



ABOVE AND BEYOND HONING

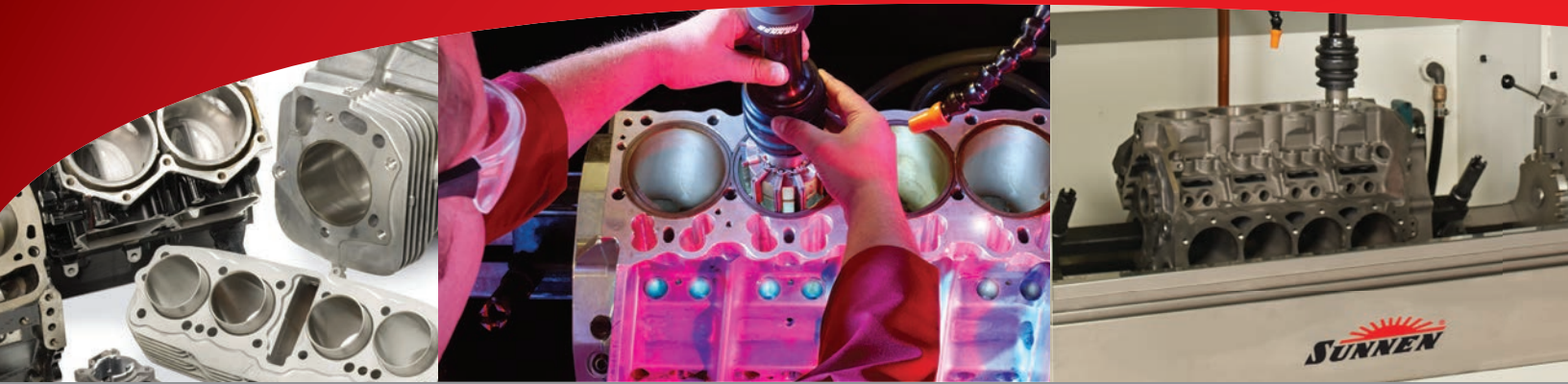
SV-25

VERTICAL HONING MACHINE



SUNNEN'S SV-25 VERTICAL HONING MACHINE

POWERFUL, RUGGED AND PRECISE



The next generation of the successful SV-20 Series, introduced in 2013, is the competitively priced SV-25. With a proven ball-screw servo stroking system combined with a new PC control, the SV-25 produces precise bore geometries on compressor blocks, oil field components, multi-bore gas/diesel engine blocks and other similar applications.

Ideal for job shops, repair facilities, and performance and production engine shops, the SV-25 is available with a variable-speed 4.1 kW (5.5 hp) spindle motor, powerful enough to drive two-stage, metal-bond, diamond abrasives for short cycle times with high accuracy and minimal labor.

The SV-25 fills the void between the SV-15 and SV-2400 series in both price and features. The result is an affordable workhorse for a variety of applications with a proven track record.



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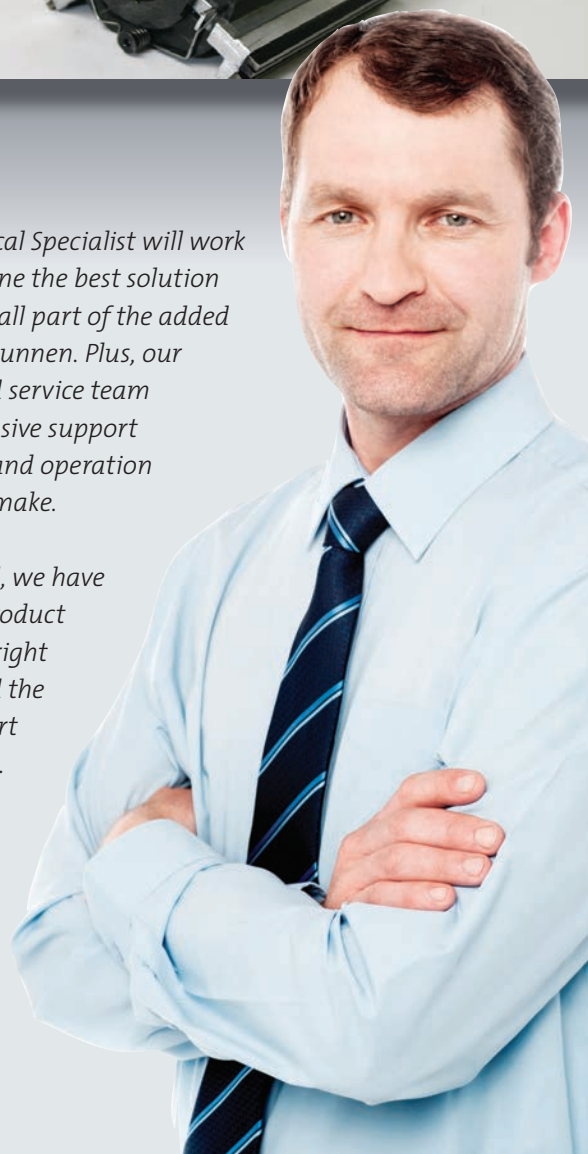
The SV-25 is the latest industry-leading Sunnen PC controlled vertical honing system. It is designed for ease of setup, flexibility and performance.

