



## DESCRIPTION

A versatile and modular line boring machine offering a choice of electric, hydraulic and pneumatic boring bar drive motors, with a mechanical drive for the feed assembly.

Choose a standard machine kit from pages 2 and 3, or configure your own machine to suit your requirements.

## KEY FEATURES

- Mechanical bi-directional variable auto-feed
- Drive and feed units which accept a variety of boring bar diameters
- Modular add-on components provide a flexible line boring solution for multiple projects
- Fast set-up time.

## PERFORMANCE AND SPECIFICATION

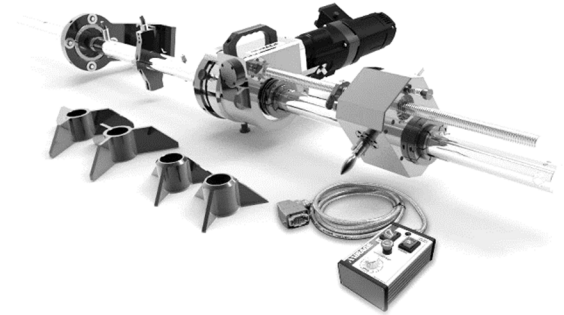
<b>BORING DIAMETER RANGE</b>	1.5" to 24"	
<b>BORING BAR STROKE</b>	305, 610 or 915mm	12, 24, or 36"
<b>POWER DRIVE MOTOR OPTIONS</b>		
Electric 110 or 220v (4 speed reversible)	2.5 KW	3.3 Hp
Pneumatic	1.7 KW	2.2 Hp
Pneumatic	3.0 KW	4.0 Hp
Hydraulic	3.7 KW	5.0 Hp
<b>VARIABLE TOOL FEED RATE (per rev)</b>	0.02 – 0.25mm	0.001 – 0.010"
<b>MACHINE WEIGHT</b>		
Estimate based on 60mm x 2m boring bar and 2 single arm mounts, drive and feed.	186kg	409 lbs
<b>SHIPPING WEIGHTS AND DIMENSIONS:</b> Available on request and dependent upon components selected.		

## SET UP AND OPERATION

Please operate within machine manual guidelines regarding set up, operation, safety and maintenance.

## Two ways to make the right choice

1. Choose one of our four standard machine packs and select the drive type you needed.
2. Alternatively, build a machine to your own specification. *See from page 4 - Configure your own line boring machine.*



### MLB610-A

#### 1.5 - 6" DIAMETER LINE BORING KIT COMPLETE WITH 30MM X 2M BORING BAR

ITEMS INCLUDED	QUANTITY
Metric Base Unit. Drive, Feed, Tool heads (1.5 - 6"), tool kit, manual and steel box	1
30mm Bar x 2000mm bar, 10mm tooling, 150mm Spacing	1
30mm Bar, Small Setup Cones (1.5 - 3.5")	1
30mm Bar, Medium Setup Cones (3.5 - 6")	1
60mm Boring Bar Single arm Mount (1 Piece)	2
30mm Collet Set. Feed, Drive, Tooling, Bearing x2	1
<b>IMPORTANT: CHOOSE YOUR DRIVE TYPE</b>	<b>PART NUMBER</b>
Electric 110v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-34
Electric 220v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-35
Pneumatic 2.2Hp / 1.7KW (166rpm)	MLB610-30
Pneumatic 4.0Hp / 3.0KW (60 rpm)	MLB610-31
Hydraulic 5.0HP / 3.7KW (100rpm)	MLB610-32
Hydraulic 5.0Hp / 3.7KW (32rpm)	MLB610-33

### MLB610-B

#### 4 - 12" DIAMETER LINE BORING KIT COMPLETE WITH 60MM X 2M BORING BAR

ITEMS INCLUDED	QUANTITY
Metric Base Unit. Drive, Feed, Tool heads (4 - 12"), tool kit, manual and steel box	1
60mm x 2000mm bar, 12mm tooling holes, 250mm Spacing	1
305mm (12") Leadscrew	1
60mm Bar Small Setup Cones (2.75 - 8.37")	1
60mm Bar Medium Setup Cones (8.37 - 12")	1
60mm Boring Bar Single arm Mount (1 Piece)	2
Mounting Bearing Housing (Housing Only - No Bearing)	1
60mm Self Aligning Mounting Bearing (Bearing Only - No Housing)	1
<b>IMPORTANT: CHOOSE YOUR DRIVE TYPE</b>	<b>PART NUMBER</b>
Electric 110v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-34
Electric 220v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-35
Pneumatic 2.2Hp / 1.7KW (166rpm)	MLB610-30
Pneumatic 4.0Hp / 3.0KW (60 rpm)	MLB610-31
Hydraulic 5.0HP / 3.7KW (100rpm)	MLB610-32
Hydraulic 5.0Hp / 3.7KW (32rpm)	MLB610-33

