### MPS-H85 Hone Head Module

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>MPS-H85</td>
<td>Hone Head Assembly includes:</td>
</tr>
<tr>
<td>MPS-455A</td>
<td>Pinion Adjustment Assembly</td>
</tr>
<tr>
<td>MPS-57A</td>
<td>Body Gear (Not shown)</td>
</tr>
<tr>
<td>MPS-79A</td>
<td>Pins (Not shown)</td>
</tr>
<tr>
<td>MPS-170A</td>
<td>Inner Feed Assembly (Not shown)</td>
</tr>
<tr>
<td>MPS-M3085</td>
<td>Master Stoneholder Set (2 per set)</td>
</tr>
<tr>
<td>MPS-3085</td>
<td>Diameter Range: 86.4-111.8 mm (3.4”-4.4”) includes:</td>
</tr>
<tr>
<td>MPS-3090</td>
<td>Stone Master Holder</td>
</tr>
<tr>
<td>MPS-3100</td>
<td>Guide Master Holder</td>
</tr>
<tr>
<td>MPS-M3105</td>
<td>Master Stoneholder Set (2 per set)</td>
</tr>
<tr>
<td>MPS-3125</td>
<td>Diameter Range: 127-177.8 mm (5.0”-7.0”) includes:</td>
</tr>
<tr>
<td>MPS-3130</td>
<td>Stone Master Holder</td>
</tr>
<tr>
<td>MPS-T10</td>
<td>Guide Master Holder</td>
</tr>
<tr>
<td>MPS-3090</td>
<td>Swaging Tool</td>
</tr>
</tbody>
</table>

Order stones from the H70 Stone Selection Guide found on page 119.

Double length Hone Heads available as a special. Contact Customer Service.

### MPS-H165 Hone Head Module

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>MPS-H165</td>
<td>Hone Head Assembly includes:</td>
</tr>
<tr>
<td>MPS-1700</td>
<td>Yoke Assembly</td>
</tr>
<tr>
<td>MPS-1600</td>
<td>Cage Assembly</td>
</tr>
<tr>
<td>MPS-95</td>
<td>Hone Body Assembly includes:</td>
</tr>
<tr>
<td>MPS-57A</td>
<td>Body Gear (Not shown)</td>
</tr>
<tr>
<td>MPS-79A</td>
<td>Pin (Not shown)</td>
</tr>
<tr>
<td>MPS-2221</td>
<td>Output Drive Adapter</td>
</tr>
<tr>
<td>MPS-455A</td>
<td>Pinion Adjustment Assembly</td>
</tr>
<tr>
<td>MPS-M1620</td>
<td>Stone and Guide Adapter Set includes:</td>
</tr>
<tr>
<td>MPS-1630</td>
<td>Stone Extension Support (2 per set)</td>
</tr>
<tr>
<td>MPS-1650</td>
<td>Guide Extension Support (2 per set)</td>
</tr>
<tr>
<td>MPS-1621</td>
<td>Stone Adapter Block (2 per set)</td>
</tr>
<tr>
<td>MPS-1641</td>
<td>Guide Adapter Block (2 per set)</td>
</tr>
<tr>
<td>MPS-M1660</td>
<td>Stone and Guide Adapter Set includes:</td>
</tr>
<tr>
<td>MPS-1660</td>
<td>Stone Master Holder Assembly (2 per set)</td>
</tr>
<tr>
<td>MPS-1680</td>
<td>Guide Master Holder Assembly (2 per set)</td>
</tr>
<tr>
<td>MPS-T10</td>
<td>Swaging Tool</td>
</tr>
</tbody>
</table>

Order stones from the H70 Stone Selection Guide found on page 119.

Double length Hone Heads available as a special. Contact Customer Service.
MPS Modular Tool System
HT/HL/STH - Type Systems

Diameter Range:
203 mm — 299 mm (8"-11.5")

MPS-H200 Hone Head Module*

Part Number Description
MPS-H200 Hone Head Assembly includes:
Yoke Assembly
Cage Assembly
Hone Body Assembly includes:
Body Gear (Not shown)
Pin (Not shown)
Output Drive Adapter
Pinion Adjustment Assembly
Stone and Guide Extension Set includes:
Guide Extension Support Assembly (2 per set)
Stone Extension Support Assembly (2 per set)
Swaging Tool

* Order single length or double length Master Holder and Adapter Block Sets for MPS-H200 Hone Head separately.
For larger diameter MPS style hone heads, request product bulletin P-39071.

