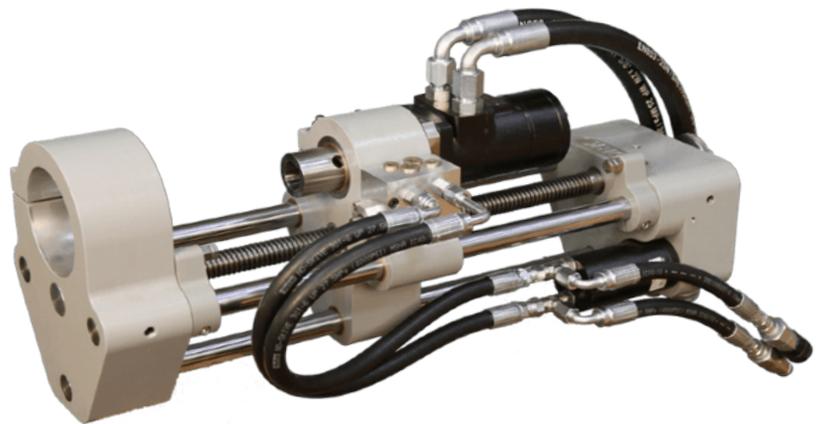


4-14 HD Line Boring Machine and Accessories Catalog



Manual Hydraulic Bar Drive
Used with 5 hp Power Unit

Proportional Hydraulic Bar Drive
Used with 10 hp Power Unit



SPR York Portable Machine Tools
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SUPERIOR

One Company, *Superior* Results.

ABOUT US

Superior (SPR) specializes in portable machining, bore welding, line isolation, and testing solutions, providing equipment and tools manufactured under the highest standards of quality control and engineering expertise along with 24/7 service and support.

Designed with the operator in mind, our tools and equipment deliver dependable and precise performance, providing cost-effective solutions and reduced downtime, making them beneficial resources in the Oil and Gas, Mining, Heavy Construction, Shipbuilding, Aerospace, Defense, and Power Generation industries.

SPR sells and rents equipment and tools; we offer our own line of portable ID/OD flange facers, linear/gantry and rotary mills, end prep bevelers, isolation and test plugs, line boring, and bore welders, as well as custom-designed equipment and tools.

Our team includes machining, test and isolation, and engineering experts, all with a thorough working knowledge of applications to support you with our equipment on any job. We understand the urgency of your projects and are committed to delivering the highest quality equipment and tools to satisfy the requirements of your clients.

SPR delivers outstanding customer service, specialized training by seasoned professionals, and tools as tough as the jobs you need them to do.



FEATURES

The York 4-14 HD (hydraulic drive) hydraulic line boring machine is built for more power. Our new three-guide bar design makes a more rigid machine allowing higher metal removal rates with less chatter. With up to 333 ft lbs of torque at the bar and a feed motor that delivers 30 ft lbs of torque, heavy cuts are made easy. York has two options available to suit every users need, the manual control machine with a 5 hp hydraulic power unit and the proportional control machine with a 10 hp hydraulic power unit.

ELECTRIC OR HYDRAULIC BORING BAR DRIVES

- M - Manually Operated
- P - Pendant Operated (Proportional Version)
- Maximum Bar Rotation Speeds of 90, 150, 280, and 460 RPM

3 HYDRAULIC POWER SUPPLIES

- 5 hp Single-Phase
- 5 hp Three-Phase
- 10 hp Three-Phase

ADDITIONAL FEATURES

- Boring diameters from 3" - 24" (76 mm - 609 mm)
- 14" (355 mm) cutting tool travel
- Up to 333 ft lbs (449 Nm) of torque at the boring bar
- Variable speeds up to 460 rpm
- Universal mount for line boring and bore welding, allowing you to set up ahead while you work.
- Works with all 4-14 options
- Machine weight 72 lbs; bar drive weight 12 lbs
- 5 hp single-phase available in 220/230V 50 or 60 Hz
- 5 hp / 10 hp three-phase available in 230, 380, 460 or 575V 50 or 60 Hz

