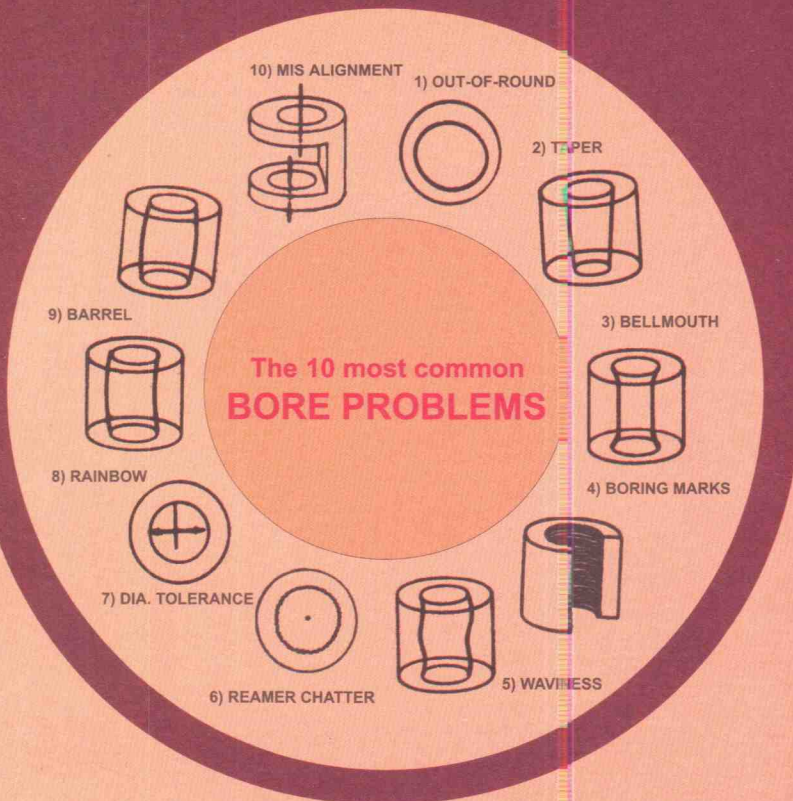


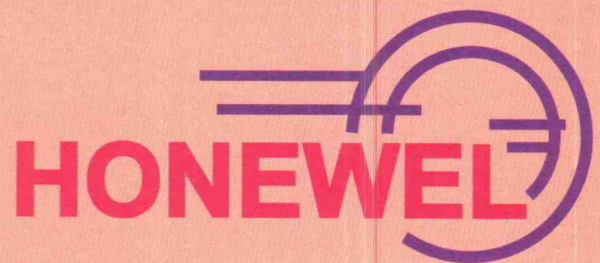
TODAY'S TOLERANCES AND FINISHES CALL FOR HONING



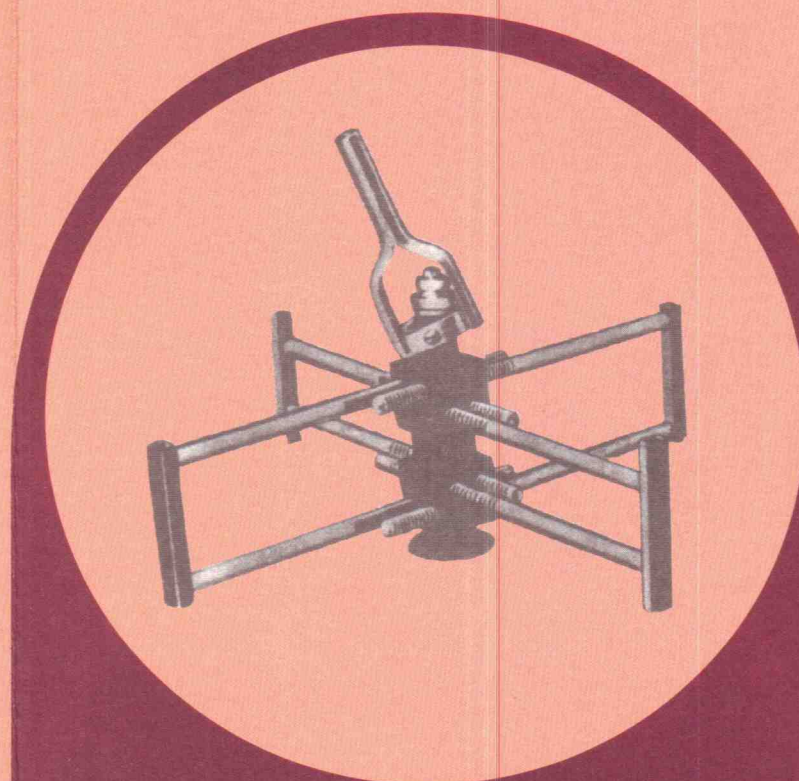
WHAT IS HONING?

Honing differs from grinding in that honing stones have a relatively large area of abrasive in contact with the work at relatively slow speeds and low pressure. Surface temperature is low and there is no surface damage. Grinding, on the other hand, has a relatively high pressure and a line contact between abrasive and bore, and runs at high speeds. Extremely high localized surface temperature is developed and the surface structure of the bore may be permanently damaged. Honing produces greater accuracy and a finer surface finish than grinding, and provides a stress free base metal surface in the bore.

Honewell honing combines the speed of grinding with the accuracy of lapping. Stock is removed first from any high spots in the bore while low areas are bridged by the honing stone until all "peaks" are levelled off. Surface finishes are accurately controlled by the size of the grains used in the stone.



HONING HEAD



HONEWELL HONING

- Produces stress free bores to any required tolerance.
- Guarantees geometrically true round and straight bores.
- Generates base-metal surfaces free from torn particles and smear metal.
- Guarantees closely controlled surface finishes to any desired RMS or AA reading.
- Is five to ten times faster than lapping on ultra-precision work.
- Outproduces internal grinding on many jobs.
- Handles open and blind hole work.
- Saves money by holding rejects and scrap parts to a minimum.
- Eliminates selective fitting of parts.
- Corrects distortion resulting from chucking, heat-treating, and assembly.
- Does not require extensive set-ups, jigs or fixturing.
- Eliminates investments in special reamers.

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