Order stones from the H70 Stone Selection Guide found on page 119.

MPS-M1870 Single Length Stone and Guide Master Holder and Adapter Block Set

MPS-M1880 Double Length Stone and Guide Master Holder and Adapter Block Set

Order stones from H70 Stone Selection Guide found on page 160.

JS9X Cage Assembly and Stone and Guide Extension Set for the MPS System
Diameter Range 279,4 mm-381,0 mm (11.0"-15.0")
Increases the diameter range of the MPS-H165 and MPS-H200 hone head modules to 279,4 mm-381,0 mm (11"-15").
Customers who currently have an MPS-H165 or MPS-H200 hone head need to order the following:
JS9X-1 Cage Assembly
JS9X-45 Stone and Guide Extension Set

For customers who do not have an MPS-H165 or MPS-H200 the following items need to be ordered for a complete unit.
MPS-1700A Yoke Assembly
MPS-95A Hone Body Assembly
MPS-455A Pinion Adjustment Assembly
MPS-M1870 Single Length Stone and Guide Master Holder and Adapter Block Set
MPS-M1880 Double Length Stone and Guide Master Holder and Adapter Block Set

Order stones from H70 Stone Selection Guide found on page 160.
NH6X Cage Assembly and Stone and Guide Extension Set for the MPS System
Diameter Range: 381,0mm-889,0mm (15”-35”)
Increases the diameter range of the MPS-H165 and MPS-H200 hone head modules to 381,0mm-889,0mm (15”-35”). Customers who currently have a MPS-H165 or MPS-H200 hone head need to order the following:

Diameter Range: Cage Stone and Guide Extensions  
381mm-508mm (15”-20”) NH6X-1520-1 NH6X-1520-45  
508mm-635mm (20”-25”) NH6X-2025-1 NH6X-2025-45  
635mm-762mm (25”-30”) NH6X-2530-1 NH6X-2530-45  
762mm-889mm (30”-35”) NH6X-3035-1 NH6X-3035-45  

For customers who do not have an MPS-H165 or MPS-H200 the following items need to be ordered for a complete unit.

1.) 381mm-508mm (15”-20”) NH6X-1520  
508mm-635mm (20”-25”) NH6X-2025  
635mm-762mm (25”-30”) NH6X-2530  
762mm-889mm (30”-35”) NH6X-3035  

2.) MPS-1700A Yoke Assembly  
3.) PH-633 Screws (4 Req.)  
PG-587 Washers (4 Req.)  
MPS-1608 Spacers (2 Req.)  
4.) Stone and guide master holder and adapter block sets must be ordered seperately. MPS-M1870 Single Length or MPS M1880 Double Length

Adapters Sets  
For use with Drive and Feed Extensions

MPS-2200A  
MPS-2235A  
MPS-2230A  
MPS-ER22  
MPS-2233A

MPS-2200 Adapter Set  
For use with MPS-H70 and MPS-H85 Hone Head Modules and MPS-1000JU5X Mandrel Driver.

Replacement Parts for Adapter Set  
MPS-2220A Output Flange  
MPS-2230A Input Yoke  
MPS-2235A Universal Cover  
MPS-2232A Trip Dogs (Package of 2) (Not shown)  
MPS-2233A Pins (Package of 2)  
MPS-ER22 Disassembly Rings (Package of 6)

MPS-2201 Adapter Set  
For use with MPS-H50, MPS-H165 and MPS-H200 Hone Head Modules.

Replacement Parts for Adapter Set  
MPS-2220A Input Yoke  
MPS-2235A Universal Cover  
MPS-2222A Output Feed Adapter  
MPS-2232A Trip Dogs (Package of 2) (Not shown)  
MPS-2233A Pins (Package of 2)  
MPS-ER22 Disassembly Rings (Package of 6)

Drive and Feed Extensions for H50, H70, H85, H165 and H200 Hone Head Modules
Select proper Drive and Feed Extension(s) for your application from the following:

MPS-E2015  
Length 150 mm (5.9”)  
For honing lengths up to 406 mm (16”)  
Shipping Weight: 1,1 kg (2.5 lbs.)