4-14 HD Manually Operated Feed Carriage (4-14 HD M)

- Boring diameters from 3" - 24" (76 mm - 609 mm)
- 14" (355 mm) cutting tool travel
- Up to 333 ft lbs (449 Nm) of torque at the boring bar
- Available maximum speeds of 90, 150, 280, and 490rpm
- Works with all York 4-14 options
- Borewelder interface

Part Number: 4-14HD-M



Use with M series bar drives



4-14 HD Proportional Feed Carriage (4-14 HD P) (Pendant Operated)

- Remote Pendant allows for convenient control of rotation speed.
- Boring diameters from 3" - 24" (76 mm - 609 mm)
- 14" (355 mm) cutting tool travel
- Up to 333 ft lbs (449 Nm) of torque at the boring bar
- Available maximum speeds of 90, 150, 280, and 490rpm
- Works with all York 4-14 options
- Borewelder interface

Part Number: 4-14HD-P



Use with P series bar drives



5 HP HYDRAULIC POWER UNITS

AVAILABLE UNITS

Features:

- 5 hp single or three phase electric
- Reversible hydrostatic drive

3-Phase

Hydraulic Power Unit

- 190 Volt, 50 Hz **Part Number: HPU-05-319050**
- 220~240 Volt, 50Hz **Part Number: HPU-05-32205**
- 380 Volt, 50 Hz **Part Number: HPU-05-338050**
- 440~460 Volt, 50 Hz **Part Number: HPU-05-344050**
- 230 Volt, 60 Hz **Part Number: HPU-05-323060**
- 440~460 Volt, 60 Hz **Part Number: HPU-05-346060**
- 575 Volt, 60 Hz **Part Number: HPU-05-357560**

Single-Phase

- 220~240 Volt, 60Hz **Part Number: HPU-05-123060**
- 220~240 Volt, 50Hz **Part Number: HPU-05-123050**

Manual Control Bar Drives

- Variable Rotational Bar Drive Motors Available
 - 90 rpm, 333 ft lb Torque (449 Nm) **Part Number: HBD-M-000-90**
 - 150 rpm, 208 ft lb Torque (280 Nm) **Part Number: HBD-M-000-160**
 - 280 rpm, 106 ft lb Torque (141 Nm) **Part Number: HBD-M-000-280**
 - 460 rpm, 65 ft lb Torque (87 Nm) **Part Number: HBD-M-000-460**
- Bar rotation lock valve mounted on bar drive
- 9 gallon (40.3 Lt) fluid tank
- Bar drive weight 26 lbs (12 kg)
- Power supply weight 275 lbs (125 kg)



10 HP HYDRAULIC POWER UNITS

AVAILABLE UNITS

Features:

- 10 hp three phase electric
- Reversible hydraulic drive

3-Phase

Hydraulic Power Unit with Remote Pendant

- 230 Volt, 50 Hz Part Number: HPU-10-323050
- 230 Volt, 60 Hz Part Number: HPU-10-323060
- 380 Volt, 50 Hz Part Number: HPU-10-338050
- 400 Volt, 50 Hz Part Number: HPU-10-340050
- 415 Volt, 50 Hz Part Number: HPU-10-341550
- 460 Volt, 50 Hz Part Number: HPU-10-346050
- 460 Volt, 60 Hz Part Number: HPU-10-346060
- 575 Volt, 60 Hz Part Number: HPU-10-357560

Proportional Bar Drives

- Variable Rotational Bar Drive Motors Available
 - 90 rpm, 333 ft lb Torque (449 Nm) **Part Number: HBD-M-000-90**
 - 150 rpm, 208 ft lb Torque (280 Nm) **Part Number: HBD-M-000-160**
 - 280 rpm, 106 ft lb Torque (141 Nm) **Part Number: HBD-M-000-280**
 - 460 rpm, 65 ft lb Torque (87 Nm) **Part Number: HBD-M-000-460**
- Bar rotation lock valve mounted on bar drive
- 19 gallon (72 Lt) fluid tank
- Bar drive weight 26 lbs (12 kg)
- Power supply weight 570 lbs (258 kg)



A) Premium Plus Package: 1.5" to 16"
(38 mm to 406 mm) - Complete 5-bar package that covers the entire operating range of the 4-14. This is a very dynamic package designed for those who work on a wide range of large and small bores.

