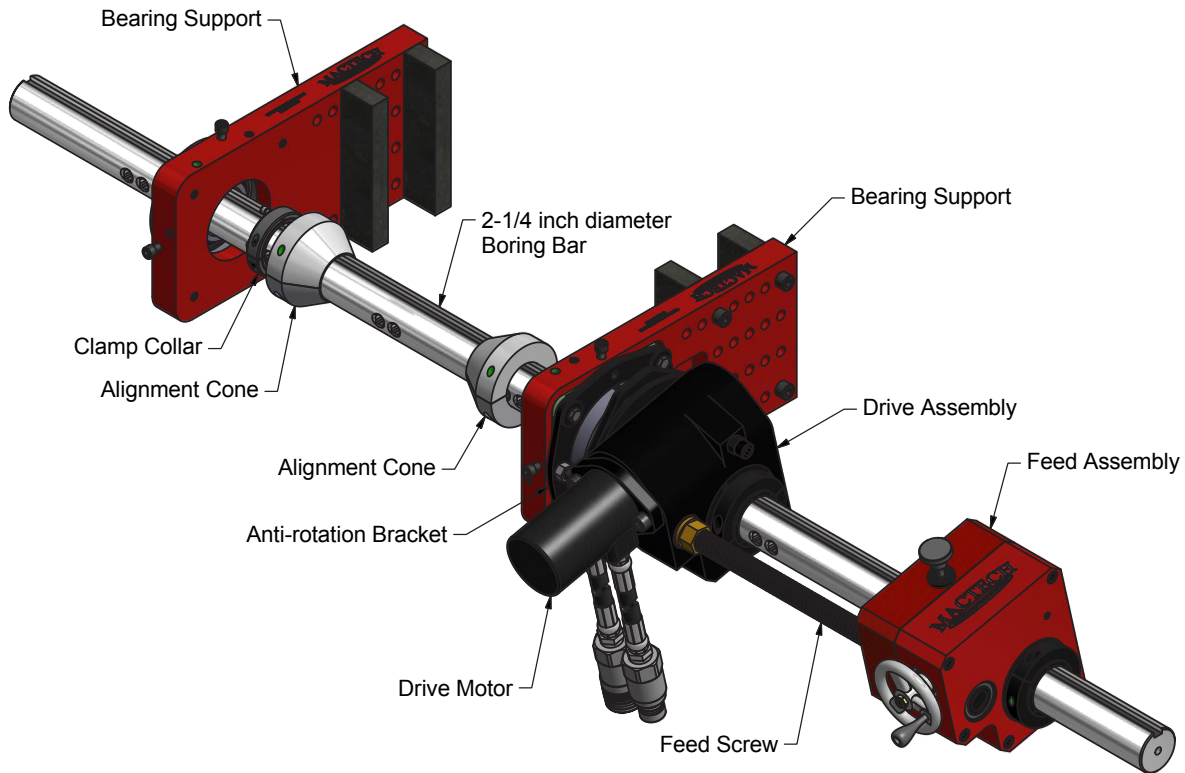


# MACTECH

## BB2250 BORING BAR SYSTEM

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### PRODUCT DESCRIPTION

Save costly shop repairs with accurate, on-site boring and welding, all with one easy setup. Mactech's simple to operate BB2250 Boring Bar is the solution for any bore repair that needs to be done right away. Teamed with the BOA Bore Welder, the BB2250 is the one-setup solution for many of your on-site repairs. Powerful, accurate machining gets your equipment up and running fast, reducing your downtime and saving you money. Or, match your BB2250 with one or all of the many useful accessories available. The go-anywhere narrow profile fits in the tightest work areas. Custom setups are our specialty, give us a call and we will make a system suited just for your application.

### FEATURES

- HIGH TORQUE, 6:1 REDUCTION GEAR DRIVE HAS POWER FOR AGGRESSIVE CUTTING
- MACHINES 2-1/2" TO 16" DIAMETER BORES
- BORE AND WELD WITH THE SAME SETUP
- BORE WELDER, FACING ARM AND TAPERED BORE ACCESSORIES AVAILABLE.
- ELECTRIC, HYDRAULIC OR AIR DRIVE

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

**MACTECH OFFSHORE**  
302 IDA ROAD  
BROUSSARD 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

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AROUND THE WORLD  
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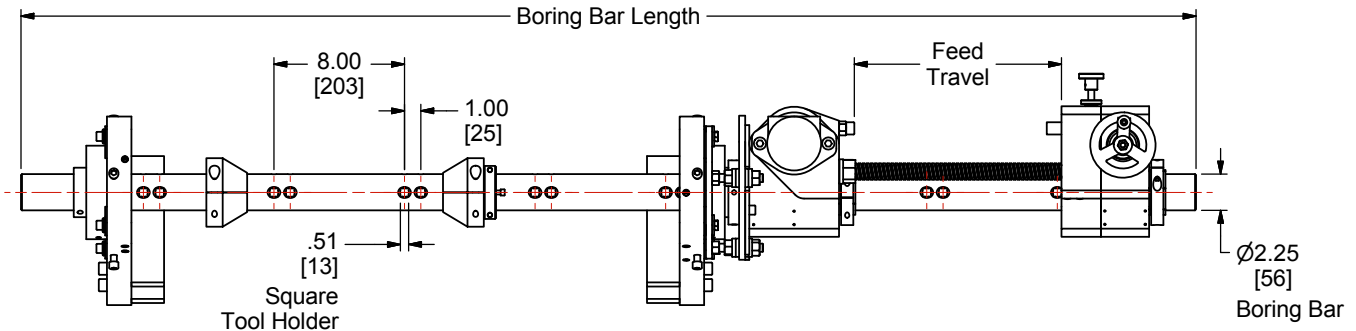
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## BORING BARS - STANDARD LENGTHS

Part No.	Length
620-4430C-48DP	48 inches (1219 mm)
620-4430C-72DP	72 inches (1829 mm)
620-4430C-96DP	96 inches (2438 mm)
620-4430C-120DP	120 inches (3048 mm)
620-4430C-144DP	144 inches (3658 mm)

## FEED SCREWS

Part No.	Feed Travel
620-4433-D4 (standard)	12 inches (305 mm)
620-4433-D4-24 (optional)	24 inches (610 mm)

All dimensions and hydraulic requirements are for reference and may be subject to change without notice. Machine performance is subject to application and operator capability; please discuss your requirements directly with a Mactech sales representative. All information given and all sales made by Mactech Inc. are subject to their terms and conditions.

