



# 5HP Hydraulic Power Supply

## OWNER'S MANUAL

**Customer Support line**

**1-888-783-9675**

### York Portable Machine Tools

SPR York Holdings ULC dba York Portable Machine Tools  
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*We at York Portable Machine Tools would like to thank you for purchasing the York 5HP Hydraulic Power Supply.*

*To get the most out of your investment, we encourage you to take a moment to read through the operator's manual.*

*We have been manufacturing line-boring machines since 1986. During this time we have experienced many different scenarios. Our product support team would be happy to lend assistance or share any "Tricks of the Trade". We can always be reached by calling 1-888-783-9675. Check our web site for tips as well: [www.sprtool.com](http://www.sprtool.com)*



## Limited Warranty

1. York Portable Machine Tools warrants that all new machines are free of all material and manufacturer's defects. The machine warranty covers all parts and workmanship for a period of twelve months from the original date of invoice.

Should defects in any material or workmanship be discovered during the warranty period, the purchaser should notify the factory or the nearest York representative as soon as possible. York Portable Machine Tools will have the option to repair or replace the defective part or machine. Freight to and from the factory shall be the responsibility of the customer.

2. To expedite quick repairs, please provide the model, serial number, date of purchase, and invoice number with the returned machine.

York Portable Machine Tool's liability on any claim, whether in contract, tort (including negligence) or otherwise, for any loss or damage arising out of, connected with, or resulting from the manufacture, sale, delivery, resale, repair, replacement or use of any product shall in no case exceed the price allocated to the product, or part thereof, which gives rise to the claim, except as specifically provided in the warranty provisions. In no event shall the York Portable Machine Tools be liable for special indirect or consequential damages or any damages resulting from loss of life or damage to property other than the property that is the subject of this warranty.

The foregoing warranties shall constitute York Portable Machine Tool's sole liability and the purchaser's sole remedy and are in lieu of all other warranties and conditions written or verbal, statutory, express or implied.

3. Warranty shall be void in the following circumstances:

- DAMAGE CAUSED BY OPERATING THE ELECTRIC MOTOR IN THE WRONG DIRECTION.
- DAMAGE CAUSED BY TAMPERING WITH THE PRESET RELIEF SETTINGS.
- DAMAGE CAUSED BY OPERATOR ABUSE OR NEGLIGENCE.
- DAMAGE CAUSED BY THIRD PARTIES.
- DAMAGE CAUSED DURING SHIPPING.
- DAMAGE CAUSED BY OPERATIONS BEYOND RATED CAPACITIES.
- DAMAGE CAUSED BY ANY MODIFICATIONS TO THE MANUFACTURER'S ORIGINAL DESIGN.
- DAMAGE CAUSED BY INCORRECT ELECTRICAL CONNECTIONS OR RUNNING THE PUMP IN THE WRONG DIRECTION.

**All returns, whether for repairs or warranty must be pre-approved by calling 1-888-783-9675 or 1-250-286-6400. York Portable Machine Tools will fax the shipper a claim number and shipping instructions. Items returned without prior authorization will not be accepted.**

All freight shall be ground. Expedited charges for expedited freight shall be the customer's responsibility. Shipments bound back to the factory must have pre approval from the factory and have the proper documentation to clear customs.



## INTRODUCTION

### 1. USING THE MANUAL

1.1 This manual describes the general operation of the York 5HP Hydraulic Power Supply. For feed carriage operation and set up, please refer to the 4-14 Owner's Manual. As the new owner of this product, we strongly urge you, and any other operators, to read both manuals and understand the information found in these manuals.

1.2 **The customer shall ensure that only people thoroughly trained in safe work procedures operate this machine.** Safe working procedures are required when operating rotating machine tools. The misuse of this machine could result in severe injury or death.



**Rotating machine parts can cause  
Serious injuries, even death!**

### 2. RECEIVING YOUR NEW YORK 5HP Hydraulic Power Supply

2.1 Individually inspect all the pieces for signs of shipping damage. Check the packing slip for any errors, omissions, or missing pieces.