MPS-E2040  
Length 399 mm (15.7”)  
For honing lengths up to 660 mm (26”)  
Shipping Weight: 1,6 kg (3.5 lbs.)

MPS-E2100  
Length 998 mm (39.3”)  
For honing lengths up to 1244 mm (49”)  
Shipping Weight: 3,0 kg (6.5 lbs.)

MPS-E2160  
Length 1600 mm (63”)  
For honing lengths up to 1844 mm (73”)  
Shipping Weight: 4,0 kg (8.8 lbs.)

MPS-E2175  
Length 1750 mm (68.9”)  
For honing lengths up to 1981 mm (78”)  
Shipping Weight: 4,5 kg (10 lbs.)

MPS Drive Tubes can easily be connected when honing lengths longer than 1981 mm (78”).

† Each Drive & Feed Extension comes with two Disassembly Rings.
Should additional rings be required order the following Part Number: MPS-ER22 Disassembly Rings (Package of 6).

GNR Drive Shaft Adapters for “Heavy Duty” Applications
These adapters allow GNR Drive Shaft Extensions to be used in place of MPS Drive Shaft Extensions in diameter 88,9 mm (3.50”) and larger. The GNR Drive Shaft Extensions are stronger than MPS Drive Shaft Extensions and should be used in more demanding applications.

When ordering adapters for standard MPS tooling above 88,9 mm (3.50”) order the following two items:
1-MPS-1720A Input Adapter and 1-MPS-1740A Output Adapter  
(Order 1-MPS-2211A Input Drive Adapter and 1-MPS-2212A Input Feed Adapter when Drive Shaft Adapters are to be used with MPS-H165 or MPS-H200 hone heads.)

When ordering adapters for GNR drive shafts and standard MPS tooling above 88.9 (3.50”) Order the following items:
1-MPS-1720A Input Adapter (picture required)  
1-MPS-1740A Output Adapter (picture required)  
(This tooling combination is recommended for rough, out-of-round holes, large diameters, or heavy duty applications.)

When quick change-over of hone heads is desired order:
1-MPS-2211A Input Adapter  
1-MPS-2212A Feed Adapter  
These components allow for the drive shaft and hone head to be easily unbolted from each other. (Not recommended for rough, out-of-round holes, large diameters, or heavy duty applications.)
Stone and Guide Sets
H50 Stone Sets for use with MPS-H50 Hone Head
Each set consists of two stone assemblies.
Stones in parentheses available 2 weeks after receipt of order.

H50 and H70 Metal Bond Superabrasive Stone Sets
H50 and H70 Metal Bond Superabrasive Stone Sets are available for use on MPS-H50, MPS-H70, MPS-H85, MPS-H165, MPS-H200 and MPS-H200 with JS9X Extension Sets.

The following stone sets are available in stock for immediate shipment.

MPS-H50 Hone Heads
H50-NM37 100 Grit CBN
H50-NM55 220 Grit CBN
H50-NM57 220 Grit CBN

MPS-H70, MPS-H85, MPS-H165, MPS-H200 and JS9X Extension Sets
H70-NM17 70 Grit CBN
H70-NM35 100 Grit CBN
H70-NM37 100 Grit CBN
H70-NM39 100 Grit CBN
H70-NM55 220 Grit CBN
H70-NM57 220 Grit CBN
H70-NM85 400 Grit CBN
H70-DM37 100 Grit Diamond
H70-DM57 220 Grit Diamond
H70-DM85 400 Grit Diamond

H70 Stone and Guide Set for use with MPS-H70, MPS-H85, MPS-H165 and MPS-H200 Hone Heads
Each set consists of two stone assemblies and two guides.
Contact Customer Service for price and availability.

