

## Stahli's automation available

Stahli Lapping Technology Ltd, headquartered in Switzerland, with other sites in Germany, USA and China, specialises in double sided flat honing, lapping and polishing. The company offers contract work as well as its own machines, including process development in ready-to-work packages.

The new Stahli FH3-505 machine concept was recently presented at the last EMO and Grindtec shows. The machine is purpose built to be automated and now Stahli is offering its own FH3 automation to the public. Stahli or the customers themselves can automate this new type of flat honing machine.

The result of this game-changing technology is a very capable package which combines the following beneficial attributes: production rates similar to a through feed traditional double disc grinder with fast stock removal rates using the very high precision of the flat honing planetary kinematics.

A big advantage compared to through feed grinders which typically grind very large amounts of stock with multiple passes, the FH3 can be ground in one cycle, even more than 1 mm. Typical cycle times are under a few minutes while still providing tolerances in the µm range.

The swivel system of the FH3 machine allows for two lower wheel assemblies creating a quick change of wheels, carrier discs, and workpieces in one swift movement between cycles. On the machine side, workpieces are being ground, while on the automation side the automated handling can easily unload ground pieces and reload raw pieces for the next cycle.

The example shown here has a single gripper for loading



unoriented workpieces into a correct orientation in the carriers mounted in the machine. There is a magnetic head attached for fast unloading, but piece-by-piece unloading would also be possible when required. For example, measuring parts externally before unloading the batch.

Customers who have already received FH3 machines have also utilised their own automation cells. It has proven to be a very flexible platform for realising either simple, or very customised solutions.

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