Part Number: P-1

B) Premium Package: 1.5" to 10"
(38 mm to 254 mm) - Complete 5 bar package that is designed for those in the heavy equipment industry that work on bores up to 10 inches, this kit can be easily upgraded at any time to 16" (406 mm) diameters.

Part Number: P-2

C) Standard Package: 2.5" to 6"
(63.5 mm to 152 mm) - 3-bar package using our 2" (52 mm) boring bars. Small bars can be added at any time if required.

Part Number: P-3

D) Combo Package: 1.5" to 6"
(38 mm to 152 mm) - Kit is designed to meet the needs of most equipment owners. This kit is upgradeable by adding components as needed.

Part Number: P-4

E) Small Bore Package: 1.5" to 3"
(38 mm to 76 mm) - 2-bar package is designed for our 1-1/4" (32 mm) bars for small diameters, we have an upgrade kit that can be added to reach 5" (127 mm) using our 1-1/4" (32 mm bars).

Part Number: P-5

Custom packaging is also available. All our bars can be supplied with either imperial or metric tool ports.

A	B	C	D	E	Package Includes
1-1/4" Bar Package					
1	1			1	4 Foot Bar
1	1		1	1	6 Foot Bar
2	2		2	2	3" Line-up Cones
2	2		1	2	Mounting Head
2	2		1	2	Bore weld Interface
2	2		2	2	Tail Support
2	2		2	2	Clamping Collars
1	1		1	1	Calibration Tool
1	1		1	1	Accessories Tool Box
2" Bar Package					
1	1	1			3 Foot Bar
1	1	1	1		5 Foot Bar
1	1	1			7 Foot Bar
2	2	2	2		2-4 " Line-up Cones
2	2	2	2		4-6" Line-up Cones
2	2				6-8" Line-up Cones
	2				8-10" Line-up Cones
1					8-16" Line-up Spiders
2	2	2	1		Mounting Head
2	2	2	1		Bore welder Interface
1					Adjustable X/Y Mounting Kit
2	2	2	2		Tail Support
2	2	2	2		Clamping Collars
1	1	1	1		Calibration Tool
1	1				6-10" Big Bore Adapter
1					10-13" Big Bore Adapter
1					13-16" Big Bore Adapter
1	1	1	1		Accessories Tool Box

2-1/4" (58 mm) bars now available using our hydraulic drives – bore up to 24" (609 mm)

Optional chrome plated bars are available.

2" (50.8 MM) BORING BARS & ACCESSORIES

2" (50.8 mm) Mounting Head

- Two bearings for added support
- One bore welder mounting plate included
- Alignment adjusting screws

Part Number: 414-201

Replacement Inserts

Part Number: 414-201A



2" (50.8 mm) Tail Support

- 4 bolt flange bearings on replaceable mounting plates

Part Number: 414-202

Replacement Weld Plate

Part Number: 414-202A

Replacement Flange Bearing

Part Number: 414-202B



X/Y Adjustable Mounting Kit

- Freedom to move - the X/Y mounting head allows you to move the bar 5/8" (15.8 mm) in any direction from center. You also have a 6 degree spherical adjustment. This feature is a huge asset for bores larger than 10" (254 mm) that might require an extra degree of precision alignment.

