

## A powerful portable spade drilling system designed for fast set-up and drilling

The Climax Spade Drilling System is designed to spade-drill holes from 1-1/2" to 3-3/8" (38 to 86 mm) diameter. Provision is made to mount straight-shank or #5 Morse taper shank spade-drills. Coolant can be delivered to the spade-drill by way of a hole through the boring bar.

This extremely powerful spade drilling system is capable of producing over 400 ft lbs (544 N·m) of torque at the bar. The System's specially designed rotational drive unit (RDU) applies a 4-to-1-gear reduction ratio to the power drive. This provides extremely high torque even at lower bar RPM's. The result: you get your job done fast.

Heavy duty, rugged construction and Climax's unique, patented spherical mounting system provide you with fast set-up and extremely precise operation. The Climax Vertical Spade Drilling System produces precise, concentrically drilled holes with no elongation or distortion.

The Vertical Spade Drilling System is truly a versatile portable machining system with a wide variety of available accessories. Contact your Climax representative for additional information.



### Ordering Information

- 30798 Right Angle Base Assembly (shown in blue). BB5000 Boring Machine sold separately. See accessories listing on reverse for a selection of bars, spade drill holders, spade drills, and other accessories.
- See accessories listing on reverse side for a selection of bars, spade drill holders, spade drills, and other accessories. Contact us for assistance in the selection of a Vertical Spade Drilling System configured to your specific requirements.

# APPLICATIONS

Fig.	No.	Description	
1	18715	Boring Bar 2-1/4 X 24 inches (57.15 X 609.6 mm) #5 Morse & Straight Shank	
	19282	Boring Bar 2-1/4 X 24 inches (57.15 X 609.6 mm) #5 Morse Taper Chrome	
	19283	Boring Bar 2-1/4 X 36 inches (57.15 X 914.4 mm) #5 Morse Taper Chrome	
	18716	Boring Bar 2-1/4 X 36 inches (57.15 X 914.4 mm) #5 Morse & Straight Shank	
	19284	Boring Bar 2-1/4 X 48 inches (57.15 X 1,219 mm) #5 Morse Taper Chrome	
	18717	Boring Bar 2-1/4 X 48 inches (57.15 X 1,219 mm) #5 Morse & Straight Shank	
	19285	Boring Bar 2-1/4 X 60 inches (57.15 X 1,524 mm) #5 Morse Taper Chrome	
	18718	Boring Bar 2-1/4 X 60 inches (57.15 X 1,524 mm) #5 Morse & Straight Shank	
	19286	Boring Bar 2-1/4 X 96 inches (57.15 X 2,438 mm) #5 Morse Taper Chrome	
	21131	Boring Bar 2-1/4 X 72 inches (57.15 X 1,829 mm) #5 Morse Taper Chrome	
	18612	Bar Boring 24 inch (610 mm) Straight Shank Coolant Hole	
	18090	Bar Boring 32 inch (813 mm) Straight Shank Coolant Hole	
	18613	Boring Bar 36 inch (914 mm) Straight Shank Coolant Hole	
	18608	Boring Bar 48 inch (1,219 mm) Straight Shank Coolant Hole	
	18609	Boring Bar 60 inch (1,524 mm) Straight Shank Coolant Hole	
	2	18590	Holder Spade Drill 1-1/2 to 2.37 inch (38.1 to 59.7 mm) Straight Shank Coolant
		18091	Holder Spade Drill 2-1/2 to 3.37 inch (63.5 to 85.6 mm) Straight Shank Coolant
18591		Holder Spade Drill 1-1/2 to 2.37 inch (38.1 to 59.7 mm) #4 Morse Taper	
18824		Holder Spade Drill 2 to 2-7/8 inch (50.8 to 73.0 mm) Straight Shank	
25230		Holder Spade Drill 2 to 2-7/8 inch (50.8 to 73.0 mm) #5 Morse Taper	
18586		Holder Spade Drill 2-1/2 to 3.37 inch (63.5 to 85.6 mm) #5 Morse Taper	
18713		Holder Spade Drill 2-1/2 to 3.37 inch (63.5 to 85.6 mm) Straight Shank	
3	18592	Drill Blade Spade 1-1/2 inch (38.1 mm) Diameter	
	18593	Drill Blade Spade 1-5/8 inch (41.3 mm) Diameter	
	18594	Drill Blade Spade 1-3/4 inch (44.5 mm) Diameter	
	18595	Drill Blade Spade 1-7/8 inch (47.6 mm) Diameter	
	18596	Drill Blade Spade 2 inch (50.8 mm) Diameter	
	18597	Drill Blade Spade 2-1/8 inch (54.0 mm) Diameter	
	18598	Drill Blade Spade 2-1/4 inch (57.2 mm) Diameter	
	18599	Drill Blade Spade 2-3/8 inch (60.3 mm) Diameter	
	18601	Drill Blade Spade 2-1/2 inch (63.5 mm) Diameter	
	18602	Drill Blade Spade 2-5/8 inch (66.7 mm) Diameter	
	18603	Drill Blade Spade 2-3/4 inch (69.9 mm) Diameter	
	18604	Drill Blade Spade 2-7/8 inch (73.0 mm) Diameter	
	17370	Drill Blade Spade 3 inch (76.3 mm) Diameter	
	18605	Drill Blade Spade 3-1/8 inch (79.4 mm) Diameter	
18606	Drill Blade Spade 3-1/4 inch (82.6 mm) Diameter		
18607	Drill Blade Spade 3-3/8 inch (85.7 mm) Diameter		
4	12564	Screw 5/8 - 18 X 1/2 inch SSSCP	
not shown	18826	Key for Morse Sleeve (Included with Morse Taper Bars)	
	18611	Pump Assembly Coolant	
	18588	Sleeve Reducing Morse Taper #3 ID TO #5 OD	
	18589	Sleeve Reducing Morse Taper #4 ID TO #5 OD	

