



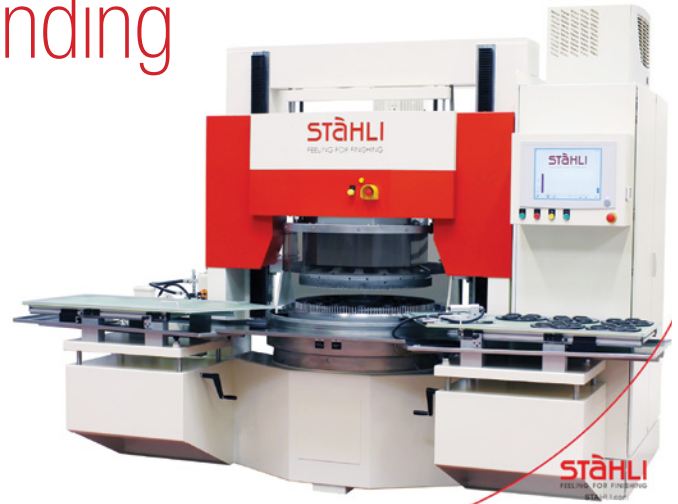
MACHINES

STÄHLI
FEELING FOR FINISHING

DLM 705 2-Wheel Flat Honing & Fine Grinding

Our DLM 705 is dedicated to high productivity, user-friendliness, economic efficiency, precision and security.

Flat Honing with super abrasive wheels or alternatively fine grinding with conventional SiC or corundum wheels – opt for a future in super finishing with a newly developed machine from the Stahli Group. Performance, sturdiness and quiet running for high stock removal stand for high precision and low piece cost.



TECHNOLOGICAL ADVANTAGES

- Frame construction for high workloads
- Mineral cast structure guarantees top thermal and mechanical endurance
- Flow cooling system of the working wheels
- Quick loading and unloading thanks to the ingenious “Sandwich-System”
- Part or full automation easily interlinked to precision deburring systems or the like
- Integrated computer-assisted measurement
- High availability
- Incidental analysis by machine control
- Remote maintenance / telediagnostic / online-support
- High precision non-contact in-process size measuring system

YOUR CHALLENGE IS OUR SPECIALTY
Fine Grinding, Flat Honing, Lapping and Polishing

Stahli is a worldwide leader in the manufacturing of precision flat honing, lapping and polishing machines. Our name is synonymous with the highest standards of performance, power, automation, productivity and efficiency for customers in such diverse industries as automotive, electronics, aerospace and ceramics. The dynamic design of our ultramodern machine line ensures precision and reliability. Stahli: always user-friendly; always environmentally sound.

Consultation and Sales, Machining and Testing Centers



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MACHINES

DLM 1205 Double-Side Flathoning Machine

- Ultra rigid, dual column/bridge construction
- Mineral cast structure guarantees top thermal properties and vibration dampening end
- Dual column allows greater workforce to improve stock removal rates
- All drives on the outside of the machine structure
- Constant working wheel temperature thanks to efficient cooling system. No thermal distortion
- Based on Siemens units, Stahli has developed a control specifically for micro-machining processes
- Nonmagnetic clamping means no work piece distortion
- Application for ferro- and non-ferromagnetic materials



FAST

- High cut rates, low temperatures (also valid for Thermoplasts)
- Time saving since pre-machining and cleaning may be omitted
- Quick loading and unloading thanks to the ingenious "Sandwich-system"
- Easily adapted to full or part automation
- Possibility for interlinks

ACCURATE

- Process controlled machining, consistent reproducibility
- Integrated computer-assisted measurement and pressure control
- Hydraulic work loads

CLEAN

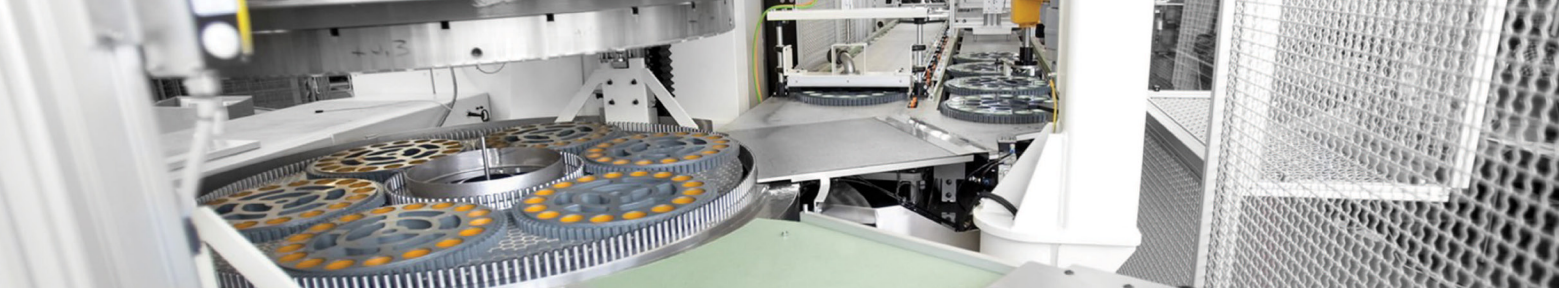
- Clean operation with less waste
- Little/no cleaning of the work pieces necessary for following working processes
- Fixed abrasive wheels eliminates sludge

