

Quick, accurate boring bar centering without cones
With Bore Repair Systems, Inc. model K94
low-profile centering kit.



FOR BORING BAR DIAMETER	ORDER KIT NUMBER
1.25"	K94.10
1.75"	K94.11
1.25" and 1.75"	K94.12
2.0"	K94.13
2.25"	K94.14

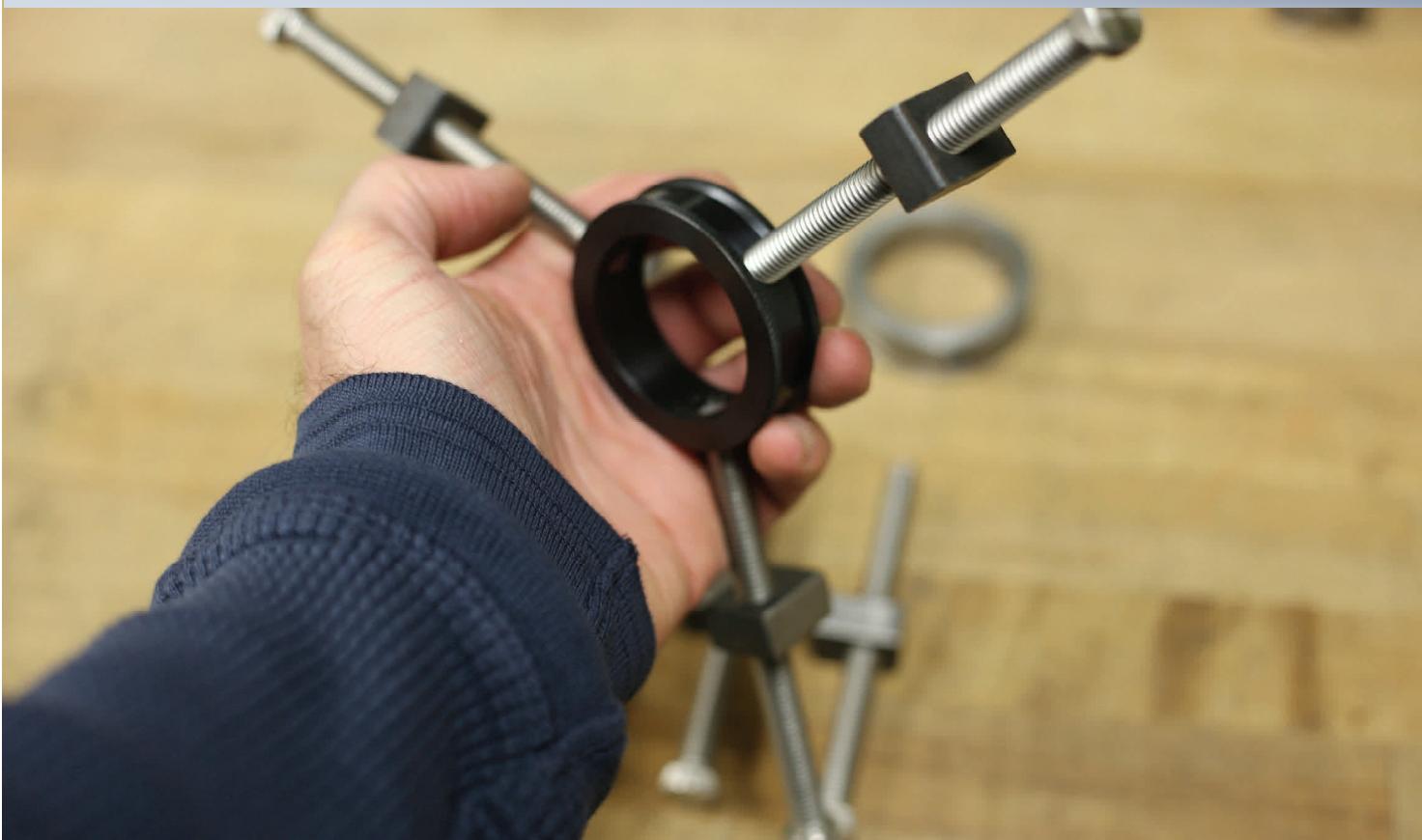
To order your kit call

Bore Repair Systems, Inc. at 603-835-2409 or order through your local Bore Repair Systems, Inc. sales rep.

Thread adjuster screws into tabs (6)



Thread adjuster screw & tab assemblies into rings (2)

