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## **This catalog makes it easy for you**

to select and order the Sunnen accessories and supplies you need.

### **If you have any questions**

or need help with a technical problem,  
U.S.A. customers call your Sunnen Field Engineer  
or Sunnen Customer Service toll free at:

**1-800-772-2878 or**

**Visit [www.sunnen.com](http://www.sunnen.com)**

Customers outside of the U.S.A.,  
contact your local authorized Sunnen distributor.



Above & Beyond HONING

[www.sunnen.com](http://www.sunnen.com)

# From the early beginnings...

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The original "home" of Sunnen Products Company was the garage of Joe Sunnen.



## ...to present day



**Sunnen World Headquarters in St. Louis, Missouri,** includes a 486,000 sq. ft. (150,000 sq. meter) manufacturing plant where we research, develop and manufacture the industry's finest honing machines, abrasives and lubricants. There are more than 500 St. Louis area employees, all dedicated to providing a superior product, technical advice and customer support.



**Sunnen machines and accessories** have been sold internationally since shortly after the company was founded. Besides the St. Louis headquarters, Sunnen has facilities in the United Kingdom, Switzerland, Italy, France, Poland, Russia, the Czech Republic and China, as well as a network of more than 50 international distributors.



**Sunnen's Technical Center** includes many of the industry's most knowledgeable honing and engine building experts. To ensure superior precision and the highest product quality, no other company in the industry has the extensive complement of high-tech equipment used in the development and testing of machines, tools and abrasives.



**Before any honing** stone or abrasive is delivered, it is inspected, graded and qualified in Sunnen's abrasives manufacturing department.

# Sunnen Engine Rebuilding Equipment

For more than 80 years Sunnen has been the leader in honing. Whether for connecting rods, piston pin bores, cylinder or main bearing bores, we have the right honing system for you.

## Rod Reconditioning



Four systems, the **LBB-1660** manual hone, **ML-2000** or **ML-5000** power stroked honing systems and the **KGM-1000 KROSSGRINDING®** system offer versatility and accuracy when honing connecting rods.

## Cylinder Bore Reconditioning



The **SV-10** is the new industry standard for cylinder bore honing in all types of engine blocks.

## OEM / Production Cylinder Honing



Sunnen's **SV-300** Series CNC honing systems are a cost effective solution for production honing applications.

## Line Honing



Sunnen's dependable **CH-100** is the best method for fast precision alignment of main bearing bores.

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So that we may better serve all of our customers, Sunnen has consolidated our parts numbering system. This allows us to offer the highest quality tooling and abrasives at the lowest possible price. This catalog has both the "old" numbers and the new numbers, so that you can make the transition.

Please be assured, only the part number has changed. The part you order is the same quality Sunnen part that you have come to depend on for the industry standard engine building honing equipment.



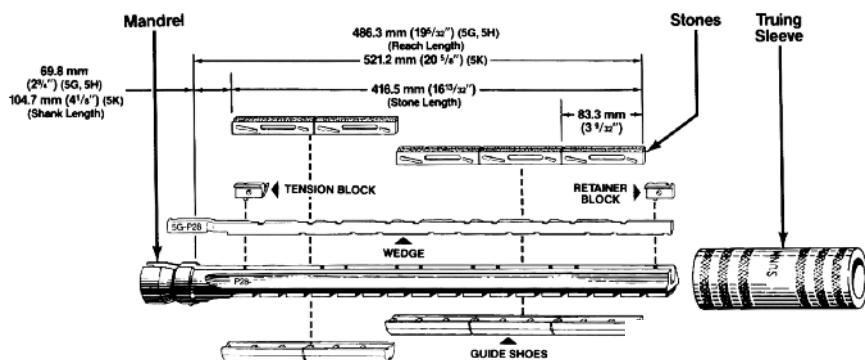
**1-800-772-2878**

# Lifetime Honing Units

## For King Pin Fitting

**Range: .744" -2.625"**  
**(18,9-66,7 mm)**

Replaceable shoe type honing units. Multiple stone length hones both bushings at once—ensures perfect bushing alignment.



Note: Catalog part numbers referencing old and new are for inventory purposes only. Part is unchanged. Mandrel can be used with fewer than 5 stones for shorter parts which require long reach.

### Honing Units

For Complete Honing Unit Order		Mandrel (Includes Wedge and Shoes)		Truing Sleeve	Stones												Replacement Parts (Included with Mandrel)		Length of Honing Stone Surface	
1 2 3		1		2	3															
Range		Old Mandrel Part No.	New Mandrel Part No.	Part No.	P20-Type (12 per Pkg.)		P28-Type (12 per Pkg.)		Old Steel Applications	New Steel Applications	Old Extra Fine Finish	New Extra Fine Finish	Shoe (2 per Pkg.)	Shim Sets	inches	mm				
inches	mm				Old Rough	New Rough	Old Med. Finish	New Med. Finish	Old Fine Finish	New Fine Finish										
.744-.781	18,9-19,8	4ML-750M*	4GP20750UA*	ST-750	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UA-B	None	10	254		
.775-.815	19,7-20,7	4ML-812M*	4GP20781UA*	ST-780	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UA-B	None	10	254		
.806-.843	20,5-21,4	4ML-812M*	4GP20812UB*	ST-812	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UB-B	None	10	254		
.838-.875	21,3-22,2	4ML-843M*	4GP20843UB*	ST-840	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UB-B	None	10	254		
.869-.906	22,1-23,0	5ML-875M*	5GP20875UB*	ST-875	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UB-B	None	12-1/2	317		
.900-.942	22,9-23,9	5ML-906M*	5GP20906UC*	ST-900	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UC-B	None	12-1/2	317		
.931-.968	23,6-24,6	5ML-937M*	5GP20937UC*	ST-937	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UC-B	None	12-1/2	317		
.962-1.003	24,4-25,5	5ML-968M*	5GP20968UC*	ST-960	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UC-B	None	12-1/2	317		
1.021-1.094	25,9-27,8	4PL-1031M*	4GP281000VA	ST-1031	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VA-B	LN-1144	13	330		
1.084-1.156	27,5-29,4	4PL-1094M*	4GP281062VA	ST-1094	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VA-B	LN-1144	13	330		
1.115-1.187	28,3-30,1	4PL-1125M*	4GP281125VB	ST-1125	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VB-B	LN-1144	13	330		
1.209-1.281	30,7-32,5	4PL-1219M*	4GP281187VB	ST-1219	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VB-B	LN-1144	13	330		
1.292-1.375	32,8-34,9	5PL-1312M*	5GP281250WB	ST-1300	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WB-D	LN-1156	16-1/4	413		
1.355-1.500	34,4-38,1	5PL-1375M*	5GP281375WC	ST-1375	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WC-D	LN-1156	16-1/4	413		
1.542-1.625	39,2-41,3	5PL-1562M*	5GP281500WD	ST-1562	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WD-D	LN-1156	16-1/4	413		
1.605-1.750	40,8-44,4	5PL-1625M*	5GP281625WD	ST-1600	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WD-D	LN-1156	16-1/4	413		
1.730-1.875	43,9-47,6	5PL-1750M*	5GP281750WE	ST-1700	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WE-D	LN-1156	16-1/4	413		
1.855-2.000	47,1-50,8	5PL-1875M*	5HP281875WE	ST-1875	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WE-D	LN-1156	16-1/4	413		
1.980-2.125	50,3-54,0	5PL-2000M*	5HP282000WF	ST-2000	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156	16-1/4	413		
2.105-2.250	53,5-57,1	5PL-2125M*	5HP282125WE	ST-2200	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156	16-1/4	413		
2.230-2.375	56,6-60,3	5PL-2250M*	5GP282250WF	ST-2200	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156	16-1/4	413		
2.355-2.500	59,8-63,5	5PL-2375M*	5HP282375WG	ST-2375	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WG-D	LN-1156	16-1/4	413		
2.480-2.625	63,0-66,7	5PL-2500M*	5HP282500WG	ST-2500	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WG-D	LN-1156	16-1/4	413		

\*Requires the use of LN5704 Concentric sleeve.

#### Notes:

- Allow for extra stock in new bushings to be sure honing unit will enter the hole.
- P20-J47 and P28-J47 medium finish stones are recommended for fitting king pins in one operation. If a large amount of stock must be removed, P20-J25 or P28-J27 stones may be used before finishing. Stone must be ordered separately.
- Quantity of stones and shoes required per honing unit is designated by the first digit of the honing unit part number. Example: 4G-P20-781UA has four shoes and four stones; 5G-P28-1250WB has five shoes and five stones.
- Replacement Tension Block (includes spring)  
For P20 Mandrels, part no. LN-1533A  
For P28 Mandrels up thru 5G-P28-1750WE, part no. LN-1336A  
For P28 Mandrels 5H-P28-1875WE and up, part no. LN-1337A
- Replacement Retainer Block  
For P20 Mandrels, part no. LN-1529A  
For P28 Mandrels up thru 5G-P28-1750WE, part no. LN-1329A  
For P28 Mandrels 5H-P28-1875WE and up, part no. LN-1330A
- Replacement Wedges  
For P20 Mandrels, part no. 4G-P20  
For P20 Mandrels, part no. 5G-P20  
For P28 Mandrels, part no. 4G-P28  
For Mandrels 5G-P28-1250WB thru 5G-P28-1750WE, part no. 5G-P28  
For Mandrels 5H-P28-1875WE thru 5G-P28-2500WG, part no. 5H-P28

# Type CR Honing Units

## For Rod Reconditioning (Journal End)

**Range: 1.450"-4.700" (36,8-119,4 mm)**

These honing units will produce a round and straight rod bore and allow you to recondition the rod to original factory size, assuring a perfect fit of inserts.

### How to Order

Order LBN-62 Honing Unit Set for complete coverage of most popular cars and trucks. Covers diameters from 1.600" to 2.700" (36,8 to 68,6 mm).

OR

Order individual honing units as needed. Each unit is complete with wedge, wedge plates and shoes.

After cap and rod faces have been ground at right angles to the side of the rod to reduce the diameter of the bore, these honing units are used to bring the bore back to standard size.



### CR80 – Replacement eccentric ring

They are specially designed to remove stock from the reduced bore without enlarging the diameter across the parting line.

