

# Single Stroke Honing®

## Tooling Selection

### Tool Dimensions

The Sunnen Single Stroke Honing® Tools are recommended for use in selected materials, where speed and accuracy are important. To aid in adapting your machine(s) for use of the Sunnen Single Stroke® Honing Tool, the following Tool Dimensions Table is provided. Mandrel dimensions may be altered using common metal cutting tools.

Letters across the top of the table refer to the Lettered Dimensions on Figures A & B.

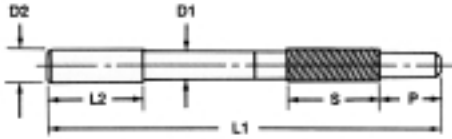


Figure A

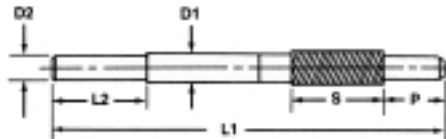


Figure B

**NOTE:** For bore diameter sizes below 5,92 mm (.233") and above 52,20 mm (2.055"), or for special designed high production tools, consult your Sunnen Field Engineer

### Single Stroke Honing® Tool Dimensions

Diameter Range† of Tool		Series No.	Fig.	L1		L2		D1		D2		S		P	
mm	in			mm	in	mm	in	mm	in	mm	in	mm	in	mm	in
05,92-06,68	0.233-0.263	A8A	A	230,17	09.062	34,93	1.375	05,79	0.228	07,54	0.2970	047,63	1.875	29,13	1.147
06,68-07,57	0.263-0.298	A8B	A	230,17	09.062	34,93	1.375	06,55	0.258	07,54	0.2970	047,63	1.875	29,13	1.147
07,57-08,46	0.298-0.333	A10A	A	230,17	09.062	34,93	1.375	07,44	0.293	07,54	0.2970	047,63	1.875	29,13	1.147
08,46-09,35	0.333-0.368	A10B	B	230,17	09.062	34,93	1.375	08,33	0.328	07,54	0.2970	047,63	1.875	29,13	1.147
09,35-09,88	0.368-0.389	A12A	A	304,44	11.986	54,76	2.156	09,25	0.364	09,36	0.3685	057,15	2.250	25,25	0.994
09,88-10,39	0.389-0.409	A12B	B	304,44	11.986	54,76	2.156	09,78	0.385	09,36	0.3685	057,15	2.250	25,25	0.994
10,39-10,90	0.409-0.429	A12C	B	304,44	11.986	54,76	2.156	10,29	0.405	09,36	0.3685	057,15	2.250	25,25	0.994
10,90-11,53	0.429-0.454	A14A	A	337,14	13.273	54,76	2.156	10,79	0.425	10,93	0.4305	066,68	2.625	29,41	1.158
11,53-11,99	0.454-0.472	A14B	B	337,14	13.273	54,76	2.156	11,43	0.450	10,93	0.4305	066,68	2.625	29,41	1.158
11,99-12,47	0.472-0.491	A14C	B	337,14	13.273	54,76	2.156	11,88	0.468	10,93	0.4305	066,68	2.625	29,41	1.158
12,47-13,18	0.491-0.519	A16A	A	362,97	14.187	54,76	2.156	12,36	0.487	12,53	0.4935	076,20	3.000	33,27	1.310
13,18-14,05	0.519-0.553	A16B	B	362,97	14.187	54,76	2.156	13,08	0.515	12,53	0.4935	076,20	3.000	33,27	1.310
14,05-14,78	0.553-0.582	A18A	A	399,69	15.736	54,76	2.156	13,92	0.548	14,08	0.5545	085,73	3.375	36,45	1.435
14,78-15,57	0.582-0.613	A18B	B	399,69	15.736	54,76	2.156	14,66	0.577	14,08	0.5545	085,73	3.375	36,45	1.435
15,57-16,48	0.613-0.649	A20A	A	431,67	16.995	54,76	2.156	15,47	0.609	15,68	0.6175	095,25	3.750	39,90	1.571
16,48-17,17	0.649-0.676	A20B	B	431,67	16.995	54,76	2.156	16,38	0.645	15,68	0.6175	095,25	3.750	39,90	1.571
17,17-18,31	0.676-0.721	A22A	A	463,40	18.244	54,76	2.156	17,04	0.671	17,26	0.6795	104,78	4.125	43,08	1.696
