Home

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Abhi Fine Products A Complete Solution for All your Honing Requirement

AB 2204

# Honing Products Portfolio

1996





A Complete Honing Solutions Under One Roof

# **About Honing**

# What is Honing?

Honing is are metal removal process by using hard tool with super abrasives sintered stones or plated Sleeves for the correction of

•Diameter of the bore •Shape of the bore •Surface finish of the bore •Positional tolerances of bores

The hone process was developed to achieve the perfection in bore geometry, size control, surface finish and surface structuring. The honing process provides the final sizing and creates the desired finish pattern on the inner bores. Finishing is accomplished by expanding abrasive stones or sleeves of suitable grit and grade against the working surface. The stones or sleeves are rotated or reciprocated or both in the part with hone abrasive under controlled pressure. A controlled Combination of rotation and reciprocation can also produce the desired cross-hatch pattern in the surface of the part being honed.

# **Types of Honing?**

There are 2 types of Honing process

- 1. Single Pass / Single Stroke Honing Process
- 2. Multi pass / Expansion Honing Process

#### Single Pass Honing:

A single Pass Honing is the Abrasives are coated on the cylindrical surface called the sleeve and these sleeves assembled on the Mandrels through which the material is removed and the desired size, geometry and surface finish are achieved.

#### Multi Pass / Expansion honing:

A Expansion honing is the abrasives are coated on the rectangular surface called the honing sticks and these sticks are assembled in such a way that it can expand and retract based on the stock removal through which the material is removed. In some cases the no of sticks in each tools may vary based on the requirements.

# Why Honing?

Cost effective machining method for:

Removing stock

•Creating exact Bore tolerances

•Achieve the surface finish

•Finishing bores of almost any material such as Cast Iron, Steel, Glass, Ceramics, and some of the Aluminium components etc.,

•It Eliminates several time & Cost consuming processes such as Lapping, Bore Grinding, Jig Grinding, Hard part reaming or Boring.

## Types of Bore forms which can be corrected through Honing process







# Abhi Fine Products

A Complete Solution for All your Honing Requirement

Auto Gauging & Auto Expansion Single Pass Honing Machine







# Customize Abhi's Vertical Single Pass Honing machines.

In order to meet Your Exact Requirements, Abhi's highprecision honing machines with very high accuracies can be supplied anywhere in the world.

These Products are reliable, durable, and flexible Honing systems designed to deliver the production quality and precision to our customers.

Abhi's commitment to service and quality assurance. Is in such a way that Our technical team will work with you in determining the number of spindles, type of tooling, fixtures, abrasives, in-process and/or post-process gaging, and method of loading and unloading the Work Piece (including robotics) if customer require.

After which a written proposal will be sent to you. When your system is built, we'll set up a live run-off / Prove out at our facility. Once all specifications are met, we'll commission your system and train our customer.

## AB 616 AGE-P Series

# Special Edition

Std Machine Specifications upto 6 Spindles:

#### Diameter Range:\*

#### 10 to 25 mm.

#### **Maximum Workpiece Dimensions:\***

- 200 L x 200 W x 200H.
- **Carriage Travel :**
- 750 mm
- **Spindle Feed:**
- Upto 3000mm/min
- Z Axis Slide:
- Servo Controlled feed

#### **Auto Gauging & Expansion**

 Incorporated with High Precise Air Gauging units &Tool Expansion System in Every Alternate Stations

#### Max Dial Plate Diameter:

• 650mm

#### **Spindle Speeds:**

1 to 2000 RPM

#### **Machine Controller:**

• PLC with Latest Upgraded Software Coolant Sump Pump:

- Separate Coolant Filtration System Floor Space
- (Coolant Tank Not Included):

3250x2000x3000 (LxBxH) (Including Filtration System)

#### **Pneumatic Requirements:**

 Base system requires 5-6Bar, we will suggest based on additional Options

#### **Electrical Requirements:**

• 415V, 50Hz, 3Phase

#### **Rotary Indexer :**

 Standard Machine is with 16 Station Indexer with 6 Spindle Column. We can Customize based on the customer requirement.

- \*Diameter range, length range and workpiece weight & Dimensions are contingent on workpiece and application.
- \*\*No of Spindles & Stations are contingent based on the Stock removal and out parameters of honing.

# Home

## Auto Gauging & Auto Expansion Single Pass Honing Machine

### Need for Auto Gauging and Expansion in Single Pass Honing

- To overcome the manual tool size correction by the operator which will lead to lessen the consistency in results.
- In order to improve the tool and machine life due to manual errors done by the operators.
- To ensure the precise control of the tool expansion
- Reduced Cost Per Component as a result of increase in tool life.
- Component Rejection rate will come down.
- No need of Skilled operator required to operate this machine
- When there is a need for Very high precise geometry or tolerance.