## MLB610-C

### 4 - 24" DIAMETER LINE BORING KIT COMPLETE WITH 60MM X 2M BORING BAR

### STANDARD MACHINE PACKS (CONTINUED)

ITEMS INCLUDED	QUANTITY
Metric Base Unit. Drive, Feed, Tool heads (4 - 12"), tool kit, manual and steel box	1
60mm x 2000mm bar, 12mm tooling holes, 250mm Spacing	1
610mm (24") Leadscrew	1
60mm Bar Small Setup Cones (2.75 - 8.37")	1
60mm Bar Medium Setup Cones (8.37 - 12")	1
60mm Boring Bar Single arm Mount (1 Piece)	2
Mounting Bearing Housing (Housing Only - No Bearing)	1
60mm Self Aligning Mounting Bearing (Bearing Only - No Housing)	1
60mm Bar, 12" - 24" Bore Kit - 12mm Square Tooling	1
2 1/4" Bar Large Setup Cones (12 - 24")	1
IMPORTANT: CHOOSE YOUR DRIVE TYPE	PART NUMBER
Electric 110v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-34
Electric 220v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-35
Pneumatic 2.2Hp / 1.7KW (166rpm)	MLB610-30
Pneumatic 4.0Hp / 3.0KW (60 rpm)	MLB610-31
Hydraulic 5.0HP / 3.7KW (100rpm)	MLB610-32
Hydraulic 5.0Hp / 3.7KW (32rpm)	MLB610-33

## MLB610-D

### 1.5 - 12" DIAMETER LINE BORING KIT COMPLETE WITH 30MM & 60MM X 2M BORING BARS

ITEMS INCLUDED	QUANTITY
Metric Base Unit. Drive, Feed, Tool heads (4 - 12"), tool kit, manual and steel box	1
60mm x 2000mm bar, 12mm tooling holes, 250mm Spacing	1
610mm (24") Leadscrew	1
60mm Bar Small Setup Cones (2.75 - 8.37")	1
60mm Bar Medium Setup Cones (8.37 - 12")	1
60mm Boring Bar Single arm Mount (1 Piece)	2
30mm Bar x 2000mm bar, 10mm tooling, 150mm Spacing	1
30mm Bar, Full Set of Setup Cones (1.5" - 6")	1
30mm Collet Set. Feed, Drive, Tooling, Bearing x2	1
IMPORTANT: CHOOSE YOUR DRIVE TYPE	PART NUMBER
Electric 110v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-34
Electric 220v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-35
Pneumatic 2.2Hp / 1.7KW (166rpm)	MLB610-30
Pneumatic 4.0Hp / 3.0KW (60 rpm)	MLB610-31
Hydraulic 5.0HP / 3.7KW (100rpm)	MLB610-32
Hydraulic 5.0Hp / 3.7KW (32rpm)	MLB610-33

## MLB610-E

### 1.5 - 24" DIAMETER LINE BORING KIT COMPLETE WITH 30MM & 60MM X 2M BORING BARS

ITEMS INCLUDED	QUANTITY
Metric Base Unit. Drive, Feed, Tool heads (4 - 12"), tool kit, manual and steel box	1
60mm x 2000mm bar, 12mm tooling holes, 250mm Spacing	1
610mm (24") Leadscrew	1
60mm Boring Bar Single arm Mount (1 Piece)	2
Mounting Bearing Housing (Housing Only - No Bearing)	1
60mm Self Aligning Mounting Bearing (Bearing Only - No Housing)	1
60mm Bar, 12" - 24" Bore Kit - 12mm Square Tooling	1
60mm Bar Full Set of Setup Cones (2.75 - 24")	1
30mm Bar x 2000mm bar, 10mm tooling, 150mm Spacing	1
30mm Bar, Full Set of Setup Cones (1.5" - 6")	1
30mm Collet Set. Feed, Drive, Tooling, Bearing x2	1
IMPORTANT: CHOOSE YOUR DRIVE TYPE	PART NUMBER
Electric 110v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-34
Electric 220v 3.3HP / 2.5KW (8/160rpm) - Complete kit with control box	MLB610-35
Pneumatic 2.2Hp / 1.7KW (166rpm)	MLB610-30
Pneumatic 4.0Hp / 3.0KW (60 rpm)	MLB610-31
Hydraulic 5.0HP / 3.7KW (100rpm)	MLB610-32
Hydraulic 5.0Hp / 3.7KW (32rpm)	MLB610-33

