CADET Line Boring Machine And Accessories Catalogue

Portable - Powerful - Flexible - Easy to Use
CADET Line Boring Machine

This general use line boring machine is perfect for contractors who are concerned about maintaining their own equipment. Whether you have a fleet of 10 or 300, the CADET will reduce your heavy equipment down time and allow you to schedule repairs to suit your needs.

The variable two speed electric bar rotation drive motor features a wide range of boring speeds. 30 - 75 Rpm in first gear, and 90 - 230 Rpm in second gear. These speeds will allow the user to use high speed steel or brazed carbide cutting tools. The feed system features bi-directional adjustable feed speed with rapid traverse.

It’s hard to beat the value packed into this machine. All the features you
CADET Line Boring Machine

York Cadet Drive and Feed Carriage

- 12" (304.8mm) cutting tool travel
- Feed Speeds of .3 to 10" per/min (8-254mm/min)
- Feed Torque 140" lbs (15.8Nm)
- Rapid Traverse: 15" per/min (381mm/min)
- Weight: 80lbs (36kg)
- Eibenstock variable 2 speed bar rotation drive 30/75-95/230 RPM
- Comes in an aluminum storage chest

Note: General use machine - cannot be substituted or upgraded, works with all bar packages and options.

Part Number: CAD-000-110V (Must use transformer for 220 volt applications)

Portable - Powerful - Flexible - Easy to Use
Choose from our Suggested Bar Packages

A) Premium Plus Package: 1.5 to 16” (38 to 406mm)
Complete 5 bar package that covers the entire operating range of the 4-14. This is a very dynamic package designed for those who work on a wide range of large and small bores.
Part Number: P-1

B) Premium Package: 1.5 to 10” (38 to 254mm)
Complete 5 bar package that is designed for those in the heavy equipment industry that work on bores up to 10 inches, this kit can be easily upgraded at any time to 16” (406mm) diameters.
Part Number: P-2

C) Standard Package: 2.5 to 6” (63.5 to 152mm)
3 bar package using our 2” (52mm) boring bars. Small bars can be added at any time if required.
Part Number: P-3

D) Combo Package: 1.5 to 6” (38 to 152mm)
Kit is designed to meet the needs of most equipment owners. This kit is upgradeable by adding components as needed.
Part Number: P-4

E) Small Bore Package: 1.5 to 3” (38 to 76mm)
2 bar package is designed for our 1-1/4” (32mm) bars for small diameters, we have an upgrade kit that can be added to reach 5” (127mm) using our 1 1/4” (32mm) bars.
Part Number: P-5

<table>
<thead>
<tr>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
</tr>
</thead>
<tbody>
<tr>
<td>1 1/4” Bar Package</td>
<td></td>
<td></td>
<td></td>
<td></td>
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<td>1</td>
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<td>4 Foot Bar</td>
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<tr>
<td>1</td>
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<td>6 Foot Bar</td>
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</tr>
<tr>
<td>2</td>
<td>2</td>
<td>2</td>
<td>3” Line-up Cones</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>2</td>
<td>1</td>
<td>Mounting Head</td>
<td></td>
</tr>
<tr>
<td>2</td>
<td>2</td>
<td>1</td>
<td>Bore weld Interface</td>
<td></td>
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<tr>
<td>2</td>
<td>2</td>
<td>2</td>
<td>Tail Support</td>
<td></td>
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<tr>
<td>2</td>
<td>2</td>
<td>2</td>
<td>Clamping Collars</td>
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<tr>
<td>1</td>
<td>1</td>
<td>1</td>
<td>Calibration Tool</td>
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<td>1</td>
<td>1</td>
<td>1</td>
<td>Accessories Tool Box</td>
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| 2” Bar Package |
|---|---|---|---|---|
| 1 | 1 | 1 | 3 Foot Bar |
| 1 | 1 | 1 | 5 Foot Bar |
| 1 | 1 | 1 | 7 Foot Bar |
| 2 | 2 | 2 | 2”-4” Line-up Cones |
| 2 | 2 | 2 | 4”-6” Line-up Cones |
| 2 | 2 | 6”-8” Line-up Cones |
| 2 | 8”-10” Line-up Cones |
| 1 | 8”-16” Line-up Spiders |
| 2 | 2 | 2 | Mounting Head |
| 2 | 2 | 2 | Bore welder Interface |
| 1 | Adjustable X/Y Mounting Kit |
| 2 | Tail Support |
| 2 | 2 | 2 | Clamping Collars |
| 1 | 1 | 1 | Calibration Tool |
| 1 | 6-10” Big Bore Adaptor |
| 1 | 10-13” Big Bore Adaptor |
| 1 | 13-16” Big Bore Adaptor |
| 1 | Accessories Tool Box |

2 1/4” (58mm) Bars now available using our Hydraulic drives – bore up to 24”(609mm)

Chrome Plated Bars Available as an Option

Custom packaging is also available. All our bars can be supplied with either imperial or metric tool ports.
# 2" (50.8mm) Boring Bars & Accessories

