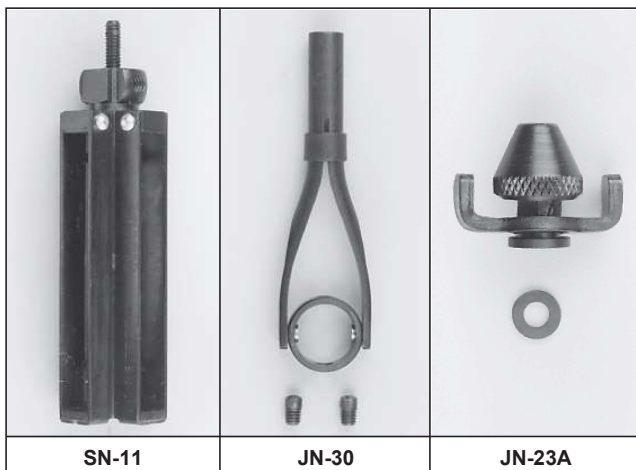


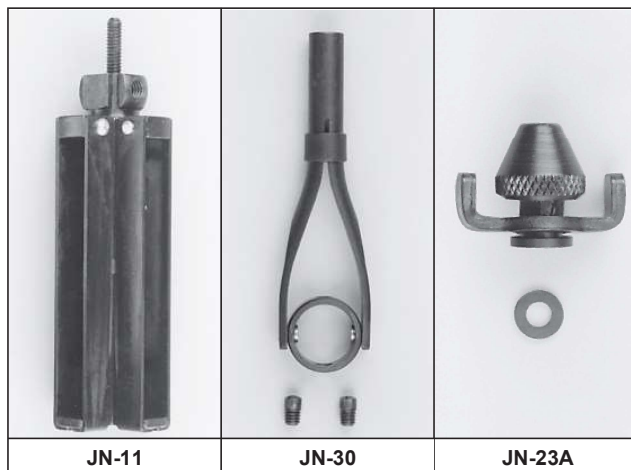
Portable Hones & Repair Parts

SN-75 Portable Hone



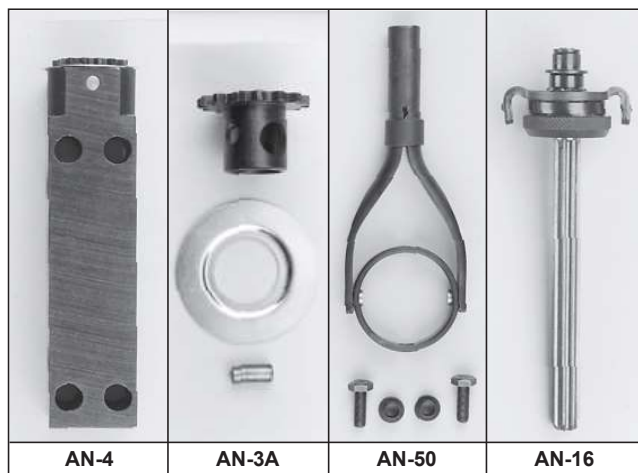
SN-11 Hone Body
JN-30 Universal Joint Complete
JN-23A Adjusting Nut and Washer

JN-95 Portable Hone



JN-11 Hone Body
JN-30 Universal Joint Complete
JN-23A Adjusting Nut and Washer

AN-112 Portable Hones



AN-4 Hone Body
AN-3A Body Gear
AN-50 Universal Joint Complete
AN-16 Center Pinion Adjustment

AN-815 Portable Hone



AN-604 Hone Body
AN-3A Body Gear Set
AN-650 Universal Joint Complete
AN-16 Center Pinion Adjustment

AN-815 Portable Hone

Hand Feed For Occasional Heavy-Duty Portable Honing

I.D. Range:

64 mm – 533 mm

2.5"–21"

AN-815 Portable Hone (includes 152 mm (6") Drive Shank, 610 mm (24") Shaft Extension, Universal Joint and Hone Head) shown assembled with single length master holder set and stone set. Requires 16 mm (5/8") chuck capacity for 63,5-127 mm (2.5"-5") diameter. Requires 19 mm (3/4") chuck capacity for 127-381 mm (5"-15") diameter. Requires 25,4 mm (1") chuck capacity for larger than 381 mm (15") diameter. See page 6 for repair parts.



Order 1-5 For Complete AN-815 Portable Hone

Diameter Range 64 mm - 533 mm 2.5" -21"				1 Basic Hone	2 Master Holder Sets	3 Stone Support	4 Stone Set	5 Shaft Extension
General Purpose Stone		Guideless and Keyway			Single Length	Double Length		
mm	in	mm	in					
64-140	2.5-5.5	64-142	2.5-5.6	AN-815	None	None	None	See tables on pages 13 - 14 for portable hone stone sets.
104-160	4.1-6.3	114-165	4.5-6.5	AN-815	AN-345	None	None	
119-178	4.7-7.0	130-183	5.1-7.2	AN-815	AN-355	AN-855	None	
152-229	6.0-9.0	163-234	6.4-9.2	AN-815	AN-365	AN-865	AN-260	
206-305	8.1-12.0	213-310**	8.4-12.2**	AN-815	AN-375	AN-875	AN-280	
279-381	11.0-15.0	284-386**	11.2-15.2**	AN-815	AN-385	AN-885	AN-290	
356-457	14.0-18.0	363-465**	14.3-18.3**	AN-815*	AN-395	AN-895	AN-340	
432-533	17.0-21.0	437-538**	17.2-21.2**	AN-815*	AN-415	AN-915	AN-450	

* For light work only in this diameter range.