ECONOMIC

- Excellent cost-performance ratio
- High productivity, low cost-per-piece
- Low wheel wear
- Recycling of flushing agent and coolant
- Tele-diagnostic service/control via Telephone modem (Teleservice)

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STÄHLI
FEELING FOR FINISHING



TECHNICAL DATA

- Working wheel-Ø up to	1250 mm
- Carrier reference-Ø for 6 pcs	340 mm
- Distance between working wheels	
- Z-axis (vertical travel)	390 mm
- Drives	
- upper spindle	38.0 kW
- lower spindle	38.0 kW
- center drive	13.0 kW
- Speeds	
- working wheels, cont. variable	0 – 300 min ⁻¹
- center drive, cont. variable	0 – 150 min ⁻¹
- Direction of rotation, all drives	at choice
- Workload upper spindle	0 - 3500 daN
- Pressure preset / ramps	at choice
- Electrical equipment	3 x 400/480 V + N + E, 50/60 Hz
- Control voltage	24 V DC
- Machine color standard	RAL 1013 pearl white RAL 2002 vermilion
- Pneumatic-connection	min. 6 bar
- Dimensions B x T x H mm	approx. 3950 x 3050 x 2780
- Weight	approx. 13,000 kg

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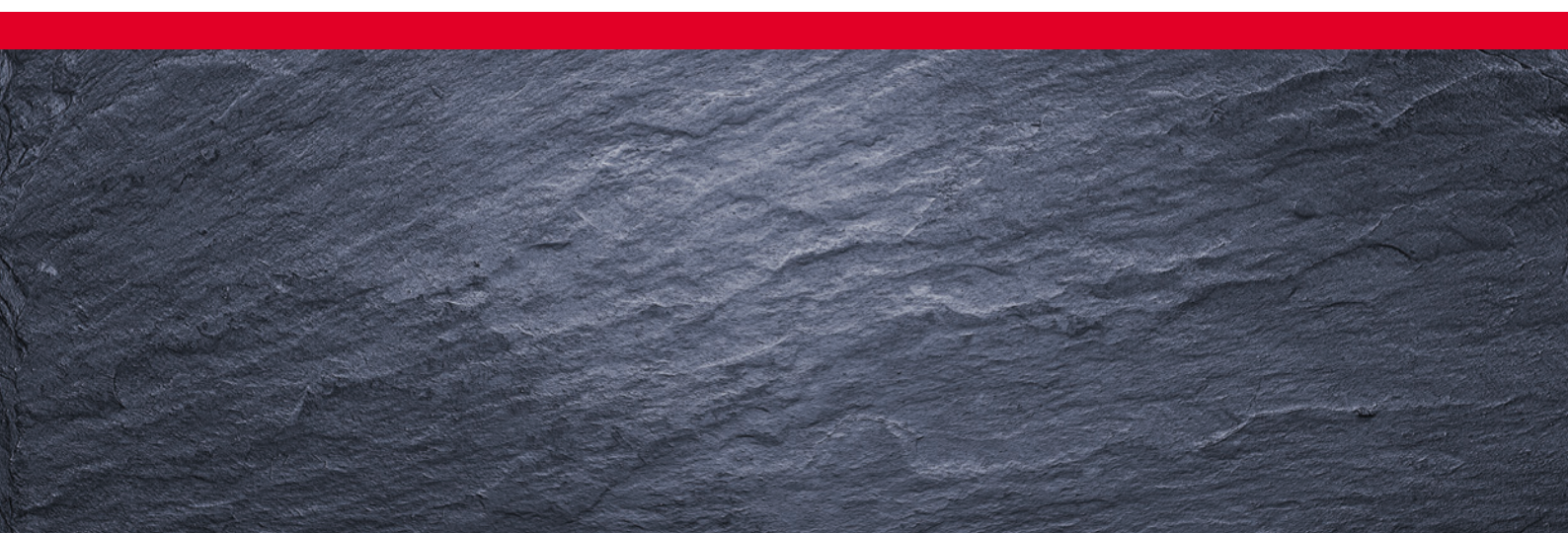


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3-Wheels Flat Honing and Fine Grinding

Automatable – Highest precision – In-process measuring – Maximum flexibility



3-Wheels Flat Honing and Fine Grinding

FH 3-505/805



Technical advantages

- New Generation of machines with 3 wheels
- Automatable
- Loading / unloading of work pieces during machining process
- Maximum production
- Flow cooling system of the working wheel
- Integrated computer-assisted measurement
- Mineral cast structure guarantees top thermal and mechanical endurance
- Incidental analysis by machine control
- Remote maintenance / tele diagnostic / online support
- Short changeover time

Technical data

For production of large series with automation is a stable machine required with high performance. Our machine series is designed for 24/7 production.