Honing Units			Replacement Parts					
①	②	For Complete Honing Unit Order	①	②	Shoe (2 per Pkg.)	Wedge Plate	Wedge	
Range		Mandrel Part No.	Mandrel	Stones	Part No.	Part No.		Part No.
inches	mm					Large	Small	
1.450-1.600	36,8-40,6	CR-1450			CR-40D	CR-85	CR-75	CR-70
1.600-1.750	40,6-44,4	CR-1600*			CR-40D	CR-85	CR-75	CR-70
1.750-1.900	44,4-48,3	CR-1750*			CR-40D	CR-85	CR-75	CR-70
1.900-2.100	48,3-53,3	CR-1900*			CR-50D	CR-120	CR-110	CR-100
2.100-2.300	53,3-58,4	CR-2100*			CR-50D	CR-120	CR-110	CR-100
2.300-2.500	58,4-63,5	CR-2300*			CR-50D	CR-120	CR-110	CR-100
2.500-2.700	63,5-68,6	CR-2500*			CR-50D	CR-120	CR-110	CR-100
2.700-2.900	68,6-73,7	CR-2700			CR-50D	CR-120	CR-110	CR-200
2.900-3.100	73,7-78,7	CR-2900			CR-50D	CR-120	CR-110	CR-200
3.100-3.300	78,7-83,8	CR-3100			CR-50D	CR-120	CR-110	CR-200
3.300-3.500	83,8-88,9	CR-3300			CR-50D	CR-120	CR-110	CR-300A
3.500-3.700	88,9-94,0	CR-3500			CR-50D	CR-120	CR-110	CR-300A
3.700-3.900	94,0-99,1	CR-3700			CR-50D	CR-120	CR-110	CR-400A
3.900-4.100	99,1-104,1	CR-3900			CR-50D	CR-120	CR-110	CR-400A
4.100-4.300	104,1-109,2	CR-4100			CR-50D	CR-120	CR-110	CR-400A
4.300-4.500	109,2-114,3	CR-4300			CR-50D	CR-120	CR-110	CR-400A
4.500-4.700	114,3-119,4	CR-4500			CR-50D	CR-120	CR-110	CR-400A

Select From Chart Below

\*Included in Set LBN-62.

### Replacement Parts

#### Tension Block

LN-1685A—For CR-1450 thru CR-1750  
LN-1337A—For CR-1900 and up

#### Shoe Clamps

(Includes 4 clamps and screws)  
LN-1637A—For CR-1450 thru CR-1750  
CR-45A—For CR-1900 and up  
Includes CR-44A (pkg. 4 screws)

#### Bronze Shoes

For Power and Long Life (Manually Stroked Rod Reconditioning)

For CR-1450 thru CR-1750 Mandrels—order P/N PD-B  
For CR-1900 thru CR-4500 Mandrels—order P/N CR-50B

### ② Stone Selection Chart

#### CR Stones for CR-1450 Thru CR-1750 Mandrels

CR-2	Medium Finishing
CR-4	Fine Finishing
Y44-J65	Aluminum Rods

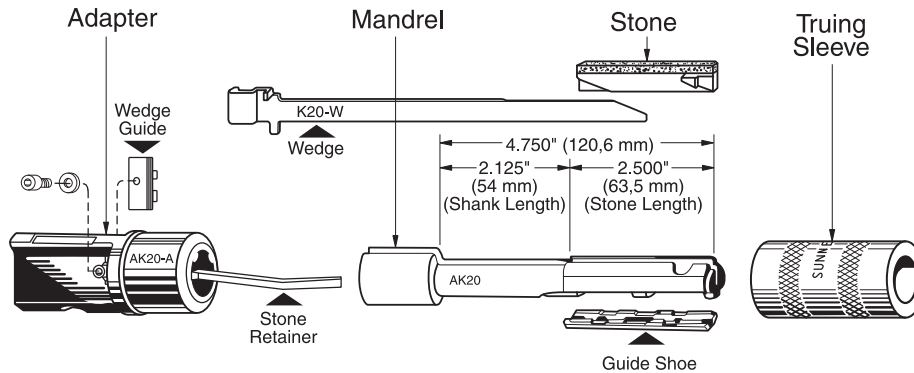
#### CR Stones for CR-1900 Thru CR-4500 Mandrels

CR-9	Aluminum Rods/Titanium
CR-10	For Rough Honing, Manual Stroking
CR-10N	For Rough Honing, Power Stroking
CR-12	For Medium Finish Honing, Manual Stroking
CR-12-8	For Medium Finish Honing, Power Stroking
CR-14	For Fine Finish Honing, Manual Stroking

# All-Steel & Lifetime Honing Units

## For Connecting Rods (Pin Fitting)

Range: .619"-1.250" (15,7-31,7 mm)



### For Con-Rod Bushings and Press-Fit Type Rods

All-steel and Lifetime mandrels, specially made for fitting pins in con-rods. Stone and shoe are of proper length to produce straight, round, accurate holes. The all-steel mandrels do not have replaceable shoes.

Part No.	Stones
K20J25	Roughing Stone for fast removal of stock in bronze bushings.
K20J47	Medium finishing stone for bronze and aluminum.
K20J67	Finishing stone for bronze and aluminum.
K20A69	Stones for honing press-fit type rods.

Part No.	Replacement Parts
K20-W	Replacement Wedge (Should be replaced when it begins to show wear.)
LN-3688A	Replacement Stone Retainer
LN-3218A	Replacement Wedge Guide

**Notes:** 1. Length of Honing Stone Surface – 2-1/2" (63,5 mm).  
2. Allow for extra stock in new bushings to be sure mandrel will enter the hole.

Note: Catalog part numbers referencing old and new are for inventory purposes only. Part is unchanged.

### Honing Units

For Complete Honing Unit Order		Mandrel (Includes K-20-W Wedge and Shoes)		Truing Sleeve	Adapter (Includes Retainer)	Stones (12 per Pkg.)				Replacement Guide Shoe (Included with Mandrels) 2 per Pkg.				
1	2	3	4			Old Rough	New Rough	Old Finish	New Finish	Old Steel Applications	New Steel Applications	Old Extra Fine Finish	New Extra Fine Finish	
Range		Old Mandrel Part No.	New Mandrel Part No.											
inches	mm													
<b>All-Steel Honing Units</b>														
.619-.650	15,7-16,5	KL-619M	K20619AS	S-619	K20-A	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	None
.650-.680	16,5-17,3	KL-650M	K20650AS	S-650	K20-A	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	None
.681-.712	17,3-18,1	KL-681M	K20681AS	S-681	K20-A	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	None
.713-.743	18,1-18,9	KL-713M	K20713AS	S-713	K20-A	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	None
<b>Lifetime Honing Units</b>														
.744-.774	18,9-19,7	KL-744M*	AK20744UA*	S-744*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UA-B
.775-.805	19,7-20,4	KL-775M	AK20775UA	S-775	AK-20A	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UA-B
.806-.837	20,5-21,3	KL-806M	AK20806UB	S-806	AK-20A	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UB-B
.838-.868	21,3-22,0	KL-838M*	AK20838UB*	S-838*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UB-B
.869-.899	22,1-22,8	KL-869M	AK20869UB	S-869	AK-20A	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UB-B
.900-.930	22,9-23,6	KL-900M*	AK20900UC*	S-900*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UC-B
.931-.961	23,6-24,4	KL-931M*	AK20931UC*	S-931*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UC-B
.962-.993	24,4-25,2	KL-962M*	AK20962UC*	S-962*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UC-B
.994-1.062	25,2-27,0	KL-1000M*	AK201000UD*	S-994*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UD-B
1.056-1.125	26,8-28,6	KL-1062M*	AK201062UD*	S-1062*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UD-B
1.119-1.187	28,4-30,1	KL-1125M*	AK201125UE*	S-1125*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UE-B
1.181-1.250	30,0-31,7	KL-1187M*	AK201187UE*	S-1187*	AK-20A*	KL-5	K20J25	KL-13	K20J67	KL-14	K20A69	KL-17	K20J85	UE-B

\*Included in LBN-64 Set.

# Lifetime Honing Units

## For Connecting Rods (Pin Fitting)

**Range: .990"-2.625"**  
**(25,1-66,7 mm)**

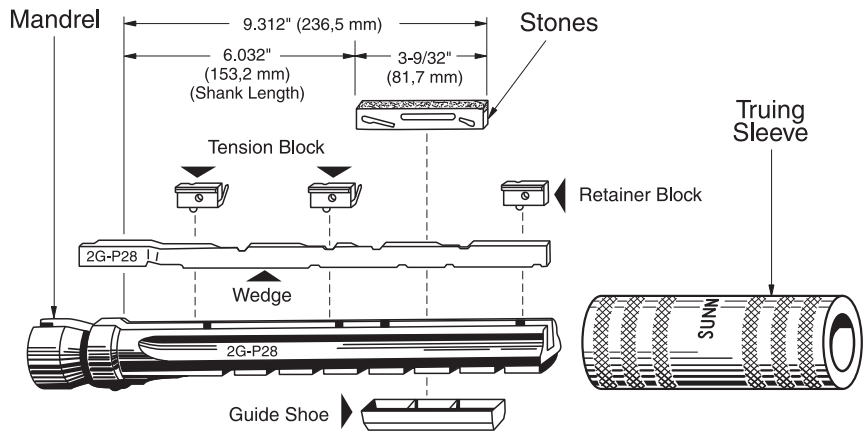
**For:**

- Pin fitting in con-rods over 1.000" (25,4 mm).
- Small cylinders in motorcycles, lawn mowers, outboard motors, etc.

Mandrel does not wear...shoes are replaceable.

**Notes:**

1. Length of Honing Stone Surface—3-9/32" (81,7 mm).
2. Allow for extra stock in new bushings to be sure honing unit will enter the hole.



Note: Catalog part numbers referencing old and new are for inventory purposes only. Part is unchanged.