## 2" (50.8mm) Mounting Head
- Two bearings for added support
- One bore welder mounting plate included
- Alignment adjusting screws

**Part Number:** 414-201  
**Replacement Inserts**  
**Part Number:** 414-201A

## 2" (50.8mm) Tail Support
- 4 bolt flange bearings on replaceable mounting plates

**Part Number:** 414-202  
**Replacement Weld Plate**  
**Part Number:** 414-202A  
**Replacement Flange Bearing**  
**Part Number:** 414-202B

## X/Y Adjustable Mounting Kit
- Freedom to move - the X/Y mounting head allows you to move the bar 5/8" (15.8mm) in any direction from center. You also have a 6 degree spherical adjustment. This feature is a huge asset for bores larger than 10" (254mm) that might require an extra degree of precision alignment.

**Part Number:** 414-309 (Kit)  
**Adjustable X/Y Mounting Head only**  
**Part Number:** 414-310  
**Adjustable X/Y Tail Support only**  
**Part Number:** 414-330
# 2" (50.8mm) Boring Bars & Accessories

## 2" Diameter (50.8mm) Boring Bars
- Staggered 1/2" tool ports every three inches along the bar.
- Tool ports are broached and threaded.
- Bars are made from C1045 precision ground shafting.
- Available chrome plated and polished.

### 3’ Bar
- **Part #** 414-213-36 Polished Bar
- **Part #** 414-213-36C Chrome Bar

### 5’ Bar
- **Part #** 414-213-60 Polished Bar
- **Part #** 414-213-60C Chrome Bar

### 7’ Bar
- **Part #** 414-213-84 Polished Bar
- **Part #** 414-213-84C Chrome Bar

*Note: For Metric bars place an M at the end of the part number.*

Custom bars and lengths available on request.

## 2" (50.8mm) Line-Up Cones
- Steel cones
- Precision alignment
- Relieved in the back to reduce weight.

### 2 to 4” (50.8 to 101.6mm)
- **Part Number:** 414-203

### 4 to 6” (101.6 to 152.4mm)
- **Part Number:** 414-204

### 6 to 8” (152.4 to 203.2mm)
- **Part Number:** 414-215

### 8 to 10” (203.2 to 254mm)
- **Part Number:** 414-214
### 2" (50.8mm) Boring Bar Accessories

#### 2" (50.8mm) Adjustable Line-Up Tool (Spider)
**For bores 8"- 16" (203mm—406.4mm)**
- For aligning and centering the bar when working with bores larger than 8” (203mm). The line up tool dials out to the diameter that you need.
- The kit comes in a custom carrying case, with two centering tools and four sets of extensions
**Part Number:** 414-501

#### 2" (50.8mm) Clamping Collars
- To secure the line up cones in place during set up
- Split collar with allen head screws
**Part Number:** 414-205

#### 2" (50.8mm) Calibration Wrench
- The calibration wrench allows accurate cutting tool adjustment in increments of .001”. All of our boring bars have broached and threaded tool ports with a scribed line on center. We put an adjusting screw at the base of the cutting tool that the calibration wrench fits into. There are 50 graduations on the wrench. With each graduation past the scribed line the cutting tool advances .001”
**Part Number:** 414-207 (c/w 5 cutting tool adjusters)

**Cutting Tool Adjusters**
**Part Number:** 414-206
(sold in package of 5)
2" (50.8mm) Accessories

2" Accessories Tool Box

Includes:
- Tool box (26”)
- Set screws
- Sample Micro 100 carbide tooling
- Wrenches
- Allen keys

Part Number: 414-250

2" (50.8mm) Large Bore Adapters

- The York large bore adapters clamp securely to our 2” (50.8mm) boring bar. The large bore adapter supports the tool bit to accommodate larger bores over 6” (152mm) in diameter. The 6-10” (152-254mm) adapter can be used with the York calibration wrench and is our standard adapter. Custom large bore adapters are also available for 10-13” (254-330mm) and 13-16” (330-406mm)

6 to 10” (152.4 to 254mm)
Part Number: 414-303

10 to 13” (254mm to 330.2mm)
Part Number: 414-301

13 to 16” (330.2 to 406mm)
Part Number: 414-302
1-1/4" (32mm) Accessories

1 1/4" (32mm) Mounting Head
- Two bearings for added support
- One bore welder mount plate included
- Alignment adjusting screws

Part Number: 414-101

Replacement Inserts
Part Number: 414-101A

1 1/4" (32mm) Tail Support
- 4 bolt flange bearing on a replaceable mounting plate

Part Number: 414-102

Replacement Weld Plate
Part Number: 414-102A

Replacement Flange
Part Number: 414-102B

1 1/4" (32mm) Line-Up Cones
- Steel cones 1 1/4 to 3” and 3 to 5”
- Precision alignment
- 1 1/4” to 3”
- 3” to 5”

1 1/4” to 3” (32 to 76mm)
Part Number: 414-103

3” to 5” (76 to 127mm)
Part Number: 414-104
**1 1/4" (32mm) Boring Bars and Accessories**