Miscellaneous Accessories & Tooling
MPS-1000-JU5X Mandrel Driver
For honing bores with interruptions, cross holes, undercuts when standard MPS tools will not bridge. MPS-1000-JU5X adapts to the MPS drive and feed extensions and can be used with standard P28/R28 tooling for the diameter range of 66 mm – 144 mm (2-5/16”-6”), where the mandrel driver has to enter the part. (Smaller mandrels may be used if the mandrel driver does not have to enter the part.)

Order mandrels and stones from the P28/R28 section on pages 58-59.

MPS-1000-JU5X available 4 weeks after receipt of order.

SC-B-GL Heavy-Duty Bronze Guide Shoe
For use with H70 Diamond or CBN Honing Stones when standard guide shoes wear excessively. Also used for special finishing applications. (2 required per stone set used.)

www.sunnen.com
## MPS Modular Tool System

**MPS Portahones and Drive Extensions**

**Diameter Range:**
25,15 mm — 66,68 mm (.990”-2.625”)

Portahones are to be used in applications below the MPS-H50 Hone Head diameter range or in situations where longer stone length is required to bridge ports or other interruptions that cannot be bridged with H50 length stones. (For applications where longer stone length is required in diameters larger than 66,68 mm [2.625”] use MPS-1000-JUX with standard P28 mandrels.) All Portahones use standard P28 or R28 stones and guide shoes. (See pages 58-59 for Stone and Guide Shoe Selection.)

This style of Portahone is specifically designed for use in MPS applications. They incorporate all the features of standard portahones, but are used with drive tube extensions that are more suited for “power” honing. **Available 4-6 weeks after receipt of order.**

For special application hone heads down to 1/2", contact your Sunnen sales representative for additional information.

**Diameter Range:** 25,15 mm – 38,1 mm (.990”-1.500”)

---

### Mandrel Number

<table>
<thead>
<tr>
<th>Diameter Range</th>
<th>2-Stone</th>
<th>3-Stone</th>
<th>4-Stone</th>
<th>5-Stone*</th>
</tr>
</thead>
<tbody>
<tr>
<td>mm</td>
<td>in</td>
<td>mm</td>
<td>mm</td>
<td>mm</td>
</tr>
<tr>
<td>25,15-26,97</td>
<td>.990-1.062</td>
<td>319,8 mm (12-19/32&quot;)</td>
<td>403,2 mm (15-7/8&quot;)</td>
<td>486,6 mm (19-5/32&quot;)</td>
</tr>
<tr>
<td>26,72-28,58</td>
<td>1.052-1.125</td>
<td>345,2 mm (13-19/32&quot;)</td>
<td>428,6 mm (16-7/8&quot;)</td>
<td>512 mm (206-5/32&quot;)</td>
</tr>
<tr>
<td>28,32-30,15</td>
<td>1.115-1.187</td>
<td>361,5 mm (14-1/16&quot;)</td>
<td>445 mm (17-3/16&quot;)</td>
<td>528 mm (209-5/32&quot;)</td>
</tr>
<tr>
<td>29,90-31,75</td>
<td>1.177-1.250</td>
<td>376,9 mm (14-3/4&quot;)</td>
<td>460 mm (17-3/4&quot;)</td>
<td>543,8 mm (21-1/2&quot;)</td>
</tr>
<tr>
<td>31,24-34,93</td>
<td>1.230-1.375</td>
<td>392,3 mm (15-1/4&quot;)</td>
<td>475 mm (18-7/32&quot;)</td>
<td>559,1 mm (21-11/32&quot;)</td>
</tr>
<tr>
<td>34,40-38,10</td>
<td>1.305-1.500</td>
<td>407,7 mm (15-7/8&quot;)</td>
<td>490 mm (19&quot;)</td>
<td>574,4 mm (22&quot;)</td>
</tr>
</tbody>
</table>

### Open Hole: Order 1, 2, 4, 5, 6 For Complete MPS Honing Unit

<table>
<thead>
<tr>
<th>Mandrel Reach Length: Indicates longest bore length that can be honed without extensions.</th>
</tr>
</thead>
<tbody>
<tr>
<td>236,5 mm (9-5/16&quot;)</td>
</tr>
</tbody>
</table>