### Honing Units

For Complete Honing Unit Order		Mandrel (Includes Wedge and Shoes)		Truing Sleeve	Stones PL-Type (12 per Pkg.)										Replacement Parts (Included with Mandrel)		
1	2	3	1	2	3										Shoe (2 per Pkg.)	Shim Sets	Wedge
Range		Old Mandrel Part No.	New Mandrel Part No.	Part No.	Old Rough	New Rough	Old Med. Finish	New Med. Finish	Old Fine Finish	New Fine Finish	Old Steel Applications	New Steel Applications	Old Extra Fine Finish	New Extra Fine Finish	Shoe (2 per Pkg.)	Shim Sets	Wedge
inches	mm																
.990-1.062	25,1-27,0	1PL-1000M*	2GP281000VA*	ST-1000	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VA-B	LN-1144	2G-P28
1.052-1.125	26,7-28,6	1PL-1062M*	2GP281062VA*	ST-1062	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VA-B	LN-1144	2G-P28
1.115-1.187	28,3-30,1	1PL-1125M*	2GP281125VB*	ST-1125	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VB-B	LN-1144	2G-P28
1.177-1.250	29,9-31,7	1PL-1187M*	2GP281187VB*	ST-1187	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VB-B	LN-1144	2G-P28
1.230-1.375	31,2-34,9	1PL-1250M*	2GP281250WB*	ST-1250	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WB-D	LN-1156	2G-P28
1.355-1.500	34,4-38,1	1PL-1375M*	2GP281375WC*	ST-1375	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WC-D	LN-1156	2G-P28
1.480-1.625	37,6-41,3	1PL-1500M*	2GP281500WD*	ST-1500	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WD-D	LN-1156	2G-P28
1.605-1.750	40,8-44,4	1PL-1625M*	2GP281625WD*	ST-1600	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WD-D	LN-1156	2G-P28
1.730-1.875	43,9-47,6	1PL-1750M	2GP281750WE	ST-1700	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WE-D	LN-1156	2G-P28
1.855-2.000	47,1-50,8	1PL-1875M	2HP281875WE	ST-1875	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WE-D	LN-1156	2H-P28
1.980-2.125	50,3-54,0	1PL-2000M	2HP282000WF	ST-2000	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156	2H-P28
2.105-2.250	53,5-57,1	1PL-2125M	2HP282125WF	ST-2100	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156	2H-P28
2.230-2.375	56,6-60,3	1PL-2250M	2HP282250WF	ST-2200	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156	2H-P28
2.355-2.500	59,8-63,5	1PL-2375M	2HP282375WG	ST-2375	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WG-D	LN-1156	2H-P28
2.480-2.625	63,0-66,7	1PL-2500M	2HP282500WG	ST-2500	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WG-D	LN-1156	2H-P28

\*Requires eccentric sleeve LN-0116A. Note: See next page for Tension Block and Retainer Block Part Numbers.

### PHT Plateau Honing Tool

For Use With PL Mandrels

Tool	For Diameter Range	Abrasive Sets (320 GRIT)
PL Style Mandrels	.990-6.00" (25,146-152,4 mm)	P28-PHT-731 (fits all PL style mandrels)

### For Blind Hole Work...

The honing units listed above can be converted by ordering: **A** and **B**

A Wedge			B Stone						
Old Mandrel No.	New Mandrel No.	Order Wedge No.	For Honing	Old Rough	New Rough	Old Finish	New Finish	Old Polish	New Polish
1PL-1000M to 1PL-1750M	2GP281000VA-2GP281750WE	2G-R28	Steel	RL-8	R28A49	RL-14	R28A65	RL-17	R28J85
1PL-1875M to 1PL-2500M	2HP281875WE-2HP282500WG	2H-R28	Cast iron, Bronze, Aluminum	RL-7	R28J47	RL-13	R28J67	RL-17	R28J85

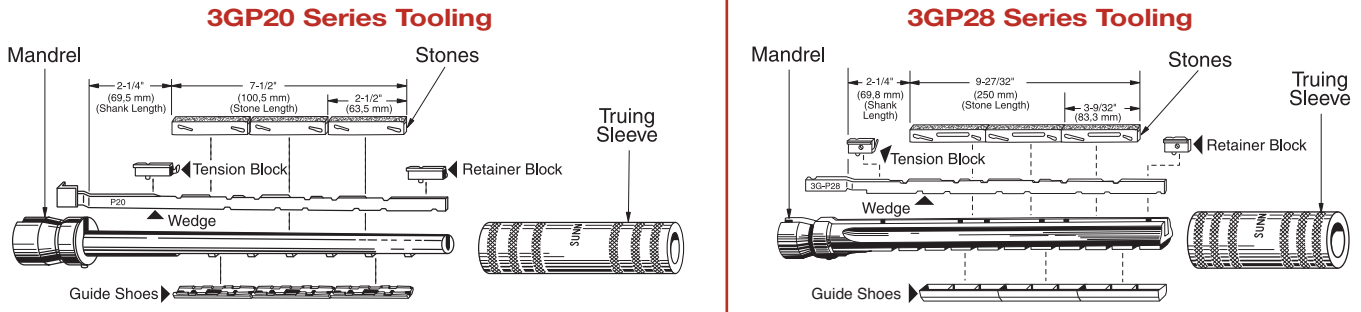
Note: Special short length hard tip stones and shoes available for honing short wheel cylinders. Call customer service department.

# Lifetime Honing Units

## For Piston Pin Fittings

**Range: .744"-2.625" (18,9-66,7 mm)**

Recommended for fast, accurate piston pin fitting. Especially for truck, tractor and diesel engines.



Note: Catalog part numbers referencing old and new are for inventory purposes only. Part is unchanged.

### Honing Units

For Complete Honing Unit Order		Mandrel (Includes Wedge and Shoes)		Truing Sleeve	Stones PL-Type (12 per Pkg.)										Replacement Parts (Included with Mandrel)	
Range		Old Mandrel Part No.	New Mandrel Part No.	Part No.	Old Rough	New Rough	Old Med. Finish	New Med. Finish	Old Fine Finish	New Fine Finish	Old Steel Applications	New Steel Applications	Old Extra Fine Finish	New Extra Fine Finish	Shoe (2 per Pkg.)	Shim Sets
.744- .781	18,9-19,8	3ML-750M*	3GP20750UA*	ST-750	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UA-B	None
.775- .812	19,7-20,6	3ML-781M*	3GP20781UA*	ST-780	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UA-B	None
.806- .843	20,5-21,4	3ML-812M*	3GP20812UB	ST-812	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UB-B	None
.838- .875	21,3-22,2	3ML-843M*	3GP20843UB*	ST-840	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UB-B	None
.869- .906	22,1-23,0	3ML-875M*	3GP20875UB*	ST-875	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UB-B	None
.900- .937	22,9-23,9	3ML-906M*	3GP20906UC*	ST-900	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UC-B	None
.931- .968	23,6-24,6	3ML-937M*	3GP20937UC*	ST-937	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UC-B	None
.962-1.000	24,4-25,4	3ML-968M*	3GP20968UC*	ST-960	ML-5	P20J25	ML-7	P20J47	ML-13	P20J67	ML-14	P20A69	ML-17	P20J85	UC-B	None
.990-1.062	25,1-27,0	3PL-1000M*	3GP281000VA*	ST-1000	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VA-B	LN-1144
1.052-1.125	26,7-28,6	3PL-1062M*	3GP281062VA	ST-1062	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VA-B	LN-1144
1.115-1.187	28,3-30,1	3PL-1125M*	3GP281125VB*	ST-1125	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VB-B	LN-1144
1.177-1.250	29,9-31,7	3PL-1187M*	3GP281187VB*	ST-1187	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	VB-B	LN-1144
1.230-1.375	31,2-34,9	3PL-1250M*	3GP281250WB*	ST-1250	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WB-D	LN-1156
1.355-1.500	34,4-38,1	3PL-1375M*	3GP281375WC*	ST-1375	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WC-D	LN-1156
1.480-1.625	37,6-41,3	3PL-1500M*	3GP281500WD*	ST-1500	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WD-D	LN-1156
1.605-1.750	40,8-44,4	3PL-1625M*	3GP81625WD*	ST-1600	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WD-D	LN-1156
1.730-1.875	43,9-47,6	3PL-1750M	3GP181750WE	ST-1700	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WE-D	LN-1156
1.855-2.000	47,1-50,8	3PL-1875M	3HP281875WE	ST-1875	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WE-D	LN-1156
1.980-2.125	50,3-54,0	3PL-2000M	3HP282000WF	ST-2100	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156
2.105-2.250	53,5-57,1	3PL-2125M	3HP282125WF	ST-2200	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156
2.230-2.375	56,6-60,3	3PL-2250M	3HP282250WF	ST-2250	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WF-D	LN-1156
2.355-2.500	59,8-63,5	3PL-2375M	3HP282375WG	ST-2375	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WG-D	LN-1156
2.480-2.625	63,0-66,7	3PL-2500M	3HP282500WG	ST-2500	PL-5	P28J27	PL-7	P28J47	PL-13	P28J67	PL-14	P28A69	PL-17	P28J85	WG-D	LN-1156

\*Requires eccentric sleeve LN-0116A. Included in LBN-11 Mandrel Set. See page 8.

#### Notes:

- Allow for extra stock in new bushings to be sure honing unit will enter the hole.
- For other Honing Stones, see pages 23 and 24.
- Replacement Wedge—For P20 Mandrels, Part No. 3G-P20. For Mandrels 3G-P28-1000VA through 3G-P28-1750WE, Part No. 3G-P28. For Mandrels 3H-P28-1875WE up, Part No. 3H-P28.

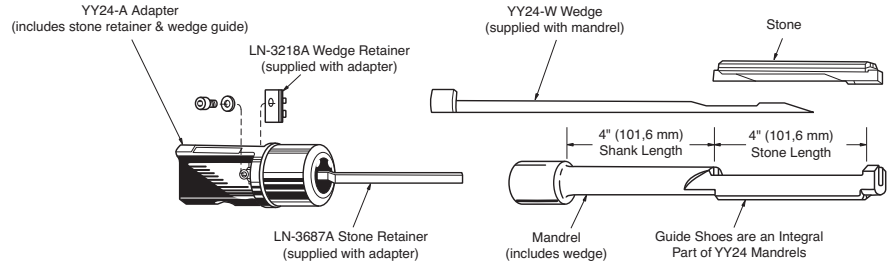
- Replacement Tension Block (Includes Spring)—For P20 Mandrels, Part No. LN-1533A. For Mandrels 3G-P28-1000VA through 3G-P28-1750WE, Part No. LN-1336A. For Mandrels 3H-P28-1875WE up, Part No. LN-1337A.
- Replacement Retainer Block—For P20 Mandrels, Part No. LN-1529A. For Mandrels 3G-P28-1000VA through 3G-P28-1750WE, Part No. LN-1329A. For Mandrels 3H-P28-1875WE up, Part No. LN-1330A.