Part Number: 414-309 (Kit)

Adjustable X/Y Mounting Head only

Part Number: 414-310

Adjustable X/Y Tail Support only

Part Number: 414-330



2" (50.8 mm) Boring Bars

- Staggered 1/2" tool ports every three inches along the bar.
- Tool ports are broached and threaded
- Bars are made from C1045 precision ground shafting
- Available chrome plated and polished

3' Bar

Part # 414-213-36 Polished Bar

Part # 414-213-36C Chrome Bar

5' Bar

Part # 414-213-60 Polished Bar

Part # 414-213-60C Chrome Bar

7' Bar

Part # 414-213-84 Polished Bar

Part # 414-213-84C Chrome Bar



Note: For Metric bars place an M at the end of the part number.

Custom bars and lengths available on request.

2" (50.8 mm) Line-Up Cones

- Steel cones
- Precision alignment
- Relieved in the back to reduce weight

2" to 4" (50.8 mm to 101.6 mm)

Part Number: 414-203

4" to 6" (101.6 mm to 152.4 mm)

Part Number: 414-204

6" to 8" (152.4 mm to 203.2 mm)

Part Number: 414-215

8" to 10" (203.2 mm to 254 mm)

Part Number: 414-214



2" (50.8 MM) ITEMS

2" (50.8 mm) Adjustable Line-Up Tool (Spider) for bores 8" - 16" (203 mm - 406 mm) or 8" - 24" (203 mm—609 mm)

- For aligning and centering the bar when working with bores larger than 8" (203 mm). The line up tool dials out to the diameter that you need.
- The kit comes in a custom carrying case, with two centering tools and four sets of extensions.



Part Number: 414-501

Part Number: 414-502

2" (50.8 mm) Clamping Collars

- To secure the line up cones in place during set up
- Split collar with Allen head screws

Part Number: 414-205

(sold in package of 2)



2" (50.8 mm) Calibration Wrench *(A SPR York Exclusive!)*

- The calibration wrench allows accurate cutting tool adjustment in increments of .001". All of our boring bars have broached and threaded tool ports with a scribed line on center. We put an adjusting screw at the base of the cutting tool in which the calibration wrench fits. There are 50 graduations on the wrench. With each graduation past the scribed line the cutting tool advances .001"

Part Number: 414-207 (c/w 5 cutting tool adjusters)

Cutting Tool Adjusters

Part Number: 414-206

(sold in package of 5)



2" (50.8 mm) Accessories Tool Box

- Tool box (26")
- Set screws
- Sample Micro 100 carbide tooling
- Wrenches
- Allen keys

Part Number: 414-250



2" (50.8 mm) Large Bore Adapters

- The SPR York large bore adapters clamp securely to our 2" (50.8 mm) boring bar. The large bore adapter supports the tool bit to accommodate larger bores over 6" (152 mm) in diameter. The 6" - 10" (152 mm - 254 mm) adapter can be used with the SPR York calibration wrench and is our standard adapter. Custom large bore adapters are also available for 10" - 13" (254 mm - 330 mm) and 13" - 16" (330 mm - 406 mm)



6" to 10" (152.4 mm to 254 mm)

Part Number: 414-303

10" to 13" (254 mm to 330 mm)

Part Number: 414-301

13" to 16" (330.2 mm to 406 mm)

Part Number: 414-302



1-1/4" (32 MM) ITEMS

1-1/4" (32 mm) Mounting Head

- Two bearings for added support
- One bore welder mount plate included
- Alignment adjusting screws

Part Number: 414-101

Replacement Inserts

Part Number: 414-101A



1-1/4" (32 mm) Tail Support

- 4 bolt flange bearing on a replaceable mounting plate

Part Number: 414-102

Replacement Weld Plate

Part Number: 414-102A

Replacement Flange

Part Number: 414-102B



1-1/4" (32 mm) Mounting Head

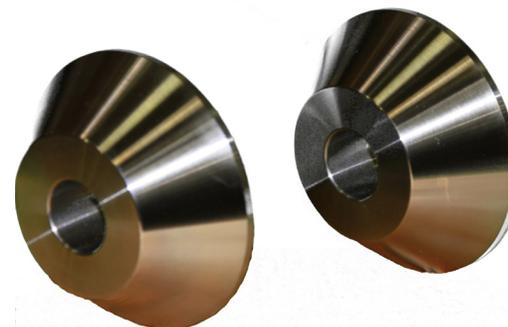
- Steel cones 1 1/4" to 3" and 3" to 5"
- Precision alignment
- 1 1/4" to 3"
- 3" to 5"