- Reliable and precise servo ball screw stroking mechanism improves geometry.
- Designed for bores with an ID of 19 - 200 mm (0.75 - 8 inches).
- Windows ® PC controlled with a large 300 mm (15 in.) color touch screen for ease of use and setup .
- Built to handle large parts including diesel engine blocks.
- Standard tool protection feature automatically checks for obstructions prior to starting the cycle.
- Built and backed by Sunnen – the leader in honing since 1924.

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.

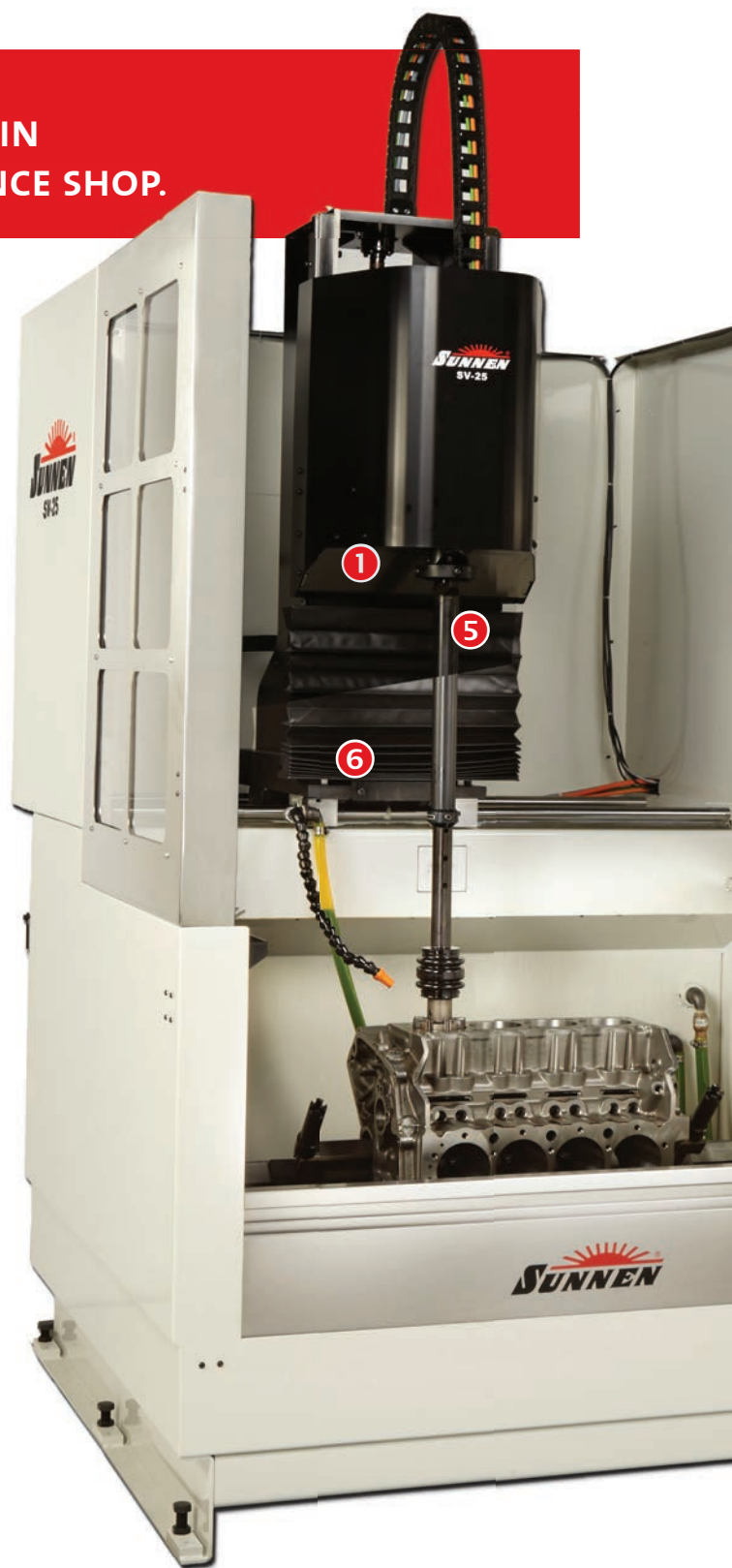
To find the Sunnen representative nearest you, visit our website:
www.sunnen.com



THE SV-25 DRIVES DIAMOND ABRASIVES IN THE PRODUCTION, JOB AND PERFORMANCE SHOP.