2.2 Immediately call our shipping/receiving department at **1-888-783-9675** if any shipping damage is discovered.

2.3 **This Unit Ships Without Hydraulic oil**, we recommend **AW46** light hydraulic fluid. **PLEASE FILL RESERVOIR WITH "CLEAN" HYDRAULIC OIL.** Install supplied Air Breather.

2.4 Insure that the electric motor is properly connected to your power supply.

2.5 **Correct motor rotation is very important. Incorrect motor direction will cause pump failure and void warranty. The output shaft should always rotate counter clockwise. (When facing output shaft or counter clockwise when facing cooler end)**

## SAFETY

### 3. SAFETY PRECAUTIONS

Proper training and safety precautions can help avoid accidents. Always follow these safety precautions:

- 3.1 Keep others clear from the machine when it is running.
- 3.2 Keep clear of the rotating bar. **Never try to remove chips while the machine is running.**
- 3.3 **Disconnect the power when inserting or adjusting the cutting tool.**
- 3.4 Wear protective goggles, footwear and ear plugs. **Please observe all Company and Government work-safe practices.**
- 3.5 **Do not** wear loose fitting clothing that could get caught up or wrapped in the machine.
- 3.6 Flying chips can cut or burn you. **Do not** remove cuttings with bare hands.
- 3.7 **Do not** operate in water. Watch for electrical hazards.



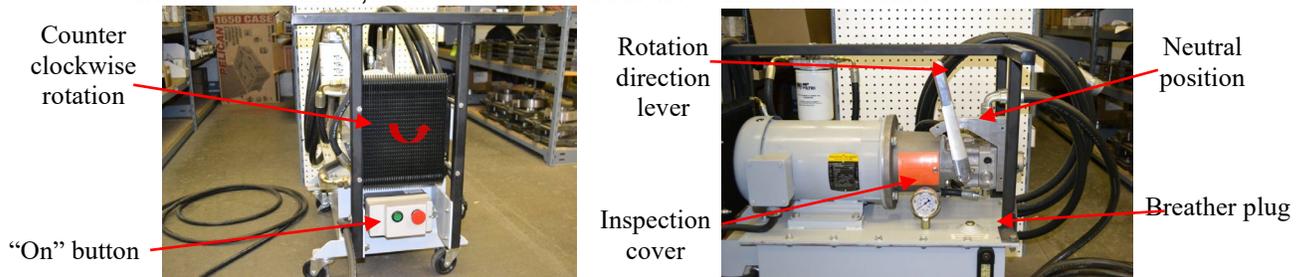
**Please observe all company and Government work safety practices.**



## Initiating the Bar Drive

### 4. Bar drive Setup

- 4.1 Mount the bar drive motor to the 4-14 feed carriage. Connect the hoses from the power supply to the hydraulic motor.
- 4.2 The valve body on the hydraulic motor is equipped with a bar lock solenoid that is operated by the On/Off on the remote. The solenoid turns the bar rotation on and off to position the tool head for tool changes. **Note: tool changes should be made with the power off.**
- 4.3 Feed rate and rotation direction is controlled on the power supply. Put the Stroke handle in the center position for neutral. To the right of neutral is clockwise rotation, and to the left is counter – clockwise rotation.



- 4.4 In neutral, turn on the electric motor on the hydraulic drive and check the gauge pressure, let it go to 100 PSI. This will insure all air is out of the system. Run handle slightly ahead and back with the bypass handle on the hydraulic pump in bypass position. This will assist in removing the air in the lines.
- 4.5 The hydraulic unit is now ready for operation. Please refer to the 4-14 manual for the correct operation of the feed system and line-boring operations in general.
- 4.6 Always shut down and start up the electric motor with the hydraulic flow in the neutral position, **do not start the electric motor under load.**

## Operational Checks

1. NEVER LET THE SYSTEM OPERATE FOR ANY PERIOD OF TIME IN THE STALLED POSITION. THIS WILL CAUSE DAMAGE TO THE COMPONENTS AND WILL VOID WARRANTY.
2. ALWAYS MAKE SURE QUICK DISCONNECTS ARE CLEAN BEFORE CONNECTING. FAILURE TO DO SO WILL CONTAMINATE THE SYSTEM AND VOID WARRANTY.
3. ALWAYS MAKE SURE OIL IS SHOWING ON THE SIGHT GAUGE OF THE RESERVOIR.
4. INSURE THE ELECTRIC MOTOR ROTATION IS CLOCKWISE.
5. **Test main pressure:** Disconnect hoses from bar drive, do not connect them together. Manual feed hoses can remain connected. Turn on power, find neutral with lever. Move lever to CW – pressure should be 1750 psi. Set lever back to neutral, move lever to CCW. The gauge in this position should also read 1750 psi. Set back to neutral.

