

HONING HEADS FOR HIGH PRODUCTION HONING MACHINES

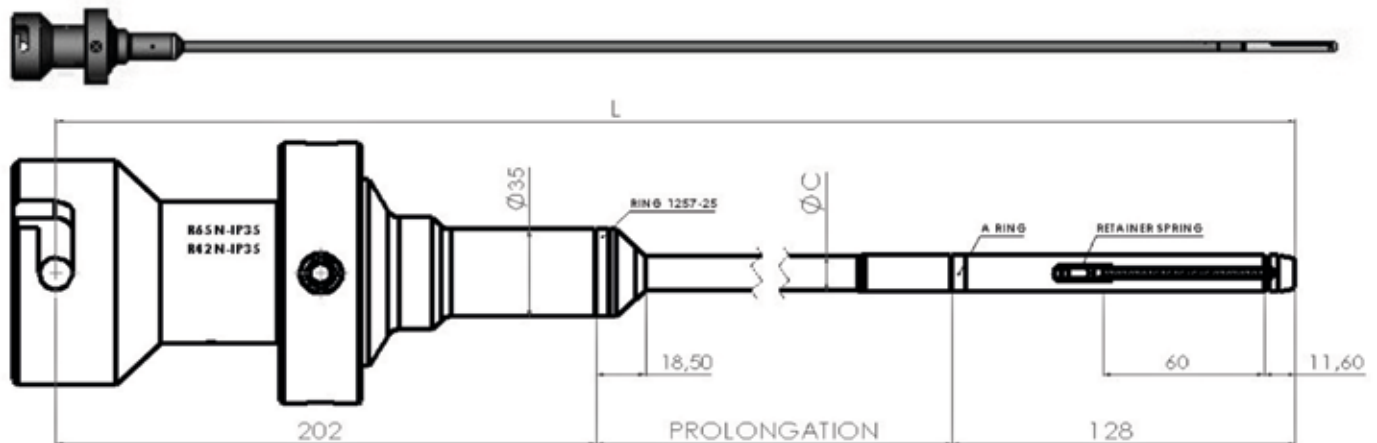
EXPANSION BY ROTATION OF INTERNAL AXIS



FOR VERTICAL AND HORIZONTAL HONING MACHINES
DIAMETER RANGE FROM 15,2 TO 155 mm

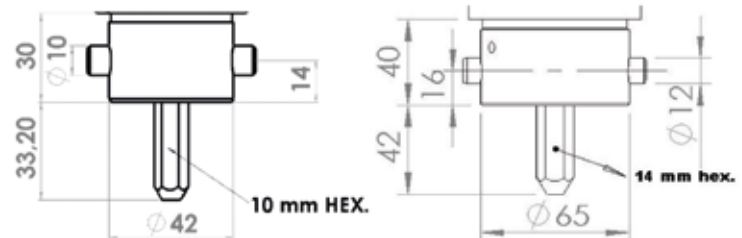
toningtec

A SERIES : 15,2 ÷ 26 DIAMETER RANGE



RETAINER SPRING

MACHINE REQUIREMENTS



This "A" mandrel series for small diameters, are supplied all together (machine couplement, honing bar and mandrel). We need a complete set for each diameter range.

Only there is one universal joint due to the elasticity of the honing bar.

See catalogue 18 to have more detailed information about prolongations and couplers

Ø RANGE	REFERENCE ²	L max.	L min.	C	B	STONE-HOLDERS Qty. per mandrel	ABRASIVE DIMENSIONS ⁶
15,2 ÷ 17	R65/152/L ¹	2000	1200	14	202	3	60x3x2,5/1,5
16,5 ÷ 18,3	R65/165/L ¹	2500	1400	16	202	3	60x3x2,5/1,5
18,3 ÷ 20	R65/183/L ¹	2500	1600	18	202	4	60x3x2,5/1,5
20 ÷ 22	R65/200/L ¹	2500	1600	18	202	4	60x3x2,5/1,5
22 ÷ 24	R65/220/L ¹	2800	1600	20	202	4	60x3x2,5/1,5
24 ÷ 26	R65/240/L ¹	3000	1800	22	202	4	60x3x2,5/1,5