1-1/4" to 3" (32 mm to 76 mm)

Part Number: 414-103 (set of 2)

3" to 5" (76 mm to 127 mm)

Part Number: 414-104 (set of 2)



1-1/4" (32 mm) Boring Bars

- Staggered 3/8" (9.5 mm) tool ports every 3" (76.2 mm) along the bar
- Tool ports are broached and threaded
- Bars are made from C1045 precision ground shafting
- Available chrome plated and polished

4' Bar (1219.2 mm)

Part Number: 414-113-48 Polished bar

Part Number: 414-113-48C Chrome bar

6' Bar (1828.8 mm)

Part Number: 414-113-72 Polished bar

Part Number: 414-113-72C Chrome bar



Note: For Metric bars place an M at the end of the part number

Custom bars and lengths available on request

1-1/4" (32 mm) Tail Support

- This adapter is used to support tooling for bores greater than 3". It will help reduce tool breakage and chatter. For maximum success we recommend using our 2" bars for bores greater than 3"

Part Number: 414-307



1-1/4" (32 mm) Clamping Collars

- Used to secure the line up cones in place during set up
- Split collar with Allen head screw

Part Number: 414-105

(sold in a package of 2)



1-1/4" (32 MM) ITEMS

1-1/4" (32 mm) Calibration Wrench

- The calibration wrench allows accurate cutting tool adjustment in increments of .001". All of our boring bars have broached and threaded tool ports with a scribed line on center. We put an adjusting screw at the base of the cutting tool that the calibration wrench fits into. There are 50 graduations on the wrench. With each graduation past the scribed line the cutting tool advances .001".

Part Number: 414-107 (c/w 5 cutting tool adjusters)

Cutting Tool Adjusters

Part Number: 414-106

(sold in package of 5)



1-1/4" (32 mm) Accessories Tool Box

- Tool box (21")
- Set screws
- Sample Micro 100 carbide tooling
- Wrenches
- Allen keys

Part Number: 414-150



2-1/4" (57 MM) ITEMS (RECOMMENDED WITH OUR HYDRAULIC BAR DRIVES)

2-1/4" (57 mm) Mounting Head (Standard)

- Two bearings for added support
- One bore welder mount plate included
- Alignment adjusting screws

Part Number: 414-601

Replacement Inserts

Part Number: 414-601A



X/Y Adjustable Mounting Head & Tail Support

- Freedom to move - the X/Y mounting head allows you to move the bar 5/8" (15.8 mm) in any direction from center. You also have a 6 degree spherical adjustment. This feature is a huge asset for bores larger than 10" (254 mm) that might require an extra degree of precision alignment.

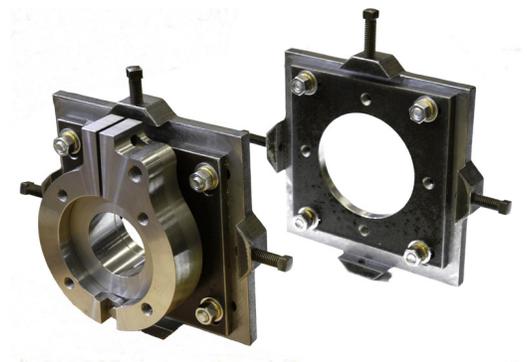
Part Number: 414-609 (Kit)

