

SHDS SERIES

SKIVING AND ROLLER BURNISHING SYSTEMS



Ø 137.185 ± 0.025

	0.18 : A-B
	0.025 LG H
	0.013/20 ^A LG H

SUNNEN'S SHDS SERIES SKIVING/ROLLER BURNISHING



Sunnen Products Company, the global leader in honing technology since 1924, now offers a cost effective bore sizing solution for hydraulic cylinders and other high production applications. The new SHDS series skiving and roller burnishing systems are up to 70 percent faster than traditional honing and are engineered to deliver precise tolerances and quality surface finishes.

The SHDS systems were designed with input from the hydraulic cylinder industry up front. Every feature was scrutinized to improve the productivity and

reliability of the machine. The prototype was tested on the punishing environment of the factory floor of a high production hydraulic cylinder manufacturer to further refine the design. This design and testing effort coupled with the use of heavy duty name brand components ensures years of trouble free operation. Change over and run times are minimized ensuring process profitability. Sunnen also offers the complete solution with not only machines but tooling, coolants, and coolant systems. Backed by a 3-year machine warranty and a global service and support network.



System shown with coolant system, safety guarding and chip removal system.



SYSTEMS FOR IMPROVED PRODUCTION RATES



Only Sunnen offers both honing and skiving/roller burnishing so the most cost effective bore finishing process may be selected for your specific application.

The advantages of the Sunnen Skiving/Roller Burnishing systems include:

- Improved surface finish – as fine as .10 to .15 microns (4 to 6 micro inch) (Ra) on average.
- Improved size control – tolerances within 0.0254 mm (.001 inch) on average and much finer for special applications.
- Increased surface hardness.
- Improved fatigue life.
- Enhanced corrosion resistance.
- Elimination of tool marks and minor surface imperfections.
- Faster production of hydraulic cylinders at a lower cost compared to other ID finishing processes.

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.

Buy with confidence

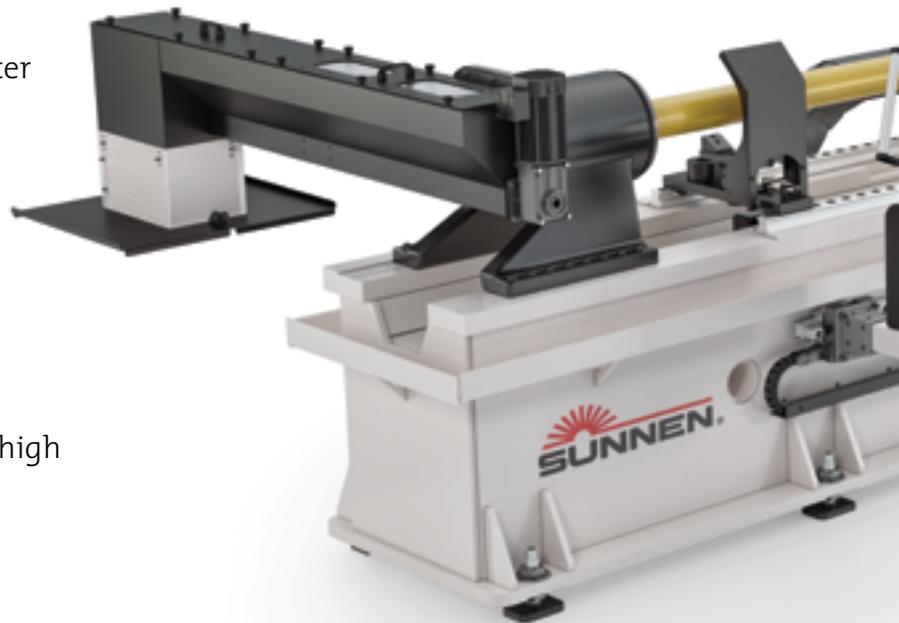


Sunnen backs the quality of its machines with a **"best in the business" 3-year standard machine warranty.**