# All-Steel Honing Units

## Tooling Required For Honing High Performance Slotted Pistons

Type YY24 Mandrels are all-steel honing units. They are applicable to the honing of import and small domestic pistons and performance pistons with small diameter pins, with slotted piston pin bores.

For a Complete Honing Unit Order Mandrel, Truing Sleeve, Stone and Adapter.



For Complete Honing Unit Order

① ② ③ ④

Range		Honing Units				
inches	mm	① Mandrel Part No.	② Sleeve	③ Adapter	④ (1 per Pkg.) Stone	Wedge
.748-.758	19,0-19,35	YY24-748M	ST-750	YY24-A	YY24-J65	YY24-W
.787-.797	19,9-20,2	YY24-787M	ST-780	YY24-A	YY24-J65	YY24-W
.800-.810	20,3-20,5	YY24-800M	ST-800	YY24-A	YY24-J65	YY24-W
.826-.836	20,9-21,3	YY24-826M	ST-826	YY24-A	YY24-J65	YY24-W
.867-.877	22,0-22,3	YY24-867M	ST-867	YY24-A	YY24-J65	YY24-W
.875-.885	22,2-22,5	RYY-875M	ST-875	Not Required	RYY-13	YY32-W
.901-.911	22,9-23,1	RYY-901M	ST-900		RYY-13	YY32-W
.912-.922	23,2-23,4	RYY-912M	ST-912		RYY-13	YY32-W
.927-.940	23,5-23,9	SYY-927M	ST-927		SYY-13	YY32-W
.975-.980	24,8-24,9	SYY-973M	ST-973		SYY-13	YY32-W
.990-1.000	25,1-25,4	SYY-989M	ST-989		SYY-13	YY32-W
1.040-1.050	26,4-26,7	SYY-1040M	ST-1040		SYY-13	YY32-W
1.094-1.104	27,8-28,0	SYY-1094M	ST-1094		SYY-13	YY32-W

Note: These honing units must be used within a range of .010" (0,25 mm) of the standard wrist pin diameter shown.

### Type RYY and SYY: For pistons with wide slots in pin hole

Type RYY and SYY Mandrels are long-wearing, all-steel units, made especially for pistons with wide slots in the piston pin holes. The mandrels have extra-wide guide shoes, and the honing stones have a double surface for bridging the wide slots.

#### Notes:

1. These honing units must be used within a range of .010" (0,25 mm) of the standard wrist pin diameter shown.
2. Use LN-0116A Eccentric Sleeve with these honing units. See page 10.
3. Honing units must be trued in prior to use.

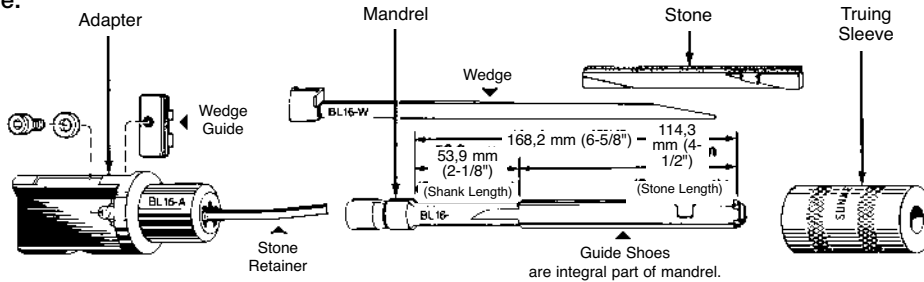
# All-Steel Honing Units

For Piston Pin Fittings

Range: .370"-.713" (9,4-18,1 mm)

Especially useful on Foreign Cars and Small Tractors.

Long-wearing honing units for small piston pin holes, distributor bushings, small king pin bushings and similar holes within the range.



Note: Catalog part numbers referencing old and new are for inventory purposes only. Part is unchanged.

## Honing Units

Range		Mandrel (Includes Wedge and Shoes)		Ship. Wt.		Truing Sleeve	Adapter (Includes Retainer)	Stones (6 per Pkg.)				Replacement Wedges
inches	mm	Old Mandrel Part No.	New Mandrel Part No.	lbs.	kg.			Old Rough	New Rough	Old Finish	New Finish	
.370-.384	9,4- 9,8	LH-370M	BL12370AS	1/4	,11	S-370	BL12-A	LH-7	L12J47	LH-13	L12J67	BL12-W
.432-.446	11,0-11,3	LH-432M	BL12432AS	1/4	,11	S-432	BL12-A	LH-7	L12J47	LH-13	L12J67	BL12-W
.495-.525	12,6-13,3	LJ-495M*	BL16495AS	1/2	,22	S-495	BL16-A	LJ-7	L16J47	LJ-13	L16J67	BL16-W
.526-.557	13,4-14,1	LJ-526M*	BL16526AS	1/2	,22	S-526	BL16-A	LJ-7	L16J47	LJ-13	L16J67	BL16-W
.557-.587	14,1-14,9	LJ-557M*	BL16557AS	1/2	,22	S-557	BL16-A	LJ-7	L16J47	LJ-13	L16J67	BL16-W
.619-.650	15,7-16,5	LJ-619M*	BL20619AS	1/2	,22	S-619	BL18-A	LJ-7	L16J47	LJ-13	L16J67	BL16-W
.650-.681	16,5-17,3	LJ-650M	BL20650AS	1/2	,22	S-650	BL18-A	LJ-7	L16J47	LJ-13	L16J67	BL16-W
.681-.713	17,3-18,1	LJ-681M*	BL20681AS	1/2	,22	S-681	BL18-A	LJ-7	L16J47	LJ-13	L16J67	BL16-W

\*Included in LBN-1A. Note: Allow for extra stock in new bushings to be sure honing unit will enter hole.

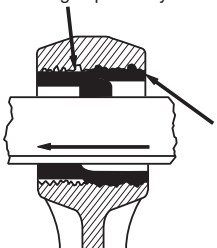
## Bushing Expander

For expanding new bushings in rods...provides another use for your versatile Sunnen Honing Machine!

- Assures 100% contact for perfect heat transfer.
- Additional protection for your pin fit.
- Squeezes bushing into every hole irregularity.
- Swedges bushings in minutes.
- Trims bushing edges square and clean.



Pressed-in bushing touches on the high spots only.



Expanded bushing fills in valleys and is locked in perfectly to rod eye.

Keeps bushings from working loose.

## Order

Expander Mandrel	Diameter Range		Expander (includes facing cutter)
	inches	mm	
ALR-720	.720-.840	18,3-21,3	AL-12*
ALR-840	.840-.900	21,3-22,9	AL-12*
ALR-900	.900-.960	22,9-24,4	AL-12*
ALR-960	.960-1.080	24,4-27,4	AL-12*

## SL-15 Roughing Cutter (Optional)



Used with the ALR series expander mandrels.

It is used to remove excess bushing stock prior to honing.

AL54 Wedge (Replacement)

## Replacement Parts for AL-12



AL-144 Facing Cutter

AL-143A Expander Bit & Spring

\*ALR expander mandrels cannot be used without AL-12 expanders. Please order separately.

# Mandrel Sets

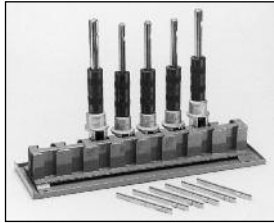
## For Pin Fitting and Rod Reconditioning

### Sunnen Mandrel Sets and Honing Unit Sets

The easy way to order. Buying in sets, using a single part number, simplifies ordering and assures having the right unit needed for the job at hand. Each set covers a particular size range or application.

#### LBN-1A All-Steel Honing Unit Set

For Small Diameters. Long wearing all-steel honing units for small piston pin holes— distributor bushings, small king pin bushings, and similar holes within the range. Includes L16J57 Roughing and L16J67 Finishing Stones. See page 7 for individual units.



*Note: Catalog part numbers referencing old and new are for inventory purposes only. Part is unchanged.*

#### Range: .495"-.713" (12,6 mm-18,1 mm)

Qty.	Old Part No.	New Part No.	Description	Qty.	Part No.	Description
1	LJ-495M	BL16495AS	Mandrel	1	S-495	Truing Sleeve
1	LJ-526M	BL16526AS	Mandrel	1	S-526	Truing Sleeve
1	LJ-557M	BL16557AS	Mandrel	1	S-557	Truing Sleeve
1	LJ-619M	BL20619AS	Mandrel	1	S-619	Truing Sleeve
1	LJ-681M	BL20681AS	Mandrel	1	S-681	Truing Sleeve
3	BL16-A	BL16-A	Adapters	1	SL-30	Mandrel Rack
2	BL18-A	BL20-A	Adapters			
6	LJ-7	L16J57	Stones			
6	LJ-13	L16J67	Stones			

Shipping Weight: 20 lbs. (9,1 kg)

#### LBN-11 Mandrel Set

For Piston Pin Fitting. Contains four (4) mandrels, truing sleeves and medium finishing stones for piston pin fitting and general work within the size range shown. Mandrels are assembled with stones. See page 5 for additional units. For convenient storage order SL-38 Mandrel Rack separately. See page 10.



*Note: Catalog part numbers referencing old and new are for inventory purposes only. Part is unchanged.*

#### Range: .900"-1.062" (22,9 mm-26,9 mm)

Qty.	Old Part No.	New Part No.	Description	Qty.	Part No.	Description
1	3ML-906M	3GP20906UC	Mandrel	1	ST-900	Truing Sleeve
1	3ML-937M	3GP20937UC	Mandrel	1	ST-937	Truing Sleeve
1	3ML-968M	3GP20968UC	Mandrel	1	ST-960	Truing Sleeve
1	3PL-1000M	3GP281000VA	Mandrel	1	ST-1000	Truing Sleeve
12	ML-7	P20J47	Stones			
12	PL-7	P28J47	Stones			

Shipping Weight: Approx. 19 lbs. (8,6 kg)

### LBN-62 Lifetime Honing Unit Set



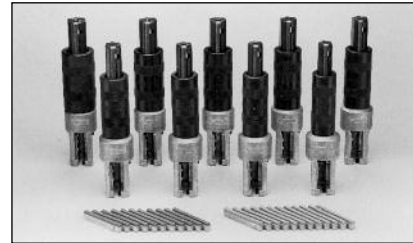
For Con Rod Reconditioning. A set of complete lifetime honing units for most popular cars and trucks. Covers diameters from 1.600"-2.700". Comes with CR-2 and CR-12 Stones for honing journal end of con rods. See page 2 for individual units.

