



ABOVE AND BEYOND HONING

HTE-1600W

HORIZONTAL TUBE HONE



SUNNEN'S ULTRA-SENSITIVE HTE-1600W TUBE HONE



Sunnen's HTE-1600W tube hone is the company's first all-electric, cost-effective hone designed specifically for small diameter/long bore length parts. The HTE produces ideal bore geometry and surface finish on parts with ID's from 4-20 mm (0.156-0.787 in) and lengths up to 1,500 mm (59 in).

The HTE features a one-piece base design that aligns tool and part. A special feature of the feed system provides maximum protection against tool overloading that often leads to breakage. Tool specific force limits and run settings are stored in the Windows®-based touchscreen control. A unique feed control system senses tight sections in the part and automatically corrects them.

IS IDEAL FOR SMALL-BORE PARTS



The HTE is ideal for improving the size, form and finish of small bores such as:

- Safety Valves in Oil Field Parts
- Small hydraulic and pneumatic actuators
- Raw Materials for Medical Stents
- Gun Barrels

The HTE is available with three fixturing options: a manual chuck, a pneumatic chuck, or a custom V-type chain vise for parts with OD's up to 375 mm (14.75 in), dependent on application.

When the HTE is a part of a total Sunnen solution, the system will provide a durable and efficient precision honing system to perform to your exact application needs.

Your Sunnen Technical Specialist will work with you to determine the best solution for your needs – it's all part of the added value you get with Sunnen. Plus, our worldwide sales and service team provides comprehensive support for the installation and operation of every system we make.

Whatever your need, we have the expertise and product range to create the right solution for you and the dedication to support you for the long run.



DEVELOPED TO HONE SMALL DIAMETERS, THE HTE IS BOTH FLEXIBLE AND PRECISE



FEATURES AND BENEFITS:

- 100 percent process control with tool overload protection.
- The active 3-axis function control manages stroke positions, motion control, stone feed, spindle speed and cutting pressure ensuring high accuracy and superior bore geometry.
- Stroke repeatability within 0.15 mm (0.006 in) during operation (dependent on application).
- One-piece base design provides a rigid, reliable structure.
- Traveling steady-rest is standard.
- Optional guide pot automatically guides the honing tool straight into the bore without operator assistance.
- Proven steel reinforced servo belt-drive stroking system with variable stroke speeds (stroke rate adjustable through operator interface adjustable during cycle).
- Temperature compensated spindle assures constant performance without bearing warm-up time required.
- Size lock system with stone wear compensation.
- Optional safety system consisting of light curtain and fencing (shown above).

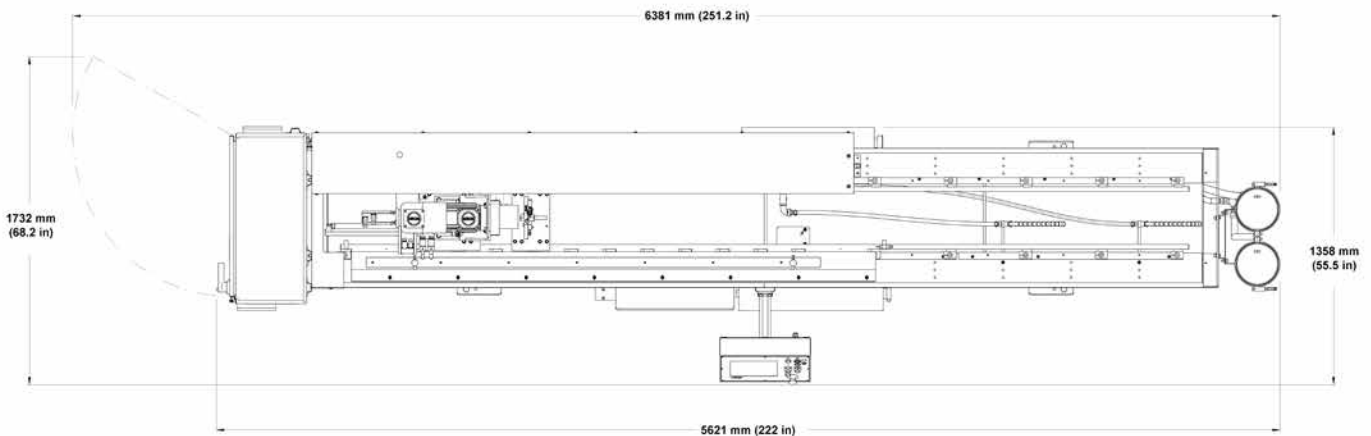
OPERATOR INTERFACE AND SOFTWARE FEATURES

All machine features are controlled via a proven Windows® software platform and PC controlled operator station, meaning no hydraulic valves to adjust or limit switches to move. The operator station swivels for ease of use. Large 305 mm (12 in) color monitor is standard. Features include:



