

### GHSS-1480/1950 Hone Head

**Diameter Range:**  
38,10 mm – 65,53 mm {1.50 - 2.58 in.}

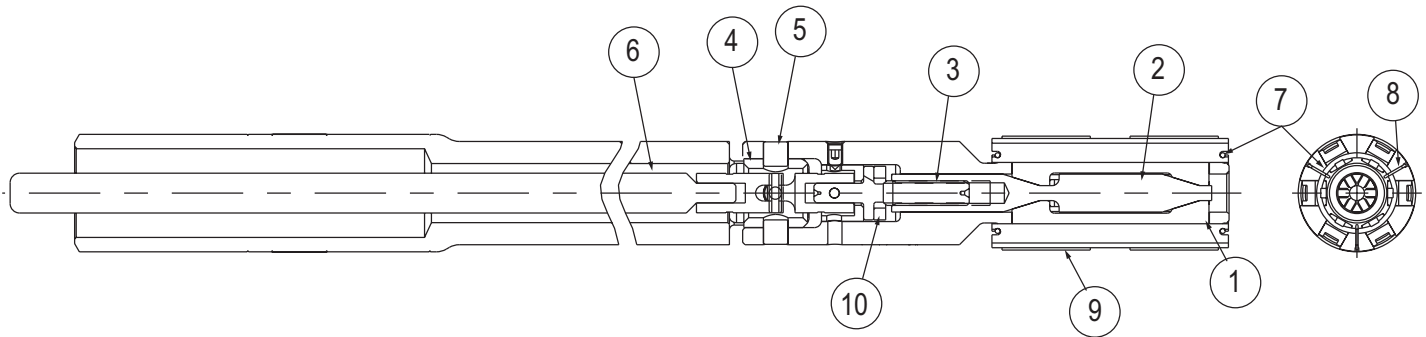
Hone Head	Diameter Range		Stone Size Prefix (6 Stones/Set)	Abrasive Grade Suffix ‡	
	mm	in		Diamond (D, G, R)	CBN (N)
GHSS-1480	38,10 - 42,16	1.50 - 1.66	GH258-1-	GMG55 GMG85	NMG37
	40,13 - 44,20	1.58 - 1.74	GH258-2-		
	42,16 - 46,23	1.66 - 1.82	GH258-3-		
	44,20 - 48,01	1.74 - 1.89	GH258-4-		NMG85
	46,23 - 50,04	1.82 - 1.97	GH258-5-		
	48,26 - 52,07	1.90 - 2.05	GH258-6-		
GHSS-1950	50,04 - 57,66	1.97 - 2.27	GH258-3-	NMG05	
	54,10 - 61,47	2.13 - 2.42	GH258-5-		
	58,17 - 65,53	2.29 - 2.58	GH258-7-		

### GHSS-1480/1950 Hone Head

**Diameter Range:**  
50,04 mm – 65,53 mm {1.97 - 2.58 in.}

Hone Head	Diameter Range		Brush Set Prefix (4 Brushes/Set)	Abrasive Grade Suffix
	mm	in		
GHSS-1480	37,85 - 45,97	1.49 - 1.81	GH258-1	PHT231 (80 Grit) PHT731 (320 Grit)
	39,88 - 46,74	1.57 - 1.84	GH258-2	
	41,91 - 47,50	1.65 - 1.87	GH258-3	
	43,94 - 49,53	1.73 - 1.95	GH258-4	
	45,97 - 51,56	1.81 - 2.03	GH258-5	
	48,01 - 53,34	1.89 - 2.10	GH258-6	
GHSS-1950	49,78 - 58,93	1.96 - 2.32	GH258-3	
	53,85 - 62,99	2.12 - 2.48	GH258-5	
	57,91 - 66,80	2.28 - 2.63	GH258-7	

‡ Other abrasive grades available - Contact Customer Service.



### Common Repair Parts - GHSS-1480 / GHSS1950 (see X-GHSS-4402F for detailed repair parts)

Item No.	GHSS1480 Part No.	GHSS1950 Part No.	Qty	Description
1	G13B10616	B13B1066	1	Expander Plates (set of 6)
2	G12B354	G12B353	1	Expansion Cone
3	G17B405	G17G184	1	Expansion Screw
4	G15A175	G15A173	1	Universal Block
5	G16A210	G16A173	4	Universal Block Screw/Pin
6	G17C176	G17C177	1	Universal Joint & Rod
7	F40925	F40926	2	Retaining Spring for Stones
8	G24A127	G24A127	3	Spring Retainer
N/S	GH50	GH50	—	Spring Tool
9	—	—	6	Stone Assembly (See Charts Above)
N/S	—	F47538	1	Thrust Bearing
10	G20A189	F47537	1	Thrust Washer
N/S	GH80049	GH80049	—	Truing Grit (70 Grit)

N/S: Not Shown

# GHSS

## Tooling GHSS 2440/2800

### GHSS-2440/2800 Hone Head

**Diameter Range:**  
61,48 – 88,90 mm (2.46 – 3.50 in.)

### GHSS-2440/2800 Hone Head

**Diameter Range:**  
65,02 – 96,01 mm (2.56 – 3.78 in.)

 HONING UNIT  
SELECTION GUIDE

 PEDESTAL MACHINES  
(ML, EC, MBB, & LBB)

 PLATED TOOLING  
(KGM & VSS MACHINES)

 CYLINDER HONING  
(SV-410 & SV-10 MACHINES)

 PORTABLE, MPS & TUBE  
HONEY ABRASIVES

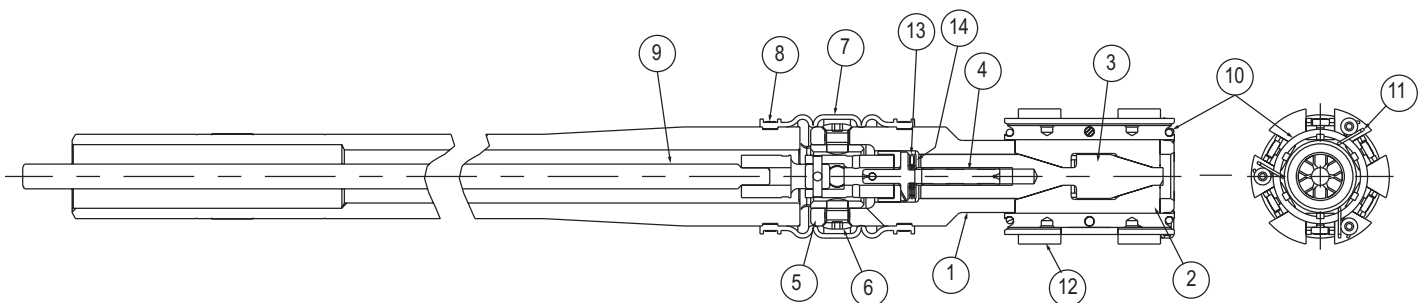
 CUSTOM ABRASIVES  
& TOOLING

Stone Sizes					
Hone Head †	Diameter Range		Stoneholder (6 Holders)	MB Superabrasive Suffix ‡	
	mm	in		Diamond (D, G, R)	CBN (N)
GHSS-2440(H)	61,48 – 64,26	2.46 – 2.53	G14C251-1-S6*	GH236GMG35E	GH236NMG65E GH236NMG85E GH236NMG05E
	65,79 – 67,31	2.59 – 2.65	G14C251-2-S6*	GH236GMG55E	
	68,83 – 70,36	2.71 – 2.77	G14C233-1-S6*	GH236DMB55E	
GHSS-2800(H)	71,63 – 76,45	2.82 – 3.01	G14C233-1-S6*	GH236GMG75E	
	75,44 – 80,01	2.97 – 3.15	G14C233-7-S6	GH236GMG85E	
	77,98 – 82,55	3.07 – 3.25	G14C233-4-S6*	GH236RMG95E	
	80,52 – 85,09	3.17 – 3.35	G14C233-2-S6	GH236RMG05E	
	82,30 – 86,87	3.24 – 3.42	G14C233-8-S6	GH236RMG05E	
	84,33 – 88,90	3.32 – 3.50	G14C233-3-S6*	GH236RMG05E	

Brush Sets Sizes					
Hone Head †	Diameter Range		Brush Set Prefix (4 Brushes/Set)	Abrasive Grade Suffix	
	mm	in			
GHSS-2440(H)	65,02 – 74,68	2.56 – 2.94	GH251-1-	PHT331 (120 Grit)	
	68,07 – 75,95	2.68 – 2.99	GH251-2-		
	71,37 – 77,22	2.81 – 3.04	GH233-1-		
GHSS-2800(H)	73,91 – 83,31	2.91 – 3.28	GH233-1-		PHT731 (320 Grit)
	80,26 – 89,66	3.16 – 3.53	GH233-4-		
	86,61 – 96,01	3.41 – 3.78	GH233-3-		

NOTES: † GHSS-2440/2800 are kits comprised of (1) hone head & (3) Stoneholder sets (marked “\*”). “H” suffix represents the hone head without stoneholder sets.

‡ Other abrasive grades available - Contact Customer Service.