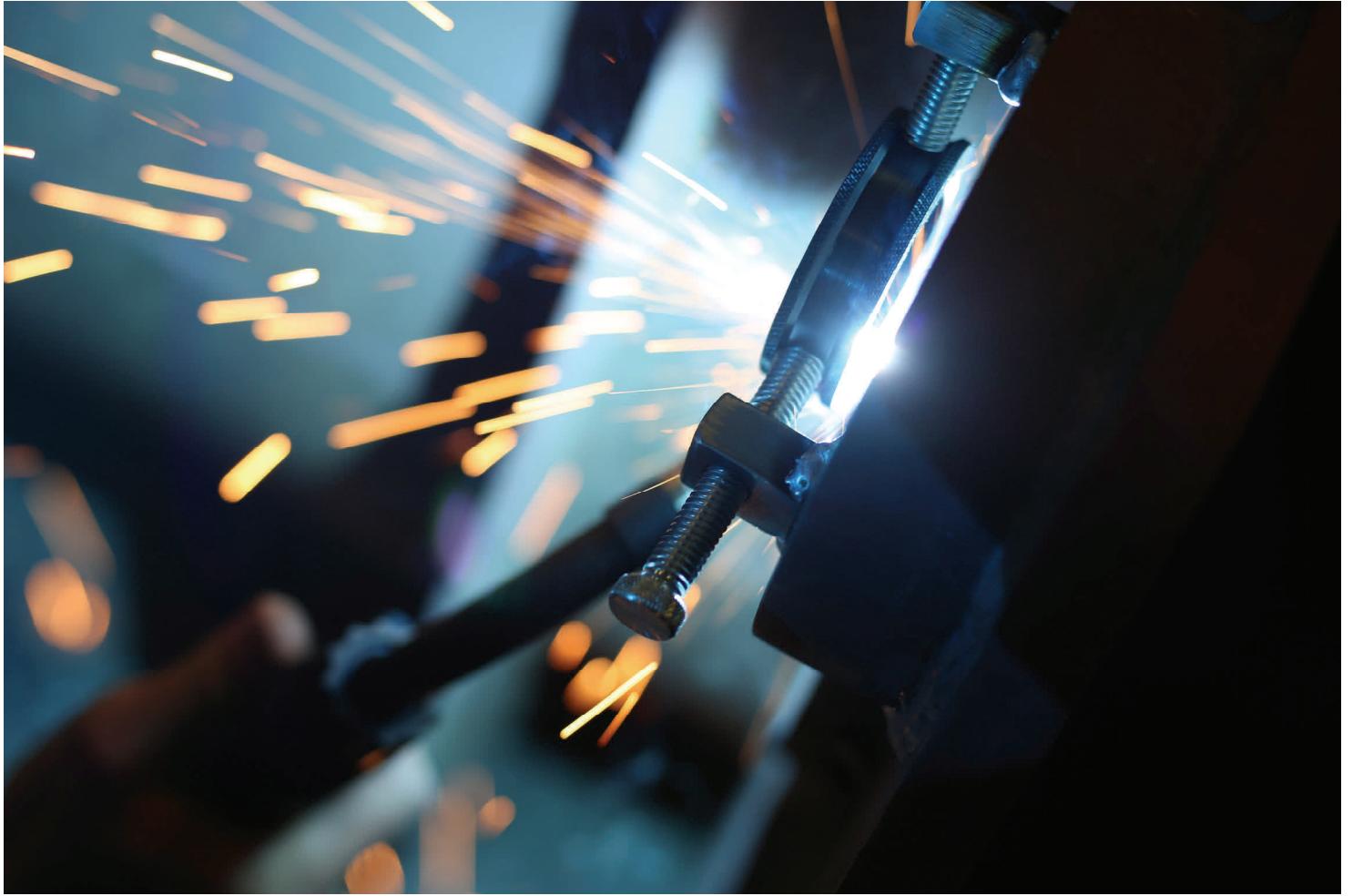


Check to make sure tabs are adjusted correctly



Weld the adjuster assemblies to the job





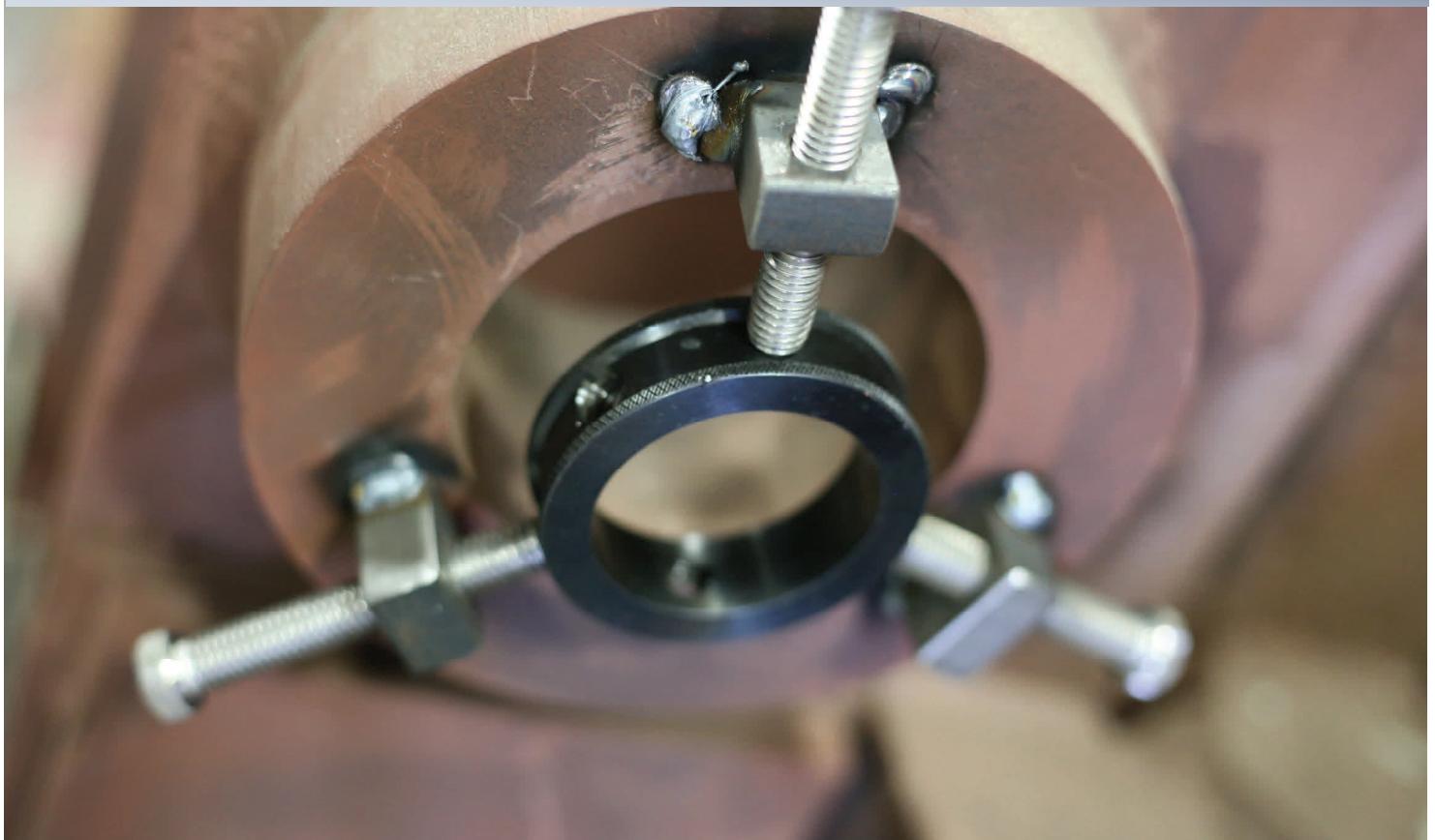
Thread the centering screws out of the rings