#### Range: 1.600"-2.700" (40,6 mm-68,1 mm)

Qty.	Part No.	Qty.	Part No.
1	CR-1600	1	CR-2100
1	CR-1750	1	CR-2300
1	CR-1900	1	CR-2500

Includes SL-37 Mandrel Rack, 2 CR-2 and 4 CR-12 Stones. Shipping Weight: 53 lbs. (24,1 kg)

### LBN-64 Lifetime Honing Unit Set



For Con Rod Bushings and Press-Fit Type Rods.

Contains nine (9) complete lifetime honing units designed for accuracy and speed in honing con rods. See page 3 for individual units. Set includes 12 K20J67 Stones, plus 12 K20A67 Stones for honing press-fit type rod forgings. For convenient storage, order SL-30 Mandrel Rack separately. See page 10.

*Note: Catalog part numbers referencing old and new are for inventory purposes only. Part is unchanged.*

#### Range: .744"-1.250" (18,9 mm-31,7 mm)

Qty.	Old Part No.	New Part No.	Description	Qty.	Part No.	Description
1	KL-744M	AK20744UA	Mandrel	1	S-744	Truing Sleeve
1	KL-838M	AK20838UB	Mandrel	1	S-838	Truing Sleeve
1	KL-900M	AK20900UC	Mandrel	1	S-900	Truing Sleeve
1	KL-931M	AK20931UC	Mandrel	1	S-931	Truing Sleeve
1	KL-962M	AK20962UC	Mandrel	1	S-962	Truing Sleeve
1	KL-1000M	AK201000UD	Mandrel	1	SL-994	Truing Sleeve
1	KL-1062M	AK201062UD	Mandrel	1	S-1062	Truing Sleeve
1	KL-1125M	AK201125UE	Mandrel	1	S-1125	Truing Sleeve
1	KL-1187M	AK201187UE	Mandrel	1	S-1187	Truing Sleeve
12	KL-5	K20J25	Stones	9	AK20-A	Adapters
12	KL-13	K20J67	Stones			
12	KL-14	K20A69	Stones			

Shipping Weight: Approx. 29 lbs. (13,2 kg)

# Ring Sets for LBB-1660 and ML4000

For Rod Reconditioning on Power-Stroke Honing Machine and CRF-100 Manually Stroke Rod Fixture



Each CR-Type Honing Unit in the 1.450"–3.300" (36,9–84 mm) range requires a Ring Set for fixturing the rods in the machine.

Order: CRF-500 Ring Set Kit-Includes all rings for 1.600" to 2.700" (36,8 mm–68,6 mm) range, plus CRF-495 Metal Storage Case.

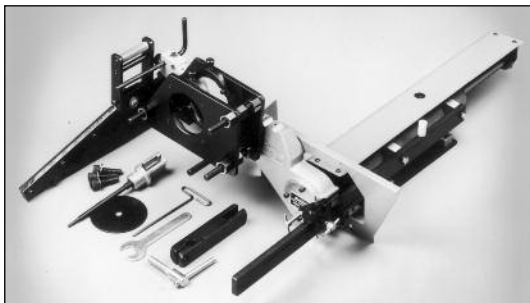
For Coolant Fed Rings 1,9" (48 mm) and above Order: CRF-6XXA (one per pack). See page 13.

To order individual ring sets in 1.450"–3.300" (36,9–84 mm) range, refer to chart below.

For Use With Honing Units	Honing Unit Range		Rings (2 Rings per Pkg.) Shipping Wt. 3 lbs. (1.4 kg)			Ring Sets (4 Rings per Set) Shipping Wt. 6 lbs. (2.7 kg)		
	inches	mm	Part No.	Range		Part No.	Range	
				inches	mm		inches	mm
CR-1450	1.450-1.600	36,9-41,6	CRF-145A	1.450-1.520	36,9-38,7	CRF-14	1.450-1.600	36,9-41,6
			CRF-152A	1.520-1.600	38,7-41,6			
CR-1600	1.600-1.750	41,6-44,9	CRF-160A	1.600-1.670	41,6-42,4	CRF-16*	1.600-1.750	41,6-44,9
			CRF-167A	1.670-1.750	42,4-44,9			
CR-1750	1.750-1.900	44,9-48,7	CRF-175A	1.750-1.820	44,9-46,2	CRF-17*	1.750-1.900	44,9-48,7
			CRF-182A	1.820-1.900	46,2-48,7			
CR-1900	1.9-2.1	48-53	CRF-519A	1.9-2.0	48-51	CRF-19*	1.9-2.1	48-53
			CRF-520A	2.0-2.1	51-53			
CR-2100	2.1-2.3	53-58	CRF-521A	2.1-2.2	53-56	CRF-21*	2.1-2.3	53-58
			CRF-522A	2.2-2.3	56-58			
CR-2300	2.3-2.5	58-63	CRF-523A	2.3-2.4	58-61	CRF-23*	2.3-2.5	58-63
			CRF-524A	2.4-2.5	61-63			
CR-2500	2.5-2.7	63-69	CRF-525A	2.5-2.6	63-66	CRF-25*	2.5-2.7	63-69
			CRF-526A	2.6-2.7	66-69			
CR-2700	2.7-2.9	69-74	CRF-527A	2.7-2.8	69-72	CRF-27	2.7-2.9	69-74
			CRF-528A	2.8-2.9	72-74			
CR-2900	2.9-3.1	74-79	CRF-529A	2.9-3.0	74-77	CRF-29	2.9-3.1	74-79
			CRF-530A	3.0-3.1	77-79			
CR-3100	3.1-3.3	79-84	CRF-531A	3.1-3.2	79-82	CRF-31	3.1-3.3	79-84
			CRF-532A	3.2-3.3	82-84			

CRF-495 Metal Storage Case stores up to 28 rings. Rings have own compartments for ease of selection and convenient storage.  
\*Included in CRF-500 Ring Set Kit. CRF-541 — Set up disk (for stroker alignment).

## Manual Stroke Rod Fixture Kit



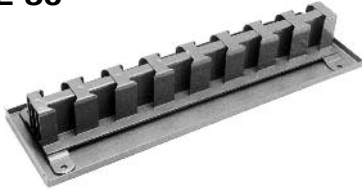
Order KKN-100, KKN-650 and MB-2410 for the Manual Stroke Rod Fixture Kit which provides controlled hand stroking:

- Rod bores are honed square with the face every time.
- Uniform "overstroking" on both ends of stones assures even wear, prolongs stone life, helps assure consistent crosshatch pattern.
- Reduces training time for operators.
- Can be factory installed when ordered with LBB-1660 or retrofitted in the field.

Note: Order CRF-500 RING SET KIT or individual ring sets separately.

# Sunnen Honing Machine Accessories

## Mandrel Storage Racks SL-30



For types ALR, AK20, BL12, BL16 and BL20 Mandrels. Each rack holds 16 mandrels. Drain pan is included.  
*Shipping Weight: 5-1/2 lbs. (2,5 kg)*

## SL-38



For lifetime honing units with 1-1/2" (38,1 mm) diameter shank. Rack holds 8 units. Includes drain pan.  
*Shipping Weight: 5 lbs. (2,3 kg)*

## SL-37



For lifetime and rod reconditioning honing units with 1 3/4" (44,4 mm) diameter shank. Rack holds 7 units. Includes drain pan.  
*Shipping Weight: 5 lbs. (2,3 kg)*

## Touch Up Paint



Sunnen machine tool lacquer in 1 pint aerosol spray can.

**MBB-90437A** Vista Green

**MBC-90411A** Pearl Gray

**MBC-90412A** Pewter Gray

*Shipping Weight: 1 lb. (.45 kg)*

## Replacement Belts



For 6-Speed Heavy-Duty Floor Type Machine

Part No.	Description
MBB-810	Spindle Drive Belt
MBB-820	"V" Drive Belt
MBB-880	Honing Oil Pump Belt (for LBB-1499) 85-1/4" (2154 mm)
MB-2292	Honing Oil Pump Belt (for LBB-1660 and LBB-1699) 109" (2768 mm)

For LBB-1710 Power-Stroke Machine

Part No.	Description
MBB-810	Spindle Drive Belt
MBB-820	"V" Drive Belt
MB-2292	Honing Oil Pump Belt
KKN-444A	Stroker Belt

For LBB-1810 and LBC-1803 Power-Stroke Machines

Part No.	Description
MBB-1830A	Motor Drive Belt (60 Hz machines)
MBB-1833A	Motor Drive Belt (50 Hz machines)
MBB-1840A	Spindle Drive Belt
KKN-444A	Stroker Belt

*Shipping Weight: 1/2 lb. (.23 kg) each belt*

## LN-0116A Eccentric Sleeve



Adapts certain mandrels to machine spindle. Compensates for mandrel run-out. One required per machine.  
*Shipping Weight: 1 lb. (.45 kg)*

## MBC-200 Work Light



The MBC-200 is equipped with a 6-foot (1,83 meters) long cord with a 3-wire moulded-on grounding type plug. All pedestal or bench machines will accept the work light under either front spindle motor hold down bolt. Takes standard 110-volt, 100 watt bulb. Bulb not included.  
*Shipping Weight: 3-3/4 lbs. (1,7 kg)*

## CRF-750 Universal Holding Fixture

For LBB-1810 and LBC-1803 Honing Machines

*Note: Can also be used on LBB-1660 Manual Hone equipped with CRF-100 Manual Stroked Rod Fixture.*



Accommodates most motorcycle and VW Cylinders and other parts within the CRF-750's range that can be placed on the honing machine. Fixture can be installed or removed quickly and easily. Takes thrust on forward and back strokes. Includes two pairs of fingers with long-wearing, adjustable carbide pads.  
*Shipping Weight: 6 lbs. (2,7 kg)*

## KKN-735A Torque Bracket Assembly



The KKN-735A is used in conjunction with the CRF-750 Universal Holding Fixture. It allows honing torque to be taken at the center of the bore length. It is especially useful for odd shaped cylinders typical of motorcycle applications.  
*Shipping Weight: 2-1/2 lbs. (1,13 kg)*

## MB-2333A Extra-Long Offset Torque Bar-23" (584 mm) Long



Useful for absorbing torque on workpieces which are too long for the standard 13" (330 mm) torque bar. Ideal for honing spindle bodies.  
*Shipping Weight: 4-1/2 lbs. (2,04 kg)*

# Sunnen Honing Machine Accessories

## CR-25 Chamfering Tool



Chamfers journal end of con-rods. Use in place of honing stone on Type CR-1900 and larger Honing Units. Carbide cutting tool has three cutting surfaces. Just flip cutter to new surface when cutting edge wears.