### Common Repair Parts - GHSS-2440 / GHSS2800 (see X-GHSS-4402F for detailed repair parts)

Item No.	GHSS2440 Part No.	GHSS2800 Part No.	Qty	Description
1	G11C445	G11C444	1	Body
2	G13A2836	G13A2826	1	Expander Plates (set of 6)
3	G12B348	G12B347	1	Expansion Cone
4	G17G184	G17G184	1	Expansion Screw
5	G15A173	G15A171	1	Universal Block
6	G16A203	G16A202	4	Universal Screw/Pin
7	F43937	F43936	1	Universal Joint Boot
8	F5121GH2	F5121GH2	2	Universal Joint Boot Tie Strap
9	G17G185	G17G185	1	Universal Joint & Rod
10	F5043GH2	F5042GH2	2	Retaining Spring for Stones
11	G24A126	G24A126	3	Spring Retainer
N/S	GH50	GH50	—	Spring Tool
12			6	Stoneholder (See Charts Above)
13	F47538	F47538	1	Thrust Bearing
14	F47537	F47537	2	Thrust Washer
N/S	GH80049	GH80049	—	Truing Grit (70 Grit)

N/S: Not Shown

### GHSS-3410/4410/5410/6410 Hone Head

**Diameter Range:**  
87,12– 137,67 mm (3.43 – 5.42 in.)

### GHSS-3410/4410/5410/6410 Hone Head

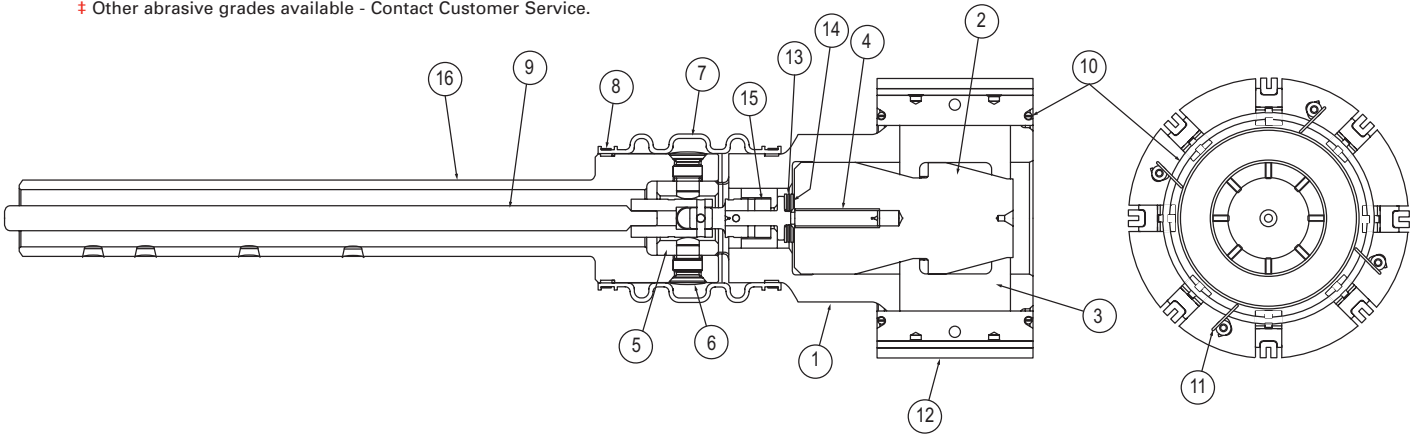
**Diameter Range:**  
86,87– 144,78 mm (3.42 – 5.70 in.)

Stone Sizes		Diameter Range		Stoneholder (6 Holders)	MB Superabrasive Suffix		
		mm	in		Diamond (D, G, R)	CBN (N)	
GHSS-3410(H)		87,12 - 91,95	3.43 - 3.62	G14C233-7-S8*	GH233GMG35E GH233GMG47E GH233GMG55E	GH233NMG57E GH233NMG65E	
		89,92 - 94,49	3.54 - 3.72	G14C233-4-S8			
		93,98 - 98,55	3.70 - 3.88	G14C233-8-S8*			
		96,27 - 100,84	3.79 - 3.97	G14C233-3-S8			
		100,84 - 105,41	3.97 - 4.15	G14C233-9-S8*			
		102,62 - 107,19	4.04 - 4.22	G14C233-6-S8			
GHSS-4410(H)		107,70 - 112,27	4.24 - 4.42	G14C233-10-S8*	GH233GMG75E GH233GMB75E GH233GMG85E GH233GMB85E GH233RMG95E GH233RMG05E	GH233NMG85E GH233NMG05E	
		112,52 - 117,09	4.43 - 4.61	G14C233-8-S8*			
		114,81 - 119,38	4.52 - 4.70	G14C233-3-S8			
		119,38 - 123,95	4.70 - 4.88	G14C233-9-S8*			
		121,16 - 125,73	4.77 - 4.95	G14C233-6-S8			
		126,24 - 130,81	4.97 - 5.15	G14C233-10-S8*			
GHSS-5410(H)		129,79 - 134,11	5.11 - 5.28	G14C233-16-S8	GH233RMG05E		
GHSS-6410(H)		133,10 - 137,67	5.24 - 5.42	G14C233-11-S8*			
GHSS-5410(H)		ranges are 25,4 mm (1.00 in) larger than the GHSS-4410 ranges					
GHSS-6410(H)		ranges are 50,8 mm (2.00 in) larger than the GHSS-4410 ranges					

Brush Sets Sizes		Diameter Range		Brush Set Prefix (4 Brushes/Set)	Abrasive Grade Suffix	
		mm	in			
GHSS-3410(H)		86,87 - 95,25	3.42 - 3.75	GH233-1	PHT331 (120 Grit)	
		89,92 - 99,06	3.54 - 3.90	GH233-7		
		96,27 - 105,66	3.79 - 4.16	GH233-8		
		102,62 - 112,01	4.04 - 4.41	GH233-9		
		109,22 - 118,62	4.30 - 4.67	GH233-10		
		117,09 - 26,24	4.61 - 4.97	GH233-11		
GHSS-4410(H)		112,27 - 120,14	4.42 - 4.73	GH233-4	PHT731 (320 Grit)	
		114,81 - 124,21	4.52 - 4.89	GH233-8		
		121,16 - 130,30	4.77 - 5.13	GH233-9		
		127,76 - 137,16	5.03 - 5.40	GH233-10		
GHSS-5410(H)		135,64 - 144,78	5.34 - 5.70	GH233-11		
GHSS-5410(H)		ranges are 25,4 mm (1.00 in) larger than the GHSS-4410 ranges				
GHSS-6410(H)		ranges are 50,8 mm (2.00 in) larger than the GHSS-4410 ranges				

NOTES: † GHSS-3410/4410/5410/6410 are kits comprised of (1) hone head & (4) Stoneholder sets (marked “\*”). “H” suffix represents the hone head without stoneholder sets.

‡ Other abrasive grades available - Contact Customer Service.



### Common Repair Parts - GHSS-3410/4410/5410/6410 (see X-GHSS-4402F for detailed repair parts)

Item No.	GHSS3410 Part No.	GHSS4410 Part No.	GHSS5410 Part No.	GHSS6410 Part No.	Qty	Description
1	G11C459	G11D320	G11G575	G11G626	1	Body
2	G13A2898	G13A2918	G13A2918	G13A2918	1	Expander Plates (set of 8)
3	G12B337	G12B337	G12G380	G12G412	1	Expansion Cone
4	G17B341	G17B341	G17B341	G17B341	1	Expansion Screw
5	G15A167	G15A167	G15A167	G15A167	1	Universal Block
6	G16A182	G16A182	G16A182	G16A182	4	Universal Block Screw/Pin
7	F43927	F43927	F43927	F43927	1	Universal Joint Boot
8	F5121GH2	F5121GH2	F5121GH2	F5121GH2	2	Universal Joint Boot Tie Strap
9	G17C159	G17C159	G17C159	G17C159	1	Universal Joint & Rod
10	F5041GH2	F5045GH2	F2075	F2075	2	Retaining Spring For Stones
11	G24A125	G24A125	G24A125	G24A125	8	Spring Retainer
N/S	GH50	GH50	GH50	GH50	—	Spring Tool
12					6	Stoneholder (See Charts Above)
13	F47530	F47530	F47530	F47530	1	Thrust Bearing
14	F47531	F47531	F47531	F47531	2	Thrust Washer
15	G20A177	G20A177	G20A177		1	Spacer
16	G18C222	G18C222	G18C222	G18C222	1	Driveshaft
N/S	GH80049	GH80049	GH80049	GH80049	—	Truing Grit (70 Grit)

N/S: Not Shown

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 HONE ABRASIVES  
 CUSTOM ABRASIVES  
 & TOOLING

