

Sunnen worldwide

Sunnen Products Company

St. Louis – USA
World Headquarters
Phone +1 314 781 21 00
Fax +1 314 781 06 92
sunnen@sunnen.com
www.sunnen.com

Sunnen AG

Ennetaach – Switzerland
European Technology Center
Phone +41 71 649 33 33
Fax +41 71 649 33 34
sales@sunnen.ch
www.sunnen.ch

Sunnen Italia S.r.l.

Ospiate di Bollate – Italy
Phone +39 02 383417 1
Fax +39 02 38341750
sunnen@sunnenitalia.com
www.sunnenitalia.com

Sunnen SAS

Saclay – France
Phone: +33 1 69 30 0000
Fax: +33 1 69 30 1111
info@sunnen.fr
www.sunnen.fr

Sunnen Products Ltd.

Hempstead Herts – UK
Phone +44 1442 393939
Fax +44 1442 391212
hemel@sunnen.co.uk
www.sunnen.co.uk

Sunnen Polska Sp. z o.o.

Warszawa – Poland
Phone +48 22 814 34 29
Fax +48 22 814 34 28
sunnen@sunnen.pl
www.sunnen.pl

Sunnen RUS »ООО«

Moscow – Russia
Phone +7 495 258 43 43
Fax +7 495 258 91 75
sunnen@sunnen-russia.ru
www.sunnen.ru

Sunnen s.r.o.

Strakonice – Czech Republic
Phone +420 383 376 317
Fax: +420 383 376 316
sunnen@sunnen.cz
www.sunnen.cz

Shanghai Sunnen

Mechanical Co. Ltd.
Shanghai – China
Phone +86 21 58133990
Fax +86 21 58132299
shsunnen@sunnensh.com
www.sunnensh.com



ABOVE AND BEYOND HONING



design: vegraphics.ch

X-SAG-HTC-E-C



Production Tube Hone

HTC-W Series

Built for high volume production



The Sunnen HTC-W Series

The HTC-W Series is the result of 30 years experience in tube hone design and manufacturing, combined with inputs from our customers around the globe. Most of the systems are custom-built and have enough power and sensibility to work from diameter 25 mm up to 1000 mm. The stock removal rate is given through a 7.0 kW servo drive and a 4-step gearbox. This configuration ensures optimum power in the whole diameter range and a stock removal rate up to 900 cm³/h. Together with the Sunnen tools, abrasives and coolant oils, all the HTC-W Systems are working at their top performance and will meet everybody's production demands.

As an **all-inclusive supplier**, Sunnen takes full responsibility for the entire process.