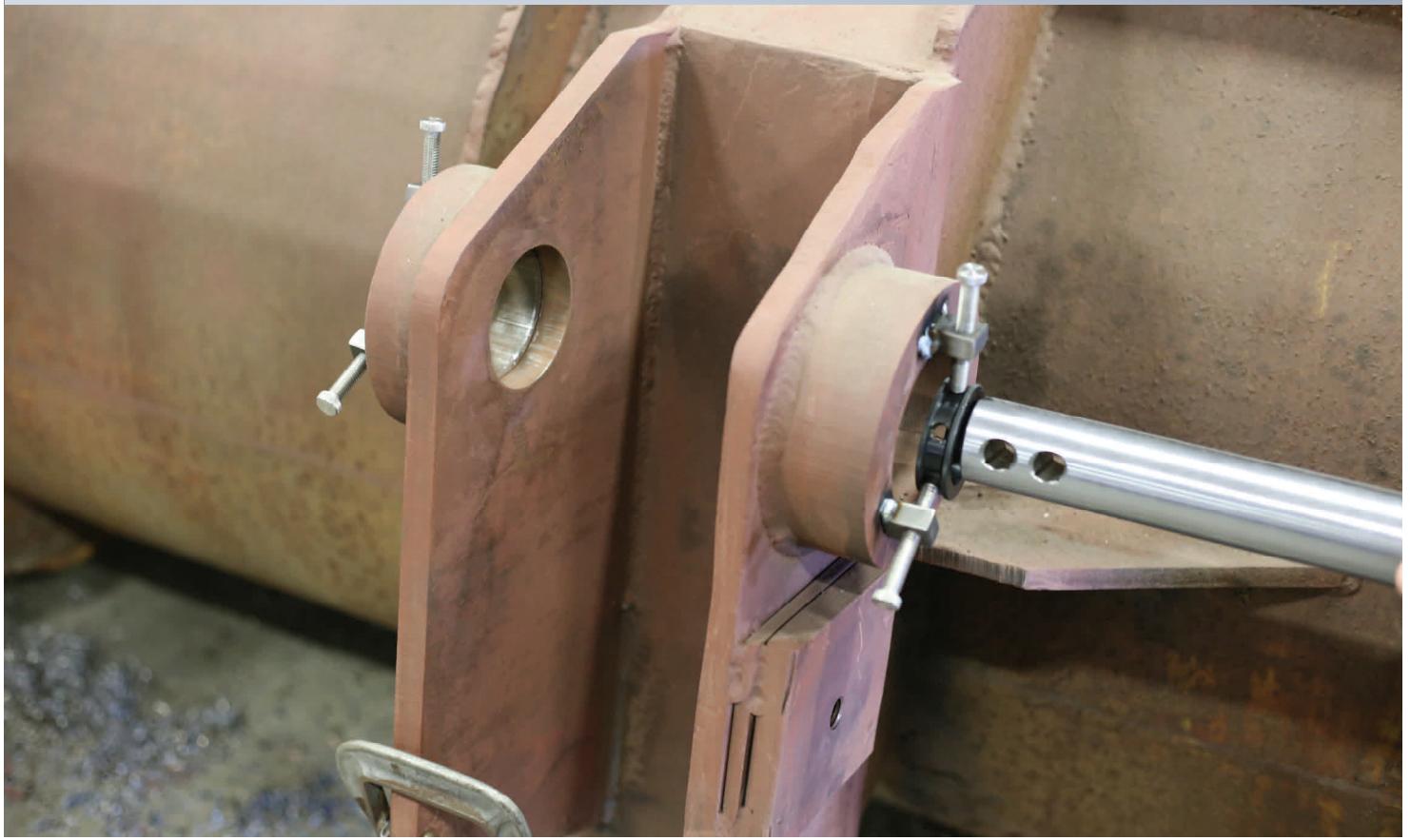
Rotate ring so the tapped holes are between screws