18,31-18,82	0.721-0.741	A24A	A	500,23	19.694	54,76	2.156	18,14	0.714	18,78	0.7395	114,30	4.500	49,83	1.962
18,82-19,76	0.741-0.778	A24B	A	500,23	19.694	54,76	2.156	18,64	0.734	18,78	0.7395	114,30	4.500	49,83	1.962
19,76-20,29	0.778-0.799	A24C	B	500,23	19.694	54,76	2.156	19,58	0.771	18,78	0.7395	114,30	4.500	49,83	1.962
20,29-21,31	0.799-0.839	A26A	A	531,98	20.944	54,76	2.156	20,14	0.793	20,38	0.8025	123,83	4.875	53,01	2.087
21,31-21,79	0.839-0.858	A26B	B	531,98	20.944	54,76	2.156	21,16	0.833	20,38	0.8025	123,83	4.875	53,01	2.087
21,79-23,42	0.858-0.922	A28A	A	560,55	22.069	54,76	2.156	21,64	0.852	21,96	0.8645	133,35	5.250	54,61	2.150
23,42-24,92	0.922-0.981	A30A	A	593,52	23.367	54,76	2.156	23,27	0.916	23,53	0.9265	142,88	5.625	59,06	2.325
24,92-26,39	0.981-1.039	A32A	A	625,25	24.616	54,76	2.156	24,77	0.975	25,11	0.9885	152,40	6.000	62,23	2.450
26,39-27,91	1.039-1.099	LH9X-_-1062	B	*	*	57,15	2.250	26,24	1.033	25,10	0.9885	152,40	6.000	62,23	2.450
27,91-29,67	1.099-1.168	LH9X-_-1125	B	*	*	57,15	2.250	27,76	1.093	25,10	0.9885	152,40	6.000	63,83	2.513
29,62-31,14	1.166-1.226	LH9X-_-1188	B	*	*	57,15	2.250	29,46	1.160	25,10	0.9885	152,40	6.000	63,83	2.513
31,14-32,66	1.226-1.286	LH9X-_-1250	B	*	*	57,15	2.250	30,99	1.220	25,10	0.9885	152,40	6.000	63,83	2.513
32,66-34,47	1.286-1.357	LH9X-_-1312	B	*	*	57,15	2.250	32,51	1.280	31,37	1.2350	152,40	6.000	65,41	2.575
34,47-35,89	1.357-1.413	LH9X-_-1375	B	*	*	57,15	2.250	34,32	1.351	31,37	1.2350	152,40	6.000	65,41	2.575
35,89-37,64	1.413-1.482	LH9X-_-1438	B	*	*	57,15	2.250	35,74	1.407	31,37	1.2350	152,40	6.000	65,41	2.575
37,62-39,14	1.481-1.541	LH9X-_-1500	B	*	*	57,15	2.250	37,47	1.475	31,37	1.2350	152,40	6.000	65,41	2.575
39,14-40,67	1.541-1.601	LH9X-_-1562	B	*	*	57,15	2.250	38,99	1.535	31,37	1.2350	152,40	6.000	65,41	2.575
40,67-42,19	1.601-1.661	LH9X-_-1625	B	*	*	57,15	2.250	40,51	1.595	31,37	1.2350	152,40	6.000	65,41	2.575
42,19-43,99	1.661-1.732	LH9X-_-1688	B	*	*	57,15	2.250	42,04	1.655	31,37	1.2350	152,40	6.000	65,41	2.575
43,99-45,49	1.732-1.791	LH9X-_-1750	B	*	*	57,15	2.250	43,84	1.726	31,37	1.2350	152,40	6.000	65,41	2.575
45,49-47,02	1.791-1.851	LH9X-_-1812	B	*	*	57,15	2.250	45,34	1.785	31,37	1.2350	152,40	6.000	65,41	2.575
47,02-48,54	1.851-1.911	LH9X-_-1875	B	*	*	57,15	2.250	46,86	1.845	31,37	1.2350	152,40	6.000	65,41	2.575
48,54-50,37	1.911-1.983	LH9X-_-1938	B	*	*	57,15	2.250	48,39	1.905	31,37	1.2350	152,40	6.000	67,44	2.655
50,37-52,20	1.983-2.055	LH9X-_-2000	B	*	*	57,15	2.250	50,22	1.977	31,37	1.2350	152,40	6.000	67,44	2.655

†Diameter range refers to a group (Series No.) of tools having a common mandrel.

\*Refers to pages 106 and 107 for overall length dimensions of LH9X Single Stroke Tools.