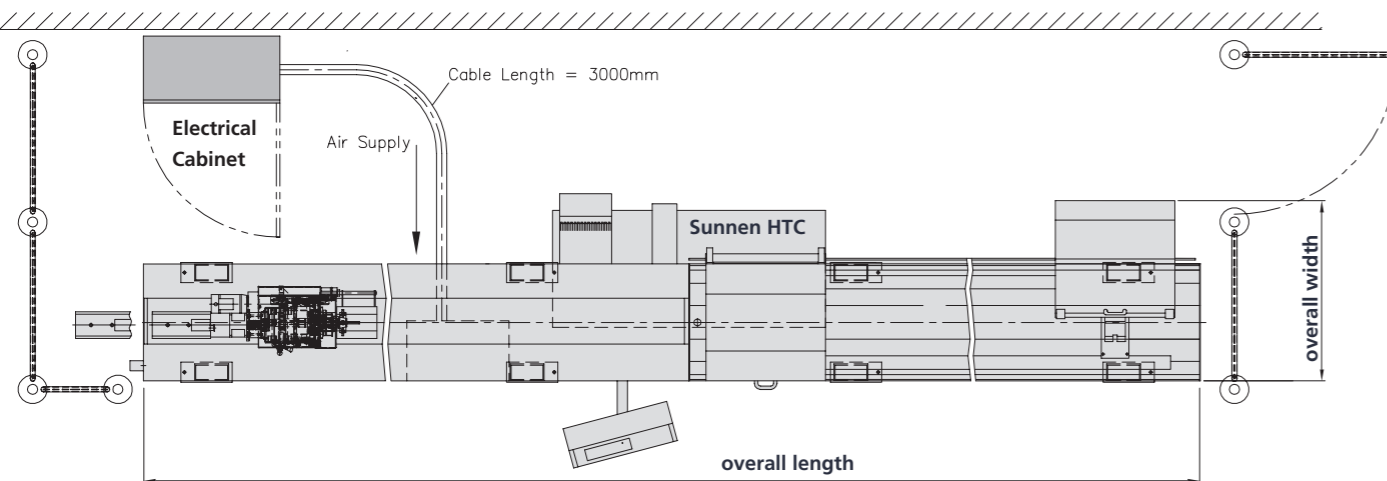
Features and Benefits

- Large diameter range with stock removal rate of 900 cm³/h and more
- Automatic bore geometry correction
- Direct cross-grinding of rough parts, without expensive bore drilling
- 100% process control with tool overload protection
- The 3-axis function control manages stroke positions, motion control, stone feed, spindle speed and the cutting pressure guarantees the most favorable accuracy and bore geometry
- Repeat position of stroke within 0.1 mm during operation, independent of different stroke speeds
- Stroke speed variable (stroke rate adjustable in 0.1 m/min increments through operator interface adjustable during cycle)
- Size lock system with stone wear compensation
- Dwell and oscillation feature
- Spark out function
- All axes are electrical driven (efficiency up to 90%)
- Storage facility for over 900 programmed set-ups
- Spindle jog, short stroke at any position
- Digital stroke position indicator
- Digital stroke speed indicator
- Digital spindle RPM readout

HTC-W Series	Variation of HTC-6300W to HTC-10300W	
Capacity <ul style="list-style-type: none"> • Stock Removal Power • I.D. Capacity • O.D. Capacity Standard • O.D. Capacity Optional • O.D. Capacity Special 	up to 900 cm ³ /h (55 in ³ /h) 25 - 1000 mm (1 - 40 in) 60 - 400 mm (2.4 - 15.8 in) 350 - 600 mm (13.8 - 23.6 in) (with additional HT-350 Fixture) 70 - 1000 mm (2.8 - 40 in) (with special work base)	
Spindle Drive System <ul style="list-style-type: none"> • SERVO-Spindle Motor • Spindle Speeds-Ininitely Variable 	7.0 kW 15 to 450 RPM	
Stroke System <ul style="list-style-type: none"> • Stroke Servo Motor • Stroking Speeds 	4.2 kW 0.1 - 40 m/min	
Tool Feed System <ul style="list-style-type: none"> • Feed Servo Motor • Feed System 	1.0 kW Rotary tool feed system by servo motor and overlap gear	
Computer Control <ul style="list-style-type: none"> • IPC (Industrial PC Control), Windows EMBEDDED control system / Screen size 15" • Languages E/D/I/F/S 		
Work Holding Fixture <ul style="list-style-type: none"> • 2 Standard • Optional HT-350 • Optional special work base 	Universal V-Type chain fixture (30 - 400 mm) Universal V-Type chain fixture (350 - 600 mm) Universal scissor fixture (70 - 1000 mm)	
Supply Requirements <ul style="list-style-type: none"> • Electrical system • Compressed air 	400 - 460 Volt; 50/60 Hz; 3-phase 30 liter per minute at 6 bar	
Lubrication System <ul style="list-style-type: none"> • Way Bearings • Spindle Bearings • Gear Reducers 	Live time lubrication Oil Bath Oil Bath	
Coolant System <ul style="list-style-type: none"> • Tank • Supply Pump • Magnetic Separator • Filter System Optional 	300 liter reservoir (500 liter optional for HTC-2300W to HTC-4300W) 38 l/min (50 l/min optional for HTC-2300W to HTC-4300W) Cleaning rate 70 % External, Turbo Separator Centrifugal filter unit with integrated Oil Chiller or Customer Solution	500 liter reservoir 50 l/min
Safety Features <ul style="list-style-type: none"> CE Version: • Standard 	1 Light Curtain on front of spindle table 1 Fence with door for back side protection	
Paint <ul style="list-style-type: none"> • Grey RAL 9002/RAL 7043 		
Optional Features <ul style="list-style-type: none"> • PF-401 Filter unit with paper cartridge filter elements for non ferrous application or very fine surface finish requirements • IPG-50 In-process gaging system for I.D. 25 - 230 mm • Chiller unit • Steady Rest for HTC-2300W to HTC-4300W (Stroke length minus 500 mm) • Double stage tools option (roughing/finishing Tooling) • Taper bore option • Part rotary device • Special applications can be addressed as required 		Standard