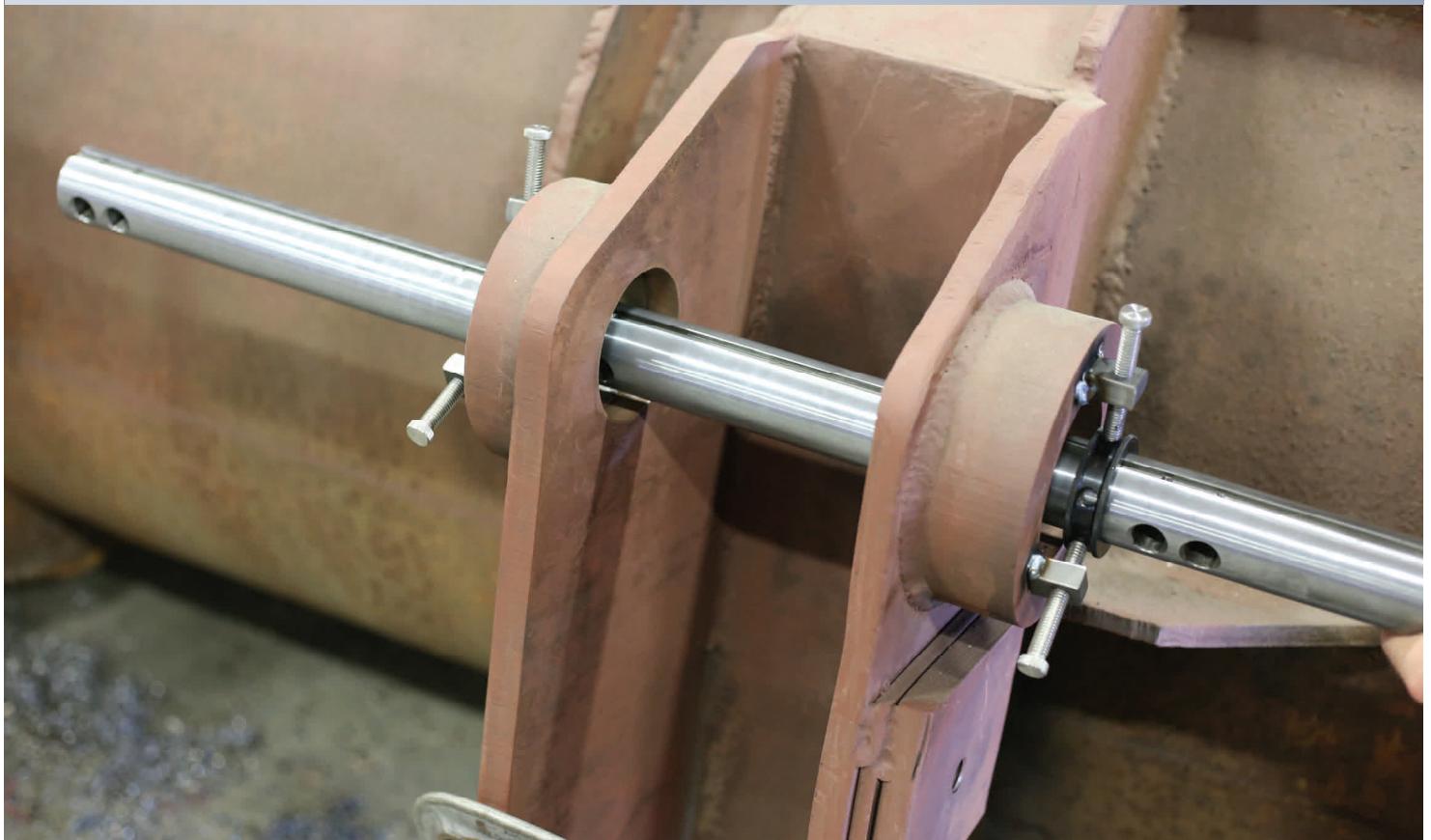
Re-tighten the centering screws to retain the ring