#### Concept of Auto Gauging and Expansion in Single Pass Honing

- Honing is done with automatic tool setting in each station individually.
- Auto Gauging which ensures the recommended results in each station.
- Auto Tool Expansion happens in every spindle tool based on the size achieved in previous Station.

#### Program Sequences of a cycle

- Rotary table Indexes to next honing station
- Execution of Honing operation
- Rotary table Indexes to Gauging station
- Auto Gauging measures output size of components in each station next to Honing Stations.
- Feedback sent to PLC controller which compares the measured output with preloaded values of each honing stations
- Continues the honing operation after indexing to the next station if the outputs are within the limit
- If the output of the previous stage honing is deviated from the preloaded values, then the Auto Expansion is done on the respective tool.
- The Honing operation continues
- All these operations are done Automatically in few seconds..

#### Advantages of Auto Gauging & Auto Expansion

- Consistent output.
- Incorporated with Artificial Intelligence
- No Need of a skilled operator, Since the machine can take care of its own, which also guide you for Maintenance activities.
- Very low Cost per Component
- Improved tool life compared to the tools used in normal single pass Honing Machine
- Very low down time, due to which High productivity.

#### How it differs from Normal Single Pass Honing Machine

- The Individual Drive in all the Individual tools can work for different speeds.
- All the Individual tools have a precise air Gauge to measure the corresponding output in every alternative station
- It helps to control the excess honing stock in every stations which in turn improve the tool life and prevents accidents.
- In this machine the auto gauging itself acts as a Poke yoke arrangement to identify the presence of component in fixture and also to ensure the correct output
- High precise Auto gauging units are Incorporated.
- High precise Auto Gauging units in each station can measure a bore in less than 3 seconds hence the cycle time is very less
- High precise Auto Gauging units can measure a bore within 0.5 micron accuracy
- High precise Auto gauging is capable to identify the taper in bore.
- No additional device for Gauging unit is required since All the operations are controlled by PLC.
- Calibration and Measurement are done through HMI.
- Interchangeable master ring gauges.

### Auto Gauging & Auto Expansion Single Pass Honing Machine

#### Spindles & Stations

Abhi's Vertical Honing machines are manufactured with latest technologies in various combinations of Spindles and Stations such as 3 Spindles and 4 Stations, 6 Spindles and 8 Stations, 5 Spindles and 6 stations and many more based on the customer requirements and these Vertical Honing Machine are capable to hone the bore diameter range of 3mm to 65mm

#### **Machine Base**

Heavy and stress relieved, Rigid fabricated base

#### **Spindles**

- Smooth & Precise Spindles which can withstand the heavier loads.
- Spindles with individual servo motors with Planetary gear Box

#### **Rotary Indexing Table**

- Based on the customer requirement fixed rotary indexing table or Servo NC Rotary indexing table will be used
- High precision Rotary indexing table is used for precise indexing..

#### **Control panel**

- Easily understandable circuits
- A Simple, User friendly, universal design, Dust proof, transparent electric control panel.

#### Pneumatic Equipment and accessories

• All our machines are manufactured with standard products of Pneumatic items incorporated with air leak and pressure drop identification also it is Maintenance free with auto lubrication.

#### **Vertical Slide**

- It has the Servo Driven Vertical slide with high torque capacity and high feed rate with large overall stroke limit which enables to hone the bigger bore length.
- The movement of spindle housing can be easily controlled with Jog wheel which give precise positioning.
- 3 level protection is enabled to control the over travel of the spindle housing which ensures 0% failure of positioning.
- The High Precision Ball Screw rod, LM rail and LM Block is used for the precise positioning which is also protected from atmosphere with metallic telescopic for improved life
- Centralized Automatic lubrication system for LM guideways & ball screws with pressure and level feedback.
- 300mm overall stroke limit which enable to hone the bigger bore length.

#### Counter Balancing System of spindle Housing

- 2 counter balancing pneumatic cylinders with high precision balancing system.
- It is designed in such a way that it can absorb the surge load which may be created during the spindle housing operation.
- With the help of this arrangement, loads for the servo motor, LM guideways and Ball screw rods will be taken care which is in turn the life of the machine will be very high.

#### **Electrical items**

- All electrical items are standard products without any issue for servicing it. Also easily replaceable.
- Only CE certified products with high rated items are used which is available globally.