EASY-TO-USE, EFFICIENT, HEAVY-DUTY UP TO 70 PERCENT FASTER THAN HONING

- **Available in three standard models**
 - 2-meter maximum part length (SHDS-2500)
 - 4-meter maximum part length (SHDS-4500)
 - 6-meter maximum part length (SHDS-6500)
- Large 394 mm (15.5 in) color HMI with intuitive controls for ease of use.
- Heavy-duty 55 mm (2.16 in) linear rails for maximum durability.
- Standard safety system with a combination of multiple E-stops, light curtains, interlocked guarding and fencing.
- Manufactured to finish the inside diameter of a hydraulic cylinder in a single pass within a minimum amount of time. Maximum feed rate of 125 mm/sec (4.9 in/sec).
- Beckhoff servo driven heavy-duty ball screws for tool feed and part clamping.
- Electrical enclosure air conditioning unit standard to protect critical electronics in high temperature environments.
- Heavy-duty welded base.
- Automatic lubrication system for ball screws and linear rails standard.
- Heavy-duty servo rack and pinion driven pressure head.
- Spindle carriage control station for ease of driveshaft installation.
- Sunnen is the complete system supplier... machines, tools, chip management, cooling systems and cutting fluids.



SUNNEN DESIGNED AND DEVELOPED INTUITIVE CONTROL SYSTEM

Features include:

- Beckhoff PLC with 394 mm (15.5 in) color touchscreen
- All machine functions controlled from the operator station
- Real time graphical display of tool position, tool feed load, spindle load and coolant pressure
- One button part clamping
- Two button part-to-part mode for high production operation
- Slow start tool feed for setup
- Tool protection function
- USB port for ease of backup
- Metric/inch units screen selectable
- Up to 100 part setups can be saved and retrieved
- Machine diagnostics
- Multiple languages screen selectable



HEAVY-DUTY SUNNEN DESIGNED AND BUILT COOLANT SYSTEM

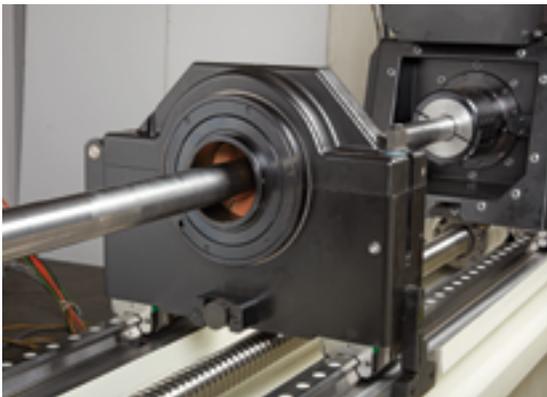
Features Include:

- 3765 liter (1000 gallon) operating capacity
- Heavy-duty welded construction using 4.75 mm (.187 in) plate with a double wall option available
- High flow 10 micron four bag filtration system
- Heavy-duty screw type pump with 760 lpm (200 gpm) max flow
- 70 micron inlet filter
- Optional chiller for hot environments
- Designed for maintainability with multiple level gages, clean out ports and instrumentation
- Heavy-duty Chip Conveyor
- Active coolant level monitoring

THE SHDS SERIES UP CLOSE



Precision long life Sunnen skiving/roller burnishing tool.



Heavy-duty tool drive shaft vibration damper.



Automatic chip removal system.



Self-contained hydraulic power unit activates rollers and skives for one pass operation and provides adjustable part clamping force.



Heavy-duty Sunnen designed and built coolant system includes separate clean and dirty tanks.