## CONFIGURE YOUR OWN LINE BORING MACHINE

### 1 SELECT BASE UNIT

Each base unit includes 1 drive unit, 1 feed unit, tool heads (4 - 12"), tool kit, manual and steel box.



BASE UNIT	CODE
Metric Base Unit	MLB610-1
Imperial Base Unit	MLB610-2

See accessories section for adapter collets for smaller bar diameters.

### 2 SELECT BORING BAR

Boring bars are chrome plated high tensile steel with full length keyway, supplied in a shipping crate. Tooling is not included with each bar. Please choose what you need from the accessories section.

60MM DIAMETER, 16MM TOOLING HOLES EVERY 150MM	PART NUMBER
60mm x 1000mm bar, 150mm spacing	MLB610-3
60mm x 1500mm bar, 150mm spacing	MLB610-4
60mm x 2000mm bar, 150mm spacing	MLB610-5
60mm x 2500mm bar, 150mm spacing	MLB610-6
60mm x 3000mm bar, 150mm spacing	MLB610-7
60mm x 3500mm bar, 150mm spacing	MLB610-8

60MM DIAMETER, 16MM TOOLING HOLES EVERY 250MM	PART NUMBER
60mm x 1000mm bar, 250mm spacing	MLB610-9
60mm x 1500mm bar, 250mm spacing	MLB610-10
60mm x 2000mm bar, 250mm spacing	MLB610-11
60mm x 2500mm bar, 250mm spacing	MLB610-12
60mm x 3000mm bar, 250mm spacing	MLB610-13
60mm x 3500mm bar, 250mm spacing	MLB610-14

2 1/4" DIAMETER, 16MM TOOLING HOLES EVERY 6"	PART NUMBER
2 1/4" x 36" bar, 6" spacing	MLB610-15
2 1/4" x 48" bar, 6" spacing	MLB610-16
2 1/4" x 72" bar, 6" spacing	MLB610-17
2 1/4" x 96" bar, 6" spacing	MLB610-18
2 1/4" x 120" bar, 6" spacing	MLB610-19
2 1/4" x 144" bar, 6" spacing	MLB610-20

2 1/4" DIAMETER, 16MM TOOLING HOLES EVERY 10"	PART NUMBER
2 1/4" x 36" bar, 10" spacing	MLB610-21
2 1/4" x 48" bar, 10" spacing	MLB610-22
2 1/4" x 72" bar, 10" spacing	MLB610-23
2 1/4" x 96" bar, 10" spacing	MLB610-24
2 1/4" x 120" bar, 10" spacing	MLB610-25
2 1/4" x 144" bar, 10" spacing	MLB610-26

### RECOMMENDED STEPS

1. Select base unit
2. Select boring bar
3. Select drive motor
4. Select motor control
5. Select leadscrew length
6. Select setup cones
7. Select mounting options
8. Select accessories

Ø 30MM BAR - 10MM TOOLING HOLES EVERY 150MM	PART NUMBER
1000mm bar length, 150mm Hole Spacing	MLB610-150
1500mm bar length, 150mm Hole Spacing	MLB610-151
2000mm bar length, 150mm Hole Spacing	MLB610-152
2500mm bar length, 150mm Hole Spacing	MLB610-153
3000mm bar length, 150mm Hole Spacing	MLB610-154
3500mm bar length, 150mm Hole Spacing	MLB610-155

Ø 30MM BAR - 10MM TOOLING HOLES EVERY 250MM	PART NUMBER
1000mm bar length, 250mm Hole Spacing	MLB610-156
1500mm bar length, 250mm Hole Spacing	MLB610-157
2000mm bar length, 250mm Hole Spacing	MLB610-158
2500mm bar length, 250mm Hole Spacing	MLB610-159
3000mm bar length, 250mm Hole Spacing	MLB610-160
3500mm bar length, 250mm Hole Spacing	MLB610-161

