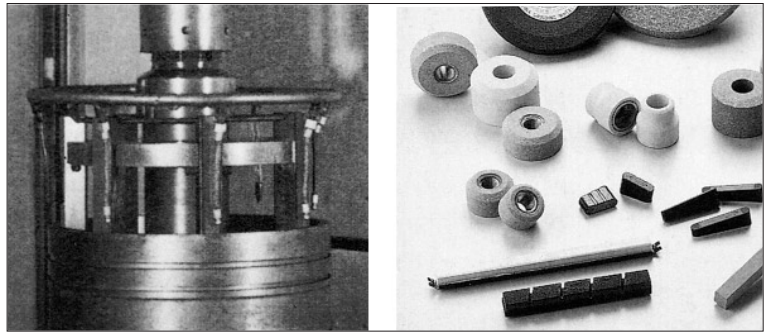


Honing Stones are applied where precise. dimensional limits and grade controls are required. They are used for manual or mechanical honing on machines where they are mounted in holders or fixtures. Honing operations are found in the auto-motive, bearing, auto accessory, pipe, and oil drilling equipment businesses.

In general, vitrified are recommended but resinoid honing stones can be used for plateau honing.

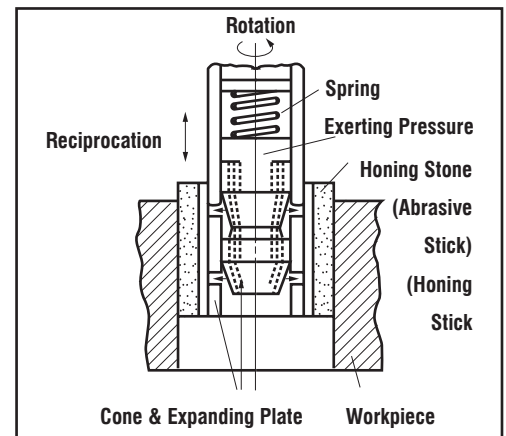
Sulphur impregnation of honing stones, especially when used for honing steels, will frequently improve both the cutting rate and durability.



Designation of KINIK Honing Stones (Example)

70-2	150 x 13 x 13	WA	120	K	8	V	S
Shape No. of Honing Stones	Size (L x W x T)	Abrasive	Grain Size	Grade ...I.J.K. ← N.O.P... (Soft ↔ Hard)	Structure 5.6.7.....10.11.12. (Soft ↔ Hard)	Bond	Impregnation S.B.X. etc

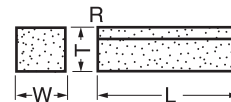
Note: 1. Sometime the grade of honing stone is marked by 1. 2. 3. ... 7. 8. 9.
2. The structure of honing stones is often omitted in marking.



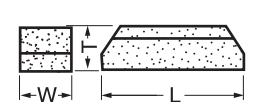
Recommendations: Vitrified Honing Stones

Thickness to be ground off (mm)	0.005~0.025				0.025~0.05			0.05~0.125			Over 0.125		
	2	4	8	5	10	20	10	20	30	15	25	40	
Surface finish (r.m.s.)	2	4	8	5	10	20	10	20	30	15	25	40	
Cast Iron	HRC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
	50~70	500J	500I	400J	400K	280L	120M	280K	180L	80L	120M	120L	
	HRC	-	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
35~50	-	500J	400K	400L	320M	120N	320L	180M	80M	120N	120M	80N	
HRC	-	-	GC	GC	GC	GC	GC	GC	GC	GC	GC	GC	
15~35	-	-	400L	400M	320N	120N	320M	220M	80N	150N	150N	800	
Steel	HRC	WA	WA	WA	WA	WA	WA	WA	WA	WA	WA	WA	
	50~70	500J	400J	320K	320J	280K	120L	320K	280L	120M	280L	150L	80M
	HRC	WA	WA	WA	WA	WA	WA	WA	WA	WA	WA	WA	
	35~50	500K	400K	320L	320K	240L	120M	320L	240M	120N	240M	120M	80N
HRC	WA	WA	WA	WA	WA	WA	WA	WA	WA	WA	WA	WA	
15~35	500L	400L	320M	320L	220M	120N	320M	220N	1200	220N	120N	100N	

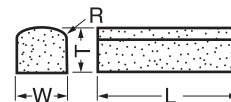
Shape: 70



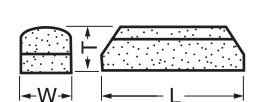
Shape: 70-3



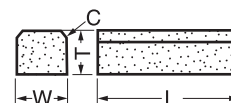
Shape: 70-1



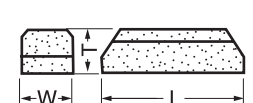
Shape: 70-4



Shape: 70-2



Shape: 70-5



Shape: 71 Mounted with FH Holder

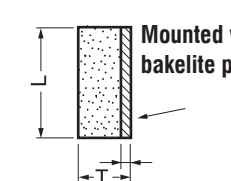


Standard Sizes (L x W x T)

Standard Sizes (L x W x T)	
20 x 2.0 x 1.5mm	3/4" x 5/64" x 1/16"
32 x 1.2 x 1.5	1-1/4" x 3/64" x 1/16"
33 x 2.3 x 2.0	1-5/16" x 3/32" x 5/64"
45 x 3.5 x 2.5	1-3/4" x 9/64" x 3/32"
56 x 4.0 x 3.0	2-1/4" x 5/32" x 1/8"
68 x 6.0 x 8.0	2-11/16" x 1/4" x 5/16"
75 x 8.0 x 10	3" x 5/64" x 3/8"
86 x 4.5 x 3	3-3/8" x 3/16" x 1/8"

Standard Sizes (L x W x T)	
100 x 10 x 10mm	4" x 3/8" x 3/8"
100 x 11 x 13	4" x 13/32" x 1/2"
100 x 13 x 13	4" x 1/2" x 1/2"
150 x 13 x 13	6" x 1/2" x 1/2"
150 x 16 x 16	6" x 5/8" x 5/8"
200 x 13 x 13	8" x 3/4" x 3/4"
200 x 20 x 20	8" x 1/2" x 1/2"

Shape: 72



Shape: 73