### Blind Hole: Order 1, 3, 4, 5, 6 For Complete MPS Honing Unit

<table>
<thead>
<tr>
<th>Portahone Adapter Set</th>
</tr>
</thead>
<tbody>
<tr>
<td>MPS-2230A Input Yoke</td>
</tr>
<tr>
<td>MPS-2235A Universal Cover (Not Shown) Order separately.</td>
</tr>
</tbody>
</table>

### Drive Extension

**MPS-E2015** motor. 150 mm (5.9") supplied with 2 MPS-ER22 Disassembly Rings. Required for hookup to MPS drive motor.

**Drive Extension Assembly**

<table>
<thead>
<tr>
<th>Drive Extension Assembly</th>
</tr>
</thead>
<tbody>
<tr>
<td>DFA-NZ3X-1 (3)</td>
</tr>
<tr>
<td>DFA-NZ3X-1 (6)</td>
</tr>
<tr>
<td>DFA-NZ3X-1 (9)</td>
</tr>
<tr>
<td>DFA-NZ3X-1 (12)</td>
</tr>
</tbody>
</table>

* Longer than 5-Stone Length Mandrels are available on special request. Contact Customer Service.

**NOTE:** When ordering, specify for open or blind hole honing.
# MPS Modular Tool System

**I.D. Range:**

37,6 mm – 44,45 mm

1.480"–1.750"

---

**Open Hole: Order 1, 2, 4, 5, 6 For Complete MPS Honing Unit**

**Blind Hole: Order 1, 3, 4, 5, 6 For Complete MPS Honing Unit**

<table>
<thead>
<tr>
<th>Mandrel Number</th>
<th>Diameter Range</th>
<th>2-Stone</th>
<th>3-Stone</th>
<th>4-Stone</th>
<th>5-Stone*</th>
</tr>
</thead>
<tbody>
<tr>
<td>1</td>
<td>37,6-41,3</td>
<td>MPS-1500WD-NZ3X</td>
<td>MPS-1500WD-NZ3X</td>
<td>MPS-1500WD-NZ3X</td>
<td>MPS-1500WD-NZ3X</td>
</tr>
<tr>
<td></td>
<td>40,8-44,5</td>
<td>MPS-1625WD-NZ3X</td>
<td>MPS-1625WD-NZ3X</td>
<td>MPS-1625WD-NZ3X</td>
<td>MPS-1625WD-NZ3X</td>
</tr>
</tbody>
</table>

**Mandrel Reach Length:** Indicates longest bore length that can be honed without extensions.

<table>
<thead>
<tr>
<th>Mandrel Reach Length</th>
<th>2-Stone</th>
<th>3-Stone</th>
<th>4-Stone</th>
<th>5-Stone*</th>
</tr>
</thead>
<tbody>
<tr>
<td>—</td>
<td>236,5 mm (9-5/16&quot;)</td>
<td>319,8 mm (12-19/32&quot;)</td>
<td>403,2 mm (15-7/8&quot;)</td>
<td>486,6 mm (19-5/32&quot;)</td>
</tr>
<tr>
<td>—</td>
<td>261,9 mm (10-5/16&quot;)</td>
<td>345,2 mm (13-19/32&quot;)</td>
<td>428,6 mm (16-7/8&quot;)</td>
<td>512 mm (20-5/32&quot;)</td>
</tr>
</tbody>
</table>

**Portahone Adapter Set**

<table>
<thead>
<tr>
<th>MPS-2230A</th>
<th>Input Yoke</th>
</tr>
</thead>
<tbody>
<tr>
<td>MPS-2235A</td>
<td>Universal Cover (Not Shown)</td>
</tr>
</tbody>
</table>

**Drive Extensions**

MPS-E2015: 150 mm (5.9") supplied with 2 MPS-ER22 Disassembly Rings. Required for hook up to MPS drive motor.

**Drive Extensions Assembly**

- **DFA-NZ3X-2 (3)**: 914 mm (3 ft.) length
- **DFA-NZ3X-2 (6)**: 1829 mm (6 ft.) length
- **DFA-NZ3X-2 (9)**: 2743 mm (9 ft.) length
- **DFA-NZ3X-2 (12)**: 3657 mm (12 ft.) length

* Longer than 5-Stone Length Mandrels are available on special request. Contact Customer Service.