- Variable stroke speeds (stroke rate adjustable in 1 m/min (3.2 ft/min) increments through operator interface adjustable during cycle)
- All axes are electrically driven (efficiency up to 90 percent)
- Crosshatch angle display
- Automatic and manual operations mode
- Recommended machine settings for ease of setup
- Capable of honing for time, number of strokes or to a programmed diameter
- 13 languages available
- Ability to save up to 999 setups
- Automatic stonewear compensation
- Jog buttons for easy setup

HTE-1600 FLOOR PLAN LAYOUT AND DIMENSIONS



THE HTE IN ACTION

The value-priced HTE-1600W is packed with features you would expect in a more expensive system. Here are just a few of the features:



The temperature-controlled servo spindle, stoker and feed system assure complete process control.



Standard dual filtration 208.5 liter (55 gallon) capacity manual paperbed filter which is easily accessible from the front of the machine.



The additional standard dual cartridge filter ensures clean honing fluid for demanding processes.

SPECIFICATIONS:

SPINDLE SPEED:

5 – 2100 RPM

SPINDLE POWER (SERVO):

.75 kW (1 Hp) variable speed controlled

STROKE (SERVO):

2,17 kW (2.9 Hp) belt drive

STROKE SPEED RANGE:

1 – 30m/min (3.3 – 98.4 ft/min)

I.D. DIAMETER RANGE:

4 - 20 mm (0.15 - 0.79 inches)

O.D. DIAMETER RANGE:

See workholding options

MAXIMUM PART LENGTH:

1,500 mm (59 inches)

MAXIMUM STROKE LENGTH :

1,600 mm (63 inches)

APPROXIMATE WEIGHT (INCLUDES COOLANT CART):

1,240 kg (2,734 lbs.)

ELECTRICAL SYSTEM:

400 VAC, 50 Hz, 3-phase

FLA = 18.6

460 VAC, 60 Hz, 3-phase

FLA=16.25

COMPRESSED AIR REQUIREMENT:

30 lpm (5.3 gpm) @ .65 - .85 MPa (94-123 psi)

OPTIONAL EQUIPMENT:

- Workholding configurations:
 - V-Block/Chain 375 mm (14.75 in) max O.D. (customized for application)
 - Pneumatic chuck 57 mm (2.24 in) max O.D.
 - Manual chuck 57 mm (2.24 in) max O.D.
- Automatic size control (ASC)
- Tool Park Unit with Bushing and Coolant Injection
- 230 VAC - 460 VAC step-up transformer
- Splash Guards
- Basic Part Coolant Application Kit
- Tubular Part Drain Rack
- CE Compliant Guarding including rear/end fencing and light curtain

MODEL NUMBERS:

HTE-1600 WG (400 VAC 50 Hz 3Ph)

HTE-1600 WCG (same as HTE-1600 WG with CE compliant guarding)

HTE-1600 WE (460 VAC 60 Hz 3Ph)

HTE-1600 WCE (same as HTE-1600 WC with CE compliant guarding)

TOOLING

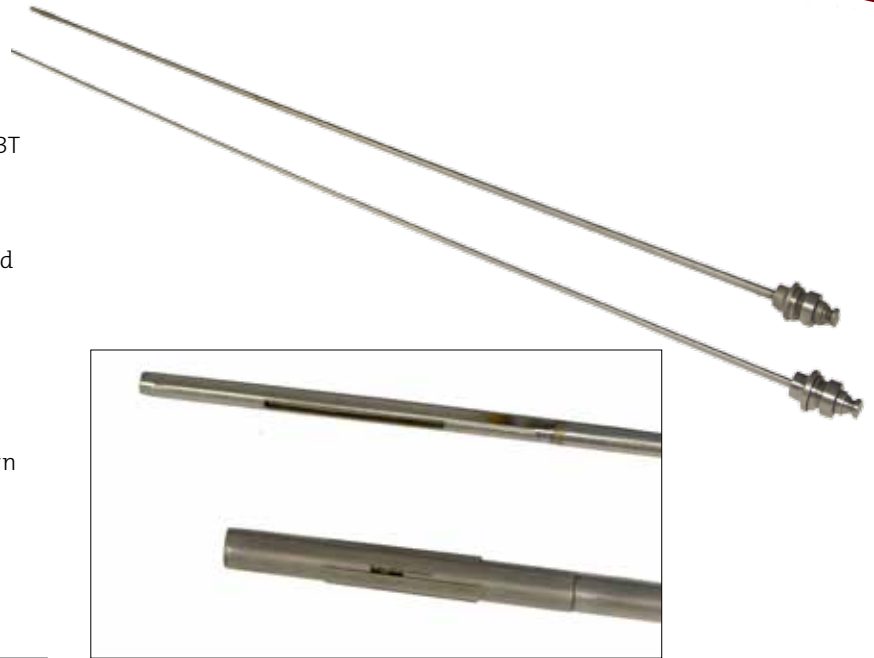
The HTE is compatible with Sunnen MMT tools and LBT tools for small, long diameter bores.

