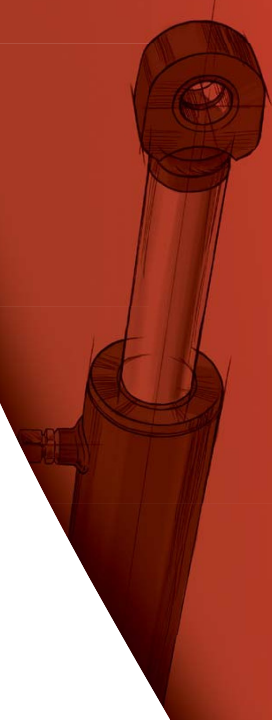


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Small Production Tube Hone

HTB-S Series

X-SAG-HTB-E-C design: vegraphics.ch

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Built for job shops

Hydraulic Cylinders, Aircraft Components and Compressor Components



Four-Stone MPS Tool
ø 50 - 650 mm

The Sunnen HTB-S Series

The HTB-S Series is the ideal system when flexibility for repair work and small production is required. The job shop system with the 3 kW spindle drive ensures maximum power up to diameter 350 mm (ID) with 400 cm³/h stock removal. Together with the Sunnen tools, abrasives and coolant oils, all the HTB-S Systems are working at their top performance and will meet customized production demands. As an **all-inclusive supplier**, Sunnen takes full responsibility for the entire process.

Features and Benefits

- Large diameter range with 400 cm³/h and more
- Repeat position of stroke within 0.1 mm during operation, independent of different stroke speeds
- Stroke speed variable (stroke rate adjustable in 1 mm/min increments through operator interface adjustable during cycle)
- Dwell and oscillation feature
- Spark out function
- All axes are electrical driven (efficiency up to 90%)
- Storage facility for over 100 programmed set-ups
- Spindle jog, short stroke
- Digital stroke position indicator
- Digital stroke speed indicator
- Digital spindle RPM readout



Technical Specifications

HTB-S Series Specifications	HTB-2000S	HTB-3000S	HTB-4000S	HTB-6000S	HTB-8000S	HTB-10000S
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	2,200 kg	2,600 kg	3,000 kg	4,200 kg	5,000 kg	5,800 kg
Coolant Capacity	300 l	300 l	300 l	500 l	500 l	500 l

HTB-S Series	Variation of HTB-6000S to HTB-10000S
Capacity <ul style="list-style-type: none"> • Stock Removal Power • I.D. Capacity • O.D. Capacity Standard • O.D. Capacity Optional 	up to 400 cm ³ /h (24.4 in ³ /h) 25 - 350 mm (1 - 13.8 in) (optional up to 550 mm) 60 - 400 mm (2.4 - 15.8 in) 350 - 600 mm (13.8 - 23.6 in) (with additional HT-350 Fixture)
Spindle Drive System <ul style="list-style-type: none"> • AC Spindle Motor • Spindle Speed range • Optional Spindle speed range 	3.0 kW variable speed controlled 30 - 400 RPM 15 - 200 RPM (up to I.D. 550 mm)
Stroke System <ul style="list-style-type: none"> • Stroke Servo Motor • Stroking Speeds 	3.2 kW 0.1 - 40 m/min
Tool Feed System <ul style="list-style-type: none"> • Feed Servo Motor • Feed System 	0.3 kW Sunnen MPS-automatic feed system
Computer Control <ul style="list-style-type: none"> • PLC Control (SIEMENS S7-300 with standard Profi Bus) • Screen size 5.7" • Languages E/D 	
Work Holding Fixture <ul style="list-style-type: none"> • 2 Standard • Optional HT-350 	Universal V-type chain fixture (60 - 400 mm)
Supply Requirements <ul style="list-style-type: none"> • Electrical system • Compressed air 	400 - 460 Volt; 50 / 60 Hz; 3-phase 30 litre 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 HTB-2000S to HTB-4000S) 38 l/min (50 l/min optional for HTB-2000S to HTB-4000S) Cleaning rate 70 % External Turbo Separator Centrifugal filter unit with integrated Oil Chiller or Customer Solution
Safety Features <ul style="list-style-type: none"> • CE Version: • Standard • Optional 	1 Light Curtain on front of spindle table 1 Light Curtain on backside of spindle table or fence
Paint	
Optional Features <ul style="list-style-type: none"> • PF-40 Filter unit with paper cartridge filter elements for non ferrous application or very fine surface finish requirements • IPC-50 In-process gaging system for I.D. 25-230 mm • Automatic tool support • Chiller unit • Steady Rest for HTB-2000S to HTB-4000S (Stroke length minus 500 mm) 	Standard

