

Supplies & Options

Order Information

1291 Small Engine Boring Fixture	057-1291-07
054 Heavy Duty Boring Fixture	054-0000-35
Single Cylinder Mounting Kit	054-1310-00
Air Float & Clamp Assembly	053-6000-18
Special Anchor Bolt for 054 boring fixture (Van Norman Boring Bars)	054-0000-96

Formula I Boring Bar Tools:

Single Pass - Solid carbide, rough cut	062-1071-50
Counterbore - Solid carbide, cut off sleeves	062-1074-50
45° Offset - Suitable for blind holes in manual center bars (Requires 45° offset toolholder & offset lapping fixture)	062-1251-50

Formula II Boring Bar Tools:

Formula II - Roughing (rough cut, single pass)	062-1071-03
Formula II - Finishing (fine cut, smooth finish, limited stock removal)	062-1072-00
Formula II - Counterbore (Cut off sleeves, counterbore blocks)	062-1074-05
60° Chamfer (Chamfer top of cylinder)	062-1076-00
Formula II 45° Offset * (Suitable for blind holes in manual center bars)	062-1251-60
Formula II 60° Offset * (Suitable for blind holes in manual center bars)-requires wide-face micrometer	062-1251-03

* Requires offset toolholder & offset lapping fixture

Contact Your Local Distributor Today

Or Call 800-553-5953

(1+ 319-377-9421 outside the US)



Single Cylinder Mounting Kit:
Optional kit for mounting single cylinders in the 054 Fixture



Air Float & Clamp Assembly:
Optional float and clamp assembly adds air float feature to FN bars when used on the 054 HD Boring Fixture



Block Lifting Fixture:
Quickly load large or small blocks (in-line or V configurations) simply by inserting the round support bar of the boring fixture through the mains. Lift-arm detaches after cylinder block is in place.



054 Engine Dolly:
The optional dolly permits fast, easy loading of blocks into the 054 fixture.

Formula I Carbide Boring Tools:

Solid carbide tools incorporate the latest technology - superior fracture resistance and exceptional machining versatility.

Ideal For:

- Automotive High Performance cylinders (nickel alloy & hard material)
- Marine engines; hard alloys or chrome cylinders and interrupted cuts
- Motorcycle cylinders; two and four-stroke; hard alloy liners
- Diesel engine sleeving and counterboring



Formula I Carbide Boring Tool



Formula II Carbide Boring Tool

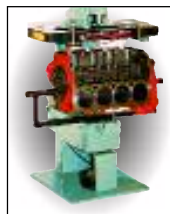
Refer to the Kwik-Way Product Catalog for additional options, replacement parts and supplies.



Valve Refacers & Cabinets



Boring Bars



Boring Fixtures & Stands



Seat Grinder Sets



Flywheel Grinders



Parts & Supplies

KWIK-WAY

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1+ 319-377-9421
FAX: 319-377-9101

KWIK-WAY®

Boring Bars and Stands

Maximum Accuracy

Cylinder Boring Bars

*For Automotive, Light Truck, Motorcycle,
Marine & Small Engine Applications*



Positive Anchoring with Uniform Clamping

The built-in clamping device quickly and positively clamps the machine to the block or table, exerting an even, uniform, downward pressure over the entire base surface without disturbing accuracy of centering or distorting the block.



Three-Finger Centering

Permits machine to be accurately centered where the greatest cylinder wear has occurred. Three steel 'fingers' are actuated by a wheel-operated plunger or by air pressure.



