

The Stolle Cross-Hatch Machine is a self-contained workstation that automatically resurfaces D&I punch sleeves. Cross-hatching relieves surface tension between the can body and the punch, and it facilitates stripping of the can with minimal roll back. It also produces a more consistent surface finish on the inside of the can, providing a better surface for the internal coating to adhere.

The machine consists of a precision high performance finishing lathe with an expanding mandrel that holds the punch sleeve. A stone is held against the punch sleeve by a pressure-regulated air cylinder that follows the contour of the punch. As the punch sleeve rotates, a drive mechanism oscillates the stone back and forth to create the cross-hatch pattern. After a cycle time of approximately 45 seconds the machine will switch off automatically, and the cycle time can be varied to suit your specific requirements. Cutting fluid is supplied to the stone during operation and is automatically shut off when the machine stops. The Cross-Hatch machine is capable of resurfacing either carbide or tool-steel punch sleeves with an easy change of the stone from diamond to Borazon.

- Consistent 15° to 45° angle cross-hatch pattern
- Surface finish of +/- 2 micro inches
- Doesn't destroy the contour of the punch sleeve profile
- Increased punch usage between re-grinds
- Punch sleeve life is increased by up to three times

The machine is supplied with an interlocked full enclosure guard. In addition, an emergency stop push button and a lever control limit switch are installed to prevent injury to the operator or damage to the machine should the work piece come loose or the machine need to be stopped quickly.



Close-ups showing cross-hatch scoring stone, air cylinder and drive mechanism



STOLLE MACHINERY

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