



**PATRIOT**  
HIGH ★ PERFORMANCE

# STEALTH™ BORING BARS





PATRIOT HIGH PERFORMANCE

**ULTRA-DEX<sup>®</sup>**

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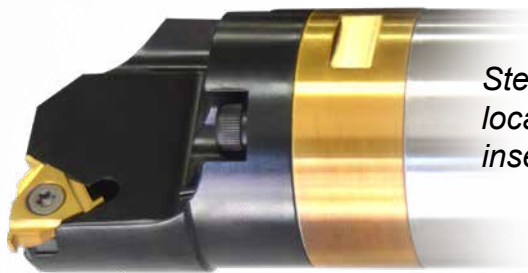
**View our complete Patriot High Performance Stealth  
catalog digitally at [archcuttingtools.com](http://archcuttingtools.com)**

Choosing the largest possible bar size with the shortest overhang will provide rigidity to minimize vibrations.

Make sure to allow clearance for chips.

5:1 Stealth bars are recommended for grooving and threading where forces are higher than in turning.

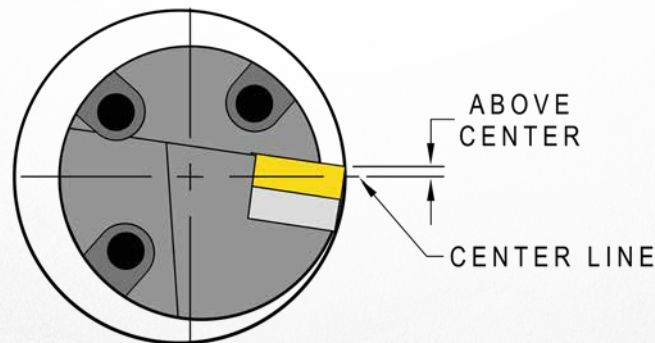
Proper clamping of the bar is crucial to performance.  
(set screws should not come in contact with the bar)



*Stealth bars  $\phi 1.0$ " and larger have a flat located on the gold ring to indicate the insert on center line.*

Overhang is measured from cutting edge to face of boring bar holder.  
Bars should not be extended past the specified diameter to length ratio.  
The Bars can be modified to reduce overall length .

To compensate for bar deflection due to extended overhangs, rotating the insert above center line will help.



## Split Collar System

To assure the best rigidity of the boring bar, the Split Collar System is the best holder. This process is achieved by locking the bar 360° on the diameter.



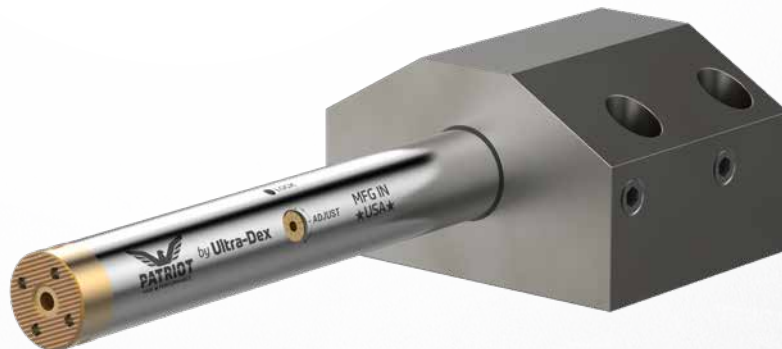
## Split Bushing System

If set screws are to be used, a split bushing must be placed on the bar before placing in the machine. Set screws will contact the bushing and tighten around the bar.



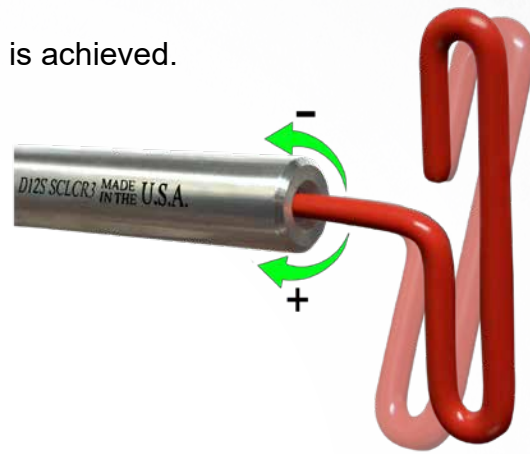
## Set Screw Lock System

Do not lock in the boring bar with set screws. This creates very poor rigidity when there is one point of contact.



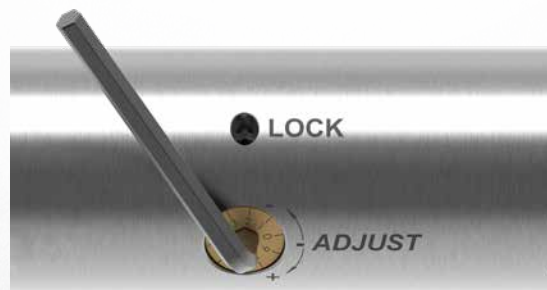
### For Bars $\varnothing.75''$ and Smaller

1. Make a test cut with the bar.
2. Insert supplied T-handle wrench into the end of the bar.
3. If the pitch of the chatter was high, tighten the adjust screw 1/16 turn.(+)
4. If the pitch of the chatter was low, loosen the adjust screw 1/16 turn.(-)
5. Make a test cut with the bar.
6. Repeat step 3 until the desired performance is achieved.

