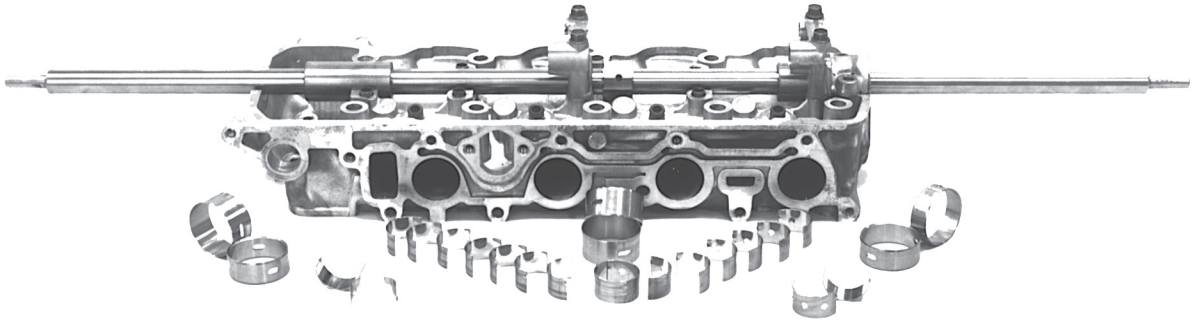
THE REVOLUTIONARY NEW WAY TO REBUILD ALUMINUM HEADS with the

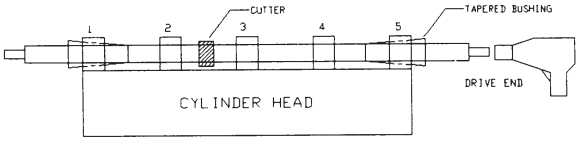
Dura-Bond® Boring System

O.H.C. Cutter System & Bearings for Aluminum Cylinder Heads



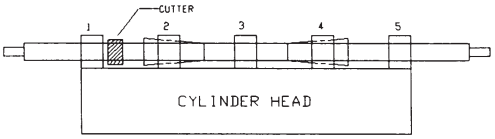
Features: Tapered bushings provide self alignment • No lengthy set up time • Bar is driven by a $^{1}/_{2}$" electric or air drill motor • "No chatter." Cutters cut and ream to a factory finish in one operation.

Our **Quick Bore System** enables you to bore a complete cylinder head and install new repair bearings in approximately 25 minutes rather than 45 minutes or longer required by other systems.



FIRST BORING PASS

RECOMMENDED BUSHING PLACEMENT IN THIS CONFIGURATION TO BORE #2, #3, AND #4.



SECOND BORING PASS

RECOMMENDED BUSHING PLACEMENT IN THIS CONFIGURATION TO BORE OUTER HOUSINGS. UTILIZE RING BUSHINGS TO SUPPORT DRIVE BAR BUSHINGS.

- Cylinder heads that are warped extensively should be straightened before line boring.
- Extra long Drive Bar allows cutting of Multi-Housings.
- Electric drill with 1/2" chuck is used to drive the bar (500 - 600 RPM).
- Tapered bushings (.005 Taper) provide self alignment and eliminate hours of set up time and expensive fixtures. Use ring bushings around drive bar bushings to mount in bored housings.
- Cutters are designed to cut and ream in one operation. New three angle cutter design requires only light pressure to feed cutter through bore and because there is no chatter, cutter leaves a factory finish.
- Our system enables a complete cylinder head to be bored and five new bearings installed in under 20 minutes rather than 45 minutes or longer required by other systems.*
- Cutter locks on Drive Bar with two set screws.
- Push cutter through one time. DO NOT REAM TWICE. DO NOT PULL CUTTER BACK THROUGH FINISHED BORED HOUSING.
- Use a constant flow of penetrating oil when cutting. This is a must to wash away cutting chips and achieve a finish necessary to install the bearing set.
- If cutter binds or stops in bore loosen the cap, do not reverse cutter rotation, this will cause breakage of carbide. Lightly work out by hand or tap straight back on bar with mallet.

Refer to our data sheet for bearing, application, cutter, and bushing sizes.
*As tested and time studied at Dura-Bond Bearing Company.