Ø 1 1/4" BAR - 10MM TOOLING HOLES EVERY 6"	PART NUMBER
36" bar length, 6" Hole Spacing	MLB610-162
48" bar length, 6" Hole Spacing	MLB610-163
72" bar length, 6" Hole Spacing	MLB610-164
96" bar length, 6" Hole Spacing	MLB610-165
120" bar length, 6" Hole Spacing	MLB610-166
144" bar length, 6" Hole Spacing	MLB610-167

Ø 1 1/4" BAR - 10MM TOOLING HOLES EVERY 10"	PART NUMBER
36" bar length, 10" Hole Spacing	MLB610-168
48" bar length, 10" Spacing	MLB610-169
72" bar length, 10" Spacing	MLB610-170
96" bar length, 10" Spacing	MLB610-171
120" bar length, 10" Spacing	MLB610-172
144" bar length, 10" Spacing	MLB610-173

Ø 1 3/4" BAR - 10MM TOOLING HOLES EVERY 6"	PART NUMBER
36" bar length, 6" Hole Spacing	MLB610-174
48" bar length, 6" Hole Spacing	MLB610-175
72" bar length, 6" Hole Spacing	MLB610-176
96" bar length, 6" Hole Spacing	MLB610-177
120" bar length, 6" Hole Spacing	MLB610-178
144" bar length, 6" Hole Spacing	MLB610-179

Ø 1 3/4" BAR - 10MM TOOLING HOLES EVERY 10"	PART NUMBER
36" bar length, 10" Hole Spacing	MLB610-180
48" bar length, 10" Hole Spacing	MLB610-181
72" bar length, 10" Hole Spacing	MLB610-182
96" bar length, 10" Hole Spacing	MLB610-183
120" bar length, 10" Hole Spacing	MLB610-184
144" bar length, 10" Hole Spacing	MLB610-185

## 3 SELECT DRIVE MOTOR OPTION

Drive motors fit to the rotational drive unit included in the base unit, they are reversible and final max bar rpm is quoted.



MOTOR OPTIONS	PART NUMBER
Pneumatic 2.2Hp / 1.7KW (166rpm)	MLB610-30
Pneumatic 4.0Hp / 3.0KW (60 rpm)	MLB610-31
Hydraulic 5.0HP / 3.7KW (100rpm)	MLB610-32
Hydraulic 5.0Hp / 3.7KW (32rpm)	MLB610-33
Electric 110v - 3.3HP / 2.5KW (8/160rpm)	MLB610-34
Electric 220V - 3.3HP / 2.5KW (8/160 rpm)	MLB610-35

## 4 SELECT DRIVE MOTOR CONTROL OPTION

All control options are built to suit the listed drive motors, (options available on request).



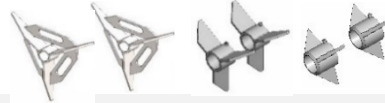
CONTROL OPTIONS	PART NUMBER
Pneumatic basic air caddy and e-stop	MLB610-40
Pneumatic full two button start. CE certified	MLB610-41
Hydraulic PP1 Electric HPU + control valves	MLB610-42
Hydraulic PP1 Diesel HPU + control valves	MLB610-43
Electric 110v control box	MLB610-44
Electric 220V control box	MLB610-45

## 5

LEADSCREWS	PART NUMBER
305mm (12") stroke leadscrew	MLB610-50
610mm (24") stroke leadscrew	MLB610-51
915mm (36") stroke leadscrew	MLB610-52

## 6 SELECT SETUP CONES

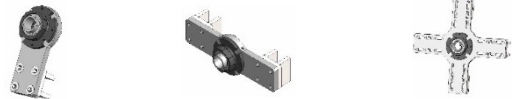
Setup cones for metric and inch bars (sold in pairs).



