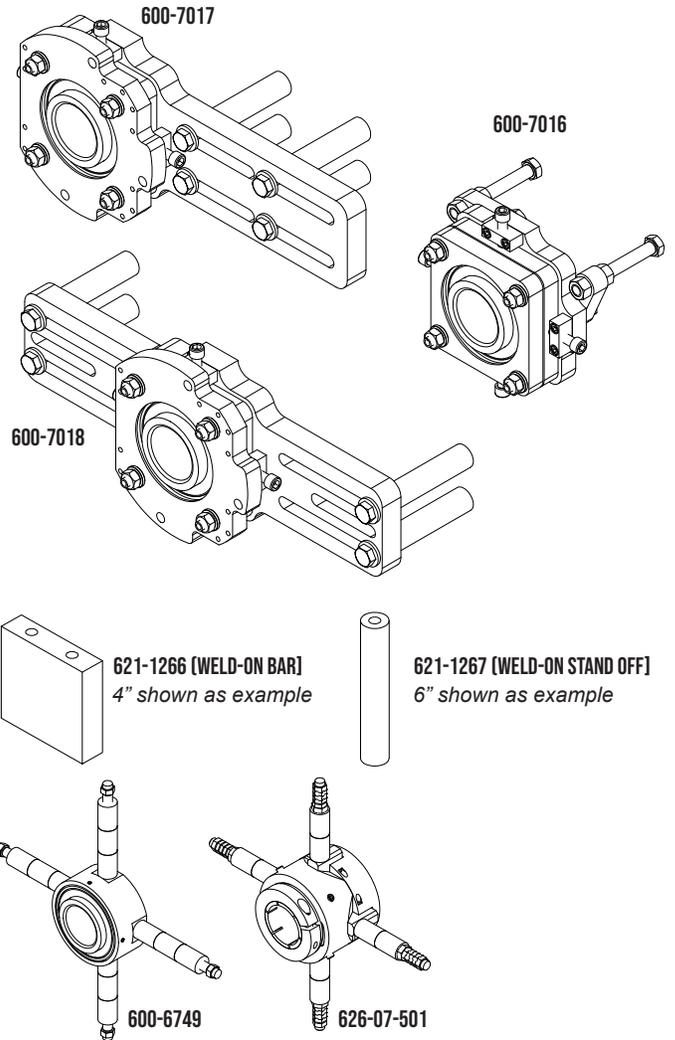
621-1353-06 6" Weld-on Stand-off
(Longer than 4" req. for Facing Head)

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)**

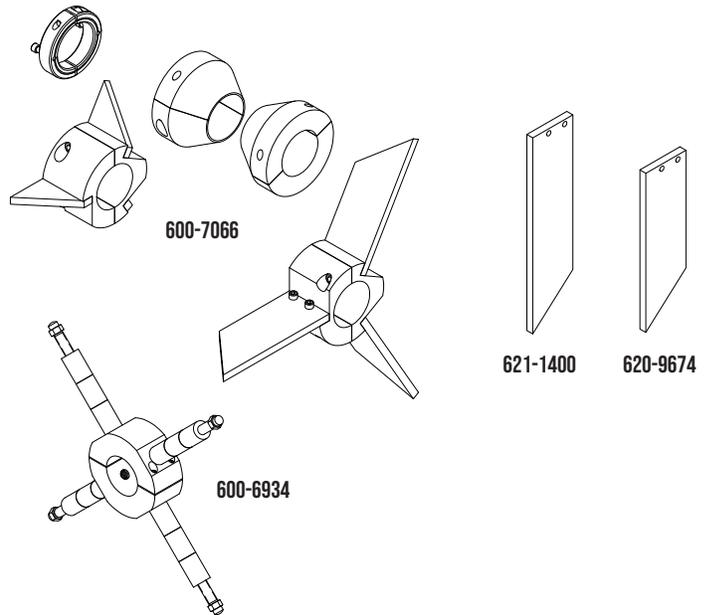
16" To 24" Boring Range (Used with 605-7053)

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)**



FEED SCREWS

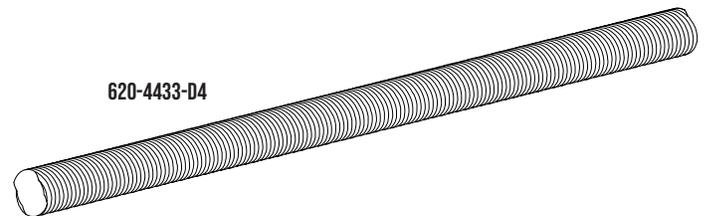
Axial Feed Rate 0.031" Rev. / 0.7mm

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)

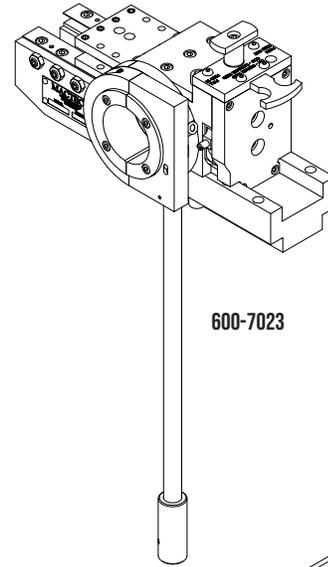
620-4433-D4-40 1"-4 Double Start Acme Feed Screw, .5 Pitch - 40" Travel / Stroke (1219mm)



FACING HEAD ACCESSORY

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

605-7023 BB252 Facing Head Assembly

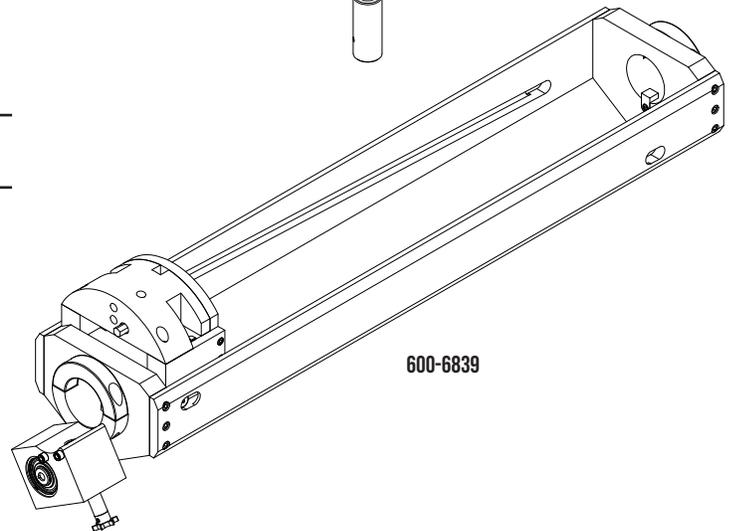


605-7023

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

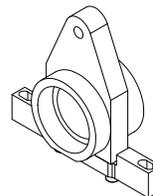
BORE WELDER ACCESSORY

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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