



MBB-1660

MANUAL HONING MACHINE



SUNNEN'S MBB-1660

The Most Versatile, Economical Bore Sizing Machine You Can Put In Your Shop

The Sunnen® MBB-1660 hones bores of any configuration. 1.5 to 165 mm (0.060 in. to 6.500 in.) in diameter 0.3 to 400 mm (1/8 in. to 16 in.) long. In regular or odd-shaped parts and any material, the MBB-1660 guarantees precision sizing and geometric accuracy with the surface finish you need. And it doesn't cost much. Add all these basics together and you have the most versatile, economical honing machine you can put in your shop.

With the MBB-1660 in your shop you are ready for any kind of I.D. work that comes along. Whether you are honing half a dozen pieces or several hundred, a job you've never run before or a repeat job, production or salvage, you can set up and start honing without delay or a lot of expense. In many cases, this machine pays for itself on the first two or three jobs. Sunnen® MBB-1660 is the biggest bargain in the industry.

The Sunnen MBB-1660 uses a simple 3-step operation:

- You gage the bore.
- You set the honing dial for the amount of stock to be removed.
- You hone until the dial says zero.

Setup takes only about 10 minutes. You change quickly from one job to another. You don't have to worry about fixtures, indexing, special tooling or critical tool adjustments. Easy-to-read charts and tables show you clearly and quickly which tooling, stones, speeds, and cutting pressures to use.

The MBB is now equipped with new safety features including:

- 1 Spindle motor brake
- 2 Interlocked belt guard
- 3 Lockable coolant access door
- 4 Foot guard

The MBB-1660 is pictured with optional work light, gage and gage stand, and drip trays.

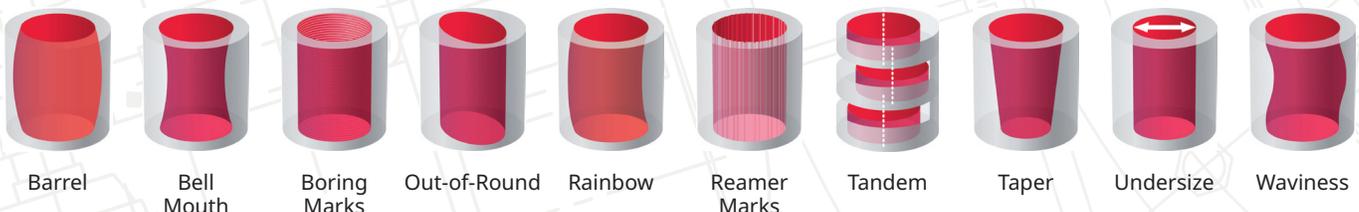


The MBB-1660 Cleans Up Problems Other Operations Leave

There are ten common bore errors that are caused by machining, heat treat or chucking. All of them can be corrected quickly and easily on the Sunnen MBB-1660.

The really important thing is that the Sunnen honing clears up these bore errors with the least possible stock removal. In many cases, this is the difference between scrapping or saving a run of expensive pieces.

BORE CONDITIONS THAT CAN BE CORRECTED BY HONING



Specifications

I.D. RANGE

1.50 mm to 165 mm
(0.0600 in. to 6.5000 in.)

LENGTH RANGE

Hones bores up to 400 mm (16 in.) in length depending on diameter

SPINDLE SPEEDS

200, 250, 320, 400, 500, 640, 800, 1000, 1270, 1600, 2000, 2500 rpm

SPINDLE MOTOR

0.375 kW (.5 HP)

SPINDLE BRAKE

Self-energizing band-type

HONING OIL PUMP

Utilizes spindle drive motor

HONING OIL CAPACITY

60 liters (16 gallons)

FILTER SYSTEM

Optional PF-150 filter available

FLOOR SPACE

762 mm W x 1524 mm D x 1600 mm H
(30 in. W x 60 in. D x 63 in. H)

MODELS

MBB1660CK: 115 V 60 Hz Single Phase

MBB1660CE: 460 V 60 Hz 3 Phase

MBB1660CD: 230 V 60 Hz 3 Phase

MBB1660CG: CE/400 V 50 Hz 3 Phase

MBB1660CH: CE/440 V 50 Hz 3 Phase

All models CE Compliant

WEIGHT (WITH HONING OIL)

287 kg (630 lbs.)

COLOR

Gray White

Sunnen Sets the Standard for Accuracy

Sunnen honing machines, no matter how basic, are known worldwide for their honing accuracy.

One reason is the unique three-point Sunnen mandrel design with one stone and two unevenly spaced guide shoes. This design enables Sunnen tooling to produce extremely round bores with the least possible stock removal. Eliminating taper and out-of-round makes bore sizing down to 0.00025 mm (0.0001 in.) a routine matter.

Another key to consistent, accurate honing performance is Sunnen's premium honing stones which are manufactured under the most exacting quality control standards in the industry. From aluminum to silicon carbide to diamond and CBN, Sunnen offers a large selection of bond types, grain sizes and stone configurations to fit any application.

As always, Sunnen honing gives you any finish you need down to 0.05 microns (2 micro in.) and you get it consistently, piece after piece.

You control bore quality with Sunnen honing because you control roundness, straightness, size and finish, the elements which make up bore quality.

Sunnen Tooling and Accessories Make Honing Easier and More Efficient

Ask your Sunnen representative or visit www.sunnen.com for your free catalog of Precision Honing Supplies. The catalog has complete information on Sunnen's industry-leading tooling and abrasives.

Besides abrasives and tooling, you will find information on other accessories to make your job easier and more efficient such as honing oils and gaging. Sunnen Industrial Honing Oil is specially formulated to deliver faster cutting, maximum stone life and the finest finish. The Sunnen precision PG series bore gages are a unique all-mechanical system, just dial your size on the setting fixture and transfer it to the gage. Complete set-up takes less than two minutes.

All the information you need is in the Precision Honing Supplies catalog.



A LEGACY OF EXCELLENCE SINCE 1924

Sunnen Worldwide

With world headquarters in St. Louis, Missouri, Sunnen is the largest fully integrated company in the world specializing in precision bore creation, sizing and finishing equipment. A Sunnen solution might include honing, lapping, skiving/roller burnishing or deep hole machining...or a combination of those processes.

Our 14 international affiliates and over 40 authorized distributors allow us to deliver top quality Sunnen machines, tools, service and training wherever they are needed around the globe.

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