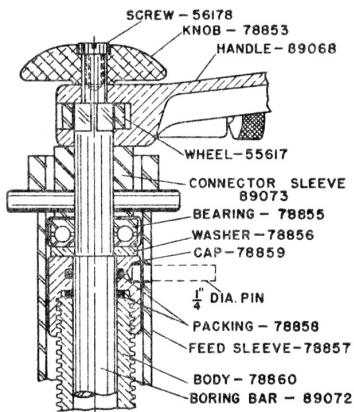




**“T” Drilling  
Machine**

**Reliable Connections™**

### Boring Bar Handling Instructions

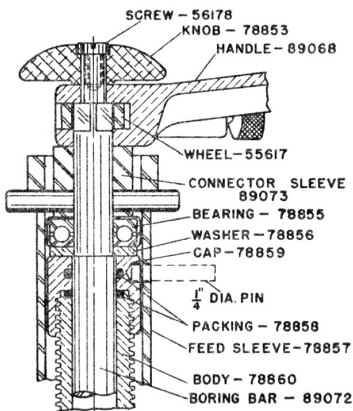


### Removal

1. Remove boring bar screw (56178).
2. Remove knob (78853), ratchet handle (89068) and wheel (55617), feed sleeve connector (89073), thrust bearing (78855) and thrust washer (78856).
3. Position feed sleeve (78857) on body (78860) until one of the holes in the upper end of feed sleeve aligns with hole in packing cap (78859).
4. Hold body rigid, preferably in a vise. Insert a 1/4" dia. pin through feed sleeve hole into packing cap.
5. With pin held in position, rotate feed sleeve counter-clockwise, which removes packing cap from body.
6. Slip packing cap off boring bar and remove "O" ring packing (78858) from recess in cap and top end of body.

*(continued)*

## Boring Bar Handling Instructions (*continued*)



### Replacement

1. Clean Boring Bar (89072) and lubricate with machine oil.
2. Place new "O" ring packing (78858) in recess at top end of body (78860).
3. Place new "O" ring packing (78858) in internal recess in packing cap (78859).
4. Slide cap (78859) down onto boring bar until it contacts body.
5. Position hole in feed sleeve (78857) in alignment with hole in packing cap (78859).
6. With body held rigid, insert a 1/4" dia. pin through aligned feed sleeve and packing cap holes and rotate feed sleeve clockwise until packing cap is securely tightened onto body.
7. Replace thrust washer (78856), thrust bearing (78855) positioned with metal covering toward top, sleeve connector (89073) with pins to the lower side, ratchet handle (89068) and wheel (55617), knob (78853) and screw (56178).

### Phone: (800) 423-1323

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