SPARE PARTS⁵

Machine coupler: R65N-IP35 or R42N-IP35

Ø RANGE	ASSEMBLY REFERENCE	HONING HEAD ³	STONE-HOLDERS (unit)	" A " RING ⁴	RETAINER SPRING	O - RING	PROLONGATION ASSEMBLY
15,2 ÷ 17	1357-115-**-00	1331-00	1331-03	1331-02	1285-05	ID12 x 2	1276-97-**-00
16,5 ÷ 18,3	1357-**-00	1330-00	1330-03	1330-02	1285-05	ID13 x 2	1329-07-**-00
18,3 ÷ 20	1357-190-**-00	1407-00	1285-8-04	1276-24	1285-05	ID14 x 2	1353-07-**-00
20 ÷ 22	1357-130-**-00	1285-00	1285-08-01	1276-24	1285-05	ID15 x 2	1353-07-**-00
22 ÷ 24	1357-131-**-00	1286-00	1285-08-02	1286-02	1285-05	ID17 x 2	1612-**-00
24 ÷ 26	1357-132-**-00	1287-00	1285-08-03	1276-14	1285-05	ID19 x 2	1613-**-00

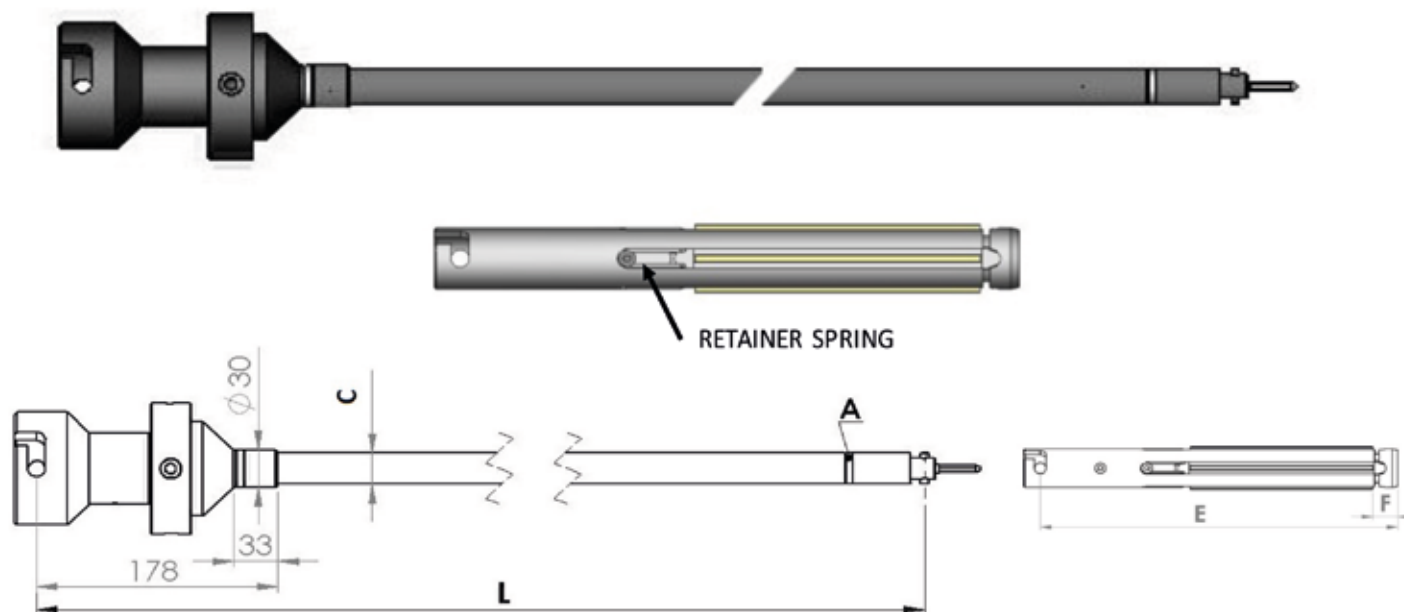
1. Total length "L" must to be specified between "L max." and "L min."
2. Stone holders included in the reference. Abrasive, welding and dressing not included in the reference.
3. Without stoneholders
4. Union ring must to be changed if it is damaged and anytime that the honing head is disassembled
5. Basic spare parts. Contact for other spare parts references mentioning the assembly reference.
6. See pages 5 / 6 for abrasive quality and references.

B SERIES : 26 ÷ 40 DIAMETER RANGE



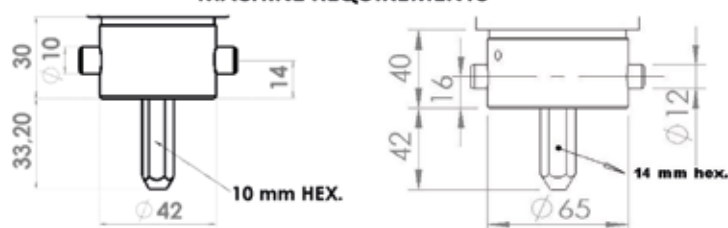
In this "B" mandrel series the mandrel and the honing bar are two different pieces .