60MM BORING BAR SETTING CONES	PART NUMBER
60mm Bar Small Setup Cones (2.75 - 8.37")	MLB610-60
60mm Bar Medium Setup Cones (8.37 - 12")	MLB610-61
60mm Bar Large Setup Cones (12 - 24")	MLB610-62
60mm Bar Full Set of Setup Cones (2.75 - 24")	MLB610-63
2 1/4" BORING BAR SETTING CONES	PART NUMBER
2 1/4" Bar Small Setup Cones (2.75 - 8.37")	MLB610-64
2 1/4" Bar Medium Setup Cones (8.37 - 12")	MLB610-65
2 1/4" Bar Large Setup Cones (12 - 24")	MLB610-66
2 1/4" Bar Full Set of Setup Cones (2.75 - 24")	MLB610-67

## 7 SELECT MOUNTING OPTIONS

Mounting options to suit metric or imperial bars (supplied complete with bearing). Please note: 2 off typically required within standard set up.



60MM BORING BAR MOUNTING OPTIONS	PART NUMBER
Single arm Mount (1 Piece)	MLB610-70
Double arm Mount (1 Piece)	MLB610-71
Universal Mount (1 Piece)	MLB610-72
ID Mount (1 Piece)	MLB610-73
ID Face Adjusting Mount (1 Piece)	MLB610-74
Four Arm Mount (1 Piece)	MLB610-75
2 1/4" BORING BAR MOUNTING OPTIONS	PART NUMBER
Single arm mount (1 Piece)	MLB610-77
Double arm mount (1 Piece)	MLB610-78
Universal mount (1 Piece)	MLB610-79
ID Mount (1 Piece)	MLB610-80
ID Face Adjusting Mount (1 Piece)	MLB610-81
Four Arm Mount (1 Piece)	MLB610-82

## 8 SELECT ACCESSORIES

### BORING BAR ADAPTER COLLET SETS

Enables the same drive, feed, mounting and accessories to be used on different bar diameters.



COLLETS – COMPLETE SETS	PART NUMBER
60mm Collet Set. Feed, Drive, Tooling	MLB610-121
30mm Collet Set. Feed, Drive, Tooling, Bearing x2	MLB610-122
2 1/4" Collet Set. Feed, Drive, Tooling	MLB610-123
1 3/4" Collet Set. Feed, Drive, Tooling, Bearing x2	MLB610-124
1 1/4" Collet Set. Feed, Drive, Tooling, Bearing x2	MLB610-125

### MOUNTING BEARINGS

Bearings and Bearing Housings are sold separately.



MOUNTING BEARINGS	PART NUMBER
Mounting Bearing Housing. (Housing only, excludes Bearing).	MLB610-130
60mm Self-aligning Mounting Bearing. (Bearing only, excludes Housing).	MLB610-131
2 1/4" Self-aligning Mounting Bearing. (Bearing only, Excludes Housing).	MLB610-132

### TOOLING HEADS

Tooling heads are sold with left-hand tools and 10 inserts for general steel / stainless steel use, (others available on request).



60MM TOOLING HEADS	PART NUMBER
60mm Bar, 4"-12" Bore Kit 16mm Tooling	MLB610-140
60mm Bar, 12"- 24" Bore Kit 12mm Square Tooling	MLB610-141
2 1/4" TOOLING HEADS	
2 1/4" Bar, 4"-12" Bore Kit 16mm Tooling	MLB610-142
2 1/4" Bar, 12"- 24" Bore Kit 12mm Square Tooling	MLB610-143
30MM TOOLING HEADS	
30mm Bar, 1 1/2" – 4 1/2" Tooling Heads, 10mm Tooling	MLB610-144

### MICRO BORE KIT

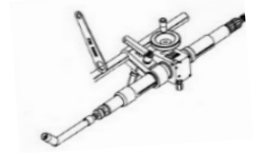
Designed to fit directly to the bar or into standard tooling adapters.



MICRO BORE KIT	PART NUMBER
Metric Micro Bore Tooling - 60mm bar - 3 tools	MLB610-146

### BORE WELDERS

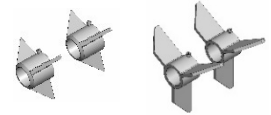
MLB interface bore welding systems 1-30" Ø



BORE WELDERS - METRIC BAR 60MM	PART NUMBER
60mm Bar Small Diameter Bore Welder (1 - 14")	MLB610-250
60mm Bar Large Diameter Bore Welder (1 - 30")	MLB610-251
BORE WELDERS – ADAPTOR KITS	
60mm Boring Bar Welder Mounting Bracket Adaptor (1-30")	MLB610-252
2 1/4" Boring Bar Welder Mounting Bracket Adaptor (1-30") & Collet Set	MLB610-253

### SET UP CONES

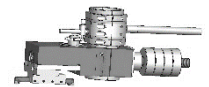
All setup cones for metric and inch bars (sold in pairs).