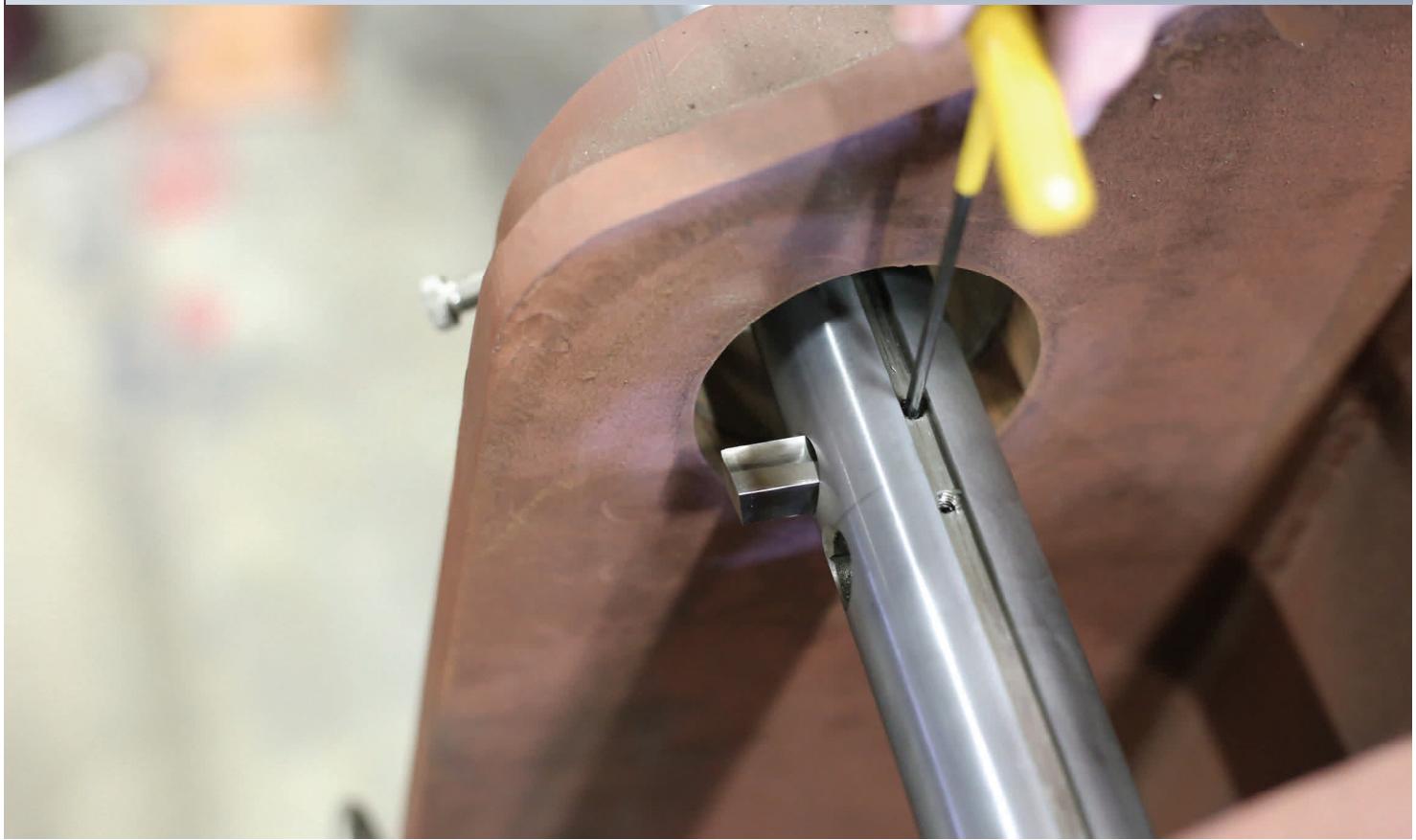
Slide bar into first ring slowly



Continue sliding bar through both rings



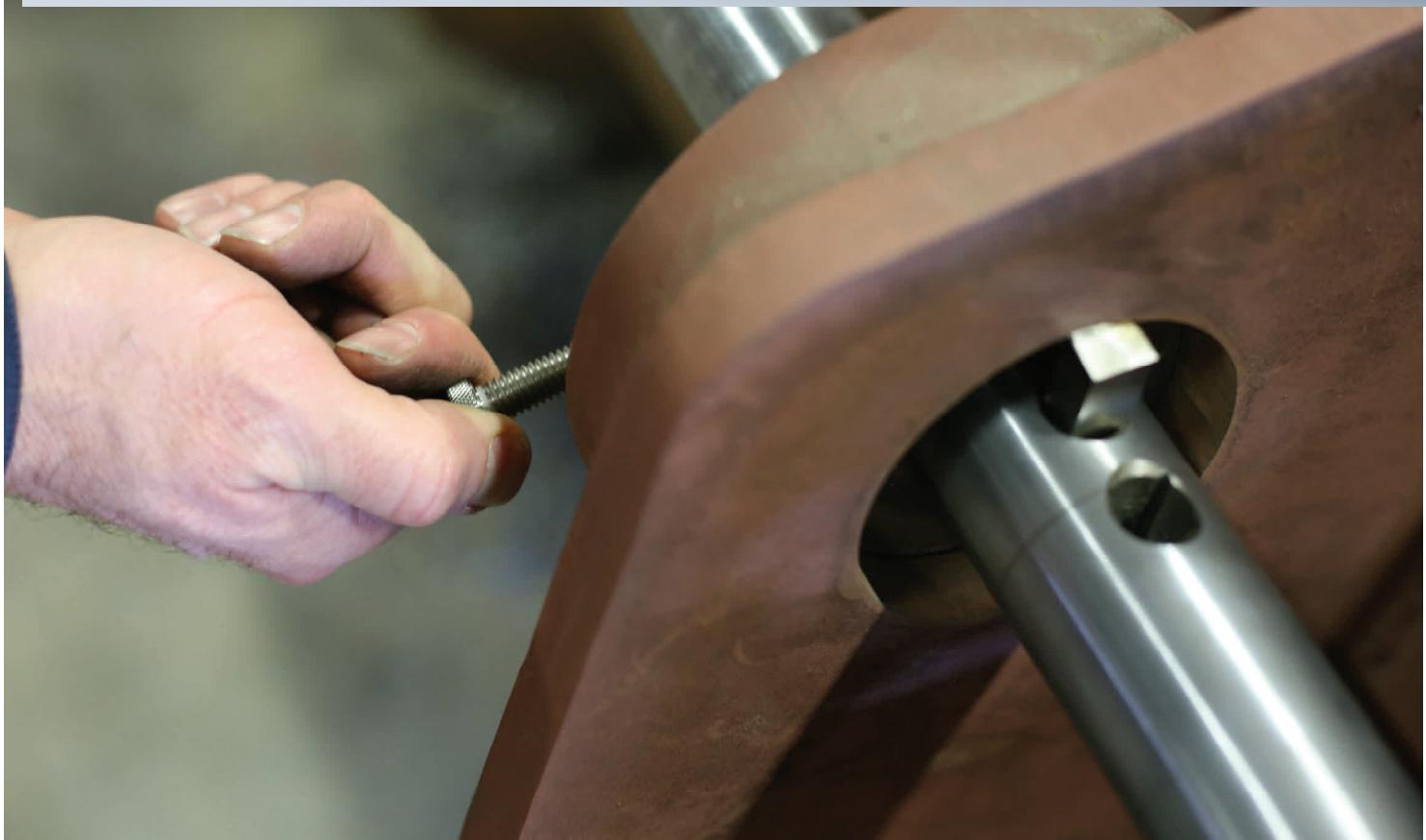