Only there is one universal joint due to the elasticity of the honing bar. See catalogue 18 for more information about couplers and prolongations



Ø RANGE	HONING BAR REFERENCE ¹	L max.	L min.	C	"A" RING ⁴
26 ÷ 32,5	R65/25/25-17F/L ¹ 1357-140-**-00	3500	1800	25	1313-12
31 ÷ 40	R65/30/30-24F/L ¹ 1276-30-**-00	3500	1800	30	1276-10

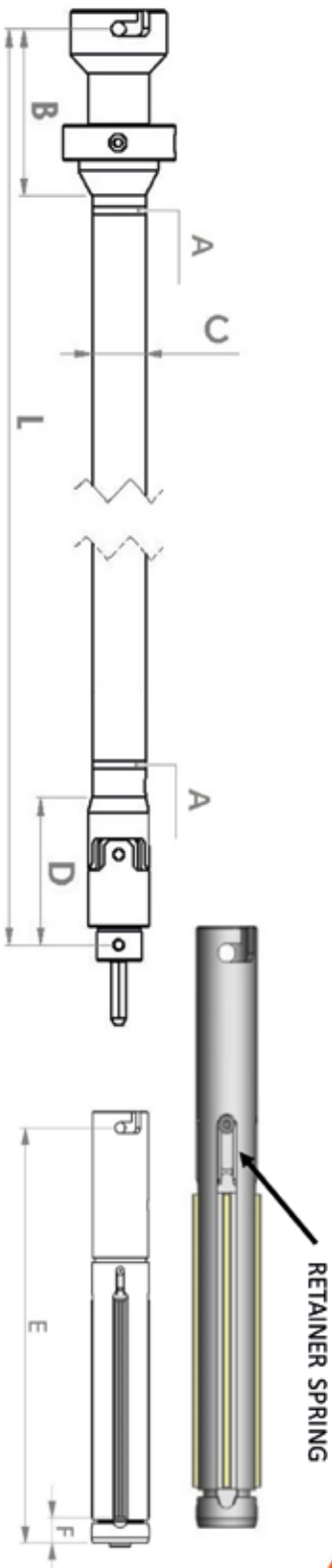
MACHINE REQUIREMENTS



Ø RANGE	HONING HEAD ²	E	F	RETAINER SPRING	O - RING	STONEHOLDERS RANGE	STONE-HOLDERS ³	STONEHOLDERS Qty. per mandrel	ABRASIVE DIMENSIONS ⁵
26 ÷ 32,5	1313-00	196	14	1283-16	ID17 x 2	26 ÷ 30	1313-04	4	100x3x3/2
						28,5 ÷ 32,5	1313-13	4	
31 ÷ 40	1314-00	251	16	1283-16	ID21 x 2	31 ÷ 34	1314-04	4	150x5x5/3
						33 ÷ 36	1314-14	4	
						35 ÷ 38	1314-12	4	
						37 ÷ 40	1314-02	4	

1. Total length "L" must be specified between "L max." and "L min."
2. Stone holders not included in the mandrel reference.
3. Abrasive it is not included in the stoneholders reference
4. "A" Union ring must be changed if it is damaged and anytime that the honing head is disassembled
5. See page 5/6 for abrasive quality and references.