SPECIFICATIONS:

BORE DIAMETER RANGE (ID) [MILD STEEL]:
50.8- 177.8 mm (2.0- 7.0 in)

MAXIMUM OUTSIDE DIAMETER:
300 mm (11.8 in)

MAXIMUM PART LENGTH:
SHDS-2500 (2-METER): 2000 mm (78.7 in)
SHDS-4500 (4-METER): 4000 mm (157.5 in)
SHDS-6500 (6-METER): 6000 mm (236 in)

SPINDLE SPEED:
1650 RPM maximum

CARRIAGE SPEED:
Maximum feed rate: 125 mm/sec (4.9 in/sec)

TOOL FEED SYSTEM:
Hydraulic actuation
40 kN (9,000 lbf) maximum thrust

MAXIMUM COOLANT FLOW:
760 liters per minute (200 gpm)

MAXIMUM COOLANT PRESSURE
1.9 MPA (275 PSIG)

VOLTAGES AVAILABLE:
Electrical System:
400 VAC 50 Hz 3 phase
480 VAC 60 Hz 3 Phase

SHDS SERIES TOOLING, OILS AND CUTTING FLUIDS

SKIVING/ROLLER BURNISHING TOOLS

Sunnen is your complete supplier of specialty skiving/roller burnishing tools designed to work with Sunnen machines and cutting fluids.

BORE DIAMETER RANGE:

50.8 MM TO 177.8 MM (2 IN TO 7 IN)

FOR CYLINDERS UP TO 6 METERS (19.7 FEET) LONG

Sunnen skiving tools produce a geometrically true round bore, a prerequisite for successful roller burnishing. This process has proven to be the fastest method of ID finishing of seamless or DOM tubing, with rates of metal removal of 2540 mm up to 3180 mm per minute (100 in - 150 in/minute). In cases where depth of cut exceeds the capacity of the skiving knives, a counter-bore cutter can be added to the skiving/roller burnishing tool assembly. The resulting tool assembly is capable of removing up to as much as 6.35 mm (.250 in) total stock removal in one operation.

Sunnen offers a full range of individual or combined skiving/roller burnishing tool assemblies. These tool assemblies are available for use on non-Sunnen machines with ranges dependent on the machine and application of 12 - 500 mm (.5 - 20 in).



Skiving/Roller Burnishing Tools

SCO-885 CUTTING OIL

Sunnen cutting oil is designed to provide optimal lubricity and chip flushing for long tool life and superior surface finish.

FIND OUT MORE

For additional details on deep hole drilling machines, tools and accessories please visit the Sunnen website, www.sunnen.com.



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 12 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.

SUNNEN PRODUCTS COMPANY World Headquarters St. Louis, USA

P: (314) 781-2100
F: (314) 781-2268
Toll Free: (800) 325-3670
sunnen@sunnen.com
www.sunnen.com

Austria – Sunnen Austria GmbH
+43 5576 74194
sales@sunnen.eu
www.sunnen.com

Belgium – Sunnen Benelux BVBA
+32 38 80 2800
info@sunnen.be
www.sunnen.com

Brazil – Sunnen do Brasil LTDA
+55 11 4368-4900
sunnen@sunnen.com.br
www.sunnen.com

Canada – Sunnen Products Company
Toll Free: (844) 356-0006
canadasales@sunnen.com
www.sunnen.com

**China – Shanghai Sunnen
Mechanical Co. Ltd.**
P: +86 21 5813 3990
F: +86 21 5813 2299
sales@sunnensh.com
www.sunnen.com

Czech Republic – Sunnen S.R.O.
+420 383 376 317
sunnen@sunnen.cz
www.sunnen.com

France – Sunnen SAS
+33 169 300 000
info@sunnen.fr
www.sunnen.com

India – Sunnen India Pvt. Ltd.
P: +91 22 6139 2800
F: +91 22 3913 6056
sales@sunnen.in
www.sunnen.com

Italy – Sunnen Italia S.r.l.
P: +39 02 383 417 1
F: +39 02 383 417 50
sunnen@sunnenitalia.com
www.sunnenitalia.com

Poland – Sunnen Polska Sp. z o.o.
P: +48 22 814 34 29
F: +48 22 814 34 28
sunnen@sunnen.pl
www.sunnen.com

Switzerland – Sunnen AG
+41 71 649 33 33
sales@sunnen.eu
www.sunnen.com

UK – Sunnen Products Ltd.
+44 1442 39 39 39
hemel@sunnen.co.uk
www.sunnen.com

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