## CR-35 Chamfering Tool



Chamfers journal end of con-rods. Use in place of honing stone on Type CR-1450 thru CR-1750.

Replacement part CR-28A Carbide Cutter. Used for both CR-25 and CR-35.

## LBN-462A Mandrel "T" Wrench

## B-300 Countersink



For chamfering the wrist pin end of connecting rods. The B-300 Countersink

includes an adapter for chucking into the Sunnen Honing Machine and will chamfer bushed type as well as press-fit connecting rods. Chamfering the rod eyes makes assembling the wrist pin easier and eliminates the possibility of galling during installation. The unit is sold complete and ready for use in any Sunnen Honing Machine.

Range: 3/8" through 1-3/8" (9,5-34,9 mm) diameters.

Shipping Weight: 1-1/2 lbs. (.68 kg)

## MB-2410 Work Tray

For LBB-1660 and LBB-1699. Package of 2.



Attaches to left and right side of machine work tray. Keeps work area of machine free of parts while honing rods and pistons.

Shipping Weight: 13-1/2 lbs. (6,1 kg)

MB-2418A Replacement Pad for MB-2410 Tray. Package of one.

Shipping Weight: 1 lb. (.45 kg)

## LBN-700 Stone Dresser



Helps keep honing stones sharp and cutting.

Shipping Weight: 1/4 lb. (.11 kg)

## Sunnen CRG-960 Rod Clamping Fixture



May be mounted on Sunnen Storage Cabinet Bench (CRG-600) or Workbench, or it may be clamped in a standard Machinist's Vise.

Shipping Weight: 14 lbs. (6,36 kg)

## LBN-730 Rod Support



Enables the operator to hone two V-6 or V-8 rods at the same time. Eases production problems associated with honing narrow connecting rods.

Shipping Weight: 6 lbs. (2,7 kg)

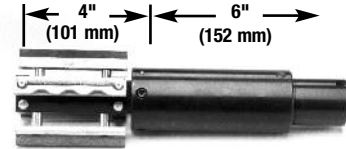
## MAN-700 Diamond Stone Dresser



When cutting action of honing stone slows down, a light stroke with the diamond dresser breaks the glaze and restores honing efficiency. Especially recommended for rod reconditioning. Consists of diamond stone on sturdy metal holder with chain for fastening to honing machine.

Shipping Weight: 1/2 lb. (.23 kg)

## AN-600 Honing Head



Diameter Range: 2.500"-6.500" (64 mm-165 mm).

Ideal for honing small engine, snowmobile and VW-type cylinders. Accuracy to .0005" (0,1 mm).

Uses same stone sets as AN model Portable Cylinder Hone (see Page 36). Can be used with any pedestal model Sunnen Honing Machine.

Shipping Weight: 10 lbs. (4,5 kg)

## LN-150 2.5X Magnifying Glass

Ground optical glass. Excellent for inspecting the condition of carbide cutters, etc. Supplied in convenient leather case.

Shipping Weight: 1/4 lb. (.11 kg)



## Stone Chart for SL and UL Type Mandrels

For Use with Flow of Honing Oil

For Use with Mandrels	Roughing	Fine Finishing	Medium Finishing	Std. Pkg.	Ship. Wt. Lbs. Per Std. Pkg.	
					lbs.	kg
SL-480 thru SL-660 †	SL-1	SL-3		6	1/2	,23
SL-720 and up †	SL-5	SL-13	SL-7	6	1-1/4	,57
	SL-8‡	SL-17**		6	1-1/4	,57
UL Type Mandrels	UL-5	UL-13	UL-7	4	3/4	,34

\*\* For extra-fine finishing.

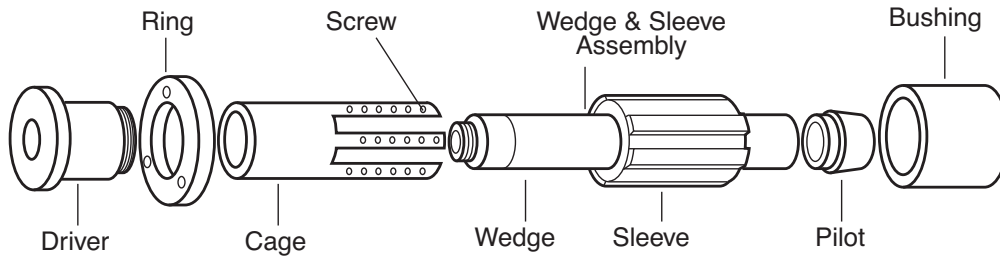
† Mandrels are no longer manufactured. Stones are available until current stock is depleted.

‡ For honing steel.



# CRT Production Rod Reconditioning Tools

For Use With KGM-1000 Rod Reconditioning Machines



The tools listed in the following chart are the most commonly specified sizes. (Allow 2-4 weeks for processing.) Other sizes available on request. Consult your local Sunnen Field Engineer or Sunnen Customer Service toll-free in St. Louis.

Complete Tool Number*	Size Range Inches	Cage Number	New Sleeve and Wedge Assembly	Pilot Number	Screw Number	Alignment Bushing No.*
CRT68-2130-D5C	2.120-2.140	CRT68-C	CRT68-2130S-D5CA	CRT68-2130-P	PHSM-601	CRC-2120
CRT68-2230-D5C	2.220-2.240	CRT68-C	CRT68-2230S-D5CA	CRT68-2230-P	PHSM-601	CRC-2220
CRT72-2250-D5C	2.240-2.260	CRT72-C	CRT72-2250S-D5CA	CRT72-2250-P	PHSM-601	CRC-2240
CRT72-2280-D5C	2.270-2.290	CRT72-C	CRT72-2280S-D5CA	CRT72-2280-P	PHSM-601	CRC-2270
CRT72-2330-D5C	2.320-2.340	CRT72-C	CRT72-2330S-D5CA	CRT72-2330-P	PHSM-601	CRC-2330
CRT76-2380-D5C	2.370-2.390	CRT76-C	CRT76-2380S-D5CA	CRT76-2380-P	PHSM-601	CRC-2370
CRT76-2430-D5C	2.420-2.440	CRT76-C	CRT76-2430S-D5CA	CRT76-2430-P	PHSM-601	CRC-2420
CRT80-2500-D5C	2.490-2.510	CRT80-C	CRT80-2500S-D5CA	CRT80-2500-P	PHSM-602	CRC-2490

\*Alignment bushing not included with complete tool. Order separately.

## Replacement Sleeves

Replacement sleeves are available for all CRT tools. Customer **MUST** send old sleeve and wedge assembly to Sunnen Products for processing. Wedge and sleeve **MUST** remain as a matched set. Call Customer Service for additional information.



# SRT Production Rod Reconditioning Tools

For Use With ML and EC Series Machines



## SRT Stone Selections

Stone Set	Stones for SRT Tool	Range for SRT-1500	Range for SRT-1600	Range for SRT-2000	Range for SRT-2530
SRT1	Must add numbers from SRT Tool charts below after stone set number – see example below	1.500"-1.580" (39-40 mm)	1.600"-1.680" (40-42 mm)	2.000"-2.080" (51-53 mm)	2.530"-2.610" (64-66 mm)
SRT2		1.580"-1.660" (40-42 mm)	1.680"-1.760" (42-44 mm)	2.080"-2.160" (53-55 mm)	2.610"-2.690" (66-68 mm)
SRT3		1.660"-1.740" (42-44 mm)	1.760"-1.840" (44-46 mm)	2.160"-2.240" (55-57 mm)	2.690"-2.770" (68-70 mm)
SRT4		1.740"-1.820" (44-46 mm)	1.840"-1.920" (46-48 mm)	2.240"-2.320" (57-59 mm)	2.770"-2.850" (70-72 mm)
SRT5		1.820"-1.900" (46-48 mm)	1.920"-2.000" (49-51 mm)	2.320"-2.400" (59-61 mm)	2.850"-2.930" (72-74 mm)
SRT6		1.900"-1.980" (48-50 mm)	2.000"-2.080" (51-53 mm)	2.400"-2.480" (61-63 mm)	2.930"-3.010" (74-76 mm)
SRT7		1.980"-2.060" (50-52 mm)	2.080"-2.160" (53-55 mm)	2.480"-2.560" (63-65 mm)	3.010"-3.090" (76-78 mm)

SRT-2000 in stock for immediate delivery. Call Sunnen for available Stone Sets  
For large applications call Sunnen customer service.

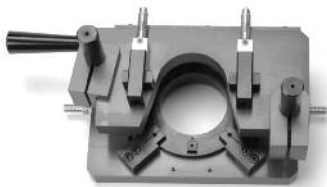
### EXAMPLE: SRT1NMG47

Stones for SRT Tool	Grit Size
NMG47*	150
NMG67*	260
NMG87	400
RMG97	500



\*Recommended for Rod Reconditioning

## AFX-1000 Production Rod Reconditioning Fixture



For use in Sunnen CGM, KGM, EC and ML type honing machines.

## Alignment Bushings

(Select bushings based on rod size)  
Available from stock

CRC-2120	CRC-2330
CRC-2220	CRC-2370
CRC-2240	CRC-2420
CRC-2270	CRC-2490

Note: For additional sizes call Automotive Customer Service for pricing and delivery times.

## AFX Ring and Finger Selections

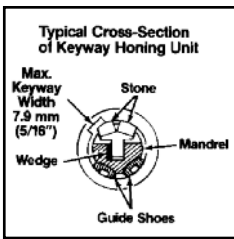
Coolant ports supplied in these rings.



