

# BB5000 24" Facing Head Accessory

## FEATURES ■ TECHNICAL DATA

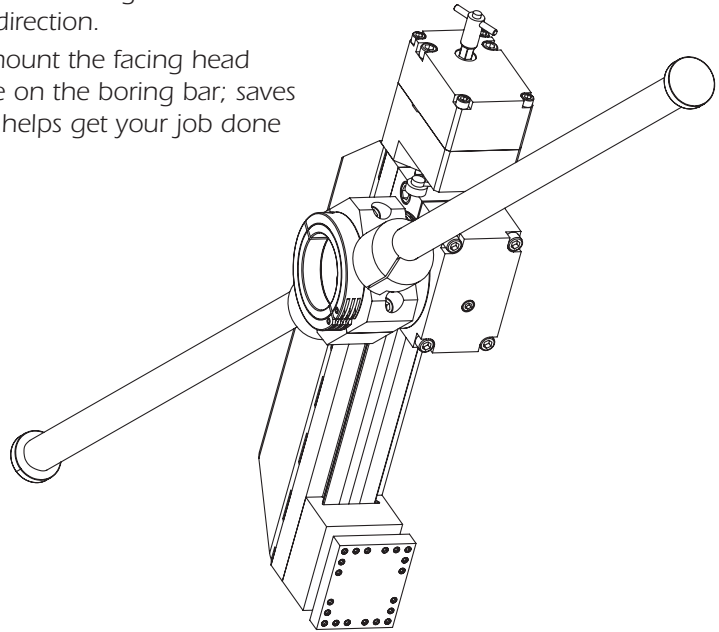
### For the BB5000 Portable Boring Machine

#### Robust, high quality facing head expands BB5000 capabilities

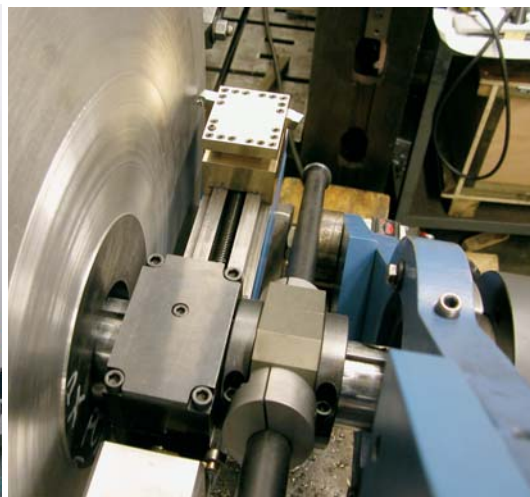
- This rugged, heavy-duty facing head has a much higher removal rate to handle large diameter facing jobs with ease.
- Broad facing range, from 2.25 to 24 inches (57.2 - 609.6 mm) without repositioning.
- Swing diameter from 20.1 to 25.3 inches (510.5 to 642.6 mm).
- Simple and robust feed trip mechanism moves the carrier inward or outward automatically.
- Rigid tool carrier and slide assembly.
- Automatic radial feed is provided by a trip-activated feed mechanism that advances from 0 to 0.011 inches (0 to 0.279 mm) per revolution.

#### Easy, flexible setup and operation

- The adjustable facing head will face in either direction.
- Quickly mount the facing head anywhere on the boring bar; saves time and helps get your job done quickly.



### Application Photos



## Specifications

	<b>US</b>	<b>Metric</b>
Facing Diameter	2.25 – 24.0	57.2 – 609.6
Swing Diameter (Turning arm can be repositioned)	20.1 – 25.3	510.5 – 642.6
Feed, Feed Rate	Automatic, 0 – 0.11/revolution	Automatic, 0 – 2.794/revolution
Operating Weight	40 lbs	18.2 kg
Shipping Weight	110 lbs	49.9 kg
Shipping Dimensions (shipped in 1 container)	38-1/8 x 17-13/16 x 6-1/8 inches	968.4 x 452.4 x 155.6 cm

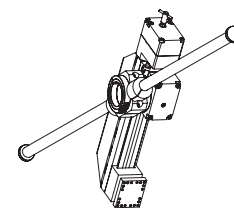
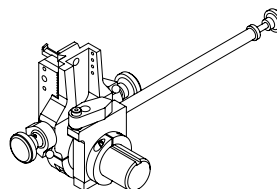
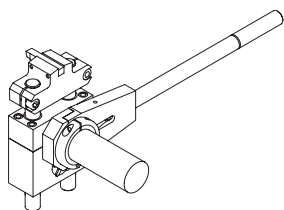
### Machining Example #1

Material:	A-36 steel plate
Motor:	Hydraulic with 11.3 in <sup>3</sup> (185.2 cm <sup>3</sup> ) displacement (Climax PN 21532)
HPU/Flow:	5 Hp, 4.7 gpm (5 Hp, 17.8 L/min)
Feed Rate:	0.004 inches (0.102 mm) per revolution
Feed Direction:	Feeding in
Bar RPM:	24
Depth of Cut:	0.020 inches (0.508 mm)
Surface Finish:	250 µin
Flatness:	0.003 over 20 inches (0.08 over 508 mm)
Tool Bit:	HSS cutter (Climax PN 32344)
Bearing Spacing:	49.5 inches (1257.3 mm) from back side of bearing mounts
Cutting Oil:	None
Machine Orientation:	Boring bar mounted vertically with 2 double arm mounts

### Machining Example #2

Material:	A-36 steel plate
Motor:	Electric 112/55 bar RPM (Climax PN 37557)
Feed Rate:	0.007 inches (0.178 mm) per revolution
Feed Direction:	Feeding in
Bar RPM:	24
Depth of Cut:	0.030 inches (0.762 mm)
Surface Finish:	350 µin
Flatness:	0.002 over 15 inches (0.051 over 381 mm)
Tool Bit:	HSS cutter (Climax PN 32344)
Bearing Spacing:	49.5 inches (1257.3 mm) from back side of bearing mounts
Cutting Oil:	None
Machine Orientation:	Boring bar mounted horizontally with 2 double arm mounts