# GHTS

## Tooling GHTS 2440/2800

### GHTS-2440/2800 Hone Head

**Diameter Range:**  
60,71 – 94,23 mm (2.39 – 3.71 in.)

Stone Sets							
Hone Head	Diameter Range		Size Prefix	Set Qty. (4 or 6)		Abrasive Suffix †	
	mm	in		Diamond (D, G, R)	CBN (N)		
GHTS-2440	60,71 - 67,06	2.39 - 2.64	GT62-	4	6	GMG35	NMG57
	64,26 - 71,12	2.53 - 2.80	GT71-	4	6	GMG55	
	69,09 - 75,95	2.72 - 2.99	GT76-	4	6	GMG57	
	73,91 - 80,52	2.91 - 3.17	GT81-	4	6	GMG75	
	78,74 - 85,34	3.10 - 3.36	GT86-	4	6	GMG85	
GHTS-2800	71,37 - 79,76	2.81 - 3.14	GT71-	4	6	RMG05	NMG05
	75,44 - 84,58	2.97 - 3.33	GT76-	4	6		
	80,26 - 89,41	3.16 - 3.52	GT81-	4	6		
	85,09 - 94,23	3.35 - 3.71	GT86-	4	6		

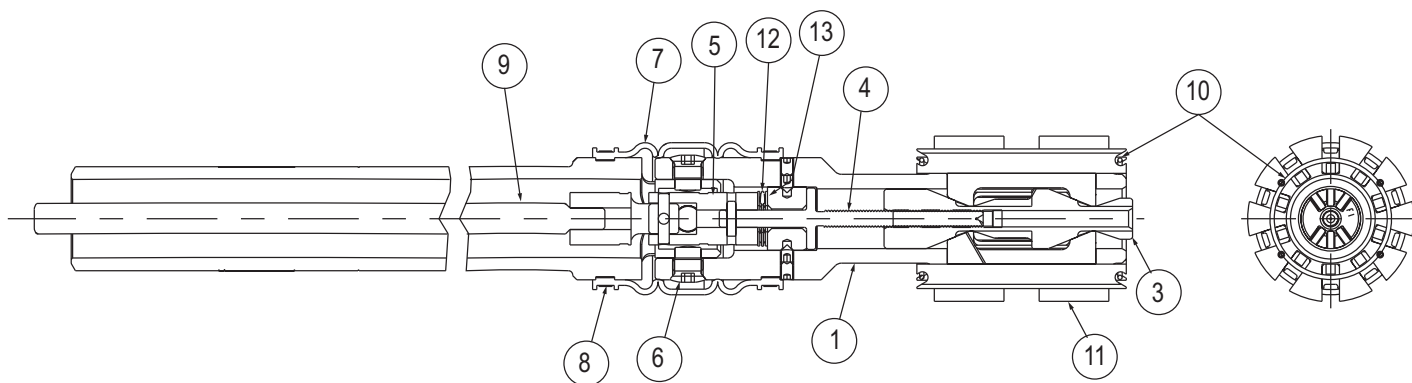
### GHTS-2440/2800 Hone Head

**Diameter Range:**  
61,21 – 99,31 mm (2.41 – 3.91 in.)

Brush Sets Sizes †						
Hone Head	Diameter Range		Size Prefix	Set Qty. (4 or 6)		Abrasive Suffix
	mm	in				
GHTS-2440	61,21 - 74,68	2.41 - 2.94	GT62-	4	6	PHT331 (120 Grit)
	65,02 - 76,20	2.56 - 3.00	GT71-	4	6	
	69,85 - 80,77	2.75 - 3.18	GT76-	4	6	
	74,68 - 85,60	2.94 - 3.37	GT81-	4	6	
	79,50 - 90,42	3.13 - 3.56	GT86-	4	6	
GHTS-2800	71,37 - 85,09	2.81 - 3.35	GT71-	4	6	PHT731 (320 Grit)
	76,20 - 89,66	3.00 - 3.53	GT76-	4	6	
	81,03 - 94,49	3.19 - 3.72	GT81-	4	6	
	85,85 - 99,31	3.38 - 3.91	GT86-	4	6	

NOTES: † Abrasive Stone Set Part Numbers are a Size Prefix + Set Qty. + Abrasive Suffix, e.g., GT62-6-GMG85 or GT71-4-PHT731.

‡ Other abrasive grades available - Contact Customer Service.



### Common Repair Parts - GHTS-2440 / GHTS2800

Item No.	GHTS2440 Part No.	GHTS2800 Part No.	Qty	Description
1	G11C553	G11C499	1	Body
2	G13A333[ ]	G13A308[ ]	1	Expander Plates ( [ ] = set qty of 4, 6, or 10)
3	G12C241	G12C232	1	Expansion Cone
4	G17B500	G17B436	1	Expansion Screw
5	G15A173	G15A171	1	Universal Block
6	G16A203	G16A202	4	Universal Block Screw/Pin
7	F43937	F43936	1	Universal Joint Boot
8	F5121GH2	F5121GH2	2	Universal Joint Boot Tie Strap
9	G17C212	G17C168	1	Universal Joint & Rod
10	F5127	F5127	2	Retaining Spring for Stones
N/S	GH50	GH50	—	Spring Tool
11	- - -	- - -	4 or 6	Stone Assembly (See Charts Above)
12	F47538	F47538	1	Thrust Bearing
13	F47537	F47537	2	Thrust Washer
N/S	GH80049	GH80049	—	Truing Grit (70 Grit)

N/S: Not Shown

# GHTS

## Tooling – GHTS 3410/4410/5410

### GHTS-3410/4410/5410 Hone Head

**Diameter Range:**  
86,87 – 140,46 mm (3.42 – 5.53 in.)

Hone Head	Diameter Range		Size Prefix	Set Qty. (6)	Abrasive Suffix †	
	mm	in			Diamond (D, G, R)	CBN (N)
GHTS-3410	86,87 - 95,25	3.42 - 3.75	GH261-1-	6	GMG37 GMG57 GMG75	NMG57
	92,96 - 101,85	3.66 - 4.01	GH261-2-	6		
	99,57 - 108,46	3.92 - 4.27	GH261-3-	6		
	106,17 - 115,06	4.18 - 4.53	GH261-4-	6		
GHTS-4410	112,27 - 120,65	4.42 - 4.75	GH261-1-	6	GMG85 RMG95 RMG05 RMG005	NMG05
	118,36 - 127,25	4.66 - 5.01	GH261-2-	6		
	124,97 - 133,86	4.92 - 5.27	GH261-3-	6		
	131,57 - 140,46	5.18 - 5.53	GH261-4-	6		
GHTS-5410	ranges are 25,4 mm (1.00 in) larger than the GHTS-4410 ranges					

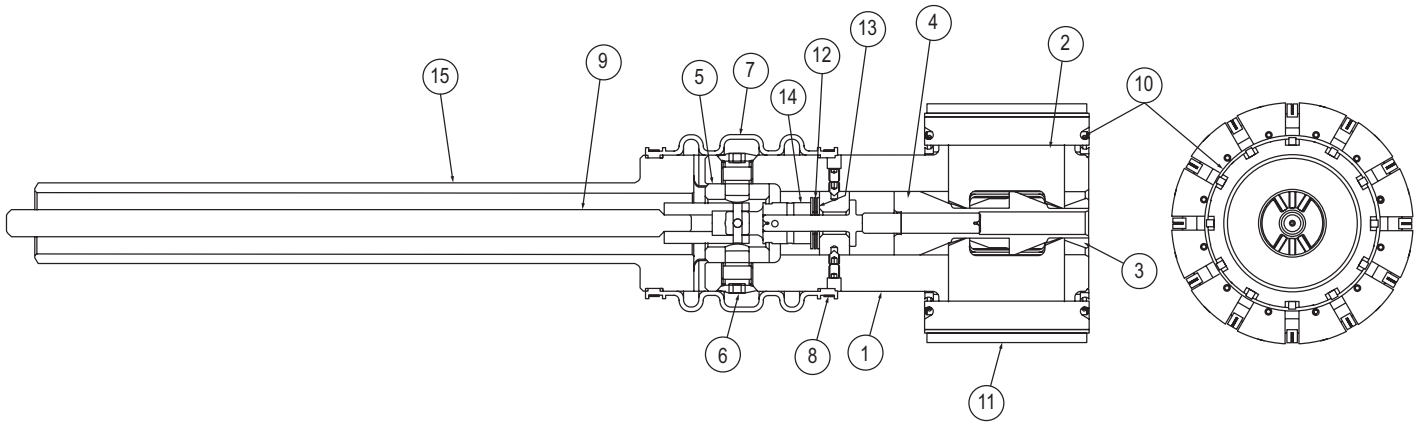
### GHTS-3410/4410/5410 Hone Head

**Diameter Range:**  
87,12 – 144,53 mm (3.43 – 5.69 in.)

Hone Head	Diameter Range		Size Prefix	Set Qty. (6)	Abrasive Suffix	
	mm	in			120 Grit	320 Grit
GHTS-3410	87,12 - 98,55	3.43 - 3.88	GH261-1	6	PHT331 (120 Grit)	
	93,98 - 105,41	3.70 - 4.15	GH261-2	6		
	100,84 - 112,27	3.97 - 4.42	GH261-3	6		
	107,70 - 119,13	4.24 - 4.69	GH261-4	6		
GHTS-4410	112,52 - 123,95	4.43 - 4.88	GH261-1	6	PHT731 (320 Grit)	
	119,38 - 130,81	4.70 - 5.15	GH261-2	6		
	126,24 - 137,67	4.97 - 5.42	GH261-3	6		
	133,10 - 144,53	5.24 - 5.69	GH261-4	6		
GHTS-5410	ranges are 25,4 mm (1.00 in) larger than the GHTS-4410 ranges					

NOTES: † Abrasive Stone Set Part Numbers are a Size Prefix + Set Qty. + Abrasive Suffix, e.g., GH261-4-GMG85 or GH261-4-PHT731.