Install cutter or dummy bit



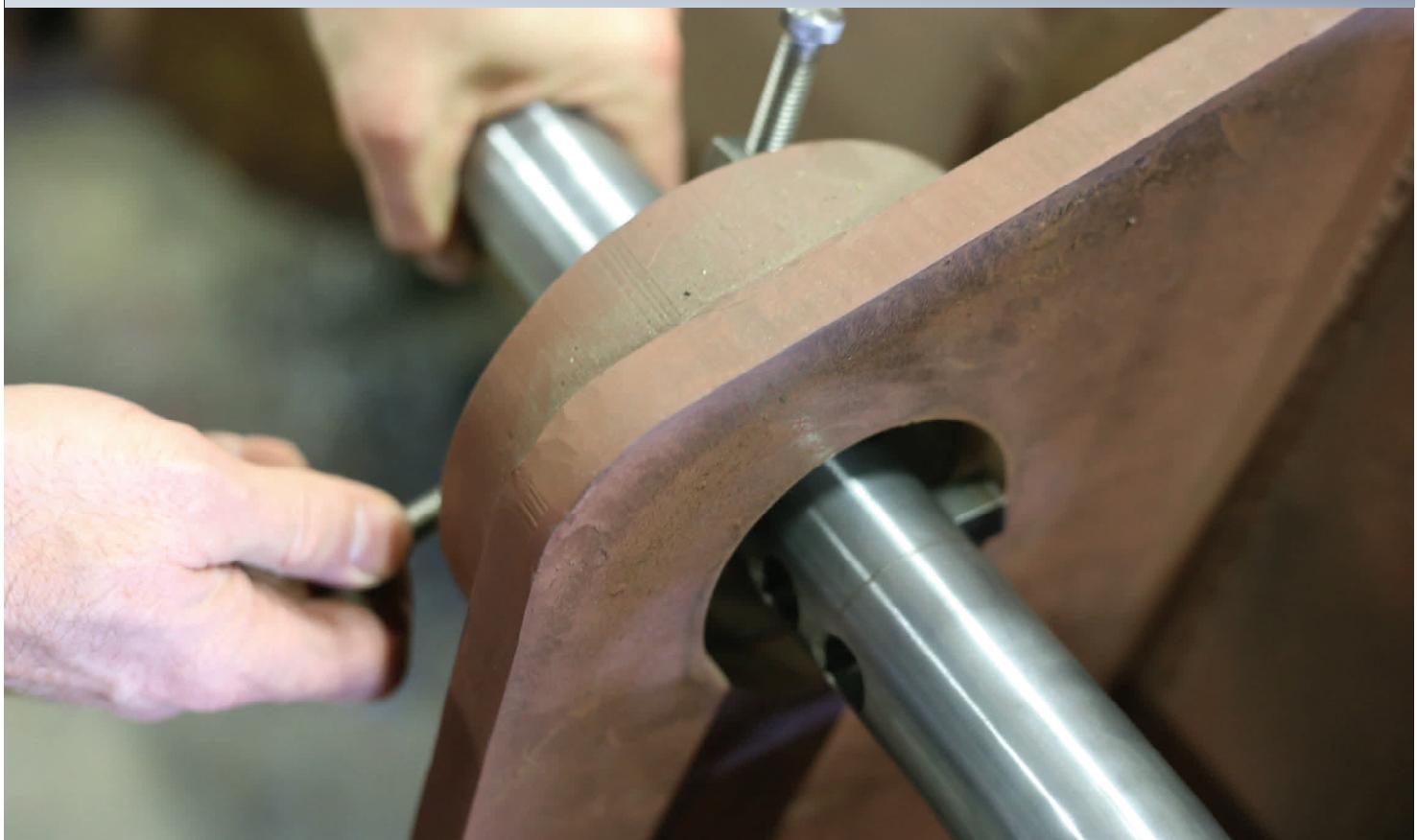
Move bit into bore at 9:00 position and adjust ring