LBT: The LBT tool was designed for for small, long diameter tube hone applications. (Pictured at right and in inset.)

BORE DIAMETER RANGE:
4,27 - 12,7 mm (0.168 - .500 in)

MMT: MMT tools can be special ordered to fit your specific application, with roundness accuracies down to 2 microns (0.00079 in) depending on application.

BORE DIAMETER RANGE:
4 - 20 mm (0.156 - 0.787 in)



SUNNEN-MADE ABRASIVES

From aluminum oxide to silicon carbide to diamond and CBN, Sunnen manufactures the industry's largest variety of mounted or un-mounted stick abrasives, bond types, grain sizes and stone configurations.

Before any stone is shipped, it is graded and qualified, maintaining the most exacting quality control standards in the industry to assure you of the most precise and consistent honing performance available.



SUNNEN PREMIUM HONING OILS & COOLANTS

Sunnen's premium honing oils and coolants provide extreme lubricity for higher honing pressure and harder abrasives, delivering faster, lower cost-per-part and ultimately more profitable cutting rates.



SUNNEN DIAL BORE GAGES

Sunnen Dial Bore Gage system provides quick, easy way to gage I.D.'s on bores with a wide range of sizes and lengths. Dial Bore Gages and Setting Fixtures are available to cover diameters from 13,71 mm to 152,4 mm (.054" to 6"), optional to 309 mm diameters (12").





A LEGACY OF EXCELLENCE SINCE 1924.

WORLDWIDE

Our global manufacturing, distribution, and sales and service network allows us to deliver quality Sunnen solutions worldwide.

And our state-of-the-art Technical Services Centers allow our technical experts to develop innovative solutions to customer application challenges. The Centers also provide answers for customer questions and training for Sunnen representatives around the world.

SUNNEN PRODUCTS COMPANY
WORLD HEADQUARTERS
St. Louis, MO – USA
Phone 1.314.781.2100
Fax 1.314.781.2268
Toll Free 1.800.325.3670
Email sunnen@sunnen.com
www.sunnen.com



AUSTRIA - SUNNEN AUSTRIA GMBH **HOHENEMS**

Phone +43 (0) 5576 74194
Fax +43 (0) 5576 74196
Email sales@sunnen.eu
www.sunnen.at Sunnen

BELGIUM - SUNNEN BENELUX BVBA **KONTICH**

Phone +32 38 80 2800
Fax +32 38 44 3901
Email info@sunnen.be
www.sunnen.be

BRAZIL - SUNNEN DO BRASIL LTDA. **SÃO PAULO**

Phone +55 11 4177-3824
Fax +55 11 4362-3083
Email sunnen@sunnen.com.br
www.sunnen.com.br

CHINA - SHANGHAI SUNNEN **MECHANICAL Co. LTD.** **SHANGHAI**

Phone +86 21 5813 3990
+86 21 5813 2299
Email shsunnen@sunnensh.com
www.sunnensh.com

CZECH REPUBLIC - SUNNEN S.R.O. **STRAKONICE**

Phone +420 383 376 317
Fax +420 383 376 316
Email sunnen@sunnen.cz
www.sunnen.cz **SUNNEN**

FRANCE - SUNNEN SAS **SACLAY**

Phone +33 169 30 00 00
Fax +33 169 30 11 11
Email info@sunnen.fr
www.sunnen.fr

INDIA - SUNNEN INDIA PVT. LTD. **MUMBAI**

Phone +91 223 913 6055
Fax +91 223 913 6056
Email sales@sunnen.in
www.sunnen.in

ITALY - ITALIA S.R.L.

ARESE
Phone +39 02 383 417 1
Fax +39 02 383 417 50
Email sunnen@sunnenitalia.com
www.sunnenitalia.com **SUNNEN**

POLAND - POLSKA Sp. z o.o. **WARSZAWA**

Phone +48 22 814 34 29
Fax +48 22 814 34 28
Email sunnen@sunnen.pl
www.sunnen.pl

SUNNEN RUS LLC **MOSCOW – RUSSIA**

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

SWITZERLAND - SUNNEN AG **ENNETAACH**

Phone +41 71 649 33 33
Fax +41 71 649 33 34
Email sales@sunnen.eu
www.sunnen.eu

UK - SUNNEN PRODUCTS LTD. **HEMPSTEAD HERTS**

Phone +44 1442 39 39 39
Fax +44 1442 39 12 12
Email hemel@sunnen.co.uk
www.sunnen.co.uk

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