



Anytime. Anywhere. (™)

## D.L. Ricci Corp. Case Study #333

# "Boring Under"

### Set-Up:

- Our Australian Rep. Mr. Park Johnstead operates FMT which is strictly sales & rental
- Park's expertise is in supplying the equipment and everything they will need
- Often, his machining expertise is required as his customers are first time users and the equipment is adapted to exactly fit the particular machining application
- This rock crusher job required its' jaw saddles welded and line bored to standard

### Plan:

- Park had a D.L. Ricci Corp. 4" Portable Feed Screw Boring Bar ready for the job
- Some adjustments were required to prep the boring bar for mounting on-site
- The following specs and times were accurately recorded by Park

### Operation:

- Set-up time with 2 man team and overhead bay crane: 4 hours  
(includes making a set of wood cradles to hold the bar in hole center)
- Machine one hole through 4 passes to finished size: 4 hours
- Finish second hole to size and tear down: 4 hours
- Hole Diameter: 640mm
- Length of Bores: 10"                      - Distance Apart: 40"
- Surface Finish: 125 or better      - Bar Speed: 70rpm
- Tolerance Held: Diameter within .003"
- Tooling: Roughing, 1/2 shank HSS 5% cobalt, Finish 1/2 shank brazed carbide
- Pump: 20hp x 20gpm (self compensating piston pump)
- Weld Metal Hardness: Rcwl C-30

### Results:

- The customer was impressed by the finish and the professional equipment
- The operator hired by the Rock Crushers was a first time user of our 4" Boring Bar