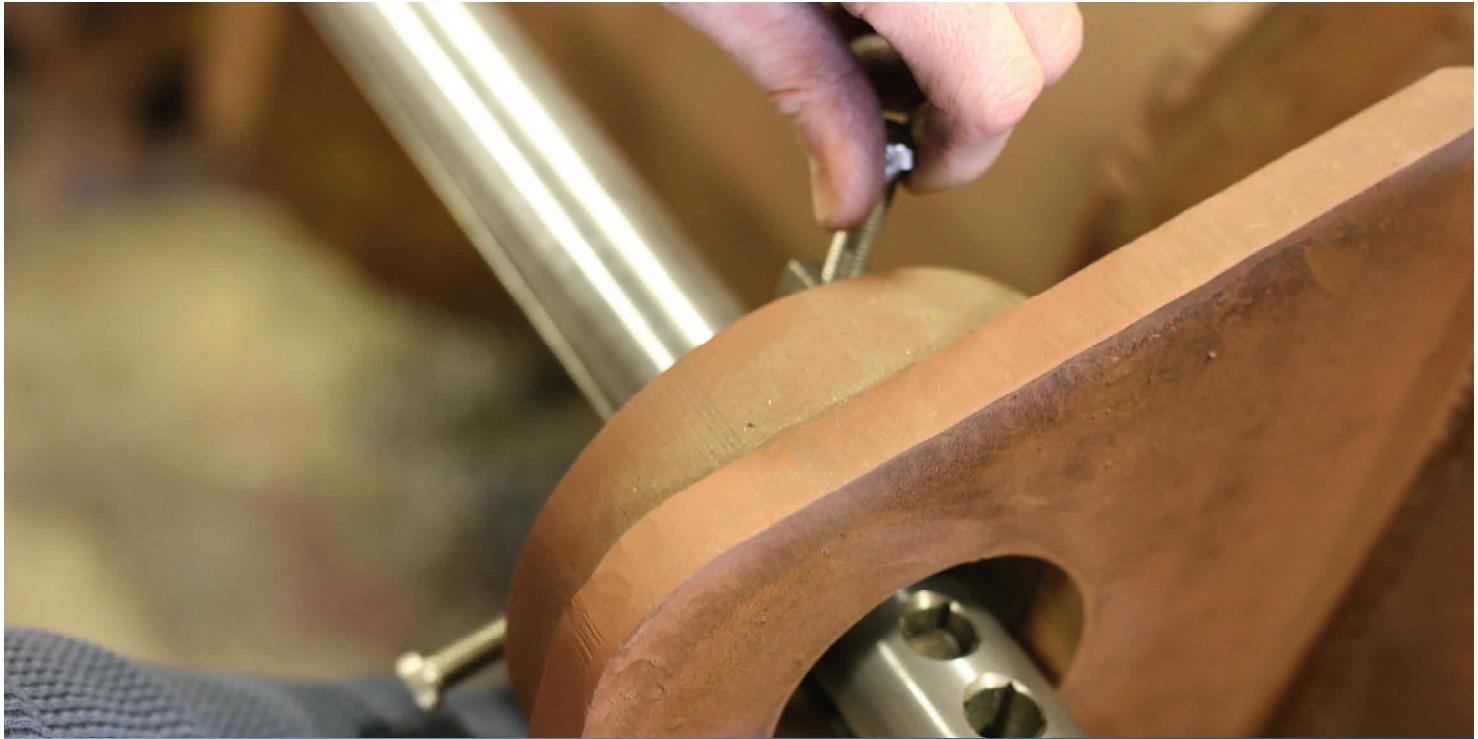


Continue to 12:00 position and adjust



Continue to 3:00 position and adjust





Continue to 6:00 position and adjust. Now rotate bar and check to see if bit is even at 9, 12, 6 and 3:00 positions. If bore is worn badly you should also use a square to ensure the bar is perpendicular to the faces



With both sides even, mount your supports to the job

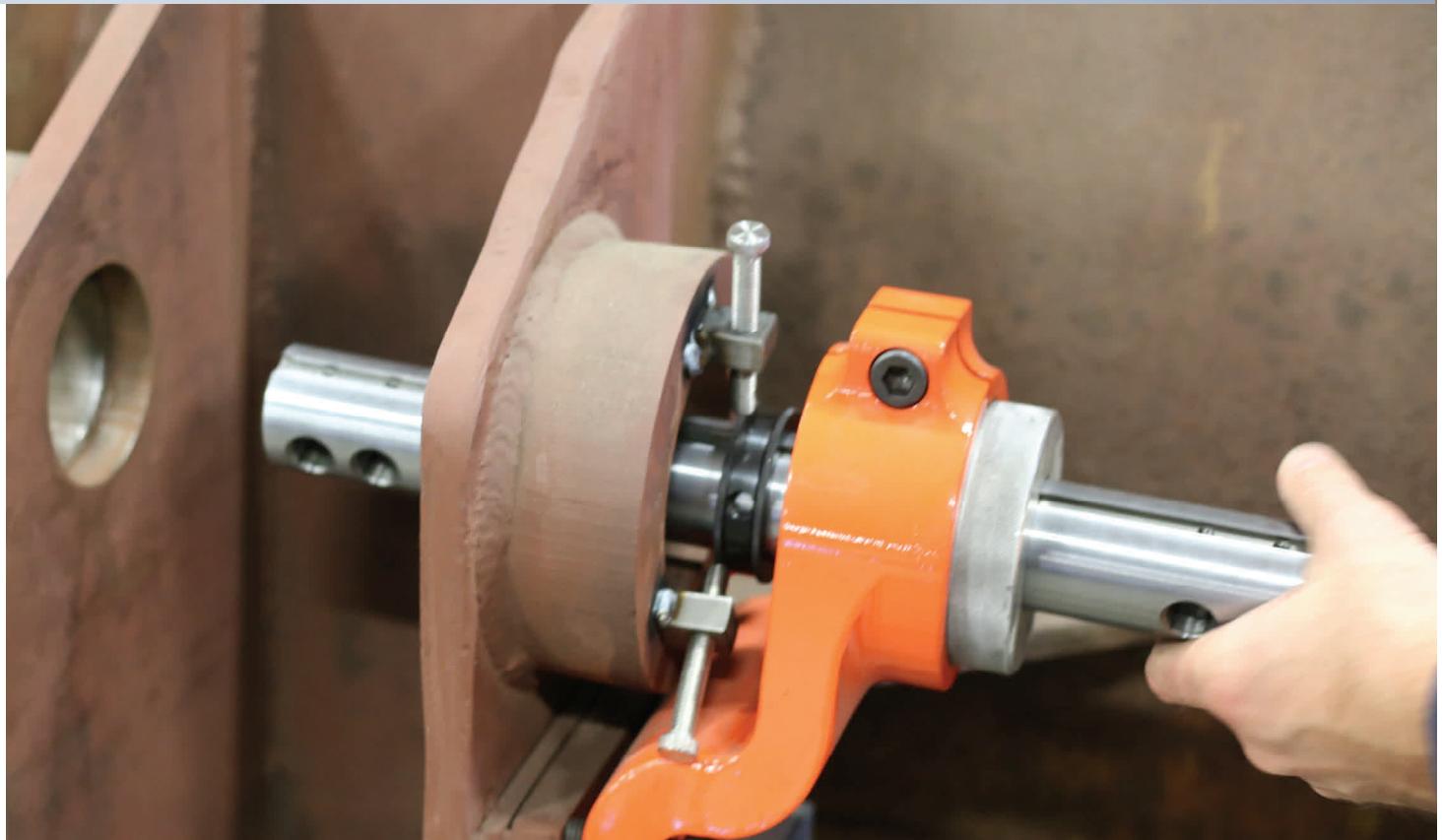
In this case, the tack plate was already mounted to job. If mounting tack plate & support assembly , now you would tack weld base plate onto the job