‡ Other abrasive grades available - Contact Customer Service.



### Common Repair Parts - GHTS-3410/4410/5410

Item No.	GHTS3410 Part No.	GHTS4410 Part No.	GHTS5410 Part No.	Qty	Description
1	G11C475	G11D361	G11G556	1	Body
2	G13A30212	G13A31312	G13A31312	1	Expander Plates (set of 12)
3	G12C233	G12C233	G12G373	1	Expansion Cone
4	G17B411	G17B411	G17B411	1	Expansion Screw
5	G15A167	G15A167	G15A167	1	Universal Block
6	G16A182	G16A182	G16A182	4	Universal Screw/Pin
7	F43927	F43927	F43927	1	Universal Joint Boot
8	F5121GH2	F5121GH2	F5121GH2	2	Universal Joint Boot Tie Strap
9	G17C159	G17C159	G17C159	1	Universal Joint & Rod
10	F5049GH2	F50410	F2075	2	Retaining Spring For Stones
N/S	GH50	GH50	GH50	—	Spring Tool
11	---	---	---	6	Stone Assembly (See Charts Above)
12	F47530	F47530	F47530	1	Thrust Bearing
13	F47531	F47531	F47531	2	Thrust Washer
14	G20A177	G20A177	G20A177	1	Spacer
15	G18C222	G18C222	G18C222	1	Drive Shank
N/S	GH80049	GH80049	GH80049	—	Truing Grit (70 Grit)

N/S: Not Shown

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 HONE ABRASIVES  
 CUSTOM ABRASIVES  
 & TOOLING

# DH-Series Diamond Honing System



Multi-Point Cutting Action for a Truly Round Bore!

With multiple points of cutting action, Sunnen's DH Diamond Hone Head offers truly round cylinder bores – superior to any product on the market. Two designs of stones are offered - an economical one with 8 points of contact for rough boring applications or double 16 points for optimum bore tolerance.

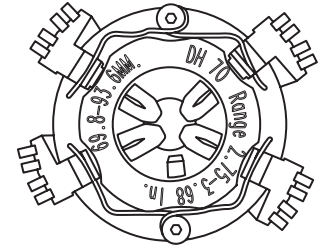
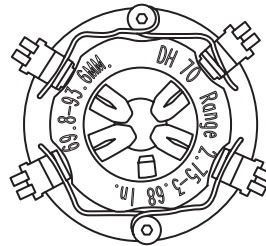
No matter which model you chose, Sunnen's DH Hone Head uses a central drive shaft assembly. This design gives you the flexibility to change diameter ranges by simply switching the body and stone assembly. You can purchase the complete system or only the diameter range you need.

Sunnen offers the largest range of diamond hone heads in the industry - from 2.75 in. to 5.555 in. (69.9- 141.1 mm). It is versatile, as well. You can use metal bond superabrasives and PHT plateau brushes. Sunnen's DH tooling, stones and holders are made as one which reduces initial truing time. With Sunnen's precision abrasives, there is no need to flip stones ... another time saver.



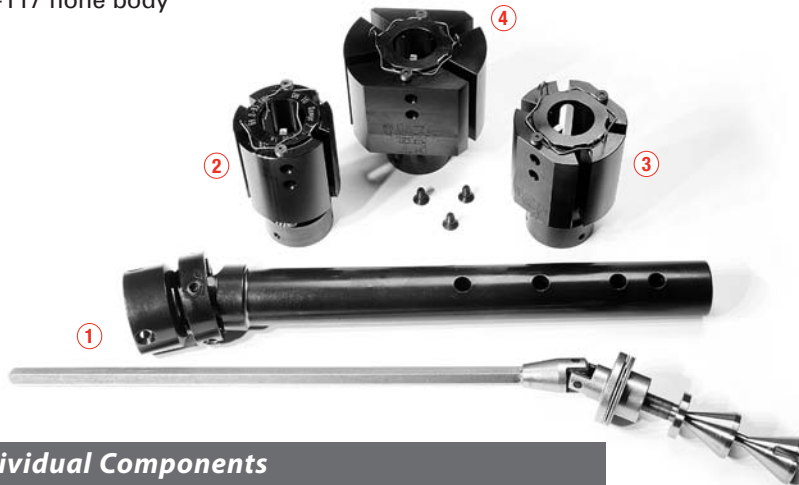
4 Stone - 8 Cutting Edges

4 Stone - 16 Cutting Edges



## Complete System for DHTKIT (2.75" - 5.55") Includes:

- ① DH-DA Drive shaft assembly
- ② DH-70 hone body
- ③ DH-93 hone body
- ④ DH-117 hone body



## Individual Components

Part Number	Description
DH-DA	Drive shaft assembly only. Common to all hone bodies.
DHT-70	Hone body and drive shaft. Range 2.75"-3.68" (69, 85-93, 47 mm)
DHT-93	Hone body and drive shaft. Range 3.68"-4.62" (93, 47-117, 34 mm)
DHT-117	Hone body and drive shaft. Range 4.62"-5.55" (117, 34-141 mm)
DH-224	Stone retaining spring
DH-228A	Diamond dressing stick

## Optional accessories for industrial use:

DH-206 (drive shaft tube) and DH-208 (feed hex rod) are available to lengthen the standard DH-DA drive assembly from 13.5" to 24.5". (Requires stone assemblies shown in table.) High Force cone and stone assembly, see next page.



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(SV-410 & SV-10 MACHINES)

PORTABLE, MPS & TUBE  
HONE ABRASIVES

CUSTOM ABRASIVES  
& TOOLING



# DH Honing Tool

## Components and Abrasives

### DH Diamond Hone Head

Body	2-Stone	4-Stone	PHT Brush	Minimum		Maximum		Available Stones	Grit Size
				mm	inches	mm	inches		
DH70	DH2S-1	N/A	DH1B-1-534	69,9	2.750	77,7	3.062	—	—
DH70	DH2S-2	N/A	DH1B-2-534	77,7	3.062	85,7	3.374	NMH55	220
DH70	DH2W-3	DH4S-3	DH1B-3-534	85,7	3.374	93,6	3.686	—	—
DH93	DH2W-4	DH4S-4	DH1B-4-534	93,6	3.686	101,5	3.998	GMH45	150
DH93	DH2W-5	DH4S-5	DH1B-5-534	101,5	3.998	109,5	4.310	GMH55	220
DH93	DH2W-6	DH4S-6	DH1B-6-534	109,5	4.310	117,4	4.622	GMH75	320
DH117	DH2W-7	DH4S-7	DH1B-7-534	117,4	4.622	125,3	4.933	GMH85	400
DH117	DH2W-8	DH4S-8	DH1B-8-534	125,3	4.933	133,2	5.244	RMH95	500
DH117	DH2W-9	DH4S-9	DH1B-9-534	133,2	5.244	141	5.555	RMH05	600

Order example: DH2S-1xxx (stone #), DH2S-1NMH55

Contact Customer Service for price and availability.


### DHH Diamond Hone Head

High-force Feed Cone and Stone Sets


Part Number	Description
DH229	High-Force Feed Cone
DHH6	Diamond Stone Set (Range 3.680"-3.880")93, 47-98, 55 mm
DHH7	Diamond Stone Set (Range 3.880"-4.080")98, 55-103, 63 mm
DHH8	Diamond Stone Set (Range 4.080"-4.280")103, 63-108, 71 mm
DHH9	Diamond Stone Set (Range 4.280"-4.480")108, 71-113,79 mm
DHH10	Diamond Stone Set (Range 4.480"-4.680")113, 79-118, 87 mm
DHH11	Diamond Stone Set (Range 4.680"-4.880")118, 87-123, 95 mm
DHH12	Diamond Stone Set (Range 4.880"-5.080")123, 95-129 mm
DHHB-6534	PHT Brush (Range 3.680"-3.880")93, 47-98, 55 mm
DHHB-7534	PHT Brush (Range 3.880"-4.080")98, 55-103, 63 mm
DHHB-8534	PHT Brush (Range 4.080"-4.280")103, 63-108, 71 mm
DHHB-9534	PHT Brush (Range 4.280"-4.480")108, 71-113,79 mm
DHHB-10534	PHT Brush (Range 4.480"-4.680")113, 79-118, 87 mm
DHHB-11534	PHT Brush (Range 4.680"-4.880")118, 87-123, 95 mm
DHHB-12534	PHT Brush (Range 4.880"-5.080")123, 95-129 mm

**NOTE:** GMH-55, GMH-75, RMH-95 and RMH-05 abrasive grades will be set up initially.


### Stone and Brush Options




**DH Stone 25**  
25 - acceptable roundness.



**DH Stone 2W**  
2W - good roundness, budget price



**DH Stone 4S**  
4S- superior or optimum roundness, more expensive. 4-stone will last longer, 16 cutting edges versus 8.



