With the invention of the Abrasive Flow Machining process, Extrude Hone Corporation developed an entirely new finish machining tool – a plastic, abrasive laden polymer with very special properties that allow it to selectively and controllably abrade surfaces that it flows across. A broad family of these abrasive medias are available to achieve a wide range of results from fine honing to aggressive surface removal.

With standard Abrasive Flow Machining the abrasive media is extruded back and forth through a workpiece. With ONE WAY FLOW Abrasive Flow Machining, the abrasive media flows through the tooling and workpiece in only one direction.

**FEATURES and BENEFITS**

+ The abrasive media flows through the tooling and the workpiece in only one direction
+ Media exits freely from the part resulting in faster processing
+ Easier cleaning of the workpieces
+ Media cylinder
  Available with different size of media cylinders: 8” (200mm), and 10” (250mm)
+ Flexible tooling and media delivery options
### ONE WAY FLOW AFM SYSTEM WITH 12" (320 MM) STROKE

<table>
<thead>
<tr>
<th>Specification</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>Media / Hydraulic Cylinder</td>
<td>10/8&quot; (250/200mm)</td>
</tr>
<tr>
<td>Media Volume (per stroke)</td>
<td>980 cu. in. (18 l)</td>
</tr>
<tr>
<td>Max Media Pressure</td>
<td>1280 psi (88 bar)</td>
</tr>
<tr>
<td>Max Media Flow Rate*</td>
<td>23 GPM (87 L/min)</td>
</tr>
<tr>
<td>Standard Hydraulic Power Unit</td>
<td>2000 psi (138 bar) 15 GPM (57 L/min)</td>
</tr>
</tbody>
</table>

### ELECTRICAL SPECIFICATIONS

- **Voltage**: 230/460 VAC, 3 phase, 60 Hz 400 VAC, 3 phase, 50 Hz
- **Motor**: 15 kW
- **Peak amperage**: 30 amps
- **Standard PLC**: Allen Bradley

### STANDARD EQUIPMENT

- Stroke counter
- Cycle complete light and horn
- Start / stop
- Automatic / manual mode
- Advance / retract
- Allen Bradley PLC
- Media displacement counter
- High flow hydraulic power unit

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**NOTE**: Specifications and availability are subject to change without notice.  
* Maximum Media Flow Rate measured without tooling