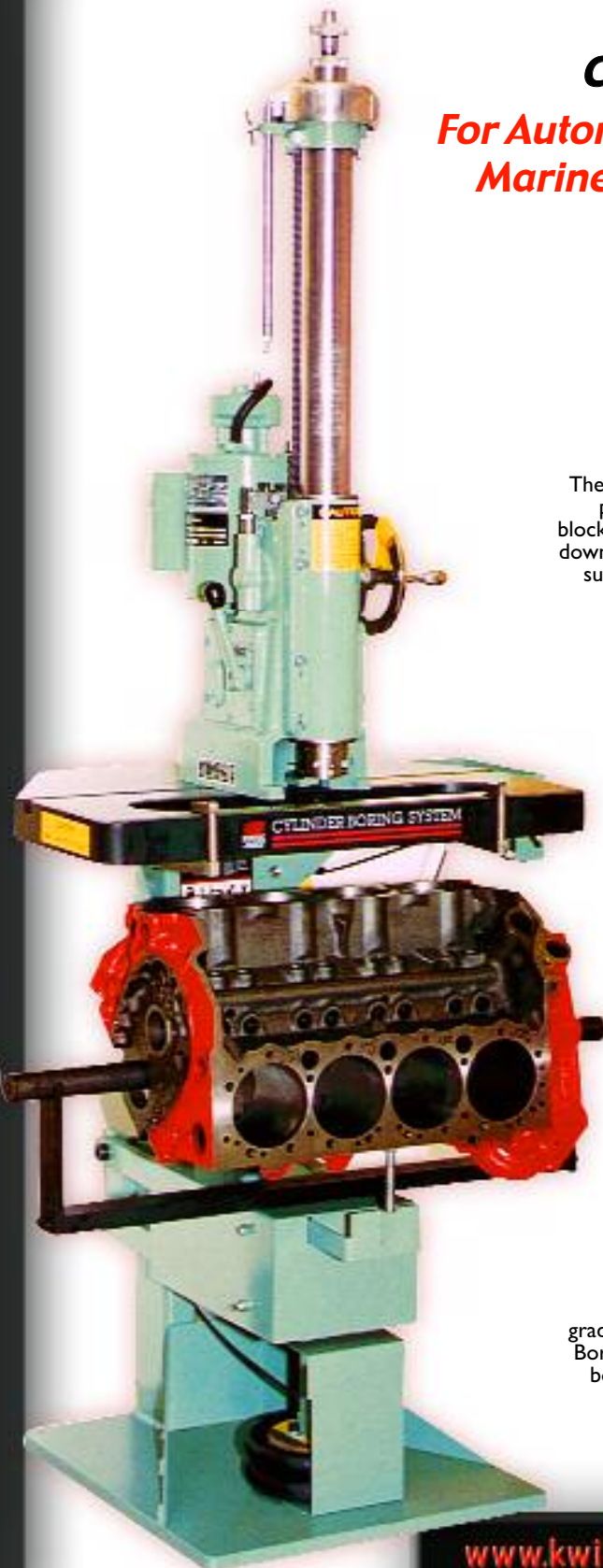
Tool Dressing

Tool dressing is quickly accomplished by jigs that hold the boring tool in proper position for each dressing operation. The lapping jig is guided by a special post.



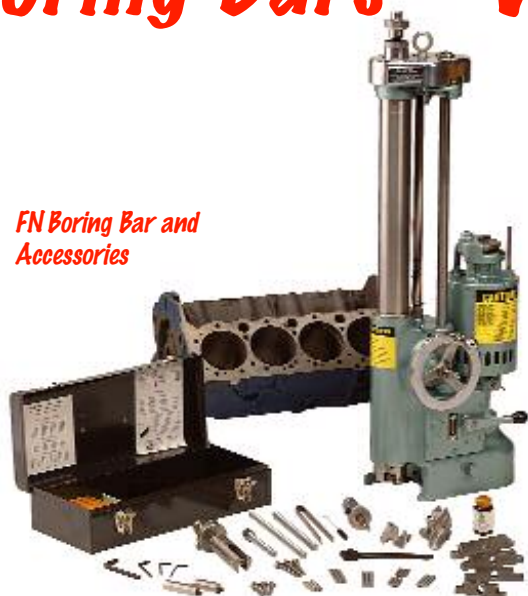
Special Micrometer for Tool Setting

Direct reading with easy-to-read graduations on both barrel and thimble. Boring tool is set to size directly in the boring head, eliminating 'sense of feel' variations in tool setting.