**Plateau PHT - Brush Options**  
Plateau PHT Brush are mounted on throwaway aluminum stone holders. For the DHT-70, DHT-93 & DHT-117 hone bodies, brush assemblies 1 through 9 offer 1 PHT brush mounted on each stone holder.

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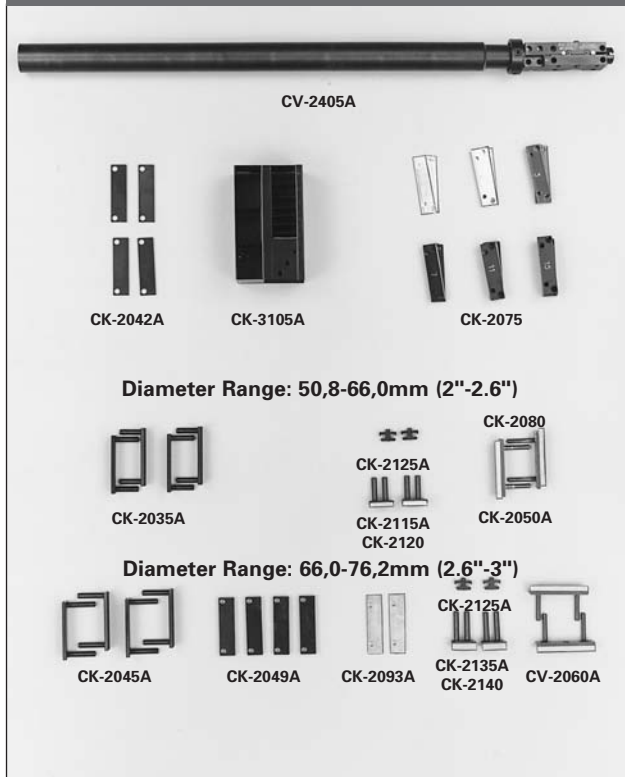
CUSTOM ABRASIVES  
& TOOLING

# CV-2400 Midget Hone Tooling Parts and Accessories



**Diameter Range:**  
50,8 mm – 76,2 mm  
2.0" – 3.0"

## CV-2400 Midget Hone Unit



Part Number	Supplied with	Description
CV-2405A	1	Midget Head and Tube Assembly
CK-2035A	2 sets	Master Stoneholder Set (2 per set) 50,8-66,04 mm (2.0"-2.6") dia.
CK-2045A	2 sets	Master Stoneholder Set (2 per set) 66,04-76,2 mm (2.6"-3.0") dia.
CK-2042A	4	Stone Shim, 3,17 mm (1/8") (1 per package)
CK-2049A	2 sets	Stone Shim Set, 7,14 mm (9/32") (2 per set)
CK-2050A	2	Main and Centering Guides (Includes CK-2080)
CK-2080	—	Guide Shoe and Screw Set (2 shoes per set) (Included with CK-2050A)
CV-2060A	2	Main and Centering Guides (1 per package) (Includes CV-2070)
CV-2070	—	Guide Shoe, with Screws
CK-2093A	2	Guide Shim 4,75 mm (3/16") (1 per package)
CK-2115A	1 set	Alignment Guide Set (2 per set) 50,8-66,0 mm (2.0"-2.6") dia. (Includes CK-2120)
CK-2120	—	Alignment Guide Shoe and Screw Set (2 shoes per set)
CK-2135A	1 set	Alignment Guide Set (2 per set) 66,0-76,2 mm (2.6"-3.0") dia. (Includes CK-2140)
CK-2140	—	Alignment Guide Shoe and Screw Set (2 shoes per set)
CK-2125A	4	Clamp (1 per package)
CK-2075	1 set	Guide Shim Set, consisting of:
CK-2071A	2 sets	Guide Shim #1 (4 per set)
CK-2072A	2 sets	Guide Shim #2 (4 per set)
CK-2073A	2 sets	Guide Shim #3 (4 per set)
CK-2074A	1 set	Guide Shim #7 (4 per set)
CK-2076A	1 set	Guide Shim #11 (4 per set)
CK-2077A	1 set	Guide Shim #15 (4 per set)
CK-3105A	1	Shim Rack

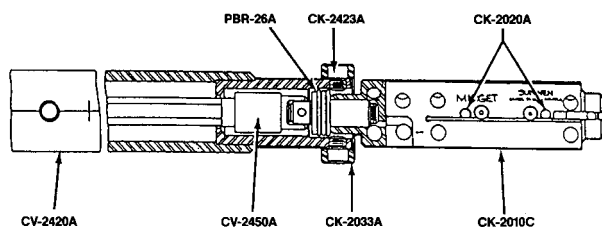
### Superabrasive Stoneholders

For CV-2400 Midget Hone Head 61-76,2 mm (2.4"-3.0").  
Not available for diameters less than 61 mm (2.4").  
Each set consists of two Master Stoneholders that use P20 diamond or CBN stones (select stones from the P20 superabrasive selection chart on page 2.45).

CK-2035A-LF4X 61-66 mm (2.4"-2.6")

CK-2045A-LF4X 66-76,2 mm (2.6"-3.0") 2 stones required per set.  
Contact Customer Service for price and availability.

## Repair Parts for CV-2400 Midget Hone Head



CV-2405A Midget Hone Head

Part Number	Qty per Machine	Description
CV-2405A	1	Midget Head and Tube Assembly
CV-2420A	1	Drive Tube-Lower Half includes
CK-2033A*	1	Universal Ring with Four Screws
CK-2423A	2	Screws (5/16-24x3/16") Socket Head
PHS-698A	2	Screws (5/16-24x3/8") Socket Head (Not Shown)
CV-2450A	1	Lower Feed Rod & "U" Joint Assembly with
PBR-26A	1	Thrust Bearing (Neiman #FT-015)
CK-2010C	1	Midget Hone Head Assembly with
CK-2015A	1	Wedge Assembly (Not Shown)
CK-2020A	1	Push Pin Set (4 Pins)

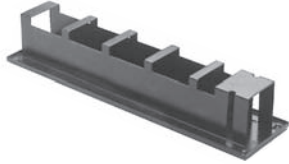
\*Not recommended to be purchased separately.



# CV-2400 Midget Hone Tooling Parts and Accessories

## Accessories

(Not included with CV-2400 Midget Hone Unit)



### CK-2040A Midget Storage Rack

For orderly storage of Stoneholders and Alignment Guides. (Order separately.)



### CK-3155A Setting Gage

Indicates shims required to set Guides to cylinder diameter. Also used to adjust Alignment Guides. (Order separately.)



### CK-3355A Stone Inserter

Changes Stones easily in seconds. Includes mounting bracket. (Order separately.)

### Replacement Parts for CK-3355A Stone Inserter:

CK-3373A Spring Retainer  
CK-3372A "In/Out" Slide



### CK-2570 Hard Guide Shoe

Long life for high production. (Not recommended with 400 grit or finer stone sets.)

Order **CK-2060A** for diameters 66,09-76,2 mm (2.6"-3").

In some cases, stones other than the RECOMMENDED STONES may hone faster or last longer. For long or repetitive production runs, it may be economical to choose a stone slightly harder or softer, coarser or finer. As a general rule, hard materials require soft stones; soft materials require hard stones; rough holes require hard stones.

**Additional abrasive specifications available to hone difficult materials.**

**Please contact Customer Service or your Sales & Application Engineer.**

## Diameter Range: 50,8 mm – 66,04 mm {2.0" – 2.6"}

		All C20 Available Stones							
		Grit Size							
		80	150	220	280	320	400	500	600
Hard---Soft	<b>Silicon Carbide Stones (J,C)</b>								
			C20-A55 C20-A57						
			C20-J54	C20-J6591		C20-J85			

## Diameter Range: 66,04 mm – 76,2 mm {2.6" – 3.0"}

		All C24 Available Stones							
		Grit Size							
		80	150	220	280	320	400	500	600
Hard---Soft	<b>Silicon Carbide Stones (J,C)</b>								
		C24-A45	C24-A55 C24-A57						C24-C05
	C24-J25	C24-J45	C24-J54 C24-J55 C24-J57	C24-J65 C24-J6591		C24-J85 C24-J87	C24-J95		

Minimum purchase quantity 6 sets.

## Recommended Stones for CV-2400 Midget Hone

Operations and Materials	Most Commonly Used Stones	Approximate R <sub>a</sub> Surface Finish	
		µm	µin
<b>Fast removal: deburred, bored, ground or reamed holes</b>			
Aluminum	C20/C24-J54	1,38	55
Brass, Soft	C20/C24-J54	1,38	55
Bronze	C20/C24-J54	1,38	55
Cast iron	C20/C24-J54	0,50	20
Steel, Soft	C20/C24-A57	2,00	80
Steel, Hardened	C20/C24-A55	0,45	18
<b>Fine finishing: previously honed holes</b>			
Aluminum	C20/C24-J95	0,30	12
Brass, Soft	C20/C24-J95	0,30	12
Bronze	C20/C24-J95	0,30	12
Cast iron	C20/C24-J95	0,10	4
Steel, Soft	C20/C24-J95	0,10	4
Steel, Hard	C20/C24-J95	0,08	3

## PHT Plateau Honing Tools

Used as a final finishing step, after initial honing to provide a plateau surface on cylinder walls.