STANDARD & OPTIONAL FEATURES

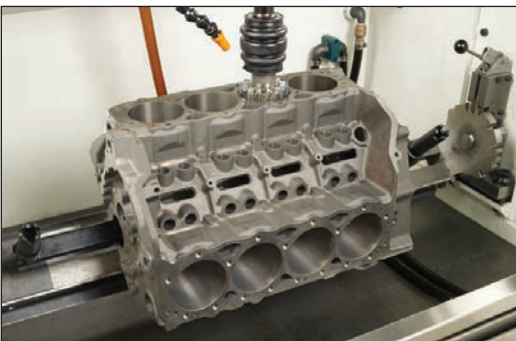
- 1 Variable speed 50-600 rpm, 4.1 kW (5.5 HP) spindle motor is powerful enough to drive two-stage, metal-bond, diamond abrasives for short cycle times with high accuracy and minimal labor.
- 2 The front loading design and weight capacity of up to 600 kg (1325 lbs) combine for versatility in honing a wide range of parts.
- 3 PC-controlled with a large 378 mm (15 in) color touch screen that is rugged and eliminates cumbersome buttons that collect oil, dirt and grime. The swiveling operator panel can be adjusted for viewing from a variety of positions.
- 4 Hand wheel allows left/right positioning of the column with 838 mm (33 in) range
- 5 Servo rotary tool feed system can be used with two-stage hone heads to complete roughing and finishing without stone changes for faster processing times. Rough to finish changeover is four times faster than previous models.
- Standard 284 liter (75 gallon) internal coolant system is equipped with two canister filters on the back of the machine, saving valuable floor space and providing increased coolant filtration for precise surface finish.
- 6 Proven 2.5 kW (3.4 HP) servo ball screw stroking system allows for increased flexibility and performance.
- 7 Heavy-duty welded base for durability.
- 8 Easy to remove settlement pans for cleaning and longer filter life.
- 9 Standard LED work area lighting.
- Standard state-of-the-art safety features include interlocked stainless steel sliding front panel, side and rear panels, front mounted light curtain, safety PLC, and safe limited setup speeds.



THE SV-25 PUTS YOU IN COMPLETE CONTROL FOR INCREASED PRECISION, CONSISTENCY, PRODUCTIVITY AND QUALITY



- **Full bore profile display** – projects a real-time display of the bore cross section (see screen shot on next page) that simplifies removing taper from the bore ... allows user to dwell in the exact position as long as necessary where bore is visually smaller – a Sunnen innovation.
- **Tool Protection** automatically checks the bottom of the bore prior to starting the cycle.
- **Size Lock** – allows you to hone to a preset diameter.
- **Rough and finish cycles** - rough cycle removes stock fast and can be set to automatically switch to finish cycle for optimum bore geometry and for the desired crosshatch angle.
- **Standard programmable Auto Dwell for unattended operation** - the machine automatically dwells in the tightest part of the bore – top, middle or bottom.
- **Advanced PC control** – allows variable speed for a much wider range of control and consistent crosshatch pattern. Switch from rough to finish honing with one push of a button.
- **Crosshatch control** – enter desired crosshatch angle and the machine automatically adjusts speeds to the entered angle.
- **Bore Oversize Setup** allows for fast setup for engine rebuilders in standard oversizes (.010 in., .020 in., .030 in.)
- **1000+** saved setup capability.
- **More standard features** include short stroke, custom tool entry, and spindle load honing.

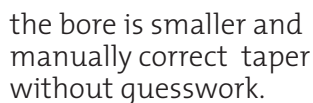


Machine Options include:

1. T-slot base plate for custom fixturing
2. Heavy-duty Manual Rollover Cradle for engine blocks accommodates in line and 60°/90°/120° V-type blocks. Special configurations are available. (pictured left). Both above options allow easy change over from cradle to T-slot)
3. Block Clamp Kit
4. 208/230 VAC Transformer
5. Full feature automation interface to reduce automation costs.



Sunnen, the leader in honing technology, was the first to offer the bore profile display which provides a real time graphical display of the bore cross section, allowing the operator to see where



914 mm (36 in.)