Boring Bars - Versatile & Accurate

FN Boring Bar and Accessories



Model FN is an Automotive and Light Truck Cylinder Boring Bar

- Manual and air-centering models. The air-centering model requires the 054 Heavy Duty Boring Fixture and air float plate.
- Two speeds and two feeds - four combinations for complete versatility
- Standard accessories and handy storage case

FWII Boring Bar and Accessories



Model FWII Boring Bar is well suited to today's down-sized engines

- Great for compact, sub-compact and import passenger cars and light trucks
- Two speeds provide necessary speed/feed range
- Bore directly off the deck of the block or use on either the 1291 Small Engine or 054 HD Boring Fixture
- Standard accessories and handy storage case

FN Boring Bar Specifications

Bore Capacity (Standard)	2.65-5.33" (675-135mm)
Bore Capacity (Air-Center)	2.95-4.48" (75-114mm)
Stroke (Standard & Air-Center)	14-1/2" (368mm)
Number of Feed-Speed Combinations	4
Motor	3/4 Hp
Shipping Weight	232 lbs (105.5 kg)

Boring Head Speed	Feed Travel
263 RPM	1.47/2.04" per minute
490 RPM	2.70/3.79" per minute

FN Order Information

FN Standard (115/60/1)	055-0001-15
FN Standard (230/60/1)	055-0001-23
FN Metric (115/60/1)	055-0001-74
FN Metric (230/60/1)	055-0001-82
FN with Air-Centering (115/60/1) *	055-0030-09
FN Standard (230/50/1)	055-0001-40
FN Metric (230/50/1)	055-0001-66
FN with Air-Centering (230/50/1) *	055-0030-68
FN Metric with Air-Centering (230/50/1) *	055-0030-76

* Air-Centering Bars require air float and clamp assembly (053-6000-18) and the 054 HD Boring Fixture (054-0000-35)

FWII Boring Bar Specifications

Bore Capacity	2.2-4.44" (56-113mm)
Stroke	12" (305mm)
Number of Speeds	2
Motor	3/4 Hp
Shipping Weight	197 lbs (89.5 kg)

Boring Head Speed	Feed Travel
380 RPM	1.04" per minute
620 RPM	1.77" per minute

FN Order Information

FWII Standard (115/60/1)	057-0010-03
FWII Standard (230/60/1)	057-0010-20
FWII Metric (115/60/1)	057-0010-11
FWII Standard (230/50/1)	057-0010-62
FWII Metric (230/50/1)	057-0010-70

Manufactured and Assembled in the USA • Three Year Limited Warranty

Due to Kwik-Way's commitment to continuous improvement, equipment specifications

800-553-5953

Designed with You in Mind

Model FWSII Boring Bar is ideal for smaller engines

Designed for small engine boring - air compressors, chain saws, go-karts, lawn mowers, marine engines and motorcycles - yet it retains the same rugged and sturdy construction and operational features as other, larger Kwik-Way boring bars. Includes standard accessories and a handy storage case.

FWSII Order Information

FWSII Standard (115/60/1)	059-0010-00
FWSII Standard (230/60/1)	059-0010-27
FWSII Metric (115/60/1)	059-0010-19
FWSII Metric (230/60/1)	059-0010-35
FWSII Standard (230/50/1)	059-0010-60
FWSII Metric (230/50/1)	059-0010-78

FWSII Boring Bar Specifications

Bore Capacity	1.75-3.75" (44-95mm)
Stroke	12" (305mm)
Number of Speeds	2
Motor	3/4 Hp
Shipping Weight	180 lbs (81.8 kg)
Boring Head Speed	Feed Travel
380 RPM	1.04" per minute
620 RPM	1.77" per minute

*FWSII Boring Bar
(shown on 1291 Small
Engine Boring Fixture)
- sold separately)*



Optional 1291 Small Engine Boring Fixture

The 1291 Stand features an elongated boring slot to accommodate single, twin and four cylinder blocks. The special floating clamp plate and parallel bars ensure precision mounting of cylinders.

Order Information

1291 Small Engine Fixture	057-1291-07
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*1291 Small Engine
Boring Fixture
(shown with FWSII
Boring Bar mounted - sold
separately)*

Optional 054 Heavy Duty Boring Fixture

For mounting your Kwik-Way FN, FW or FWS Boring Bar. Kwik set-up for in-line, V-6 and V-8 blocks.

The 054 features a massive table, large boring slot and simple, positive clamping and lift mechanism.

Optional marine tooling available.

Order Information

054 HD Boring Fixture	054-0000-35
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Standard Equipment - 054

Parallels (2)	054-1014-38
Support Bar	054-1005-20
Anchor bolt	062-0905-96

054 Options:

Special Anchor for VN Boring Bar (sold Separately)	062-0905-96
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*Model 054 Heavy Duty Boring
Stand
(shown with FN Boring Bar mounted -
sold separately)*

Built to Last • Accurate • Versatile • Affordable