### PLEASE NOTE:

The information contained in the manual is up-to-date at the time of printing. Please feel free to call the York service department for clarification or further instruction on any of the information contained in this manual.

North America Toll Free Ph: 1-888-783-9675  
International Ph:250-286-6400 Fax:250-286-6160  
E-Mail: [techsupport@sprtool.com](mailto:techsupport@sprtool.com)  
Web: [www.sprtool.com](http://www.sprtool.com)



### 5HP Parts List

ITEM	QTY	PART#	DESCRIPTION
01	1	HD-1014	HOSE ASSY B
02	1	HD-1015	HOSE ASSY A
03	2		JIC ADAPTOR #2404-6-8
04	4	HD-1016	COOLER SPACERS
05	1	HD-1027	OIL COOLER
06	15		1/4" PLATED FLAT WASHERS
07	14		1/4"NC PLATED G5 NUTS
08	4		1/4"NC PLATED G5 HEX HD CAPSCREWS
09	4		1/4"X1 1/2"NC PLATED G5 HEX HD CAPSCREWS
10	1	HD-1030	GUARD
11	2		3/8" X1"NC SS HEX HD CAPSCREWS
12	12		3/8" SS FLAT WASHERS
13	21'		ELECTRICAL WIRE
14	3	2524	3/8" STRAIN RELIEF
15	2		STARTER SWITCH SCREWS C/W SWITCH
16	3		3/4" STRAIN RELIEF STEEL LOCKNUT
17	1	HD-1024-	STARTER SWITCHES (see below)
		HD-1024-0	230 Volt, 60 Hertz, Single Phase
		HD-1024-1	230 Volt, 50 Hertz, Single Phase
		HD-1024-2	208-240 Volt 60 Hertz, Three Phase
		HD-1024-3	460 Volt, 60 Hertz, Three Phase
		HD-1024-4	380 Volt, 50 Hetz, Three Phase
		HD-1024-5	190 Volt, 50 Hetz, Three Phase
		HD-1024-6	208-240 Volt, 50 Hetz, Three Phase
		HD-1024-7	460 Volt, 50 Hertz, Three Phase
18	2		1/4"X1"NC FLAT HD CAPSCREWS
19	1	HD-1012	TANK
20	16		5/16"NC PLATED FLANGE NUTS
21	2		1/2"NPT SCULLY FLANGE
22	2		PIPE PLUG #5409-8
23	2		3/8"NC SS NUTS
24	1	HD-1017	SIGHT LEVEL GLASS
25	8		3/8"NC SS LOCKWASHER
26	2		3/8"NC FLANGED NUT C/W SIGHT LEVEL GLASS
27	4	HD-1018	CASTORS

