HTB-S SERIES
Small Production Tube Hone
The HTB-S series is the ideal system when flexibility for repair work and small production is required. The job shop system with the 3.5 kW spindle drive ensures maximum power up to diameter (ID) 400 mm 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.

**Simple touch control** with clear, self-explanatory screen. The ideal system for optimized process control for job-shop repair machines. No programming skills required. A new setup is quickly performed step by step. The system recommends all necessary cycle parameters. These parameters can be stored also.

**Easy to operate** - The 100% control of the process ensures optimal stock removal and protection of the tool. The system indicates high and low spots, additionally a self correction mode is available. For best stock removal and optimum stone wear the tool expansion is controlled continuously and avoids overloading of the tooling for maximum protection.

Built for job shops

Hydraulic cylinders, aircraft and compressor components

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 3.5 kW spindle drive ensures maximum power up to diameter (ID) 400 mm 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.

**Simple touch control** with clear, self-explanatory screen. The ideal system for optimized process control for job-shop repair machines. No programming skills required. A new setup is quickly performed step by step. The system recommends all necessary cycle parameters. These parameters can be stored also.

**Easy to operate** - The 100% control of the process ensures optimal stock removal and protection of the tool. The system indicates high and low spots, additionally a self correction mode is available. For best stock removal and optimum stone wear the tool expansion is controlled continuously and avoids overloading of the tooling for maximum protection.

**KEY FACTS**
- Flexible low production honing
  - Diameter up to 550 mm
  - Stroke length up to 10’000 mm
  - Stock removal rate up to 400 cm³/h

**PRECISION PERFORMANCE**
- Reliable accuracy and consistency
  - Repeatable full and short stroke within 0.1 mm
  - Dwell and oscillation feature
  - Sparkout function

**EASY OPERATION**
- Reduced cost per bore
  - Short setup and changeover time
  - Program memory for over 100 setups
  - Variable stroke speed during cycle
  - Easy to maintain

The slide disengagement function allows quick removal of the tool from the bore by simply pushing the slide back.

The manual tool support is standard, an automatic version can be selected as an option.
Technical specifications

CAPACITY
Stock removal power: up to 400 cm³/h
Inside diameter: 25 - 400 mm (optional up to 550 mm)
Outside diameter: 30 - 400 mm (optional up to 600 mm)
Stroke length: 2'000 / 3'000 / 4'000 / 6'000 / 8'000 / 10'000 mm

DIMENSIONS
Length: 6'200 - 23'200 mm
Width: 1'200 - 1'500 mm
Weight: 2'200 - 5'800 kg

SPINDLE DRIVE SYSTEM
Motor (AC): 3.5 kW
Speed range (Infinitely variable): 30 - 400 RPM (optional 15 - 200 RPM)

STROKE SYSTEM
Motor (Servo): 5.2 kW
Speed range (Infinitely variable): 1 - 40 m/min

TOOL FEED SYSTEM
Motor (Servo): 0.3 kW
Motion: Sunnen MPS-Automatic

COMPUTER CONTROL
SIEMENS S7-1500 touch panel, screen size 7"

WORK HOLDING FIXTURE
Universal V-type chain fixture (30 - 400 mm)

SUPPLY REQUIREMENTS
Electrical system: 400 - 460 VAC, 50/60 Hz
Pneumatics: 6 bar

COOLANT SYSTEM
Capacity: 300 l, 38 l/min (up to 4 m)
Magnetic separator: 500 l, 50 l/min (6 to 10 m)
70% cleaning rate

SAFETY FEATURES
CE / Front: Light curtain, Back/Sides: Fence with door (optional)

PAINT
Grey RAL 9002 / Black RAL 9005

OPTIONAL FEATURES
Universal V-type chain fixture (350 - 600 mm)
Automatic tool support
Steady rests for 2 to 4 meter machines
In-process gaging system for inside diameter 25 - 230 mm
Filter unit for non ferrous application or very fine surface finish requirements
Coolant oil chiller unit