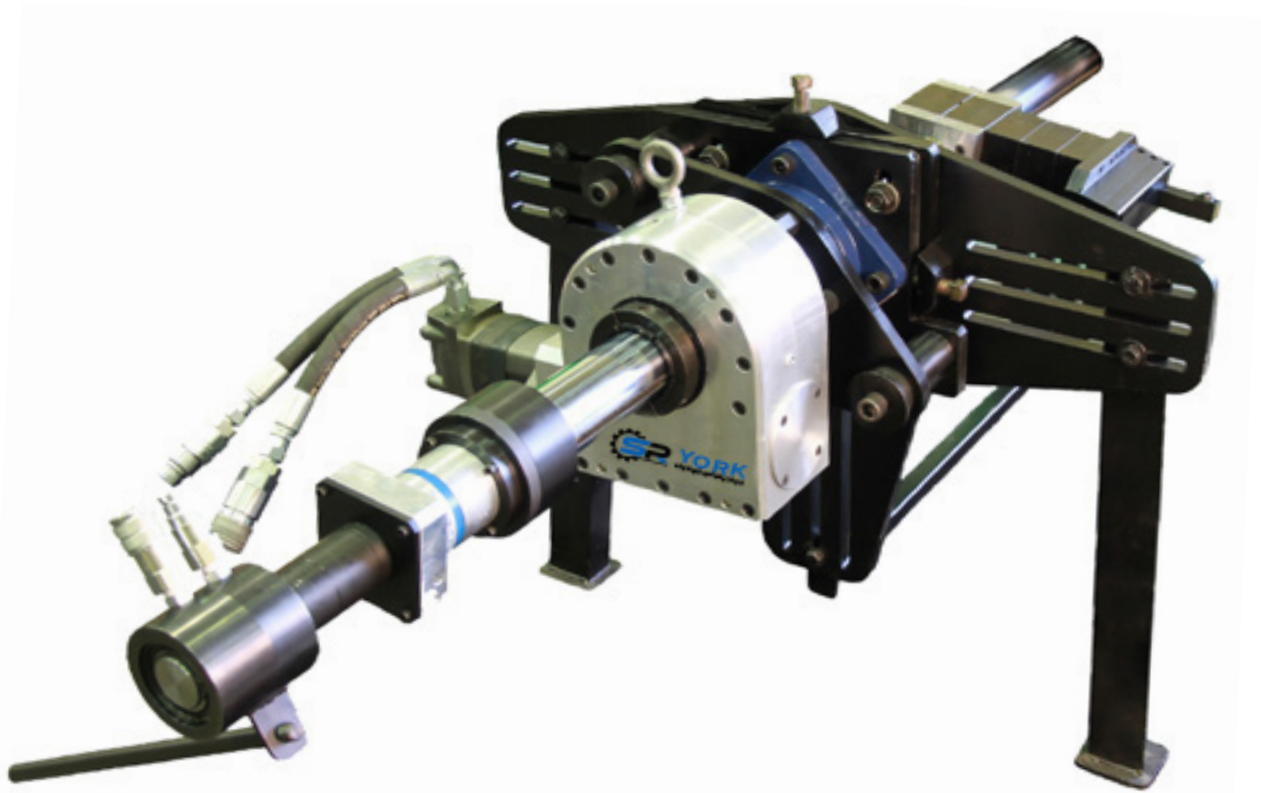




**YORK**  
PORTABLE MACHINE TOOLS

# 12-36 Line Boring Machine and Accessories Catalog



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.

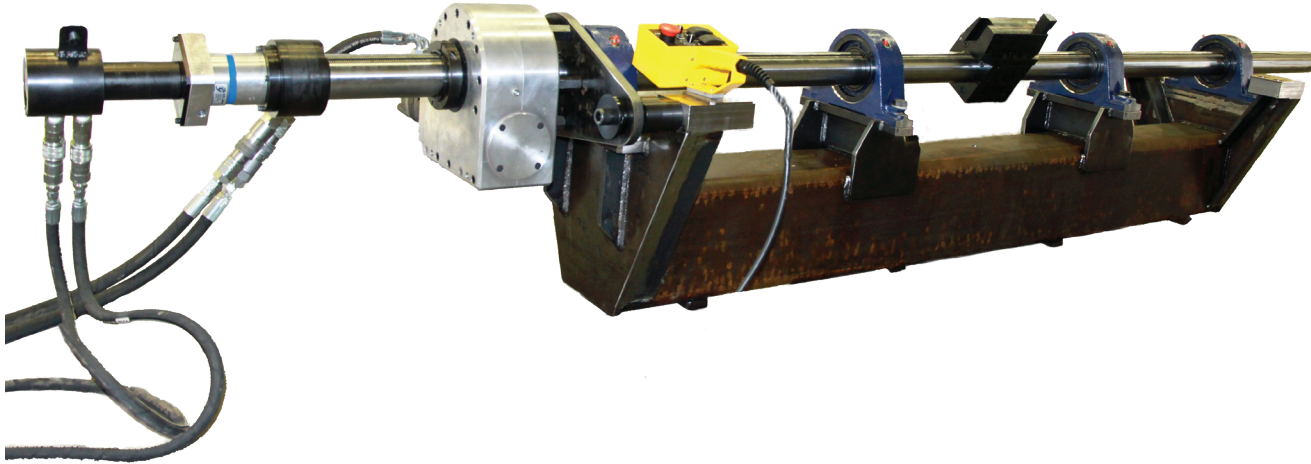
Our team includes machining, test and isolation, and engineering experts, all with a thorough working knowledge of applications to support you with our equipment on any job. We understand the urgency of your projects and are committed to delivering the highest quality equipment and tools to satisfy the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