28	4		3/8"LG DIA. FLAT WAHSERS (1 1/2" OD)
29	2	HD-1037	ANGLE BRACKET
30	4		3/8"NS SS NYLOCK NUTS
31	2		90deg MALE JIC FITTING #2701-6-6
32	4		STRAIGHT JIC FITTING #2700- 6-6
33	1	HD-1022	HOSE ASSY F
34	1	HD-1023	PRESSURE GAUGE 2000PSI
35	1		STRAIGHT FEMAIL JIC FITTING #2705-4-6
36	16		5/16"X3/4"NC PLATED G5 HEX HD FLANGE BOLT
37	1	HD-1001	COVER PLATE TANK LID
38	1	G6-13 SUPPORT CLAMP	5/8" INSULATED HOSE CLAMP
39	1	HD-1041	AIR BREATHER
40	7		#6 JIC BULKHEAD LOCKNUT
41	1	HD-1025	TUBE ASSY A
42	2	HD-1026	TUBE ASSY C&D
43	2		STRAIGHT ORB X JIC FITTING #6400-6-8
44	1		5/8" GEAR CLAMP
45	1	HD-1028	TUBE ASSY E
46	1	HD-1029	TUB ASSY F
47	1		STRAIGHT PIPE X JIC FITTING #2404-6-6
48	1	HD-1031	SUCTION STRAINER
49	1	HD-1032	TUBE ASSY B
50	2	HD-1034	CROSS PORT RELIEF
51	1	HD-1042	HOT OIL SHUTTLE VALVE
52	1	HD-1043	GAUGE SHUTTLE VALVE
53	1	HD-1020	TRANSMISSION VALVE BODY
54	1	HD-1044	CHARGE RELIEF VALVE
55	3		1/8"NPT PIPE PLUG
56	3		90deg ORB X JIC FITTING #6801-6-6
57	1	HD-1040	TUBE ASSY G
58	1	HD-1013	TRANSMISSION VALVE BODY BRACKET
59	2		1/4"X3"NC PLATED HEX HD CAPSCREWS
60	1	HD-1045	HOSE ASSY D
61	1	HD-1046	HOSE ASSY C
62	1	HD-1047	HOSE ASSY E
63	2		JIC REDUCER MALE/FEMALE FITTING #2406-6-8
64	1	HD-1052	COUPLING HALF
65	1	HD-1053	COULPING INSERT
66	1	HD-1048	COUPLING HALF, MODIFIED
67	1	HD-1021-	ELECTRIC MOTORS
		HD-1021-0	230 Volt, 60 Hertz, Single Phase
		HD-1021-1	230 Volt, 50 Hertz, Single Phase
		HD-1021-2	230/460 Volt, 60 Hertz, Three Phase
		HD-1021-3	190/380 Volt, 50 Hertz, Three Phase
		HD-1021-4	220/440 Volt, 50 Hertz, Three

			Phase
		HD-1021-5	575 Volt, 60 Hertz, Three Phase
68	4		3/8"x3/4" or 1 1/4"NC SS HEX HD CAPSCREWS
69	1		3/4 TO 1/2" REDUCER BUSHING*
70	1		3/4" SHORT ELBOW*
71	2		ELECTRIC MOTOR COVER SCREWS C/W MOTOR
72	1		ELECTRIC MOTOR COVER C/W MOTOR
73	2		1/4"X1" KEY
74	1	HD-1039	BELL HOUSING
75	4		1/2" SS FLAT WASHERS
76	4		1/2"X1"NC SS HEX HD CAPSCREWS
77	1		3/16"X1" KEY
78	2		3/8"X1/2"NC SS HEX HD CAPSCREWS
79	1	HD-1019	HYDRAULIC PUMP
80	2		JIC X ORD RUN TEE FITTING #6804-8-8
81	1	HD-1003	BRACKET
82	2	8X70mm	BRACKET BOLTS
83	1	HD-1004	COUPLING
84	1	HD-1002	SHOULDER BOLT
85	1	HD-1006	LEVER
86	1	DYL24664	SPRING, 11/32X0.47X1 1/2"
87	1		5/16"NC SS NYLOCK NUT
88	1	HD-1005	HANDLE
89	1	HD-1007	LEVER PIN
90	3		10-24X1" SS FLAT HD SCREW
91	1	414-003	DRIVER SCREW
92	4		3/8"X1"NC SS SOCKET HD CAPSCREW
93	3		ORB PLUG FITTING #6409-8
94	4		5/16"X1 1/2" SS SOCKET HD CAPSCREW
95			
		HD-1035-1 HD-1035A	REPLACEMENT COIL (110V 50/60 HZ)
		HD-1035-2 HD-1035C	REPLACEMENT COIL (230V 50 HZ)
		HD-1035-3 HD-1035B	REPLACEMENT COIL ( 230V 60 HZ)
96	4		10-24X1 1/4" SOCKET HD CAPSCREW
97	1	HD-1049	ET POWER CORD
98	1		1/4"X1" NC PLATED G5 HEX HD CAPSCREW