

Honing Stones

Diamond & CBN Honing Stones

Honing is a low- speed, high- pressure surface finishing operation in which stock is removed by the cutting action of abrasive or Super Abrasive grit embedded in one or more honing stones.

We offer Honing stones, manufactured from Super Abrasives Diamond & CBN. Diamond & CBN Honing Stones are economical and having longer service life. In modern manufacturing, Diamond & CBN honing stones represent the most cost effective and best technological solution. Almost all types of materials can be honed with PARAS DIMAOND Co.'s Honing Stones to obtain optimum surface finish, high tolerances and high removal rates. The noise level of Diamond & CBN hone is far lesser compared to conventional abrasives hones. This has an impact on the process reliability and the precision of the honed bore

Selection of the grit size

Material removal rate and the surface quality to be achieved depend on the size of the grinding grits. It also influences the tool life of the grinding tool. In principle, you can achieve a higher material removal rate and a longer tool life by selecting coarse grains. On the other side, finer grains do improve the surface.

Concentration

Low concentration provides more Aggressive cutting, coarser finish and potentially higher wheel wear, while high concentration provides less Aggressive cutting, finer finish and lower wheel wear.

Standard grit sizes for DIAMONDS AND CBN

According to FEPA Standards

Type of Bond	Symbol
Metallic / Metal Bond	M

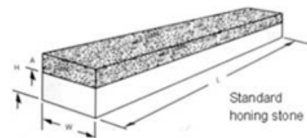
At **PARAS DIAMOND Co. INDUSTRIAL DIAMOND TOOL DIVISION** – We manufacture & offered Diamond / CBN Honing Stones with Following Bonds:

Resinoid / Resin Bond	R
Electrode posited / Electroplated Bond	E
Ceramic / Vitrified Bond	V

PARAS - Diamond & CBN Honing Stones

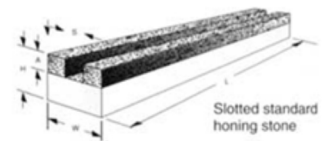
Standard Shapes According to PARAS DIAMOND CO.

Standard honing stone : Honing stones having abrasive layer on steel base. Honing stone is soldered on honing shoe / carrier.



To write dimension: W X H X L X A

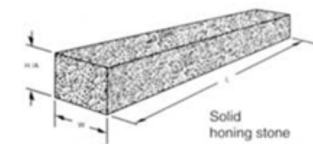
Slotted standard honing stone : Same as standard honing stone but with a slot longitudinally for better cutting, cooling and chip removal



To write dimension: W X H X L X AS

Solid honing stone:

This stone consists only the abrasive (No steel base) and is also soldered on the honing shoe / carrier or holder segment



To write dimension: W X H X L X A

Compact honing stone

Honing stones for direct fitting into the body of the honing holder. This type of stone is generally used for very small bore honing.

To write dimension: W X H X L X A

Drawing of the stone required for manufacturing.

W = Width (mm) H = Height (mm)

L = Length (mm) A = Abrasive height (mm)

S = Slot width (mm)

Type of Super Abrasives	Symbol
DIAMOND	D
CBN	B

Applications of DIAMOAND & CBN HONING STONES	
Cylinder Block	Rocker Arm
Connecting Rod	Hydraulic Tube
Fuel Injection Parts	Cast iron
Gear Bore	Tungsten carbide
Gun Barrel	Hardened Steel
Non Ferrous Metals & Alloys	Glass etc

While ordering, please specify the following details :

- 1.Type and Shape of the Honing Stone
- 2.Complete dimensions of Diameter, Width & Depth of impregnation
- 3.Grit Size
- 4.Concentration
- 5.Bond
- 6.Application

Note:

If possible, please include the Drawing of the Honing Stone.

Other honing stones, those depicted above can be made available against your specific request