**1 1/4" (32mm) Boring Bars**
- Staggered 3/8" (9.5mm) tool ports every 3" (76.2mm) along the bar
- Tool ports are broached and threaded
- Bars are made from C1045 precision ground shafting
- Available chrome plated and polished

**4’ Bar**
- **Part Number:** 414-113-48 Polished bar
- **Part Number:** 414-113-48C Chrome bar

**6’ Bar**
- **Part Number:** 414-113-72 Polished bar
- **Part Number:** 414-113-72C Chrome bar

*Note: For Metric bars place an M at the end of the part number*

**Custom bars and lengths available on request**

**1 1/4" (32mm) 3-5" (76 to 127mm) Large Bore Adaptor**
- This adaptor is used to support tooling for bores greater than 3”. It will help reduce tool breakage and chatter. For maximum success we recommend using our 2” bars for bores greater than 3”

- **Part Number:** 414-307

**1 1/4" (32mm) Clamping Collars**
- Used to secure the line up cones in place during set up
- Spit collar with allen head screw

- **Part Number:** 414-105
1-1/4" (32mm) Accessories

**1 1/4" (32mm) Calibration Wrench**

- The calibration wrench allows accurate cutting tool adjustment in increments of .001”. All of our boring bars have broached and threaded tool ports with a scribed line on center. We put an adjusting screw at the base of the cutting tool that the calibration wrench fits into. There are 50 graduations on the wrench. With each graduation past the scribed line the cutting tool advances .001”.

**Part Number:** 414-107  
(c/w 5 cutting tool adjusters)

**Cutting Tool Adjusters**  
**Part Number:** 414-106  
(sold in package of 5)

**1 1/4" (32mm) Accessories Tool Box**

**Includes:**
- Tool box (21”)
- Set screws
- Sample Micro 100 carbide tooling
- Wrenches
- Allen keys

**Part Number:** 414-150
Optional Accessories

**Facing Tools**
- The York facing tools are designed to machine surfaces 90 degrees to the bore. The facing tool attaches to our 2" (50.8mm) boring bar. Two tool ports are set in the facing tool; one at 45 degrees and the other at 90 degrees. Each revolution of the bar actuates a gear driven lead screw that advances the cutting tool .005" (.127mm).

**Part Number:** FT-1000 Max 10” (254mm)

**Part Number:** FT 9000 Max 18” (457mm)

**Off-Set Drive**
(A unique feature no one else has)
- Our offset drive feature allows more flexibility than through the bar designs. The York line-boring machine is an excellent choice for working in constricted areas, as the driveline allows 30 degrees offset in any direction from the boring bar alignment.

**Part Number:** OFF-000

**Carbide Insert Tool Package**
1/2" (12.7mm)
- The York insert tool places the carbide cutting surface into the center of the bore - substantially improving cutting tool performance while extending tool holder life. Our tool holders use standard inserts that are readily available from most cutting tool suppliers. Insert tooling takes the guesswork out of tool geometry and improves the overall performance of your line-boring machine.

**Part Number:** ITK-000
Optional Accessories

**Thru Bar Measuring Kits**
1.9 - 12" (48.26 - 304.8mm) or 
1.9- 16" (48.26—406.4mm) Diameters

- Our thru-bar measuring tool allows you to accurately measure the bore without removing the bar. The measuring tool is placed into an adjacent tool port and traversed into the bore. By loosening the setscrew, the spring loaded measuring tool snaps opens - capturing the size of the bore. Tighten the setscrew and traverse the tool from the bore. Pull the measuring tool out of the bar. Using a micrometer, measure the thru-bar tool for the diameter of the bore.

**1.9" to 12" (48.26 to 304.8mm)**  
**Part Number:** MT2-1000

**1.9" to 16" (48.26 to 406.4mm)**  
**Part Number:** MT2-2000

**Snap Ring Tool**
- 3.8 to 7" (96.5 to 177.8mm)
- 5/8" stroke (15.8mm)
- Hydraulic feed
- Accurate adjustment

**Part Number:** SR- 000

**Ripper Shank Repair Kit**
- A unique option that saves having to pull the tracks to repair worn bores on D-9 to D-10 Cat

(*Call us for kits to repair other models)

**Part Number:** RIP-000
Optional Accessories

Micro 100 Brazed Carbide Cutting Tools
- Micro 100 is highly shock resistant, will not chip or break under normal machining conditions and is unexcelled in interrupted cutting. Micro 100 carbide is a space age carbide with superior rupture strength for exceptional machining versatility.

#6 - 3/8” P.O.R
Part Number: AR-6 or AL-6 MICRO 100 “A” Style
Part Number: BR-6 or BL-6 MICRO 100 “B” Style

#8 - 1/2” P.O.R
Part Number: AR-8 or AL-8 MICRO 100 “A” Style
Part Number: BR-8 or BL-8 MICRO 100 “B” Style

Bore Welder Adaptor Plates
Part Number: 414-212
(Sold in package of 2)

* NOTE: Will work with most brands of bore welders

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