Mounting Head Only

Part Number: 414-610 Adjustable X/Y

Adjustable X/Y Tail Support Only

Part Number: 414-630



2-1/4" (57 mm) Tail Support

- 4 bolt flange bearing on a replaceable mounting plate

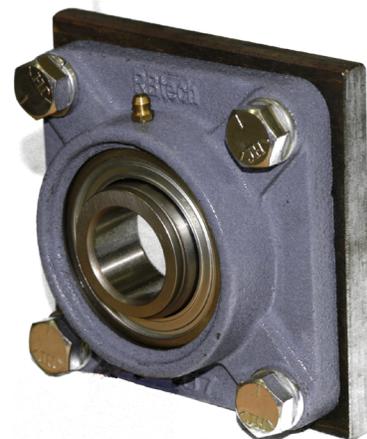
Part Number: 414-602

Replacement Weld Plate

Part Number: 414-602A

Replacement Flange

Part Number: 414-602B



2-1/4" (57 MM) ITEMS (RECOMMENDED WITH OUR HYDRAULIC BAR DRIVES)

2-1/4" (57 mm) Boring Bars

- Staggered 1/2" (12.7 mm) tool ports every 3" (76 mm) along the bar.
- Tool ports are broached and threaded
- Bars are made from C1045 precision ground shafting.
- Available chrome plated and polished

3' (914 mm) Boring Bar

Part Number: 414-613-36 Polished Bar

Part Number: 414-613-36C Chrome Bar

5' (1524 mm) Bar

Part Number: 414-613-60 Polished Bar

Part Number: 414-613-60C Chrome Bar

8' (2438 mm) Bar

Part Number: 414-613-96 Polished Bar

Part Number: 414-613-96C Chrome Bar



Note: For Metric bars place an M at the end of the part number.

Custom bars and lengths available on request.

2-1/4" (57 mm) Line-Up Cones

- Steel cones
- Precision alignment
- Relieved in the back to reduce weight

2" to 4" (50.8 mm to 101.6 mm)

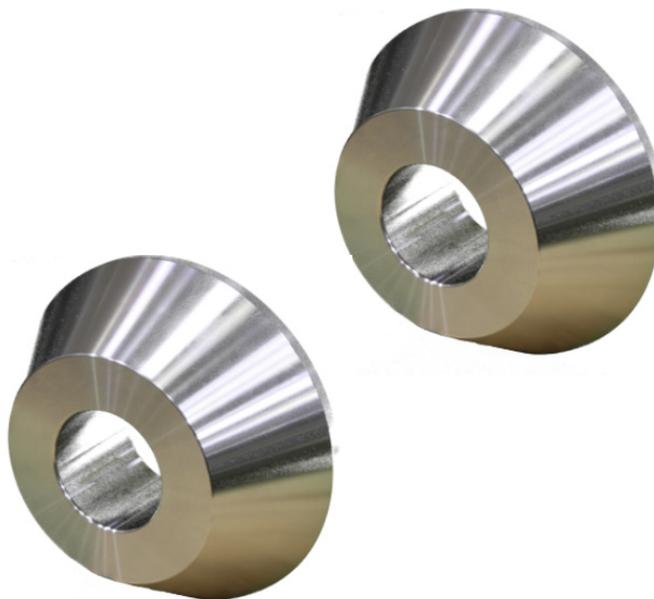
Part Number: 414-603 (Set of 2)

4" to 6" (101.6 mm to 152.4 mm)

Part Number: 414-604 (Set of 2)

6" to 8" (152.4 mm to 203.2 mm)

Part Number: 414-615 (Set of 2)



2-1/4" (57 mm) Adjustable Line-Up Tool (Spider) for bores 8" - 16" (203 mm - 406 mm) or 8" - 24" (203 mm - 609 mm)

- For aligning and centering the bar when working with bores larger than 8" (203 mm). The line up tool dials out to the diameter you need.
- The kit comes in a custom carrying case, with two centering tools and four sets of extensions.



Part Number: 414-503

Part Number: 414-504

2-1/4" (57 mm) Clamping Collars

- Used to secure the line up cones in place during setup
- Split collar with Allen head screw

Part Number: 414-605



Accessories Tool Box

- Tool Box (26")
- Set Screws
- Sample Micro 100 carbide tooling
- Allen keys
- Key Stock
- Wrenches

Part Number: 414-250



OPTIONAL ACCESSORIES

Facing Tools

- The York facing tools are designed to machine surfaces 90 degrees to the bore. The facing tool attaches to our boring bar. Two tool ports are set in the facing tool; one at 45 degrees and the other at 90 degrees. Each revolution of the bar actuates a gear driven lead screw that advances the cutting tool .005" (.127 mm).