C SERIES : 35 ÷ 155 DIAMETER RANGE



Ø RANGE	HONING BAR REFERENCE ¹	B	C	D	"A" RING ⁴	HONING HEAD ²	E	F	RETAINER SPRING	O - RING	STONEHOLDERS RANGE	STONE-HOLDERS ³	STONEHOLDERS Qty. per mandrel	ABRASIVE DIMENSIONS ⁵
35 ÷ 44	R65/32/24/L 1357-150-**-00	144	32	**	1279-12	1315-00	268	16	1278-17	ID 28 x 2	35 ÷ 39 37 ÷ 41 40 ÷ 44	1315-01 1315-12 1315-02	4	X type See page 5
43 ÷ 52	R65/35/28/L 1377-155-**-00	144	35	106	1257-25	1373-00	278	16	1278-17	ID 28 x 2	43 ÷ 48 45 ÷ 50 47 ÷ 52	1315-04 1315-03 1315-14	4	X type See page 5
46 ÷ 67	R65/40/35/L 1419-10-**-00	146	40	110	1263-11	1316-00	350,5	17,5	1278-17	ID 36 x 2,5	49 ÷ 57 56 ÷ 64 59 ÷ 67	1316-03 1316-04 1316-02	4	Y type See page 5
62 ÷ 86	R65/50/42/L 1419-20-**-00	145	50	128	1263-52	1317-00	383	23,5	1278-17	ID 44 x 2,5	62 ÷ 74 74 ÷ 86	1317-04 1317-02	4	Y type See page 5
74 ÷ 105		145	50	128	1263-52	1318-00	385	23,5	-----	ID 56 x 2,5	74 ÷ 85 83 ÷ 95 93 ÷ 105	1318-12 1318-13 1318-04	4	Y type See page 5
100 ÷ 155	R65/90/65/L	145	90	145	1506-03	1351-00	398	23,5	-----	ID 66 x 3	100 ÷ 107,6 107,6 ÷ 115,2 115,2 ÷ 122,8 122,6 ÷ 130,2 100 ÷ 119 116 ÷ 136 135 ÷ 155	1351-08 1351-09 1351-10 1351-11 1351-07 1351-04 1351-12	6	200 x 13 x 13 Y type See page 5

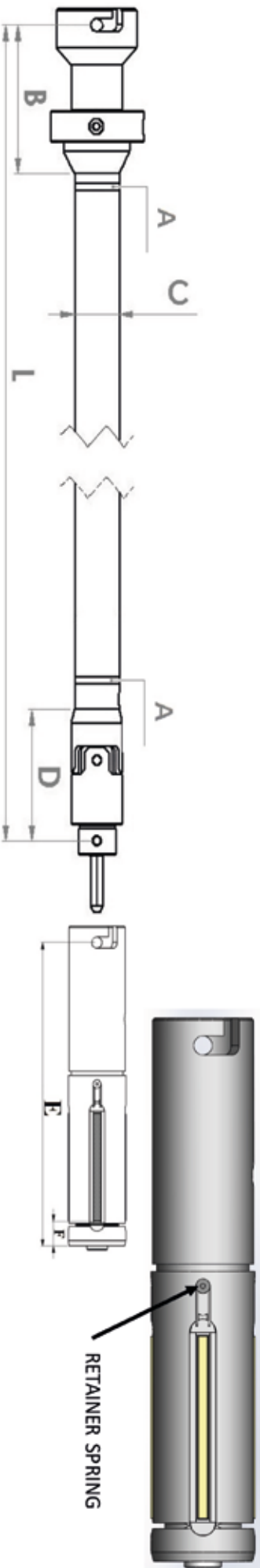
MACHINE REQUIREMENTS

1. Length must be specified for the correct reference
2. Stone holders not included in the reference.
3. Abrasive it is not included in the stoneholders reference
4. Union ring must be changed if it is damaged and anytime that the honing head is disassembled
5. See page 5 / 6 for abrasive quality and references.

** The "D" length has the same diameter of the honing bar. ("C" diameter)

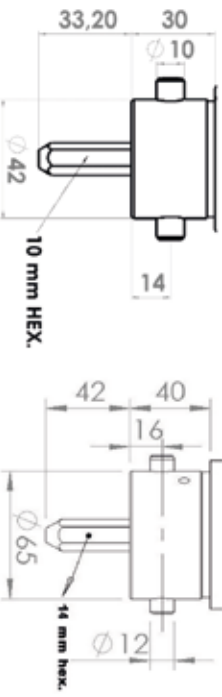


D SERIES : 35 ÷ 155 DIAMETER RANGE (SHORT MANDRELS)



Ø RANGE	HONING BAR REFERENCE ¹	B	C	D	"A" RING ⁴	HONING HEAD ²	E	F	RETAINER SPRING	O - RING	STONEHOLDERS RANGE	STONE-HOLDERS ³	STONEHOLDERS Qty. per mandrel	ABRASIVE DIMENSIONS ⁵
35 ÷ 44	R65/32/24/L 1357-150-**-00	144	32	**	1279-12	1348-00	219	14	1278-17	ID 28 x 2	35 ÷ 39	1348-04	4	
											37 ÷ 41			
43 ÷ 52	R65/35/28/L 1377-155-**-00	144	35	106	1257-25				1278-17	ID 28 x 2	40 ÷ 44		4	
											43 ÷ 48			
47 ÷ 67	R65/40/35/L 1419-10-**-00	146	40	110	1263-11				1278-17	ID 36 x 2,5	45 ÷ 50		4	
											47 ÷ 52			
58 ÷ 84	R65/50/42/L 1419-20-**-00	145	50	128	1263-52	1328-00	283	21	1278-17	ID 44 x 2,5	49 ÷ 57		4	
											56 ÷ 64			
69 ÷ 104		145	50	128	1263-52	1328-00	285	21,5	ID 56 x 2,5	58 ÷ 72		4	
											59 ÷ 67			
100 ÷ 155	R65/90/65/L	145	90	145	1506-03				ID 66 x 3	1327-04		6	
											116 ÷ 136			
											135 ÷ 155			