## CAPABILITIES

The BB2250 Boring Bar is capable of machining 2-1/2" to 16" (64 to 406 mm) inside diameters.

## BORING BAR

2-1/4" diameter (57 mm) chrome plated bar. Square tool holder broaches accept 1/2" (12 mm) square tooling. Boring bars are available in 48", 72", 96", and 144" standard lengths (1219, 1829, 2438, and 3658 mm).

## DRIVE SYSTEM

The BB2250 drive system includes a 6:1 reduction gear drive, available with air, hydraulic or electric motor.

## FEED RATE

0" to 0.015" axial feed per revolution (0 to 0.4 mm axial feed per revolution).

## FEED SCREWS

Steel, 1-4 Acme thread double-start feed screw.

## FEED TRAVEL

12" travel (305 mm) - 20 inch long (508 mm) feed screw.

24" travel (610 mm) - 32 inch long (813 mm) feed screw.

## TOOLING

The BB2250 Boring Bar tool holders accept standard 1/2" (12 mm) square tool bits.

The BB2250 Boring Bar package includes all components required for a basic bore machining setup. The package includes your choice of electric, hydraulic, or air drive motor. High-performance hydraulic power supplies are available for the hydraulic motors.

Also available is a Bore Repair Package with everything you need for on-site repairs and a Bar Reducer Adapter Kit allows you to use a 2-1/4 inch diameter boring bar system with a 1-1/4 inch diameter boring bar.

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## TOOL HOLDER EXTENSIONS

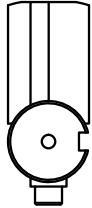
Tool holder extensions can be purchased separately or as a set.



Tool Holder  
600-4006  
4–6 inch I.D.  
(102–152 mm)



Tool Holder  
600-4007  
6–8 inch I.D.  
(152–203 mm)



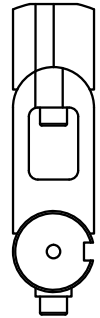
Tool Holder  
600-4008  
8–10 inch I.D.  
(203–254 mm)



Tool Holder  
600-4009  
10–12 inch I.D.  
(254–305 mm)



Tool Holder  
600-4006  
Extension  
600-4028  
12–14 inch I.D.  
(305–356 mm)



Tool Holder  
600-4007  
Extension  
600-4028  
14–16 inch I.D.  
(356–406 mm)

## DRIVE MOTORS

Drive	Horsepower / Watts / Voltage	Max Bar RPM	Max Continuous Torque
Air Motor* 605-6762	3.9 hp / 3000w	116 rpm	162 ft-lbs / 220 Nm
Hydraulic Motor** 600-6763	3.4 hp	83 rpm	68 ft-lbs / 92 Nm
Electric Motor 600-6655	3 hp / 2200w / 220V	13/95 rpm	182/25 ft-lbs / 247/34 Nm
Electric Motor 600-6657	3 hp / 2200w / 110V	13/95 rpm	182/25 ft-lbs / 247/34 Nm

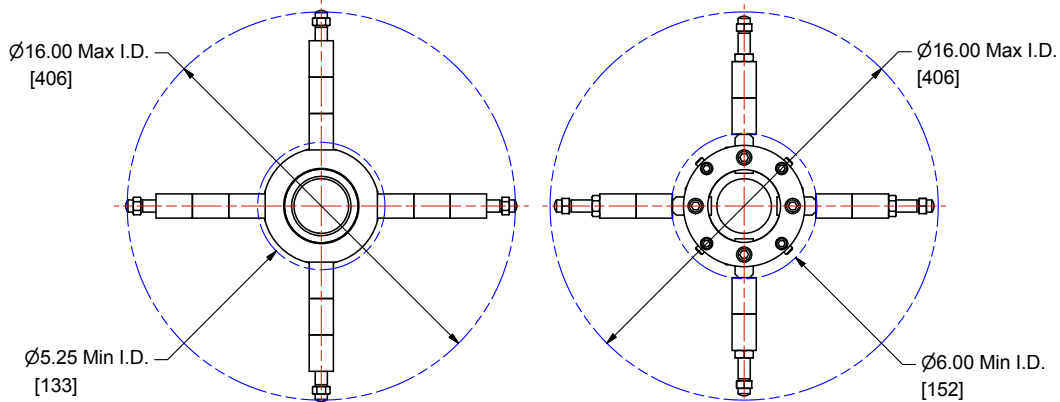
\* Air motors require 100 cfm @ 100 psi air supply (2.8 m<sup>3</sup>/min @ 6.9 bar)

\*\* Hydraulic motor performance is based on 8 gpm @ 1000 psi hydraulic power supply (30 lpm @ 69 bar)

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## INTERNAL BEARING SUPPORTS

Supports the boring bar inside the bore. Used in long or oversized bores that require additional support between the standard bearing supports. Internal bearing supports are not part of the standard package, and can be purchased separately.



INTERNAL BEARING SUPPORT: 600-6749

INTERNAL BEARING SUPPORT: 626-07-501

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