

GRIT SELECTION

GRIT	FINISH RANGE
800-LA (2500 MESH)	Ra 3-10 (.05 - .2 Micrometer)
600	Ra 8-12 (.2 - .3 Micrometer)
400 (800 MESH)	Ra 10-20 (.3 - .6 Micrometer)
320	Ra 18-30 (.5 - .7 Micrometer)
240	Ra 24-32 (.6 - .8 Micrometer)
180 (170/200 MESH)	Ra 30-40 (.7 - 1.0 Micrometer)
120	Ra 35-50 (.9 - 1.4 Micrometer)
80	Ra 45-64 (1.2 - 1.6 Micrometer)
60	Ra 60-80 (1.5 - 2 Micrometer)
40	Ra 70-125 (1.7 - 3.2 Micrometer)
20	Ra 125-250 (3.2 - 6.3 Micrometer)

The amount of work to be performed and the degree of surface finish improvement required govern grit selection. Coarse finishes may require progressively finer Flex-Hones to meet final surface finish requirements. In very general terms, final finish will be in the following ranges. This chart is intended to offer a starting point in selecting a grit but the final selection must be verified by actual trial.



ABRASIVE/GRIT OPTIONS

ABRASIVE TYPES	20	40	60	80	120	180	240	320	400	600	800
SC = Silicon Carbide	X	X	X	X	STANDARD			X	X	X	
AO = Aluminum Oxide	X	X	X	X	X	X	X	X	X	X	X
BC = Boron Carbide	X	X	X	X	X	X	X	X	X	X	X
Z Grain - Alumina Zirconia No. 1525 (25% Zirconia/75% Alumina)			X	X	X	X	X				
Z Grain - Alumina Zirconia No. 1549 (40% Zirconia/60% Alumina)					X	X	X				
Diamond	Diamond is available in mesh 170/200, 800 and 2500										
Levigated Alumina	Available in extra fine grit only										
CBN	Available in mesh 170/200, 800, 2500										
Ceramic	Available on special order										

SUGGESTED RPM

The Flex-Hone Tool is a low RPM tool. Specific RPM is dependent on the diameter of the tool and the application. General speed ranges are given but, again, machine trials are required to verify the parameters.

The smaller the hone, the faster the speed.
The larger the hone, the slower the speed.

HONE DIA.	RPM
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19" to 36"	60 - 120 RPM
12" to 18"	125 - 200 RPM
8" to 11"	225 - 300 RPM
4" to 7 1/2"	350 - 600 RPM
2" to 3 3/4"	600 - 900 RPM
1/2" to 2"	900 - 1,000 RPM
4mm to 1/2"	1,000 - 1,200 RPM