914 mm (36 in.)

1229 mm (48 in.)

WORK AREA

SPECIFICATIONS:

SPINDLE SPEED:

50 - 600 RPM

SPINDLE POWER:

4.1 kW (5.5 hp)

STROKER:

2.5 kW servo (3.4 hp)

Variable speed: 5-100 SPM

Stroke Length: up to 680 mm (26.8 in)

CARRIAGE TRAVEL:

838 mm (33 in.) left/right travel available
(X axis)

MAXIMUM WORKPIECE WEIGHT:

600 kg (1325 lbs)

WORKPIECE ENVELOPE:

1219 mm W x 760 mm D (48 in x 30 in)

MACHINE WEIGHT:

Dry Weight: 1329 kg (2930 lbs.)

Shipping Weight: 1823 kg. (4020 lbs)

HONING FLUID/FILTER SYSTEM:

Honing Oil Reservoir: 284-liter (75-gallon) capacity with two standard canister filters.

VOLTAGES AVAILABLE

Electrical System:

400 VAC 50 Hz 3 phase: 19.8 amps

460 VAC 60 Hz 3 Phase: 18.3 amps

(CE Compliant)

* DIAMETER RANGE, LENGTH RANGE AND WORKPIECE WEIGHT ARE CONTINGENT ON WORKPIECE AND APPLICATION.

SV-25 TOOLING, ABRASIVES AND LUBRICANTS

You get many tooling choices with the SV-25. It allows you to choose the exact tooling and abrasive to meet your specific production requirements and will use the same Sunnen tooling you've come to depend on. Sunnen is the only full-line company that produces its own precision honing abrasives. And with the largest variety of diamond or Borazon® superabrasives and conventional vitrified abrasives, you are assured of most exact and consistent surface finish in the industry.



GHSS/GHTS TOOLING

Sunnen's GHSS/GHTS multi-stone tools are designed for use with metal bond CBN and diamond abrasives for fast cutting action and reduced cycle times. The GHTS is a two-stage tool that performs both rough and fine honing operations (stone or brush) within the same honing tool – without changing stones – to reduce your bore sizing costs.

BORE DIAMETER RANGE:

GHSS: 37,59 - 140,71 mm
(1.480 - 5.540 inches)

GHTS: 62 - 140,7 mm
(2.440 - 5.540 inches)

DH-SERIES DIAMOND HONING SYSTEM

Sunnen's Diamond Honing System features multi-point cutting action that spreads out force for faster, rounder bores and greatly improves productivity and performance. Three different tools cover the size range. An excellent choice for blind bores or ported cylinder heads.

BORE DIAMETER RANGE:

70 - 141 mm (2.75 - 5.5 in.)

SUNNEN CV-TYPE TOOLING

Industry standard CV-Type tools are the reason an SV-20 can do the same job as bigger machines costing two or three times as much. CV-Type tools cut fast. They're rugged, economical and easy to use. They have a large range, and the stones can be changed in seconds. Bores are finished faster and more accurately with minimum stock removal.

BORE DIAMETER RANGE:

51 - 203 mm (2-8 inches)

SUNNEN CK-TYPE TOOLING

Two abrasives and two die cast zinc guides provide an effective way to finish a large range of bore diameters. These tools use conventional abrasives and can be fitted with metal bond super abrasives, plus they're well suited for short production runs, engine rebuilding, and other precision honing operations.

BORE DIAMETER RANGE:

51-203 mm (2 - 8 inches)

P20/P28 MANDRELS

These mandrels incorporate multiple stones aligned end-to-end to allow for long bore honing, with the P28 accommodating blind bore honing as well. Both P20 and P28 mandrels have replaceable abrasives and guide shoes. Requires CV-1010 adapter.

BORE DIAMETER RANGE:

P20: 19 mm - 25,40 mm
(.75 in - 1.000 in)

P28: 25,15 mm - 152,40 mm
(0.990 in - 6.000 in)

MPS/ANR MODULAR TOOLING

The MPS and ANR Tooling System can be used to convert any "big work" honing machine into a state-of-the-art bore finishing system. Allows you to hone a wide variety of materials, sizes and bore conditions quickly and economically. MPS and ANR Tooling.

BORE DIAMETER RANGE:

MPS: - 50 - 299 mm
(1.98 - 11.5 inches)

ANR: 64 - 533 mm
(2.5 - 21 in)

SUNNEN ABRASIVES & LUBRICANTS

From aluminum oxide to silicon carbide to diamond and CBN, Sunnen offers 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 honing performance available.

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.



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.

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