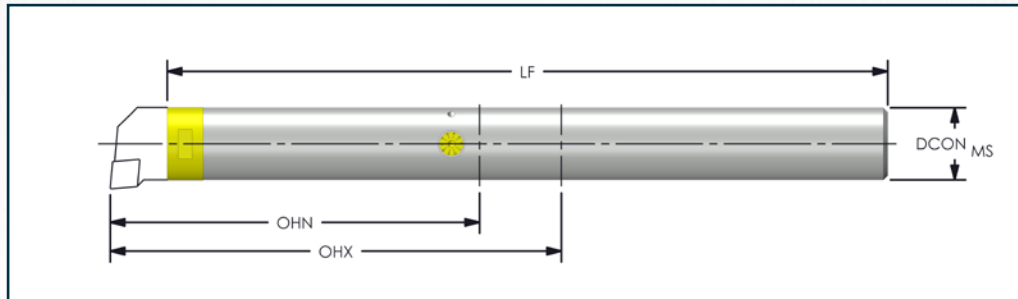


### For Bars $\varnothing 1.0''$ and Above

1. Make a test cut with the bar.
2. Loosen lock screw two complete turns in the negative direction.
3. If the pitch of the chatter was high, tighten the adjust screw 1/2 digit.(+)
4. If the pitch of the chatter was low, loosen the adjust screw 1/2 digit.(-)
5. Make a test cut with the bar.
6. Repeat step 3 until the desired performance is achieved.
7. Tighten lock screw. DO NOT over tighten lock screw.



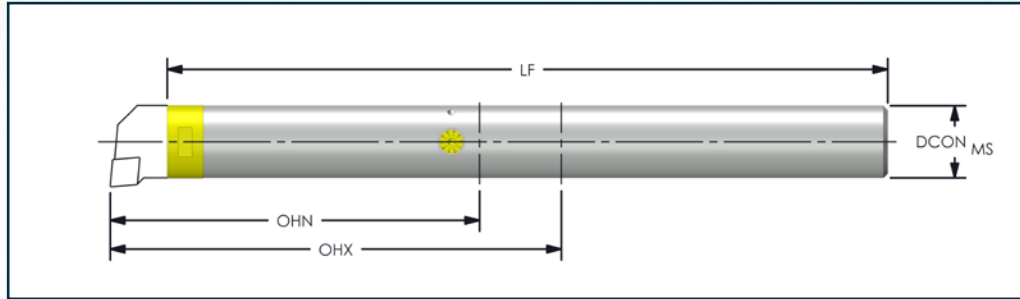
**HANGOUT SPECS**



**5:1 Ratio**

	DCONms	OHN	OHX	LF	Weight (LBS)
<b>5:1 Ratio</b>	1.000	5.750	7.50	9.00	4.5
	2.000	6.375	10.00	12.00	10.7
	2.500	6.750	12.50	16.00	22.8
<b>7:1 Ratio</b>	1.000	5.000	7.00	10.00	2.2
	1.250	5.000	8.75	12.00	4.1
	1.500	5.750	10.50	15.00	7.5
	1.750	6.000	12.25	18.00	11.3
	2.000	6.375	14.00	20.00	18.0
<b>10:1 Ratio</b>	2.500	6.750	17.50	27.00	42.0
	3.000	12.500	21.00	31.00	63.0
	1.000	6.000	10.00	14.00	3.1
	1.250	6.750	12.50	16.00	5.7
	1.500	9.000	15.00	19.00	11.0
	1.750	10.625	17.50	23.00	17.0
	2.000	12.375	20.00	26.00	25.0
	2.500	15.875	25.00	33.00	42.0
	3.000	19.375	30.00	40.00	88.0
	4.000	26.375	40.00	50.00	182.0

HANGOUT SPECS  
CARBIDE REINFORCED



**12:1 Ratio**

DCONms	OHN	OHX	LF	Weight (LBS)
1.000	9.250	12.00	16.00	5.9
1.250	12.160	15.00	18.00	9.0
1.500	14.750	18.00	22.00	16.4
1.750	16.435	21.00	25.00	25.4
2.000	17.750	24.00	29.00	37.7
<b>14:1 Ratio</b>				
1.000	9.250	14.00	18.00	6.9
1.250	12.160	17.50	22.00	10.9
1.500	14.750	21.00	25.00	18.6
1.750	16.435	24.50	29.00	31.0
2.000	17.750	28.00	33.00	44.2



**Customer Service**

**888-390-2050**

**or**

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