With both mounts attached to job, loosen screws



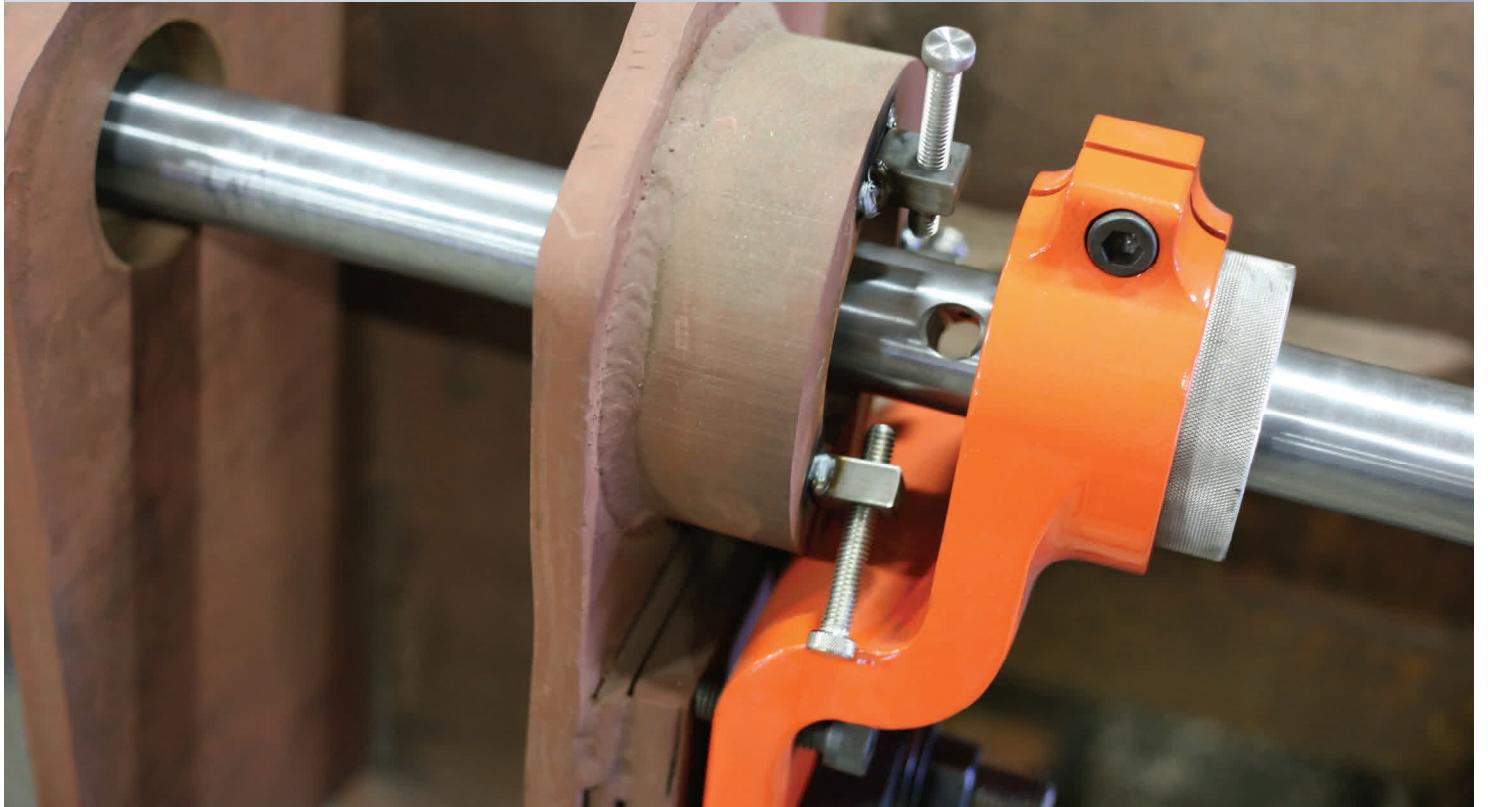
Slide bar out of mounts



Now remove both centering rings



Leave centering tabs and screws if desired. This will allow easy re-centering if you find that bar still needs further adjustment.



With your centering rings removed, bar centered and mounts securely attached, install bearing in place of setup plug and on other support install your boring bar drive & motor as shown in your manual. You are now ready to machine.

Bore Repair Systems, Inc.

www.borerepair.com—603-835-2409