- Boring diameters from 8" - 36" (203 mm - 914 mm)
- Twin lead screws for balanced feeding
- Variable and reversible feed rates
- Variable and reversible rotation speeds
- X/Y adjustable bearing mounts



## SETUP

The SPR York 12-36 line boring machine can be set up several ways depending on the work area. Tack weld plates are provided; however, in some cases, an existing bolt pattern on the work piece may be used. If so, a special set-up fixture would be required and can be manufactured by SPR York.

- Using the bar length chart (pg. 6), select the correct length boring bar for the job.
- Attach the three-leg mounting fixture to the work piece.
- Mount the bearings on each end and bolt them to the bearing plates.
- Insert the boring bar.
- Mount the two halves of the head to the boring bar. Tool head extensions may be required for larger bores. Extensions are provided in the kit.
- Center the bar by sweeping the bore. Adjust the bar alignment with the jacking screws on the jacking plate. When the bar is aligned, tighten the bearing to the jacking plate to prevent further movement.
- Attach the feed motor to either end of the boring bar and connect the hydraulic bar drive.

## FEED SYSTEM WITH PENDANT

- Feed speeds from 0" - 2" per minute
- Traverse speeds from 3" - 4" per minute
- Hydraulic feed motor with variable speed
- 20 ft (7 m) control cables

**Part number: 1236-145**



## HYDRAULIC POWER SUPPLY 10HP

- Reversible hydrostatic drive unit with variable bar speeds
- 350 ft lbs torque (474 Nm)
- 15 gallons per minute at 2400 PSI
- Available in 220 and 480 or 575 volt 3 phase
- 50 Hz or 60 Hz
- 14 gal (63 L) reservoir with oil cooling