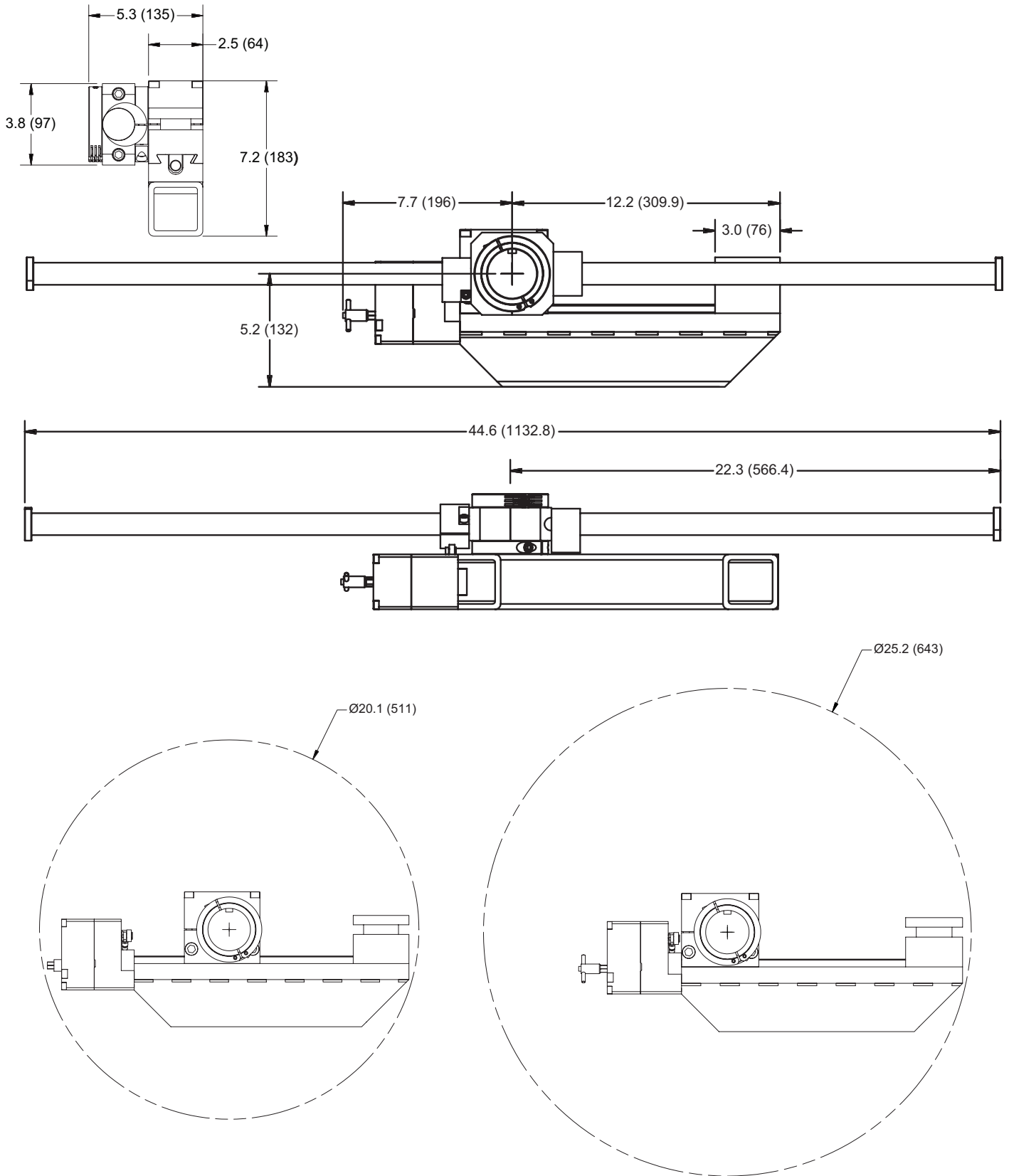
## Ordering Information



Climax PN	31412	30051	30044	36936	36954	45040
Item Name	Adjustable Range Facing Heads			Facing & Grooving Heads		Heavy Duty Facing Head
Bar Dia.	1.25 inch (31.8 mm)	2.0 inch (50.8 mm)	2.25 inch (57.2 mm)	2.25 inch (57.2 mm)	2.25 inch (57.2 mm)	2.25 inch (57.2 mm)
Swing Dia.	6.6 - 9.4 inches (167.6 - 238.8 mm)	9.1 - 22.2 inches (231.1 - 563.9 mm)	10.0 - 18.6 inches (254 - 472.4 mm)	13.5 inches (342.9 mm)	20.3 inches (515.6 mm)	20.1 - 25.3 inches (510.5 - 642.6 mm)
Facing Dia.	2.1 - 8.8" (53.3 - 223.5 mm)	2.5 - 18" (63.5 - 457.2 mm)	2.5 - 18 inches (63.5 - 457.2 mm)	2.5 - 12 inches (63.5 - 304.8 mm)	2.5 - 19.0 inches (63.5 - 482.6 mm)	2.25 - 24.0 inches (57.2 - 609.6 mm)
Grooving Dia.	n/a	n/a	n/a	4.0 - 12.0 inches (101.6 - 304.8 mm)	4.0 - 19.0 inches (101.6 - 482.6 mm)	3.3 - 24.0 inches (83.8 - 609.6 mm)

## Operational Dimensions

Dimensions in inch (mm)



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