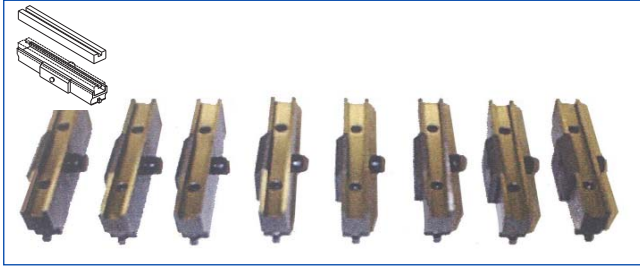
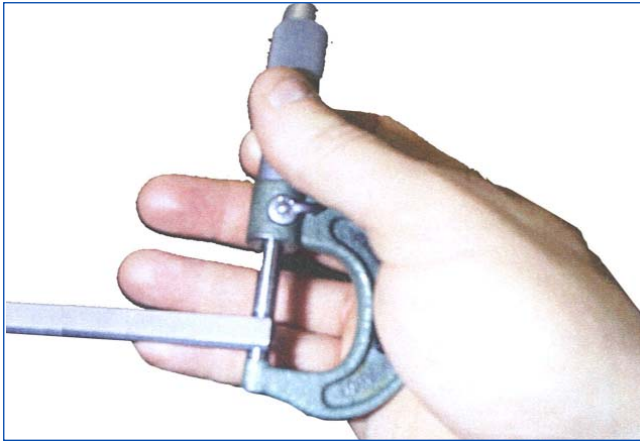


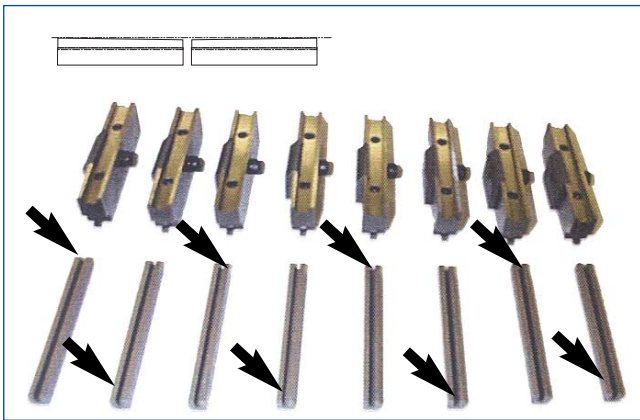
## SPECIAL INSTRUCTIONS for TRUING SUNNEN® GH DIAMOND HONING STONES Used on Sunnen CK-21 Honing Machines



Align the holders in order and face them the same way, with the location number at the top.



Measure the thickness of the stones and place them with the thickest side of the stones all in the same direction.



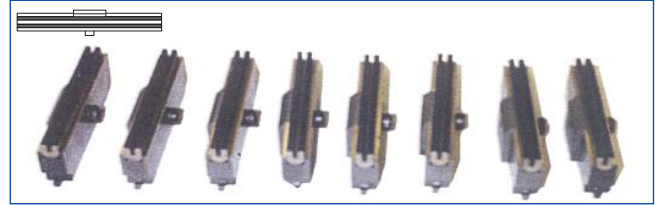
Place the stones with the holders. When the stones are installed in the holders the thick side of the stone is installed on the top of one holder and at the bottom of the next. You will alternate this way for all 8 stones.

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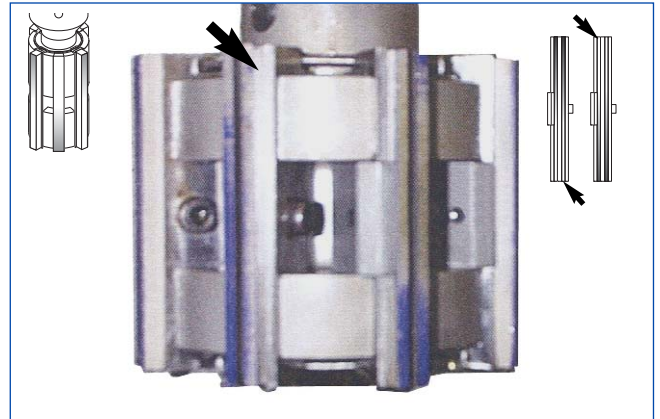
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Paint dykem on the top edge of the stones.



Run a short cycle in the cylinder and then stop the hone. A wear pattern on the stones will then show you the condition of the stones. The high spot of the stone will rub the dykem off first, therefore you must wear down the high stones.

Run one cylinder and determine if the top or the bottom of the cylinder is larger. Then on the next cycles dwell the hone in the part of the cylinder that is tight. This does two things, first the dwelling causes the high spots on the stone to wear down quicker, and second when the cycle continues the stones are now forced into a smaller tapered bore that was caused by the dwelling; this also helps wear down the high spots on the stones. This process is then repeated until a straight bore is achieved. During the truing cycles the coolant can be turned on and off to help speed up the process.

*Refer to Instructions packaged with your tool and to Sunnen's GH Tooling & Abrasives Selection Guide X-GH-2901.*