**Part Number: 1236-001**



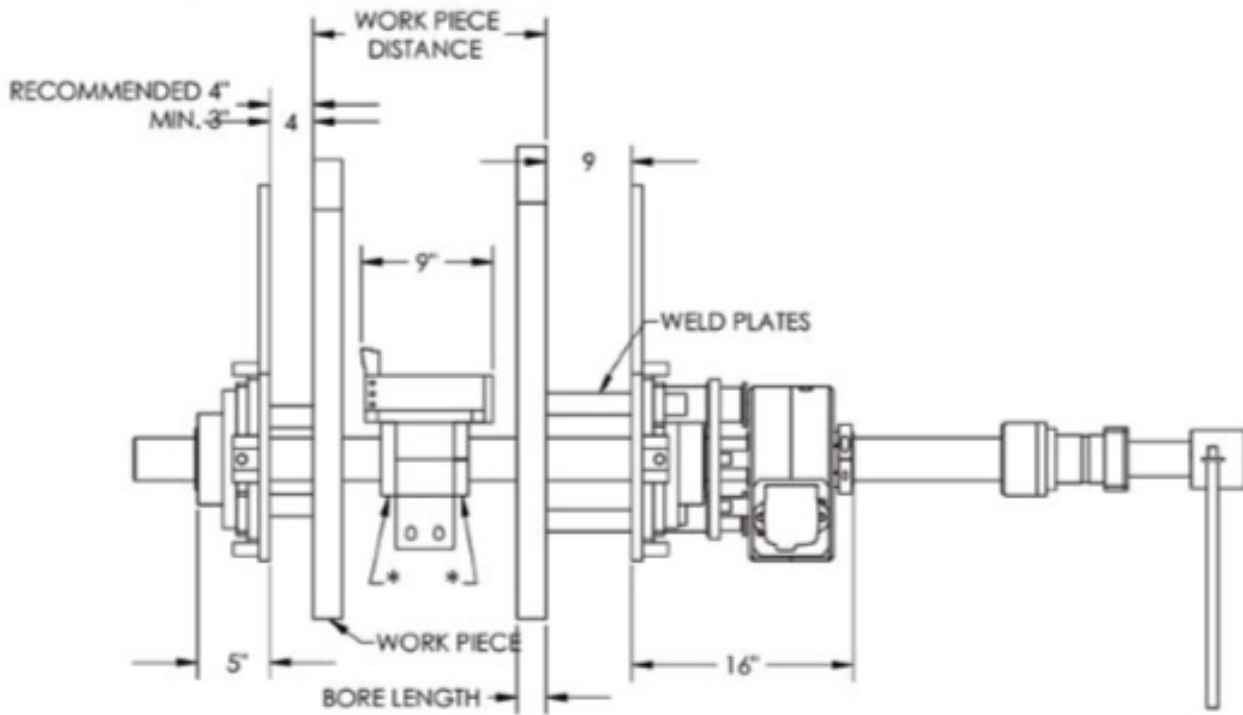
## ROTATIONAL DRIVE

- Feed speeds from 0" - 2" per minute
- Traverse speeds from 3" - 4" per minute
- Hydraulic feed motor with variable speed
- 20 ft (7 m) control cables

**Part number: 1236-145**



**TO DETERMINE RECOMMENDED BAR LENGTH**



**34" PLUS WORKPIECE DISTANCE = MINIMUM BAR LENGTH**

## 12-36 LINE BORING MACHINE PARTS AND OPTIONS

### 3" (76 MM) BORING BAR

- Chrome boring bar
- Full length lead screws

**Part Number: 1236-101** (under 10 ft)

**Part Number: 1236-150** (over 10 ft)



### THREE LEG X/Y MOUNTING

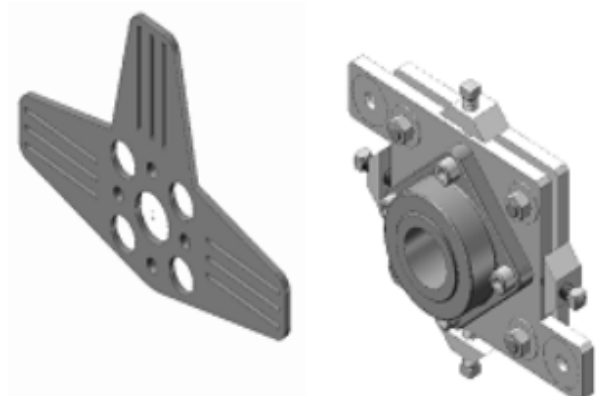
- 3" (76 mm) X/Y bearing assembly
- Jacking plates and set screws

**Part Number: 1236-303**

Three leg mounting fixture

**Part Number: 1236-320**

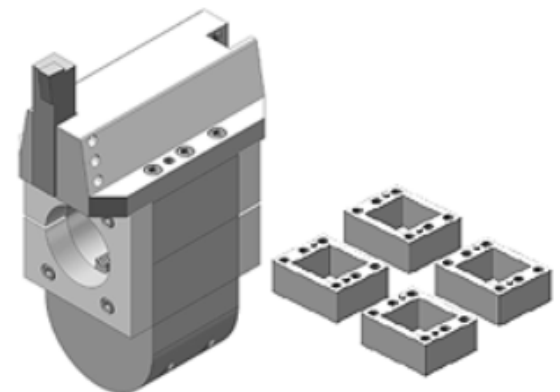
X/Y mount with bearing



### TOOL HEAD WITH EXTENSION BLOCKS

- 1" (25.4 mm) insert tooling
- Extension blocks 12" - 24" (305 mm - 610 mm)
- Extension blocks 24" - 36" (610 mm - 915 mm)

**Part Number: 1236-415**

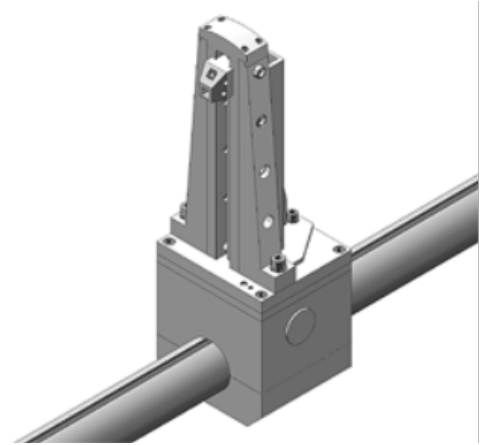


## 12-36 LINE BORING MACHINE PARTS AND OPTIONS

### OPTIONAL FACING HEAD AND GROOVING TOOL

- Facing from 12" to 36" (304 mm - 914 mm) diameters

**Part Number: 1236-600**



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### OPTIONAL SMALL BORING HEAD

- 8" - 12" (203mm - 304 mm)

**Part Number: 1236-410**