For Diameter Range		
mm	in	(320 Grit)
50,8-60,9	2.00-2.40	C20-PHT-732
58,4-73,7	2.30-2.90	C24-PHT-732

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(SV-410 & SV-10 MACHINES)

PORTABLE, MP3 & TUBE  
HONE ABRASIVES

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# CV-3000 Junior Hone Tooling Parts and Accessories

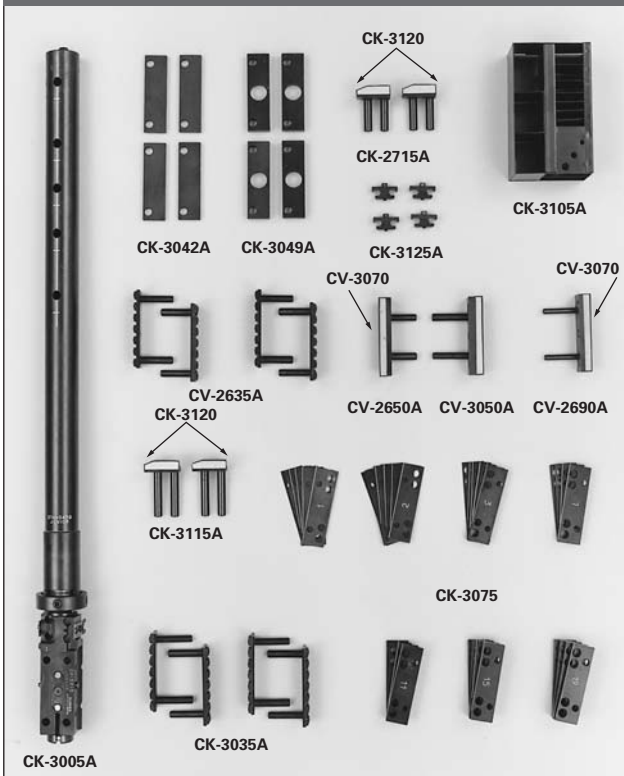


Diameter Range:

76 mm – 102 mm

3.0" – 4.0"

## CV-3000 Junior Hone Unit



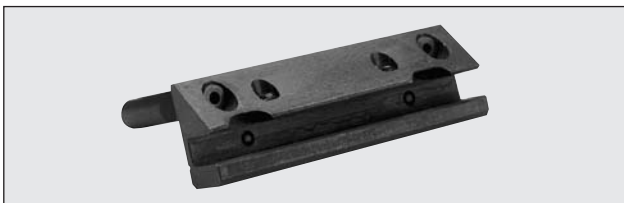
Part Number	Supplied with	Description
CV-3005A	1	Junior Head and Tube Assembly
CK-2635A	2 sets	Master Stoneholder Set (2 per set) 76,2-88,9 mm(3.0"-3.5") dia.
CK-3035A	2 sets	Master Stoneholder Set (2 per set) 88,9-102 mm (3.5"-4.0") dia.
CK-3042A	4	Stone Shim, 6,35 mm (1/4") (1 per package)
CK-3049A	2 sets	Stone Shim Set, 11,1 mm (7/16") (2 per set)
CV-2650A	1	Main Guide 76,2-88,9 mm (3.0"-3.5") dia. (Includes CV-3070)
CV-3050A	1	Main Guide 88,9-102 mm (3.5"-4.0") dia. (Includes CV-3070)
CV-3070	—	Guide Shoe, with Screws
CV-2690A	1	Centering Guide (Includes CV-3070)
CK-2715A	1 set	Alignment Guide Set (2 per set) 76,2-88,9 mm (3.0"-3.5") dia. (Includes CK-3120)
CK-3115A	1 set	Alignment Guide Set (2 per set) (Includes CK-3120)
CK-3120	—	Guide Shoe and Screw Set (2 shoes per set)
CK-3125A	4	Clamp (1 per package)
CK-3105A	1	Shim Rack
CK-3075	1 set	Guide Shim Set, consisting of:
CK-3071A	2 sets	Guide Shim #1 (4 per set)
CK-3072A	2 sets	Guide Shim #2 (4 per set)
CK-3073A	2 sets	Guide Shim #3 (4 per set)
CK-3074A	1 set	Guide Shim #7 (4 per set)
CK-3076A	1 set	Guide Shim #11 (4 per set)
CK-3077A	1 set	Guide Shim #15 (4 per set)
CK-3078A	1 set	Guide Shim #19 (4 per set)

### CK-3030A Superabrasive Stoneholders

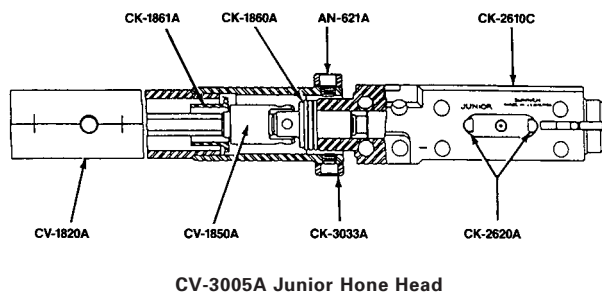
For CV-3000 Junior Hone Head.

Each set consists of two Master Stoneholders that use P28 diamond or CBN stones (select stones from the P28 superabrasive selection chart on page 2.50).

Two stones required per set.



## Repair Parts for CV-3000 Junior Hone Head



Part Number	Qty per Machine	Description
CV-3005A	1	Junior Head and Tube Assembly
CV-1820A	1	Drive Tube-Lower Half includes
CK-3033A*	1	Universal Ring with
AN-621C	1	Screws (Package of 4) consists of
AN-621A	2	Screws (5/16-24 x 15/32") Socket Head
PHS-698A	2	Screws (5/16-24 x 3/8") Socket Head (Not Shown)
CV-1850A	1	Lower Feed Rod & "U" Joint Assembly with
CK-1861A	1	Bushing
CK-1860A	1	Thrust Bearing
CK-2610C	1	Junior Hone Head Assembly with
CK-3015A	1	Wedge Assembly (Not Shown)
CK-2620A	1	Push Pin Set (4 Pins)

\*Not recommended to be purchased separately.

# CV-3000 Junior Hone Tooling Parts and Accessories

## Accessories

(Not included with CV-3000 Junior Hone Unit)



### CK-3040A Standard Storage Rack

For orderly storage of Stoneholders and Alignment Guides. (Order separately.)



### CK-3155A Setting Gage

Indicates shims required to set Guides to cylinder diameter. Also used to adjust Alignment Guides. (Order separately.)



### CK-3355A Stone Inserter

Changes Stones easily in seconds. Includes mounting bracket. (Order separately.)

#### Replacement Parts for CK-3355A

##### Stone Inserter:

CK-3373A Spring Retainer  
CK-3372A "In/Out" Slide



### CK-3570 Hard Guide Shoe

Long life for high production. (Not recommended with 400 grit or finer stone sets.)

For CK-3570 Hard Guide Shoes order:

CK-2650A Main Guide for dia. 76,2-88,9 mm (3.0"-3.5").  
CK-3050A Main Guide for dia. 88,9-102 mm (3.5"-4.0").

In some cases, stones other than the RECOMMENDED STONES may hone faster or last longer. For long or repetitive production runs, it may be economical to choose a stone slightly harder or softer, coarser or finer. As a general rule, hard materials require soft stones; soft materials require hard stones; rough holes require hard stones.

**Additional abrasive specifications available to hone difficult materials.**

**Please contact Customer Service or your Sales & Application Engineer.**

## All C30 Available Stones

		Grit Size							
		80	150	220	280	320	400	500	600
<b>Aluminum Oxide Stones (A)</b>									
Hard---Soft	C30-A24 C30-A25			C30-A53 C30-A54 C30-A55 C30-A56	C30-A63				
		C30-A45 C30-A47		C30-A5681 C30-A5681A C30-A57	C30-A65				
<b>Silicon Carbide Stones (J,C)</b>									
Hard---Soft	C30-J25			C30-J54 C30-J55 C30-J56 C30-J57	C30-J63 C30-J64 C30-J65		C30-J83 C30-J84 C30-J85 C30-J86 C30-J87	C30-J93 C30-J95	C30-C05 C30-C0381 C30-C0391
		C30-J45 C30-J46							

Minimum purchase quantity 6 sets.

## Recommended Stones for CV-3000 Junior Hone

Material	Stone to Use	Approximate R <sub>a</sub> Surface Finish	
		µm	µin
<b>Fast removal: deburred, bored, ground or reamed holes</b>			
Aluminum	C30-J57	1,38	55
Brass, Soft	C30-J55	1,38	55
Bronze	C30-J57	1,38	55
Cast iron	C30-J57	0,50	20
Steel, Soft	C30-A25	2,00	80
Steel, Hardened	C30-A55	0,45	18
<b>Fine finishing: previously honed holes</b>			
Aluminum	C30-J95	0,30	12
Brass, Soft	C30-J95	0,38	15
Bronze	C30-J95	0,38	15
Cast iron	C30-J95	0,10	4
Steel, Soft	C30-J95	0,18	7
Steel, Hardened	C30-J95	0,13	5

## PHT Plateau Honing Tools

Used as a final finishing step, after initial honing to provide a plateau surface on cylinder walls.