MACHINE REQUIREMENTS



1. Length must be specified for the correct reference
2. Stone holders not included in the reference.
3. Abrasive it is not included in the stoneholders reference
4. "A" Union ring must be changed if it is damaged and anytime that the honing head is disassembled
5. See page 5 / 6 for abrasive quality and references.

** The "D" length has the same diameter of the honing bar. ("C" diameter)

All the superabrasives references must to specify the physical dimensions and the abrasive reference.

PHYSICAL DIMENSIONS

For not mounted abrasives L x A x T/X:



Not mounted abrasives goes directly tin welded or glued on the stone-holders

L x A x T dimensions are specified in the honing head chart

For composed abrasives :



NORMAL SERIES

REFERENCE	LENGTH L	EXISTING PROFILES	REFERENCE	LENGTH L	EXISTING PROFILES
X1	150		Y1	200	
X2			Y2		
X3			Y3		
X4			Y4		

SHORT SERIES

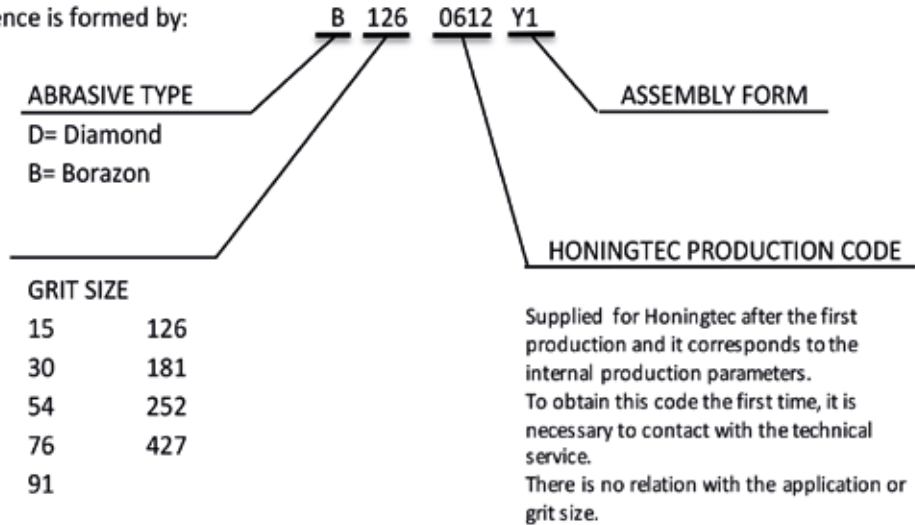
REFERENCE	LENGTH L	EXISTING PROFILES
Z1	100	
Z2		
Z3		
Z4		

For abrasive quality see page 7



ABRASIVE REFERENCE

The abrasive reference is formed by:



The roughness chart, only it is approximate.

The quality of honing oil has significant importance. We recommend the use of HONINGTEC honing oils.

For more details, contact with technical service.

Ra (µm) CHART

MATERIAL	GRIT SIZE									Recommended abrasive type
	427	252	181	126	91	76	54	30	15	
Bimetallic pipes (without WC)	2,4	1,8	1,2	1	0,7	0,5	0,4			Borazon
Bimetallic pipes (with WC)		1,7	1,1	0,9	0,65	0,5	0,4			Diamond
Cast Iron		2,8	2,3	1,5	1,1	0,8	0,5	0,25	0,12	Diamond
Hard steel > 45HRC		2,3	2	1,1	0,9	0,9	0,55	0,2	0,08	Borazon
Soft steel < 45 HRC		2,5	2,3	1,3	1,1	1,1	0,65	0,25	0,10	Borazon
Aluminium, Brass, Bronze			2,5	1,4	1,1	1,1	0,6	0,25	0,14	Diamond



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