

Cylinder Flex Hone Tool Instructions

The flex-hone tool should be rotating upon entry and removal from cylinder. RPM from 1200 to 60 depending on diameter stroke from 30 to 200 per minute depending upon RPM average 350-500 RPM at 60-120 strokes. Final stroking may be accelerated to develop 45 degree cross hatch. OEM high production needs experimentation with different mineral or water soluble honing oils for optimum results. For convenience use a 10-30 wt. Motor oil or our Flex Hone oil. Wash cylinders, preferably with water, brush and detergent, they dry and oil. Experiment honing time from 10-45 seconds just sufficient to develop Plateaued finish free from cut, torn and folded metal. Do not over hone.