

VARING Honing Tools specifications



- Depth of cut can be set manually or by hydraulics *
- High accuracy
- Simple construction, long lifespan
- Easy operation
- Diamond honing sticks, suitable for Nikasil plated cylinders
- Also for short stroke engines

Technical data

Type	Working Diameter [mm]	Total height [mm]	Height of abrasives [mm]	Mass [g]
V1	26-32	93	50	450
V2	32-40	113	60	600
V3	38-48	136	75	850
V4	45-58	150	85	1250
V5	55-71	173	100	2000
V6	65-81	178	100	2000
V7	76-94	180	100	2700
V8	88-106	180	100	3000

Recommended allowance and surface finish class after processing

	material	grit of honing sticks						
		400/315	250/200	160/125	100/80	63/50	40/28	20/14
		315/250	200/160	125/100	80/63	50/40	28/20	14/10
allowance [mm]	steel	0,15	0,10	0,08	0,06	0,01	0,001	0,001
	cast iron	0,20	0,15	0,10	0,08	0,03	0,002	0,002
roughness of processed surface [Ra]	steel	5	2,5	2,5-1,32	1,32-0,63	0,63-0,32	0,32-0,16	0,16-0,08
	cast iron	5	5-2,5	2,5	2,5-1,75	1,32-0,63	0,63-0,32	0,32-0,16

■ Recommended abrasive for cylinder boring of engines (depending on the diameter):

- rough: 125/100 or 100/80
- finish: 80/63 or 63/50

Always use lubricant while honing! It might not be accurate enough until the running-in period. Afterwards, 0.005-0.01 mm can be achieved. Do not apply too much tension on the abrasives, it might jam the tool and damage the workpiece! Refer to a technical book of honing for further details. For professional use only!

* If the depth of cut is set by hydraulics then the tool has to be adapted to the specific machine.