** Do not use WW (Guideless) Stone Sets in this range due to lack of stability.

Accessories

AN-670

Universal Joint



Order an additional Universal Joint when using the AN-815 in a drill press or other rigid stroking device.

Drive Shanks



mm	in	Part Number
76	3	AN-608A
152	6	AN-618A†

† Supplied with hone.

Shaft Extensions



mm	in	Part Number
152	6	AN-840
305	12	AN-841†
610	24	AN-842
1220	48	AN-844

Master Holder Sets

Stone



Single Length Master Holder

Stones



Double Length Master Holder

Stone Support



AN-85

Quick Coupler

Provides instant coupling or uncoupling of hone from drive motor.

AN-97 Replacement Yoke Adapter



AN-89A Replacement Coupler Sleeve



Master Holder Sets, listed in the table above, are used with Type W47, WW51 and WY51 Stone Sets. Double Length Master Holders require two stone sets— use when it is necessary to bridge interruptions in the bore. Each Master Holder Set consists of two holders for stones and two holders for guides.

Stone Supports are required to give rigidity to the hone assembly when honing bores larger than 178 mm (7") diameter.

Piloted Portable Hones

Use to hone one bore in line with another bore on the same axis.
Three models cover the diameter range of 44,5-533,4mm (1.75"-21").



AN-815-A40X Piloted Portable Hone
Diameter Range: 63.5mm-533.4mm (2.50"-21")

The SN-75-887X and JN-95-887X Piloted Portable Hones are furnished with a 25,4 mm (1") diameter pilot bar. The AN-815-A40X is furnished with a 38,1 mm (1-1/2") diameter pilot bar. The pilot bar must be long enough so that it will not stroke out of the pilot bushing during the honing operation.
BE SURE TO SPECIFY PILOT LENGTH BAR on your order.

The pilot bushing is made by the user. It must be made to fit the bore before and after honing. The bushing O.D. should be tapered to fit the bore opposite the bore being honed. The bushing I.D. should be .025 mm (.001") larger than the diameter of the pilot on the hone.

The hone is used first in one bore with the pilot bushing positioned in the other bore. When this bore is finished, the pilot bushing is placed in the honed bore and the hone is entered from the other side to finish the second bore. Both outside ends of the tandem bores must be accessible.

SN-75-887X Piloted Portable Hone, 44,5 mm-50,8 mm (1.75"-2.00") diameter range, includes 76,0 mm (3") drive shaft, 304,8 mm (12") shaft extension, and 25,4 mm (1") diameter pilot bar up to 610 mm (24") long (does not include stone sets).

JN-95-887X Piloted Portable Hone, 50,8 mm-60,0 mm (2.00"-2.60") diameter range, includes 76,0 mm (3") drive shaft, 304,8 mm (12") shaft extension, and 25,4 mm (1") diameter pilot bar up to 610 mm (24") long (does not include stone sets).

Extra length 25,4 mm (1") diameter pilot bar for SN-75-887X or JN-95-887X hones will be supplied at an added price per foot or portion thereof, over the 610 mm (24") furnished with the hone.

AN-815-A40X Piloted Portable Hone, 63,5 mm-533,4 mm (2.50"-21.00") diameter range for light duty use in diameters larger than 381 mm (15"), includes 152,4 mm (6") drive shaft, 304,8 mm (12") shaft extension, and 38,1 mm (1.5") diameter pilot bar up to 610 mm (24") long (does not include stone sets, stone supports or master holder sets).

Extra length 38,1 mm (1.5") diameter pilot bar for AN-815-A40X hone will be supplied at an added price per foot or portion thereof, over the 610 mm (24") furnished with the hone.

The SN-75-887X Piloted Portable Hone uses the same S18 stone sets as the SN-75 Portable Hone. The JN-95-887X Piloted Portable Hone uses the same T20, U22 or V24 stone sets as the JN-95 Portable Hone. See page 5 for stone selection. Stone sets, stone supports and master holder sets used with the AN-815-A40X Piloted Portable Hone are found on page 8.

These hones may be driven by a heavy duty electric or air drill, or used in a drill press. To establish optimum rpm for your application, divide 1200 by the hole diameter in inches. Example: $1200 \div 6" = 200$ (RPM). Or, divide 30000 by bore diameter in mm. Example: $30000 \div 150 \text{ mm} = 200$ (RPM).

Hole Size		Recommended Drill Chuck Size	
mm	in	mm	in
44,45-127,0	1.75-5	15,8	5/8
127,0-381,0	5-15	19,0	3/4
381,0 and up	15 and up	25,4	1

A universal joint is built into each of these piloted portable hones. A second universal joint is required when the driving power is obtained from a drill press, or other rigid stroking device to provide the necessary full floating action at the honing head as shown below:

For Piloted Portable Hone	Order Additional Universal Joint
SN-75-887X	AN-70
JN-95-887X	AN-70
AN-815-A40X	AN-670 (Heavy-Duty)