For Diameter Range		(320 Grit)
mm	in	
73,7-86,4	2.90-3.40	C30-PHT-731

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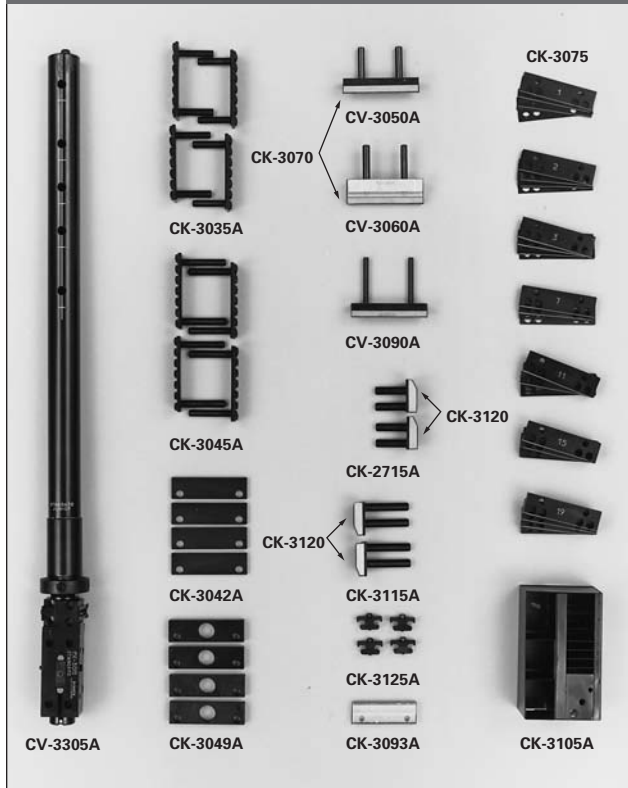
CUSTOM ABRASIVES  
& TOOLING

# CV-3300 Standard Hone Tooling Parts and Accessories

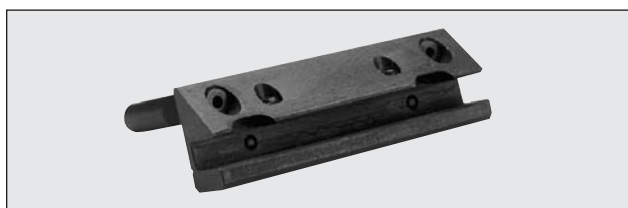


**Diameter Range:**  
84 mm – 127 mm  
3.3" – 5.0"

## CV-3300 Standard Hone Unit



Part Number	Supplied with	Description
CV-3305A	1	Standard Head and Tube Assembly
CK-3035A	2 sets	Master Stoneholder Set (2 per set) 84-104,8 mm (3.300"-4.125") dia.
CK-3045A	2 sets	Master Stoneholder Set (2 per set) 104,8-127 mm (4.125"-5.000") dia.
CK-3042A	4	Stone Shim, 6,35 mm (1/4") (1 per package)
CK-3049A	2 sets	Stone Shim Set, 11,1 mm (7/16") (2 per set)
CV-3050A	1	Main Guide 84-104,8 mm (3.300"-4.125") dia. (Includes CV-3070)
CV-3060A	1	Main Guide 104,8-127 mm (4.125"-5.000") dia. (Includes CV-3070)
CV-3070	—	Guide Shoe, with Screws
CV-3090A	1	Centering Guide (Includes CV-3070)
CK-2715A	1 set	Alignment Guide Set (2 per set) 84-95,2 mm (3.300"-3.750") dia. (Includes CK-3120)
CK-3115A	1 set	Alignment Guide Set (2 per set) 95,2-127 mm (3.750"-5.000") dia. (Includes CK-3120)
CK-3120	—	Guide Shoe and Screw Set (2 shoes per set)
CK-3125A	4	Clamp (1 per package)
CK-3093A	1	Centering Guide Shim 9,5 mm (3/8")
CK-3105A	1	Shim Rack
CK-3075	1 set	Guide Shim Set, consisting of:
CK-3071A	2 sets	Guide Shim #1 (4 per set)
CK-3072A	2 sets	Guide Shim #2 (4 per set)
CK-3073A	2 sets	Guide Shim #3 (4 per set)
CK-3074A	1 set	Guide Shim #7 (4 per set)
CK-3076A	1 set	Guide Shim #11 (4 per set)
CK-3077A	1 set	Guide Shim #15 (4 per set)
CK-3078A	1 set	Guide Shim #19 (4 per set)

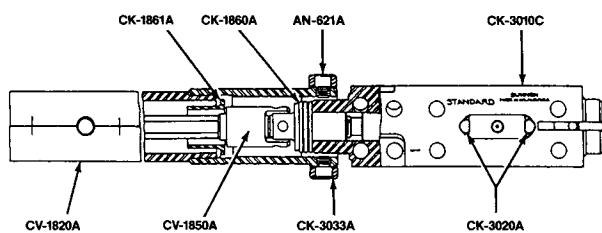


### CK-3030A Superabrasive Stoneholders (83,8mm-117,5 3.3"-4.625")

For CV-3300 Standard Hone Head. Each set consists of two Master Stoneholders that use P28 diamond or CBN stones (select stones from the P28 superabrasive selection chart on page 2.50).

Two stones required per set.

## Repair Parts for CV-3300 Standard Hone Head



CV-3305A Standard Hone Head

Part Number	Qty per Machine	Description
CV-3305A	1	Standard Head and Tube Assembly
CV-1820A	1	Drive Tube-Lower Half includes
CK-3033A*	1	Universal Ring with
AN-621C	1	Screws (Package of 4) consists of
AN-621A	2	Screws (5/16-24 x 15/32") Socket Head
PHS-698A	2	Screws (5/16-24 x 3/8") Socket Head (Not Shown)
CV-1850A	1	Lower Feed Rod & "U" Joint Assembly with
CK-1861A	1	Bushing
CK-1860A	1	Thrust Bearing
CK-3010C	1	Standard Hone Head Assembly with
CK-3015A	1	Wedge Assembly (Not Shown)
CK-3020A	1	Push Pin Set (4 Pins)



# CV-3300 Standard Hone Tooling Parts and Accessories

## Accessories

(Not included with CV-3000 Junior Hone Unit)



### CK-3040A Standard Storage Rack

For orderly storage of Stoneholders and Alignment Guides. (Order separately.)



### CK-3155A Setting Gage

Indicates shims required to set Guides to cylinder diameter. Also used to adjust Alignment Guides. (Order separately.)



### CK-3355A Stone Inserter

Changes Stones easily in seconds. Includes mounting bracket. (Order separately.)

#### Replacement Parts for CK-3355A

##### Stone Inserter:

CK-3373A Spring Retainer  
CK-3372A "In/Out" Slide



### CK-3570 Hard Guide Shoe

Long life for high production. (Not recommended with 400 grit or finer stone sets.)

For CK-3570 Hard Guide Shoes order:

CK-2650A Main Guide  
for dia. 84-104,8 mm (3.3"-4.125").

CK-3060A Main Guide  
for dia. 104,8-127 mm (4.125"-5.0").

In some cases, stones other than the RECOMMENDED STONES may hone faster or last longer. For long or repetitive production runs, it may be economical to choose a stone slightly harder or softer, coarser or finer. As a general rule, hard materials require soft stones; soft materials require hard stones; rough holes require hard stones.

**Additional abrasive specifications available to hone difficult materials.**

**Please contact Customer Service or your Sales & Application Engineer.**

## All C30 Available Stones

		Grit Size							
		80	150	220	280	320	400	500	600
		<b>Aluminum Oxide Stones (A)</b>							
Hard---Soft	C30-A24 C30-A25				C30-A53 C30-A54 C30-A55 C30-A56	C30-A63 C30-A65			
			C30-A45 C30-A47		C30-A5681 C30-A5681A C30-A57				
		<b>Silicon Carbide Stones (J,C)</b>							
Hard---Soft	C30-J25				C30-J54 C30-J55 C30-J56 C30-J57	C30-J63 C30-J64 C30-J65	C30-J83 C30-J84 C30-J85 C30-J86 C30-J87	C30-J93 C30-J95	C30-C05 C30-C0381 C30-C0391
			C30-J45 C30-J46						

Minimum purchase quantity 6 sets.