Ø 30MM BORING BAR SETTING CONES	PART NUMBER
30mm Bar, Small Setup Cones (1.5 - 3.5")	MLB610-192
30mm Bar, Medium Setup Cones (3.5 - 6")	MLB610-193
30mm Bar, Full Set of Setup Cones(1.5 - 6")	MLB610-194
Ø 1 1/4" BORING BAR SETTING CONES	
1 1/4" Bar, Small Setup Cones (1.5 - 3.5")	MLB610-195
1 1/4" Bar, Medium Setup Cones (3.5 - 6")	MLB610-196
1 1/4" Bar, Full Set of Setup Cones (1.5 - 6")	MLB610-197

### FACING HEADS

All facing heads supplied with trip and counterbalance.



FACING HEADS - METRIC BAR 60MM	PART NUMBER
Small Diameter Facing Head (1 1/2" - 15 1/2")	MLB610-200
Medium Diameter Facing Head (1 1/4" - 20")	MLB610-201
Large Diameter Facing Head (1 1/4" - 32")	MLB610-202

### SMALL BORE KITS



60 - 30mm Bar Set. Drive, Feed & Bearing Collets. Set Up Cones & Tooling.	MLB610-190
2 1/4" – 1 1/4" Bar Set. Drive, Feed & Bearing Collets. Set Up Cones & Tooling.	MLB610-191

## 8 SELECT ACCESSORIES (CONTINUED)

### TOOLING

Tool Holders for metric and inch boring bars and boring kits.



TOOLING - 16MM (FOR 4 -12" TOOLING HEADS)	PART NUMBER
16mm inserted tool holder - (For 4 - 6" Tooling Head Kit)	MLB610-300
16mm inserted tool holder - (For 6 - 8" Tooling Head Kit)	MLB610-301
16mm inserted tool holder - (For 8 - 12" Tooling Head Kit)	MLB610-302
TOOLING - 12MM (FOR 12 -24" TOOLING HEADS)	
12mm inserted tool holder (for 12 -24" Tooling Head Kit)	MLB610-303
TOOLING - 10MM (FOR 1.5 - 4" TOOLING HEADS)	
10mm inserted tool holder - 25mm (For 1.5" - 4" Tooling Head Kit)	MLB610-308
10mm inserted tool holder - 45mm (For 1.5" - 4" Tooling Head Kit)	MLB610-309
10mm inserted tool holder - 65mm (For 1.5" - 4" Tooling Head Kit)	MLB610-310
TOOLING - 16MM (FOR 4 - 12" TOOLING HEADS - REDUCES DIAMETER TO 2.5")	
16mm inserted tool holder + adjusting screw (For 4 - 12" Tooling Head Kit - reduces diameter to 2.5")	MLB610-314

### TOOLING INSERTS

Tooling Inserts for metric and inch boring bars and boring kits.

TOOLING INSERTS	PART NUMBER
Carbide Inserts for 16mm tooling (General grade steel / stainless steels)	MLB610-316
Carbide Inserts for 12mm tooling (General grade steel / stainless steels)	MLB610-317
Carbide Inserts for 10mm tooling (General grade steel / stainless steels)	MLB610-318
Carbide Inserts for Microbore tooling (General grade steel / stainless steels)	MLB610-319
DRILLING ACCESSORIES	
Drill stand and front support bearing -( requires single arm support to mount Drive unit)	MLB610-330
60mm bar, 5MT / 1/2" parallel bore - for 12" stroke	MLB610-331
60mm bar, 5MT / 1/2" parallel bore - for 24" stroke	MLB610-332
60mm bar, 5MT / 1/2" parallel bore - for 36" stroke	MLB610-333
Drill Morse Taper sleeve set (5-4, 4-3, 3-2)	MLB610-334
MAGNETIC DIAL INDICATOR	
50mm magnetic back plunge type dial test indicator	MLB610-340
Bar Mounting (16mm) magnetic back dial test indicator holder	MLB610-341
BORE MEASURING	
12" max diameter electronic digital caliper	MLB610-342
24" max diameter electronic digital caliper	MLB610-343
Manual Bore Measuring to 12"	MLB610-344
Digital Bore Measuring to 24"	MLB610-345