Part Dia.	Use w/CRF Ring	Finger Part No.
1.450"-1.520" (36-38 mm)*	CRF-145NB2X*	FX-318
1.520"-1.600" (38-40 mm)*	CRF-152NB2X*	FX-319
1.600"-1.670" (40-42 mm)*	CRF-160NB2X*	FX-320
1.670"-1.750" (42-44 mm)v	CRF-167NB2X*	FX-321
1.750"-1.820" (44-46 mm)*	CRF-175NB2X*	FX-322
1.820"-1.900" (46-48 mm)*	CRF-182NB2X*	FX-323
1.900"-2.000" (48-51 mm)	CRF-619	FX-068
2.000"-2.100" (51-53 mm)	CRF-620	FX-069
2.100"-2.200" (53-56 mm)	CRF-621	FX-070
2.200"-2.300" (56-58 mm)	CRF-622	FX-071
2.300"-2.400" (58-61 mm)	CRF-623	FX-072
2.400"-2.500" (61-63 mm)	CRF-624	FX-073
2.500"-2.600" (63-66 mm)	CRF-625	FX-074
2.600"-2.700" (66-68 mm)	CRF-626	FX-075
2.700"-2.800" (68-71 mm)	CRF-627	FX-076
2.800"-2.900" (71-74 mm)	CRF-628	FX-077
2.900"-3.000" (74-76 mm)	CRF-629	FX-078
3.000"-3.100" (76-79 mm)	CRF-630	FX-079
3.100"-3.200" (79-81 mm)	CRF-631	FX-080

\* Non-stock items – allow 4-6 weeks delivery

0 in stock for immediate delivery. Call Sunnen for available Stone Sets

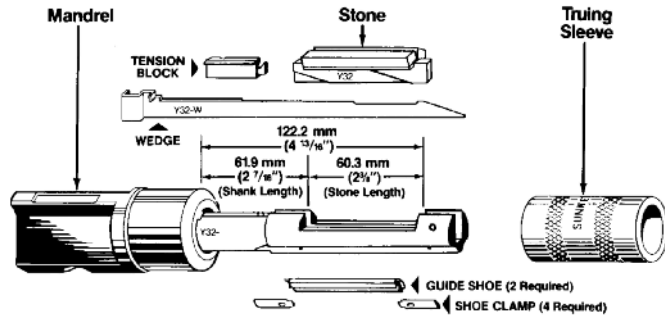


# Keyway Honing Units

## Y32 Keyway Honing Units

Diameter Range: .992" - 1.375"  
(25,20 - 34,93 mm)

For honing parts with keyways, i.e.: harmonic balancers.



## Order 1-4 For Complete Y32 Keyway Honing Units

Diameter Range 25,20 mm - 34,93 mm .992" - 1.375"		① Y32 Mandrel Supplied with a Y32-A Adapter and Wedge	② Truing Sleeve	③ Alignment Bushing*	④ Honing Stone	Replacement Guide Shoes† (2 required)	
mm	inches					With Standard Shank	For machines with fully adjustable spindle nose
25,20-26,97	.992-1.062	Y32-1000PB	S-994	C-1000	See Chart Below	General Purpose Furnished with Mandrel	For hard, rough parts or carbide, ceramic, etc. Order Separately
26,77-28,57	1.054-1.125	Y32-1062PB	S-1062	C-1062		PB-B	PB-H
28,37-30,15	1.117-1.187	Y32-1125PB	S-1125	C-1125		PB-B	PB-H
29,95-31,75	1.179-1.250	Y32-1187PC	S-1187	C-1187		PC-B	PC-H
31,55-33,32	1.242-1.312	Y32-1250PC	S-1250	C-1250		PC-B	PC-H
33,12-34,92	1.304-1.375	Y32-1312PC	S-1312	See note below*		PC-B	PC-H

\*Note: Alignment Bushing - Select the bushing whose bore diameter is just under finish size. When setting up the job for the first time, the undersize alignment bushing can be honed out to finish size with the same tooling used for honing the workpiece.

†Superabrasive Stone Inserted Guide Shoes for situations where a longer life shoe is needed. Contact Customer Service for ordering information. Available 4 weeks after receipt of order.

## Y32 Mandrel Replacement Parts

- Y32-W** Wedge  
Replace when wear begins to show.
- LN-1617A** Shoe Clamp Set  
For Mandrels with PB Suffix.  
4 clamps with screws
- LN-1627A** Shoe Clamp Set  
For Mandrels with PC Suffix.  
4 clamps with screws
- LN-1575A** Tension Block

## ④ Stone Selection Chart

For Steel Applications	<b>Y32-A55</b>
For Bronze and Cast Iron Applications	<b>Y32-J67</b>

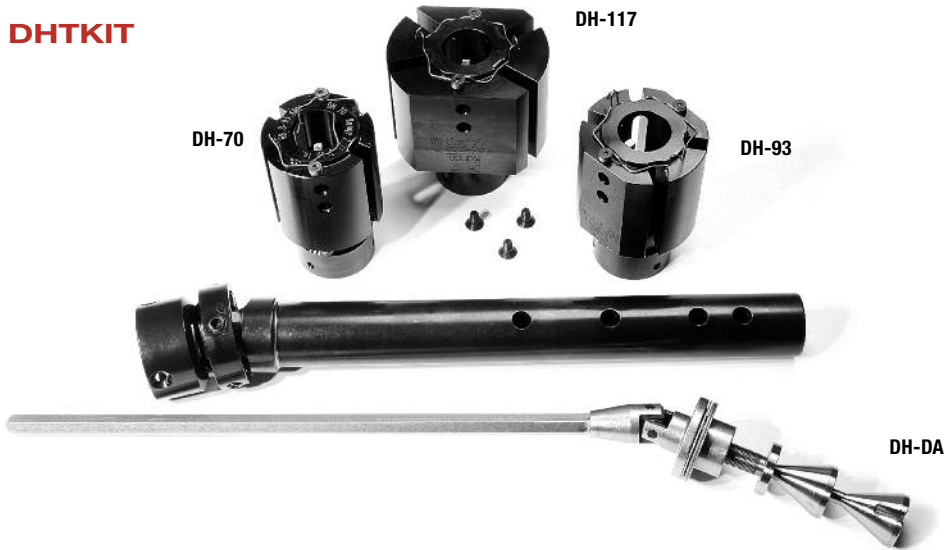
Contact customer service for additional stone selections.





# DH-Series Diamond Hone Heads

## DHTKIT



### Complete System for DHTKIT (2.75" – 5.55") includes:

- DH-DS Drive shaft assembly
- DH-70 hone body
- DH-93 hone body
- DH-117 hone body

### Individual Components

Part No.	Description
DH-DA	Drive shaft assembly only. Common to all hone bodies.
DHT-70	Hone body and drive shaft. Range 2.75"–3.68"
DHT- 93	Hone body and drive shaft. Range 3.68"–4.62"
DHT-117	Hone body and drive shaft. Range 4.62–5.55"

DH-228A Diamond dressing stick

Optional accessories for industrial use:

DH-206 (drive shaft tube) and DH-207 (feed hex rod) are available to lengthen the standard DH-DA drive assembly from 13.5" to 24.5".  
*(Requires stone assemblies shown in table.)*

High Force cone and stone assembly, see next page.

# DH-Series Diamond Hone Heads



## DH Diamond Hone Head Size Ranges

Drive Shaft Assy.	Body	2-Stone*	4-Stone*	PHT Brush*	Minimum		Maximum		Available* Stones	Grit Size
					mm	inches	mm	inches		
DHDA	DHT70	DH2S-1-__	N/A	DH1B-1-534	69,9	2.750	77,7	3.062	NMH35	100
DHDA	DHT70	DH2S-2-__	N/A	DH1B-2-534	77,7	3.062	85,7	3.374	NMH55	220
DHDA	DHT70	DH2S-3-__	DH4S-3-__	DH1B-3-534	85,7	3.374	93,6	3.686	NMH85	400
DHDA	DHT93	DH2S-4-__	DH4S-4-__	DH1B-4-534	93,6	3.686	101,5	3.998	GMB45	150
DHDA	DHT93	DH2S-5-__	DH4S-5-__	DH1B-5-534	101,5	3.998	109,5	4.310	GMH55	220
DHDA	DHT93	DH2S-6-__	DH4S-6-__	DH1B-6-534	109,5	4.310	117,4	4.622	GMH75	320
DHDA	DHT117	DH2S-7-__	DH4S-7-__	DH1B-7-534	117,4	4.622	125,3	4.933	GMH85	400
DHDA	DHT117	DH2S-8-__	DH4S-8-__	DH1B-8-534	125,3	4.933	133,2	5.244	RMH95	500
DHDA	DHT117	DH2S-9-__	DH4S-9-__	DH1B-9-534	133,2	5.244	141	5.555	RMH05	600

Order example: DH2S-1xxx (stone #), DH2S-1NMH65

Call Sunnen for additional stone availability.

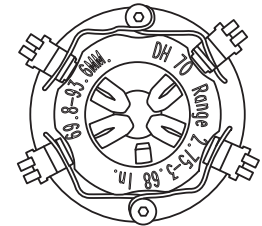
## DHH Diamond Hone Head

High-force Feed Cone and stone sets.  
Check availability for difficult materials.

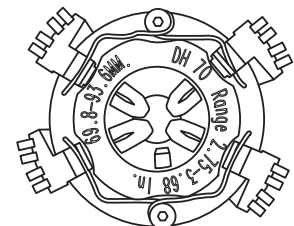
Item Number*	Description
DH229	High-Force Feed Cone
DHH6-GMH__	Diamond Stone Set (Range: 3.680"–3.880") (93, 47-98, 55 mm)
DHH7-GMH__	Diamond Stone Set (Range: 3.880"–4.080") (98, 55-103, 63 mm)
DHH8-GMH__	Diamond Stone Set (Range: 4.080"–4.280") (103, 63-108, 71 mm)
DHH9-GMH__	Diamond Stone Set (Range: 4.280"–4.480") (108, 71-113, 79 mm)
DHH10-GMH__	Diamond Stone Set (Range: 4.480"–4.680") (113, 79-118, 87 mm)
DHH11-GMH__	Diamond Stone Set (Range: 4.680"–4.880") (118, 87-123, 95 mm)
DHH12-GMH__	Diamond Stone Set (Range: 4.880"–5.080") (123, 95-129 mm)
DHHB-6534	PHT Brush Set (Range: 3.680"–3.880") (93, 47-98, 55 mm)
DHHB-7534	PHT Brush Set (Range: 3.880"–4.080") (98, 55-103, 63 mm)
DHHB-5534	PHT Brush Set (Range: 4.080"–4.280") (103, 63-108, 71 mm)
DHHB-9534	PHT Brush Set (Range: 4.280"–4.480") (108, 71-113, 79 mm)
DHHB-10534	PHT Brush Set (Range: 4.480"–4.680") (113, 79-118, 87 mm)

Note: GMH55, GMH75, RMH95 and RMH05 abrasive grades will be set up initially.