Technical Specifications

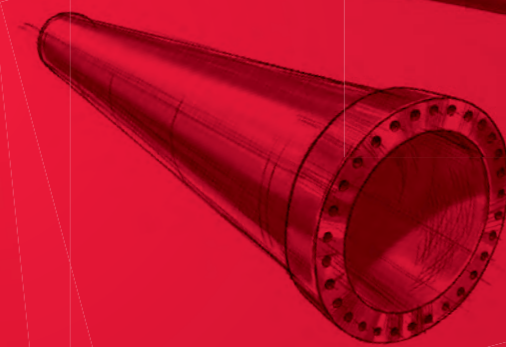
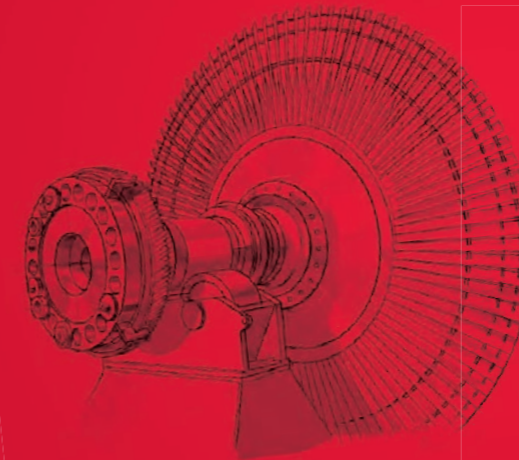
HTC-X300W Series Specifications	HTC-2300W	HTC-3300W	HTC-4300W	HTC-6300W	HTC-8300W	HTC-10300W
Maximum Stroke Length	2'000 mm	3'000 mm	4'000 mm	6'000 mm	8'000 mm	10'000 mm
No. of Steady Rests	Optional	Optional	Optional	1	1	2
Overall Length	6'200 mm	8'200 mm	10'200 mm	14'700 mm	18'700 mm	23'200 mm
Overall Width	1'200 mm	1'200 mm	1'200 mm	1'500 mm	1'500 mm	1'500 mm
Spindle Center Height to Floor	1'100 mm	1'100 mm	1'100 mm	1'100 mm	1'100 mm	1'100 mm
Height	1'523 mm	1'523 mm	1'523 mm	1'523 mm	1'523 mm	1'523 mm
Weight	2'600 kg	3'000 kg	3'400 kg	4'600 kg	5'400 kg	6'200 kg
Coolant Capacity	300 l	300 l	300 l	500 l	500 l	500 l



NOTE: Sunnen reserves the right to change or revise specifications and product design in connection with any feature of our products contained herein. Such changes do not entitle the buyer to corresponding changes, improvements, additions, or replacements for equipment, supplies or accessories previously sold. Information contained herein is considered to be accurate based on available information at the time of printing. Should any discrepancy of information arise, Sunnen recommends that user verify the discrepancy with Sunnen before proceeding in any bore sizing and finishing operation.

Main Focus:

Cylinder Liners, Hydraulic Cylinders, Extrusion Cylinders, Aircraft Components, Compressor Components



Aircraft Industry



The **unique touch screen control** of Sunnen guarantees lowest manufacturing costs per part due to:

Four-Stone GL Tool
ø 12.7 - 65 mm
4 abrasive stones in use

Multi-Stone GHSS Tool
ø 37 - 141 mm
6 - 8 abrasive stones in use

Four-Stone MPS Tool
ø 50 - 177 mm
Easy handling

Four-Stone HB Tool
ø 76 - 1 200 mm
Large diameter range

Four-Stone HB-SL Tool
ø 97 - 670 mm
up to 500 cm³/h

Automatic bore geometry correction
The system indicates high and low spots and corrects the geometry with appropriate short strokes without operator intervention.

Easy set-up
All parameters are stored and the system recommends the required tool, sets the spindle speed and all necessary cycle parameters. A new set-up can be made within 2 minutes, step-by-step.

Tool overload protection
The 100% control of the process ensures optimal stock removal and protection of the tool.



The flexible fixture system
Standard or with optional part rotary device, the HTC-W can be equipped according to tube shapes and customer needs



The versatile HTC-W System
For every application material, the HTC-W system is the ideal system and fits in all production industries.