**NOTE:** When ordering, specify for open or blind hole honing.
MPS Modular Tool System
MPS Portahones and Drive Extensions

**Diameter Range:**
43.94mm – 66.68mm
1.730" – 2.625"

---

### 1. Mandrel Number

<table>
<thead>
<tr>
<th>Mandrel Number</th>
<th>Diameter Range</th>
<th>2-Stone</th>
<th>3-Stone</th>
<th>4-Stone</th>
<th>5-Stone*</th>
</tr>
</thead>
<tbody>
<tr>
<td>43.94-47.62</td>
<td>1.730-1.875</td>
<td>2-MPSP-1750WE</td>
<td>3-MPSP-1750WE</td>
<td>4-MPSP-1750WE</td>
<td>5-MPSP-1750WE</td>
</tr>
<tr>
<td>47.12-50.80</td>
<td>1.855-2.000</td>
<td>2-MPSP-1875WE</td>
<td>3-MPSP-1875WE</td>
<td>4-MPSP-1875WE</td>
<td>5-MPSP-1875WE</td>
</tr>
<tr>
<td>53.47-57.15</td>
<td>2.105-2.250</td>
<td>2-MPSP-2125WF</td>
<td>3-MPSP-2125WF</td>
<td>4-MPSP-2125WF</td>
<td>5-MPSP-2125WF</td>
</tr>
<tr>
<td>56.64-60.32</td>
<td>2.230-2.375</td>
<td>2-MPSP-2250WF</td>
<td>3-MPSP-2250WF</td>
<td>4-MPSP-2250WF</td>
<td>5-MPSP-2250WF</td>
</tr>
<tr>
<td>59.82-63.50</td>
<td>2.355-2.500</td>
<td>2-MPSP-2375WG</td>
<td>3-MPSP-2375WG</td>
<td>4-MPSP-2375WG</td>
<td>5-MPSP-2375WG</td>
</tr>
<tr>
<td>62.99-66.67</td>
<td>2.480-2.625</td>
<td>2-MPSP-2500WG</td>
<td>3-MPSP-2500WG</td>
<td>4-MPSP-2500WG</td>
<td>5-MPSP-2500WG</td>
</tr>
</tbody>
</table>

**Mandrel Reach Length:** Indicates longest bore length that can be honed without extensions.

| Open Hole | 236,5 mm (9-5/16") | 319,8 mm (12-19/32") | 403,2 mm (15-7/8") | 486,6 mm (19-5/32") |
| Blind Hole | 261,9 mm (10-5/16") | 345,2 mm (13-19/32") | 428,6 mm (16-7/8") | 512 mm (20-5/32") |

### 4. Portahone Adapter Set

- MPS-2230A: Input Yoke
- MPS-2235A: Universal Cover (Not shown) Order separately.

### 5. Drive Extensions

- Supplied with 2 MPS-ER22 Disassembly Rings. Required for hookup to MPS drive motor.
  - MPS-E2015: 150 mm (5.9")
  - MPS-E2040: 399 mm (15.7")
  - MPS-E2100: 998 mm (39.3")
  - MPS-E2160: 1600 mm (63.0")
  - MPS-E2175: 1750 mm (68.9")

### 6. Feed and Adapter Assembly

- LN-7120

**Note:** Will also adapt to SNR & JNR Tooling

* Longer than 5-Stone Length Mandrels are available on special request. Contact Customer Service.
### Repair Parts List for Obsolete Style Portahones

**[G]-MPSP-1000VA thru [G]-MPSP-1375WC**
- [G]-MPSP-1000VA
- [G]-MPSP-1062VA
- [G]-MPSP-1125VB
- [G]-MPSP-1187VB
- [G]-MPSP-1250WB
- [G]-MPSP-1375WC
- [J]-MPSP-1
- [J]-MPSP-2
- [J]-MPSP-3
- [J]-MPSP-4
- [J]-MPSP-4
- [J]-MPSP-5
- DFA-N2Z3X
- Feed Nut
- LN-7308
- Thrust Bearing
- LN-7307
- Feed Nut End
- LN-7311
- Feed Screw

