

acuwire-L

The acuwire-L is designed to hone bores from 0.4 to 2.00 mm. As all Schläfli machines the acuwire-L is perfect to machine hard material as ruby, carbide, technical ceramics and steel. It is possible to mount long single parts as well as multiple short parts. Depending on the workpiece geometry the parts are cast into a quill shaft or a mechanical clamping fixture is used.

Part OD

up to 10mm (customized solutions for bigger ODs are available)

Bore size range

0.4 – 2.0 mm

Maximum part or arbor length

200 mm, option: 280 mm

Process control

Siemens SIMATIC S7

Spindle motor

500-4'000 min⁻¹

Electrical specification

voltage 110VAC – 240VAC

frequency 50 Hz – 60 Hz

Dimensions (length x width x depth)

1600 x 650 x 1430 mm

Weight

300 kg



APPLICATIONS

Ceramic tubes



Workpiece specifications

Material	Zirconium oxide
Inner diameter	0.90 mm
Outer diameter	1.302 mm
Length	10.1 mm

Honing process data

Achieved tolerances (diameter)	0/+0.002 mm
Material removal	0.17mm
Number of pieces / clamping (=1 group)	17
Cycle time (group)	23 minutes. 48 seconds
Cycle time (workpiece)	1 minute 24 seconds

Carbide workpiece



Workpiece specifications

Material	Carbide
Inner diameter	0.8 mm
Outer diameter	9.6 mm
Length	7.4 mm

Honing process data

Achieved tolerances (diameter)	+/- 0.001
Honing length	4 mm
Number of pieces / clamping (=1 group)	24
Cycle time (group)	19.6 minutes
Cycle time (workpiece)	49 seconds

AVAILABLE ACCESSORIES

Standard clamping (arbor)

Customized clamping

[Tooling: honing wire with entry and final diameter according to customer specification, gradation: 0.001](#)

[Diamond suspension](#)

[Casting-system acucast-H](#)

[System to mount workpieces onto the honing wire: acuthread](#)

[Guiding wire, gradation: 0.001](#)

[DeCast 600 system to extract the workpiece](#)

OmniFlow compound to cast the workpiece

[Carbide gauge pins](#)