A new machine - A new approach in the field of micro-chipping



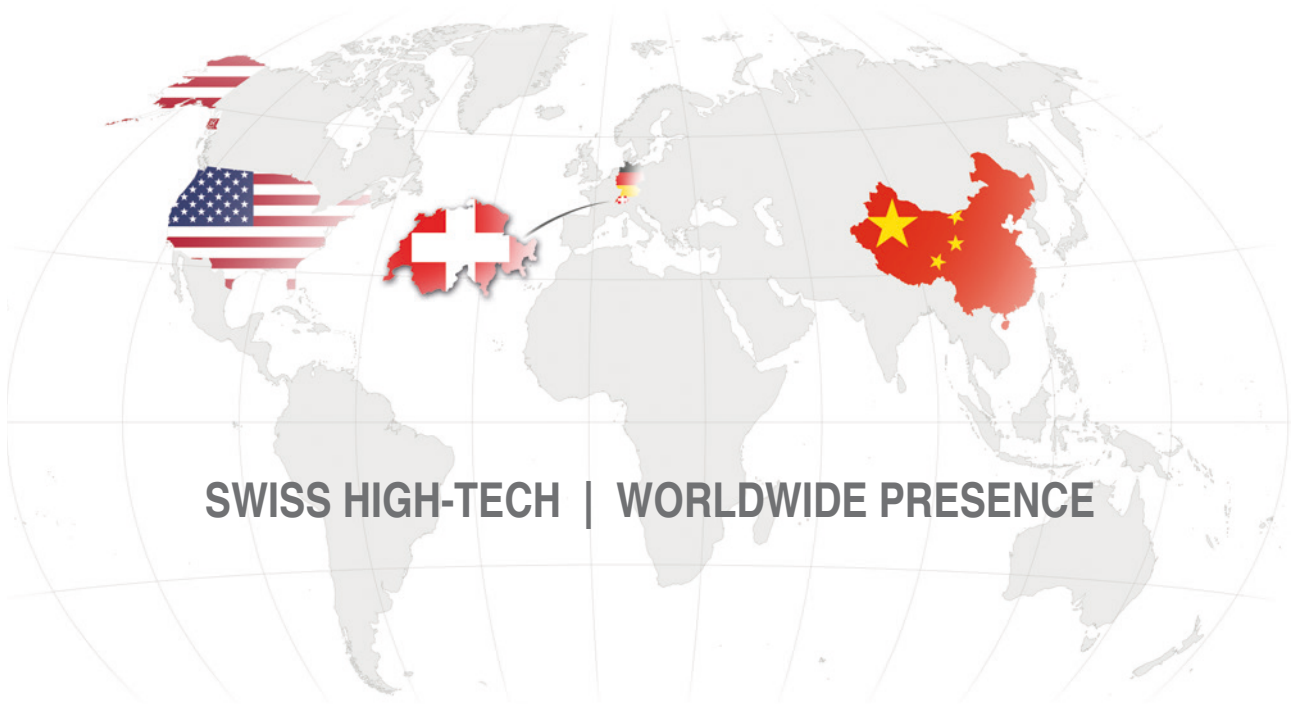
		FH3-505	FH3-805
Working wheel diameter, external		534 mm	860 mm
Carrier reference-Ø		180 mm (6)	285 mm(6)
Switch off precision		0.1 my	0.1 my
Optimal work piece thickness		0.5 - 60 mm	110 mm
Drives	upper spindle	9.5 kW	21 kW
	lower spindle	9.5 kW	21 kW
	centre drive	2.6 kW	6.7 kW
Speeds	Working wheels, cont. variable	0-400 min ⁻¹	0-400 min ⁻¹
	Centre drive, cont. variable	0-200 min ⁻¹	0-200 min ⁻¹
Workload upper spindle		0-1350 daN	0-2400 daN
Pressure preset / ramps		at choice	at choice
Types of workload		electrical cylinder	hydraulic cylinder
Electrical equipment		3x400-480 Volt, 50/60 Hz	3x400-480 Volt, 50/60 Hz
Machine colour standard		Pearl white RAL 1013 Vermillion RAL 2002	Pearl white RAL 1013 Vermillion RAL 2002
Weight		6000 kg	11000 kg
Dimensions		1700x3550x2300 mm	2150x4225x2685 mm
Pneumatic connection		6 bar	6 bar

We are one of the leading companies worldwide in the manufacture of flat honing, lapping and polishing machines. At our customers we are known just as much by our standard products as by custom-made and need-oriented special products.

This special know-how results from decades of experience from daily new assignments in contract work and the support of our expert and committed workforce. We are happy to pass on our know-how to our customers within the framework of contract

work, tests and complex or experimental project studies. Put to the test our reliability and innovative dynamism.

Further information may be obtained from the addresses listed or from our homepage.



SWISS HIGH-TECH | WORLDWIDE PRESENCE

www.stahli.com

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