**[G]-MPSP-1750WE thru [H]-MPSP-2500WG**
- [G]-MPSP-1750WE
- [H]-MPSP-1875WE
- [H]-MPSP-2000WF
- [H]-MPSP-2125WF
- [H]-MPSP-2250WF
- [H]-MPSP-2375WG
- [H]-MPSP-2500WG
- [J]-P28-MPSP
- [J]-PH-P28-MPSP
- [J]-PH-P28-MPSP
- [J]-PH-P28-MPSP
- [J]-PH-P28-MPSP
- [J]-PH-P28-MPSP
- [J]-P28-MPSP
- [J]-P28-MPSP
- [J]-P28-MPSP
- [J]-P28-MPSP
- [J]-P28-MPSP
- [J]-P28-MPSP
- [J]-P28-MPSP
- LN-7358
- Feed Nut
- PBR-66A
- Thrust Bearing
- LN-7357
- Feed Nut End
- LN-7361
- Feed Screw
- LN-7366
- Wedge Block
- LN-7278A
- Fork
- LN-7374
- Ring
- LN-7377
- Screws (4 Required)

**[G]-MPSP-1500WD thru [G]-MPSP-1625WD**
- [G]-MPSP-1500WD
- [G]-MPSP-1625WD
- [J]-P28-MPSP
- [J]-P28-MPSP
- LN-7358
- Feed Nut
- PBR-66A
- Thrust Bearing
- LN-7357
- Feed Nut End
- LN-7361
- Feed Screw
- LN-7366
- Wedge Block
- LN-7278A
- Fork
- LN-7374
- Ring
- LN-7377
- Screws (4 Required)

**[H]-MPSP-1375WC thru [H]-MPSP-2500WG**
- [H]-MPSP-1375WC
- [H]-MPSP-1500WD
- [H]-MPSP-1625WD
- [J]-P28-MPSP
- [J]-P28-MPSP
- LN-7358
- Feed Nut
- PBR-66A
- Thrust Bearing
- LN-7357
- Feed Nut End
- LN-7361
- Feed Screw
- LN-7366
- Wedge Block
- LN-7278A
- Fork
- LN-7374
- Ring
- LN-7377
- Screws (4 Required)

*Note: Specify Blind or Open Hole.
These Portahones have precision fit wedges. It is recommended that the entire unit be returned to the factory for wedge replacement.

†For blind hole application, change “P28” to “R28.”

†Note: Specify Blind or Open Hole.
These Portahones have precision fit wedges. It is recommended that the entire unit be returned to the factory for wedge replacement.

<table>
<thead>
<tr>
<th>†Note: Specify Blind or Open Hole. This Portahones have precision fit wedges. It is recommended that the entire unit be returned to the factory for wedge replacement.</th>
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</tr>
</thead>
<tbody>
<tr>
<td>Note: Specify Blind or Open Hole. These Portahones have precision fit wedges. It is recommended that the entire unit be returned to the factory for wedge replacement.</td>
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</tbody>
</table>

www.sunnen.com
CV-2400 Midget Hone Tooling
Parts and Accessories

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

For Use In: CK10, CK21, CV616, SV10, SV200, SV300 Machines

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### CV-2400 Midget Hone Unit