## Recommended Stones for CV-3000 Junior Hone

Material	Stone to Use	Approximate R <sub>a</sub> Surface Finish	
		µm	µin
<b>Fast removal: deburred, bored, ground or reamed holes</b>			
Aluminum	C30-J57	1,38	55
Brass, Soft	C30-J55	1,38	55
Bronze	C30-J57	1,38	55
Cast iron	C30-J57	0,50	20
Steel, Soft	C30-A25	2,00	80
Steel, Hardened	C30-A55	0,45	18
<b>Fine finishing: previously honed holes</b>			
Aluminum	C30-J95	0,30	12
Brass, Soft	C30-J95	0,38	15
Bronze	C30-J95	0,38	15
Cast iron	C30-J95	0,10	4
Steel, Soft	C30-J95	0,18	7
Steel, Hardened	C30-J95	0,13	5

## PHT Plateau Honing Tools

Used as a final finishing step, after initial honing to provide a plateau surface on cylinder walls.

For Diameter Range		(320 Grit)
mm	in	
73,7-86,4	2.90-3.40	C30-PHT-731

HONING UNIT  
SELECTION GUIDE

PEDESTAL MACHINES  
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CYLINDER HONING  
(SV-410 & SV-10 MACHINES)

PORTABLE, MP3 & TUBE  
HONE ABRASIVES

CUSTOM ABRASIVES  
& TOOLING

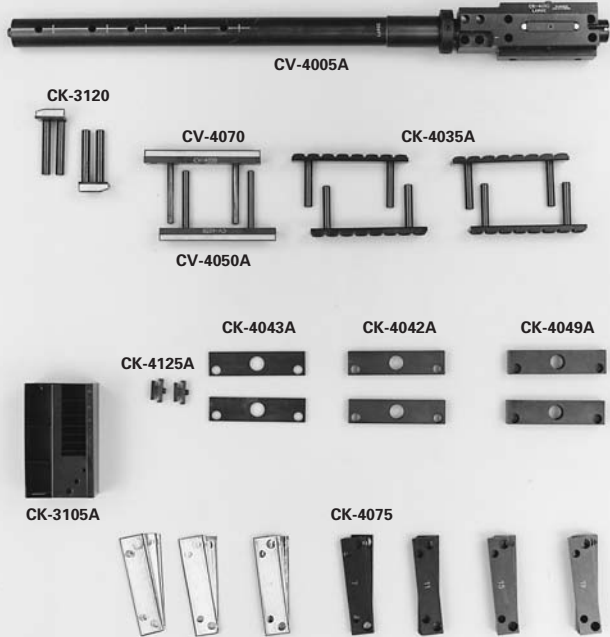
# CV-4000 Large Hone Tooling Parts and Accessories



**Diameter Range:**  
102 mm – 203 mm  
4.0" – 8.0"

## CV-4000 Large Hone Unit (Shipped complete with items listed in Fig. 1; Fig. 2 order separately)

**Figure 1 - Diameter Range: 102-152mm (4"-6")**



**Figure 2 - Diameter Range: 152-203mm (6"-8")**



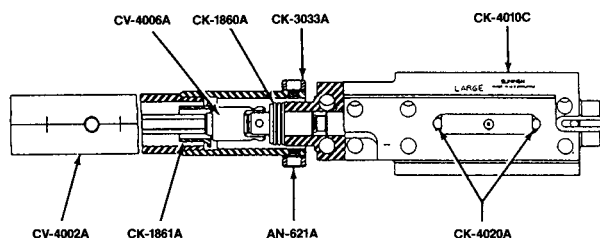
Part Number	Supplied with	Description
CV-4005A	1	Large Head and Tube Assembly
CK-4035A	2 sets	Master Stoneholder Set (2 per set) 102 mm-152 mm (4.0"-6.0") dia.
CV-4050A	2	Guide (Includes CV-4070) (1 per package)
CV-4070	—	Guide Shoe, with Screws
CK-4115A	1 set	Alignment Guide Set (Includes CK-3120) (2 per set)
CK-3120	—	Guide Shoe and Screw Set (2 shoes per set)
CK-4042A	2	Stone Shim 6,35 mm (.25") (1 per package)
CK-4043A	2	Stone Shim 12,7 mm (.5") (1 per package)
CK-4049A	2	Stone Shim 19,05 mm (.75") (2 per package)
CK-4125A	2	Clamp (1 per package)
CK-3105A	1	Shim Rack
CK-4075	1 set	Guide Shim Set, consisting of:
CK-4071	8 ea.	Guide Shim #1
CK-4072	8 ea.	Guide Shim #2
CK-4073	8 ea.	Guide Shim #3
CK-4074	4 ea.	Guide Shim #7
CK-4076	4 ea.	Guide Shim #11
CK-4077	4 ea.	Guide Shim #15
CK-4078	4 ea.	Guide Shim #19
<b>Figure 2 (Not included with CV-4000)</b>		
CK-4045A	2 sets	Master Stoneholder Sets (2 per set)
CK-4049A	2 sets	Stone Shim Set 19,05 mm (.75") (2 per set)
CK-4093A	2	Main and Centering Guide Shims (1 per package)
CK-4135A	1 set	Alignment Guide Set (Includes CK-3120) (2 per set)
CK-3120	—	Guide Shoe and Screw Set (2 per set)

### Superabrasive Stoneholders

For CV-4000 Large Hone Unit.  
Each set consists of two Master Stoneholders that use 2 P28 diamond or CBN stones per holder (select stones from the P28 superabrasive selection chart on page 2.50).

**CK-4035A-JD7X**  
103,2-165,1 mm (4 1/16"-6.5")  
**CK-4045A-JD7X**  
154,0-215,9 mm (6 1/16"-8.5")

## Repair Parts for CV-4000 Large Hone Head



CV-4005A Large Hone Head

Part Number	Qty per Machine	Description
CV-4005A	1	Large Head and Tube Assembly
CV-4002A	1	Drive Tube-Lower Half includes
CK-3033A*	1	Universal Ring with
AN-621C	1	Screws (Package of 4) consists of
AN-621A	2	Screws (5/16-24 x 7/32") Socket Head
PHS-698A	2	Screws (5/16-24 x 3/8") Socket Head (Not Shown)
CV-4006A	1	Lower Feed Rod & "U" Joint Assembly with
CK-1861A	1	Bushing
CK-1860A	1	Thrust Bearing
CK-4010C	1	Large Hone Head Assembly with
CK-4015A	1	Wedge Assembly (Not Shown)
CK-4020A	1	Push Pin Set (4 Pins)

\*Not recommended to be purchased separately.



# CV-4000 Large Hone Tooling Parts and Accessories

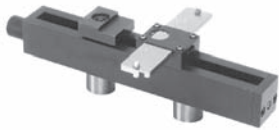
## Accessories

(Not included with CV-3000 Junior Hone Unit)



### CK-4040A Standard Storage Rack

For orderly storage of Stoneholders and Alignment Guides. (Order separately.)



### CK-4155A Setting Gage

Indicates shims required to set Guides to cylinder diameter. Also used to adjust Alignment Guides. (Order separately.)



### CK-4355A Stone Inserter

Changes Stones easily in seconds. Includes mounting bracket. (Order separately.)

#### Replacement Parts for CK-4355A Stone Inserter:

CK-4373A Spring Retainer  
CK-4372A "In/Out" Slide



### CK-4570 Hard Guide Shoe

Long life for high production shops. Recommended for use if honing with diamonds. (Not recommended with 400 grit or finer stone sets.)

In some cases, stones other than the RECOMMENDED STONES may hone faster or last longer. For long or repetitive production runs, it may be economical to choose a stone slightly harder or softer, coarser or finer. As a general rule, hard materials require soft stones; soft materials require hard stones; rough holes require hard stones.

**Additional abrasive specifications available to hone difficult materials.**

**Please contact Customer Service or your Sales & Application Engineer.**

## All Available Stones

		Grit Size							
		80	150	220	280	320	400	500	600
		<b>Aluminum Oxide Stones (A)</b>							
Hard---Soft		C40-A25	C40-A45	C40-A55					
			C40-A47	C40-A57					
		<b>Silicon Carbide Stones (J,C)</b>							
Hard---Soft		C40-J25	C40-J45	C40-J55			C40-J85	C40-J95	C40-C05
		C40-J27	C40-J47	C40-J56	C40-J57	C40-J67	C40-J87		

All in stock C40 stones sold in individual sets.

## Recommended Stones for CV-4000 Large Hone

Material	Stone to Use	Approximate R <sub>a</sub> Surface Finish	
		µm	µin
<b>Fast removal in deburred, bored, ground or reamed holes</b>			
Aluminum	C40-J57	1,38	55
Brass, Soft	C40-J55	1,38	55
Bronze	C40-J55	1,38	55
Cast iron	C40-J57	0,50	20
Steel, Soft	C40-A25	2,00	80
Steel, Hardened	C40-A55	0,45	18
<b>Fine finishing in previously honed holes</b>			
Aluminum	C40-J95	0,30	12
Brass, Soft	C40-J95	0,30	10
Bronze	C40-J95	0,30	10
Cast iron	C40-J95	0,10	4
Steel, Soft	C40-J95	0,12	8
Steel, Hard	C40-J95	0,08	3

## PHT Plateau Honing Tools

Used as a final finishing step, after initial honing to provide a plateau surface on cylinder walls.

For Diameter Range		
mm	in	(320 Grit)
101,6-152,4	4.00-6.00	C40-PHT-731
152,4-203,2	6.00-8.00	C40-PHT-731

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# Notes

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