

# Extrude Hone™ TEM • Thermal Energy Method

## P400



**Reliable and high-production deburring system is available with a choice of chamber diameters to fit any application**

The Kennametal Extrude Hone™ P400 thermal deburring machine is designed to be a reliable and flexible deburring system. The P400 features a chamber capacity exceeding both the “C” and “S” machine models.

The P400 thermal deburring machine, designed for a max closing pressure of 400 US tons (3558 kN), is available with four different chamber diameters — 8" (200mm), 10" (250mm), 12.6" (320mm), or 16" 400mm — for perfectly meeting individual customer requirements.

Five process stations located on an indexing table allow the P400 to perform high production deburring, while a stainless steel upper combustion chamber surrounded by a continuous flow water cooling ring ensures reliable operation.



### Features and Benefits

- Robust, three-post machine frame**  
 Engineered for durability and reliability with hydraulic ram providing reliable chamber closing.
- Modularly constructed enclosure**  
 Low-noise hydraulic power unit reduces noise into the production environment and delivers increased safety for the machine operator.
- Water cooling of the deburring chamber**  
 Enables system to be used in continuous operation.
- Hydraulically operated gas charging system**  
 Achieves consistent quality with high-precision gas delivery system.
- User-friendly HMI control with touchscreen interface**  
 Facilitates quick set ups and fine-tuning of parameters, convenient machine monitoring and operation, and integral fault diagnostics.



P400XL measurements in **bold**.

## Electrical Specifications

The operator interface is located in the front of the machine, with the control cabinet mounted to the side. The machine control unit is a Programmable Logic Controller (PLC). Working cycle can either be sequenced manually in single step mode or started in automatic mode.

### Electrical

Supply Voltage	460 VAC/3 PH/60 Hz or 380 VAC/3 PH/50 Hz
Control & Valve Voltage	24 V DC
Power	25 kVA
Main Switch	50 amps

### Controls

Standard PLCs	Allen Bradley SLC 500/ Siemens S7-300
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## Connection Requirements

### Water

Machine	approx. 4 GPM (15 liters/min)
Hydraulic unit	approx. 6 GPM (23 liters/min)
Temperature	not to exceed 85° F, .300 micron
Pressure	50 psi

## Approximate Values for Gas Mixture Pressures

Material	Natural Gas
Steel	8–20 bar (116–290 psi)
Cast Iron	5–20 bar (73–290 psi)
Zinc	5–10 bar (73–145 psi)
Aluminum	5–10 bar (73–145 psi)
Brass	8–25 bar (116–363 psi)

Fuel gas can be natural gas or methane.

## Machine Specifications

P400	42" (1070mm)
P400XL	<b>48" (1220mm)</b>

Available Chambers (Ø x H)	Ø 8" (200mm) x 10" (250 mm)
	Ø 8" (200mm) x 12" (300 mm)
	Ø 10" (250mm) x 10" (250 mm)
	Ø 10" (250mm) x 12" (300 mm)
	Ø 12.6" (320mm) x 12" (300 mm)
	Ø 16" (400mm) x 12" (300 mm)
	Ø 16" (400mm) x 19.7" (500 mm)

Max Chamber Pressure	8" (200mm) — 400 psi (27 bar)
	10" (250mm) — 300 psi (20 bar)
	12.6" (320mm) — 212 psi (14 bar)
	16" (400mm) — 145 psi (10 bar)

Part Loading (standard)	Manual loading, 5 stations
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Cycle Time	60–90 seconds
Weight	approx. 26,000 lbs (11,800 kg)

## Standard Equipment

- Exhaust system.
- Remote gas charge system adjustment.
- Machine diagnostics built into PLC.
- Touchscreen interface with pendant.
- Water-cooled chamber.
- Modem.

## Accessories/Options

- Natural gas compressor.
- Closed-Loop Cooling system.
- Provision for automation.
- Hydrogen fuel gas.
- Wet scrubber.
- Double shot.
- Recessed lower closure.
- Roof and gas sniffer.

Note: Specifications and availability are subject to change without notice.

### Kennametal Extrude Hone GmbH

Berghäuser Str. 62  
D-42859 Remscheid  
Germany  
Tel: +49 2191 900250  
Fax: +49 2191 900254  
remscheid.information@  
kennametal.com

### Kennametal Extrude Hone Limited

1 Sovereign Business Park  
Joplin Court, Crownhill  
Milton Keynes MK8 0JP  
United Kingdom  
Tel.: +44 (0) 1908 26 36 36  
Fax: +44 (0) 1908 26 21 41

### Kennametal Extrude Hone GmbH

Memminger Straße 37  
D-87746 Erkheim  
Germany  
Tel.: +49 8336-8005-0  
Fax: -500  
erkheim.information@  
kennametal.com

[www.extrudehone.com](http://www.extrudehone.com)