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Qty per Machine</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>CV-2405A</td>
<td>1</td>
<td>Midget Head and Tube Assembly</td>
</tr>
<tr>
<td>CK-2035A</td>
<td>2 sets</td>
<td>Master Stoneholder Set (2 per set)</td>
</tr>
<tr>
<td>CK-2045A</td>
<td>2 sets</td>
<td>Master Stoneholder Set (2 per set)</td>
</tr>
<tr>
<td>CK-2042A</td>
<td>4</td>
<td>Stone Shim, 3,17 mm (1/8”) (1 per package)</td>
</tr>
<tr>
<td>CK-2049A</td>
<td>2 sets</td>
<td>Stone Shim Set, 7,14 mm (9/32”) (2 per set)</td>
</tr>
<tr>
<td>CK-2050A</td>
<td>2</td>
<td>Main and Centering Guides (Includes CK-2080)</td>
</tr>
<tr>
<td>CK-2080</td>
<td>—</td>
<td>Guide Shoe and Screw Set (2 shoes per set)</td>
</tr>
<tr>
<td>CV-2060A</td>
<td>2</td>
<td>Main and Centering Guides (1 per package)</td>
</tr>
<tr>
<td>CV-2070</td>
<td>—</td>
<td>Guide Shoe, with Screws</td>
</tr>
<tr>
<td>CK-2093A</td>
<td>2</td>
<td>Guide Shim 4,75 mm (3/16”) (1 per package)</td>
</tr>
<tr>
<td>CK-2115A</td>
<td>1 set</td>
<td>Alignment Guide Set (2 per set)</td>
</tr>
<tr>
<td>CK-2120</td>
<td>—</td>
<td>Alignment Guide Shoe and Screw Set</td>
</tr>
<tr>
<td>CK-2135A</td>
<td>1 set</td>
<td>Alignment Guide Set (2 per set)</td>
</tr>
<tr>
<td>CK-2140</td>
<td>—</td>
<td>Alignment Guide Shoe and Screw Set</td>
</tr>
<tr>
<td>CK-2125A</td>
<td>4</td>
<td>Clamp (1 per package)</td>
</tr>
<tr>
<td>CK-2075</td>
<td>1 set</td>
<td>Guide Shim Set, consisting of:</td>
</tr>
<tr>
<td>CK-2071</td>
<td>8 ea.</td>
<td>Guide Shim #1</td>
</tr>
<tr>
<td>CK-2072</td>
<td>8 ea.</td>
<td>Guide Shim #2</td>
</tr>
<tr>
<td>CK-2073</td>
<td>8 ea.</td>
<td>Guide Shim #3</td>
</tr>
<tr>
<td>CK-2074</td>
<td>4 ea.</td>
<td>Guide Shim #7</td>
</tr>
<tr>
<td>CK-2076</td>
<td>4 ea.</td>
<td>Guide Shim #11</td>
</tr>
<tr>
<td>CK-2077</td>
<td>4 ea.</td>
<td>Guide Shim #15</td>
</tr>
<tr>
<td>CK-3105A</td>
<td>1</td>
<td>Shim Rack</td>
</tr>
<tr>
<td>CK-2035A-LF4X</td>
<td>61-66 mm (2.4”-2.6”)</td>
<td></td>
</tr>
<tr>
<td>CK-2045A-LF4X</td>
<td>66-76,2 mm (2.6”-3.0”)</td>
<td></td>
</tr>
</tbody>
</table>

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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 pages 48 - 53).

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Repair Parts for CV-2400 Midget Hone Head

<table>
<thead>
<tr>
<th>Part Number</th>
<th>Qty per Machine</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>CV-2405A</td>
<td>1</td>
<td>Midget Head and Tube Assembly</td>
</tr>
<tr>
<td>CV-24020A</td>
<td>1</td>
<td>Drive Tube-Lower Half includes</td>
</tr>
<tr>
<td>CK-2033A*</td>
<td>1</td>
<td>Universal Ring with Four Screws</td>
</tr>
<tr>
<td>CK-2423A</td>
<td>2</td>
<td>Screws (5/16-24x3/16”) Socket Head</td>
</tr>
<tr>
<td>PHS-699A</td>
<td>2</td>
<td>Screws (5/16-24x3/8”) Socket Head (Not Shown)</td>
</tr>
<tr>
<td>CV-2450A</td>
<td>1</td>
<td>Lower Feed Rod &amp; “U” Joint Assembly with</td>
</tr>
<tr>
<td>PBR-26A</td>
<td>1</td>
<td>Thrust Bearing (Neiman FT-015)</td>
</tr>
<tr>
<td>CK-2010C</td>
<td>1</td>
<td>Midget Hone Head Assembly with</td>
</tr>
<tr>
<td>CK-2015A</td>
<td>1</td>
<td>Wedge Assembly (Not Shown)</td>
</tr>
<tr>
<td>CK-2020A</td>
<td>1</td>
<td>Push Pin Set (4 Pins)</td>
</tr>
</tbody>
</table>

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*Not recommended to be purchased separately.