#### **Optional Accessories / Equipment**

- Custom Specified Honing Tools
- Floating Tool Holders
- Coolant Filtration System with Magnetic separator
- Special Custom Floating Fixture Package

## Auto Gauging & Auto Expansion Single Pass Honing Machine

#### Features of Our PLC Machine Controller

- Machine is constructed to meet Industry 4.0 and Industrial IoT for smart factory compliance (Available for specific models only)
- High speed communication protocol is used for machine controls to reduce cycle time and data loss
- Based on the requirement HMI / IPC are used and theses HMI / IPC Supports additional storage capacity of 16 GB to 32GB CF card which helps to store recipe and program for easy operation.
- Data logging and production details of the machine can be shared in a network (Available for specific models only)
- Machine connectivity to cloud is possible (Available for specific models only)
- Control panel is designed with high standard materials to meet all safety and environment conditions
- If any error occurs troubleshooting guides are available in pdf format and can be access thru HMI for easy maintenance
- Higher resolution feedback encoders are used to ensure the repeatability and quality production
  (Available for specific models only)
- Spindle motor speed can be easily varied via HMI
- Machine can connect with any mobile or tablet via Wi-Fi connectivity to view machine status (optional with Additional Cost)
- Robot control inputs can be connected for pick & place application with this machine (optional with Additional Cost)
- Component feed conveyor control input and output from the machine can be integrated (optional with Additional Cost).

#### Uniqueness of Single Pass Honing Machines & Tools

- High Production rate with Shorter Cycle Time
- High accurate Geometry achieved consistently for smaller diameter Bores
- Reduced labor cost through Automation
- Lower cost per component as a result of better Tool life

#### Applications (The Perfect Choice for Small Bores )

- Automotive Industries such as finishing of small cylinders for internal combustion engines, air bearing spindles and gears including transmission and other precision gears, Sprockets, Rocker arms Etc.,
- Hydraulics Industries such as finishing of Hydraulic Valves, Valve Bodies, Pumps, Diesel Fuel Injectors.,
- Aerospace Industries
- Gun barrels, Gear hobs
- Refrigeration compressor components
- Turbocharger housings and bearings
- Connecting rods
- Small engine cylinders
- Medical parts, Parking Pawls
- Powdered metal components, Ceramic components



Home

# Single Pass Honing Tools



- Suitable for through & Blind bores with or with out Undercuts.
- These are Electroplated Tools with Sleeve / Integral type
- The Sleeves can be coated with Diamond / CBN based on the requirement of honing components
- These types of tools can even produce the required Hatch Pattern in the components.
- These types of tools has the guaranteed tool life which can achieve a very less cost per components with consistent results in the output.
- In These type of tools, the sleeves can be replaced for 2 to 3 Times, no need to buy a complete set which is again a cost reducing fact
- Suitable for Mass productions with components Diameter Range 5mm to 60mm.

# **Special Honing Fixtures**



Home





#### **Basics of Fixture Design**

Since the Fixtures for honing has a major role and impact in the geometry of the output components, Abhi has designed the fixtures in such a way that it can achieve the required geometry and also an operator friendly i.e., even an inexperienced operator can load the components without any mistakes and difficulties.

Honing is a typical process where the tool and the fixture must follow the correct path along with axis of the component's bore, whereas the Geometry will get affected if these doesn't follow the correct path, so the fixture takes a major role in defining the tool's path. For which Abhi has designed the Rigid fixtures, Axial floating fixtures and Radial and Axial Floating fixtures based on the honing component in such a way that the tool and the fixture will guide without disturbing the present axis of the component's bore during the Honing process.

#### **Rigid Fixture**

The Rigid fixture for a lengthy and Tandom bore component with manual clamping which is mounted with very close tolerance, through which we can achieved very close Bore geometry

#### **Axial Floating Fixture**

The Axial floating fixture with pneumatic clamping which reduces cycle time and takes care of the axis straightness between the Tool and Components, through which we can achieve very close Bore Geometry.

#### Radial & Axial Floating Fixture

The Radial and Axial floating fixture which takes care of both the axial and radial shift between the Tool and Components, through which we can achieve very close Bore Geometry.

**Rigid Fixture** 

# **Special Floating Tool Holders**

Home





During Honing process, the alignment of the pilot bore with the tool axis is a prerequisite for the correct function of the honing tool. On the usage of Honing tools on a vertical Honing machine, it is often necessary to compensate for axial errors between the tool adapter and the bore to be Honed. This error can be corrected either by aligning the tool on the machine or using a floating holder. A floating holder is particularly useful if the offset changes continuously due to the thermal expansion of the machine or at different positions during the rotation of Spindles.

### Collet Type Floating Holders

 Collect Type Floating Holders can Float Axially and guide the tool axially to enter in the proper axis of the component.

### Side Lock Floating Holders

 Floating Holders with side lock arrangement for easy mounting of the tools also it can Float Axially which guides the tool to enter in the proper axis of the component.

### Link with Side Lock Floating Holders

 Link Type Floating Holders with side lock arrangements to easy mounting and unmounting of tools which can Float Radially and Axially which guides the tool to enter in the proper axis of the component even if the component has some radial shift.

# **OUR BUSINESS ASSOCIATES**



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Industry 4.0

# **ABHI FINE PRODUCTS**

A Complete Tooled Up Solutions for All Your Honing Requirements Under One Roof.



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