Part Number: FT-1100 Max 10" (254 mm)

Use with 2" boring bar

Part Number: FT-2100 Max 10" (254 mm)

Use with 2-1/4" boring bar

Part Number: FT 9000 Max 18" (457 mm)



FT-1100



FT-9000

FT1100M, FT2100M for metric bar

Off-Set Drive *(A SPR York Exclusive!)*

- Our offset drive feature allows more flexibility than thru-bar designs. The York line-boring machine is an excellent choice for working in constricted areas, as the drive-line allows 30 degrees offset in any direction from the boring bar alignment.

Part Number: OFF-000



Carbide Insert Tool Package 1/2" (12 mm)

- The York insert tool places the carbide cutting surface into the center of the bore, substantially improving cutting tool performance while extending tool holder life. Our tool holders use standard inserts that are readily available from most cutting tool suppliers. Insert tooling takes the guesswork out of tool geometry and improves the overall performance of your line boring machine.

Part Number: ITK-000



Thru-Bar Measuring Kits

- Our thru-bar measuring tool allows you to accurately measure the bore without removing the bar. The measuring tool is placed into an adjacent tool port and traversed into the bore. By loosening the setscrew, the spring loaded measuring tool snaps opens - capturing the size of the bore. Tighten the setscrew and traverse the tool from the bore. Pull the measuring tool out of the bar. Using a micrometer, measure the thru-bar tool for the diameter of the bore.

1.9" to 12" (48.26 mm to 304.8 mm)

Part Number: MT2-1000 fits Imperial bars

1.9" to 16" (48.26 mm to 406.4 mm)

Part Number: MT2-2000 fits Imperial bars

1.9" - 12" (48.26 mm - 304.8 mm)

Part Number: MT2-3000 fits Metric bars

1.9" - 16" (48.26 mm to 406.4 mm)

Part Number: MT2-4000 fits Metric bars



MT2-1000



MT2-4000

Snap Ring Tool

- 3.8" to 7" (96.5 mm to 177.8 mm)
- 5/8" stroke (15.8 mm)
- Hydraulic feed
- Accurate adjustment

Part Number: SR-300-2.00

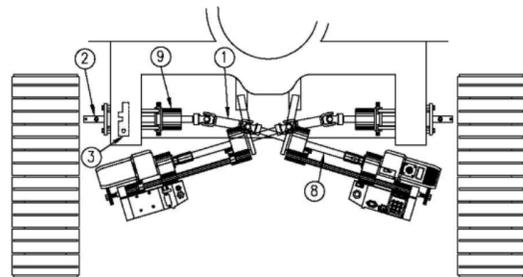
Part Number: SR-300-2.25



Ripper Shank Repair Kit

- A unique option that saves having to pull the tracks to repair worn bores on D-9 to D-10 Cat (*Call us for kits to repair other models)

Part Number: RIP-000



Micro 100 Brazed Carbide Cutting Tools

- Micro 100 is highly shock resistant, will not chip or break under normal machining conditions and excels in interrupted cutting. Micro 100 carbide is a space age carbide with superior rupture strength for exceptional machining versatility.

#6 - 3/8"

Part Number: AR-6 or AL-6 MICRO 100 "A" Style

Part Number: BR-6 or BL-6 MICRO 100 "B" Style

#8 - 1/2"

Part Number: AR-8 or AL-8 MICRO 100 "A" Style

Part Number: BR-8 or BL-8 MICRO 100 "B" Style

MICRO 100



Bore Welder Adapter Plates

Part Number: 414-212

(Sold in package of 2)

*** NOTE: Will work with most brands of bore welders**





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