## 4 Stone - 8 Cutting Edges



## 4 Stone - 16 Cutting Edges



\* Special order - contact Customer Service for availability.



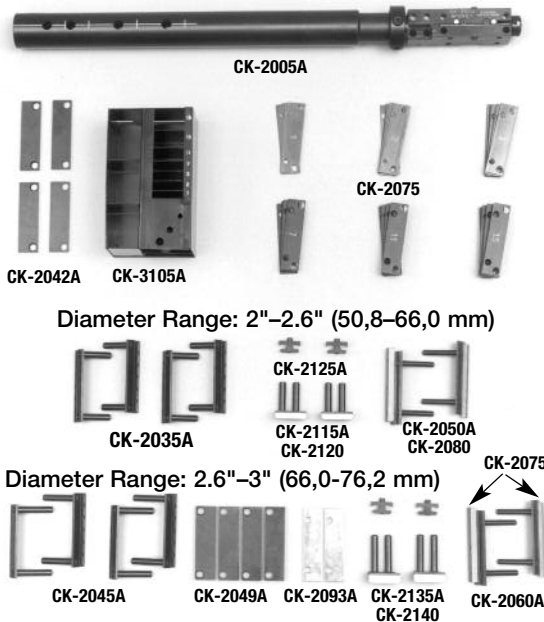
# SV/CV/CK Accessories & Supplies

## CK-2000 Midget Hone Head

Range: 2.000" to 3.000" I.D. (51 mm to 76 mm)

### Basic Parts

Diameter Range: 2" – 3" (50,8 – 76,2 mm)



Diameter Range: 2"-2.6" (50,8-66,0 mm)

Diameter Range: 2.6"-3" (66,0-76,2 mm)

### CK-2075 Shim Kit



(Included with CK-2000 Hone Head)

Kit Includes:

Part No.	Qty.	Description
CK-2071A	8	Guide & Stone #1
CK-2072A	8	Guide & Stone #2
CK-2073A	8	Guide & Stone #3
CK-2074A	4	Guide & Stone #7
CK-2076A	4	Guide & Stone #11
CK-2077A	4	Guide & Stone #15

### CK-2000 Midget Hone Head Set

Part No.	Supplied with CK-2000	Description
CK-1823A	1	Tapered Locking Screw (Not shown)
CK-2005A	1	Midget Head and Tube Assembly
CK-2042A	4	Stone Shim, 1/8" (3,17 mm) (1 per package)
CK-3105A	1	Shim Rack
CK-2075	1 set	Guide Shim Set
CK-2035A	2 sets	Master Stoneholder Set (2 per set)
CK-2050A	2	Main and Centering Guides (Includes CK-2080)
CK-2080	-	Guide Shoe and Screw Set (2 shoes per set) (Included with C-2050A)
CK-2115A	1 set	Alignment Guide Set (2 per set) (Includes CK-2120)
CK-2120	-	Alignment Guide Shoe and Screw Set (2 shoes per set) (Included with CK-2115A)
CK-2125A	4	Clamp (1 per package)
CK-2045A	2 sets	Master Stoneholder Set (2 per set)
CK-2049A	2 sets	Stone Shim Set, 9/32" (7,14 mm) (2 per set)
CK-2060A	2	Main and Centering Guides (Includes CK-2070)
CK-2070	1	1 Guide Shoe and 1 Screw Set (3 per set) (Included with CK-2060A)
CK-2135A	1 set	Alignment Guide Set (2 per set) (Includes CK-2140)
CK-2140	-	Alignment Guide Shoe and Screw Set (2 shoes per set) (Included with C-2135A)
CK-2093A	2	Guide Shim 3/16" (4,75 mm) (1 per package)

### Accessories

(Not included with CK-2000)

#### CK-2040A Midget Storage Rack



For orderly storage of Stoneholders and Alignment Guides.

Shipping Weight: 3 lbs. (1,36 kg)

#### CK-3155A Setting Gage



Indicates shims required to set Guides and Stones to cylinder diameter. Also used to adjust Alignment Guides.

Shipping Weight: 3 1/2 lbs. (1,59 kg) (Used also with CK-2600 and CK-3000 Hone Heads.)

#### CK-3355A Stone Inserter



Changes Stones easily in seconds. Includes mounting bracket.

Shipping Weight: 7-1/2 lbs. (3,40 kg) (Used also with CK-2600 and CK-3000 Hone Heads.)

#### CK-3373A Spring Retainer



Holds the CK-3372 slide in position during stone insertion or removal.

Also used on the CK-4355A inserter.

#### CK-2570 Hard Guide Shoe



For long life in high production shops.

Shipping Weight: 1/2 lb. (.22 kg) (Not recommended with 400 grit or finer stone sets.)

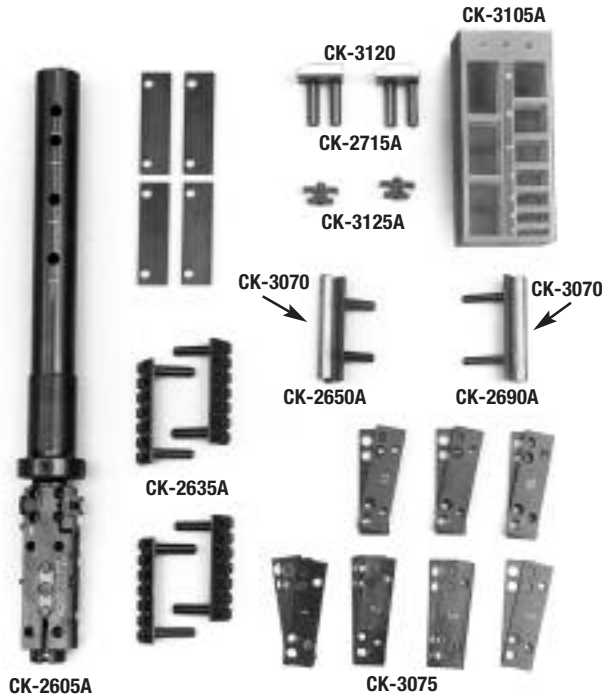
# SV/CV/CK Accessories & Supplies

## CK-2600 Junior Hone Head

Range: 2.600" to 3.500" I.D. (66 mm to 89 mm)

### Basic Parts

Diameter Range: 2.6"-3.5" (66-89 mm)



### CK-2600 Junior Hone Set

Part No.	Supplied with CK-2600	Description
CK-1823A	1	Tapered Locking Screw (Not shown)
CK-2605A	1	Junior Head and Tube Assembly
CK-3042A	4	Stone Shim, 1/4" (6,35 mm) (1 per package)
CK-2715A	1 set	Alignment Guide Set (2 per set) (Includes CK-3120)
CK-3120	-	Alignment Guide Shoe and Screw Set (2 shoes per set) (Included in CK-2715A)
CK-3125A	2	Clamp (1 per package)
CK-3105A	1	Shim Rack
CK-3075	1 set	Guide Shim Set
CK-2635A	2 sets	Master Stoneholder Set (2 per set)
CK-2650A	1	Main Guide (Includes CK-3070)
CK-3070	-	1 Guide Shoe and 1 Screw Set (Included in CK-2650A and CK-2690A)
CK-2690A	1	Centering Guide (Includes CK-3070)

### CK-3075 Shim Kit

(Included with CK-2600 Hone Head)



Kit Includes:

Part No.	Qty.	Description
CK-3071A	8	Guide & Stone #1
CK-3072A	8	Guide & Stone #2
CK-3073A	8	Guide & Stone #3
CK-3074A	4	Guide & Stone #7
CK-3076A	4	Guide & Stone #11
CK-3077A	4	Guide & Stone #15
CK-3078A	4	Guide & Stone #19

Applicable to CK-3000 and CK-2600 Hone Heads.

### Accessories

(Not included with CK-2600)

#### CK-3040A Standard Storage Rack

For orderly storage of Stoneholders and Alignment Guides. Shipping Weight: 3-1/2 lbs. (1,59 kg) (Used also with CK-3000 Hone Head.)



#### CK-3155A Setting Gage

Indicates shims required to set Guides and Stones to cylinder diameter. Also used to adjust Alignment Guides. Shipping Weight: 3-1/2 lbs. (1,59 kg) (Used also with CK-2000 and CK-3000 Hone Heads.)



#### CK-3355A Stone Inserter

Changes Stones easily in seconds. Includes mounting bracket. Shipping Weight: 7-1/2 lbs. (3,40 kg) (Used also with CK-2000 and CK-3000 Hone Heads.)



#### CK-3373A Spring Retainer

Holds the CK-3372 slide in position during stone insertion or removal. Also used on the CK-4355A inserter.



#### CK-3570 Hard Guide Shoe

For long life in high production shops. Recommended for use if honing with diamonds. Shipping Weight: 1/2 lb. (.22 kg) (Not recommended with 400 grit or finer stone sets.)



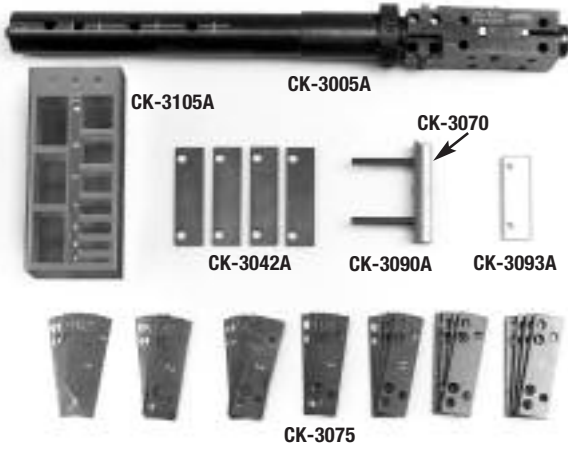
# SV/CV/CK Accessories & Supplies

## CK-3000 Standard Hone Head

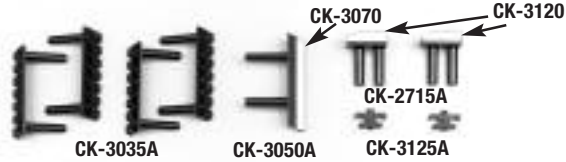
Range: 3.000" to 5.000" I.D. (76 mm to 127 mm)

### Basic Parts

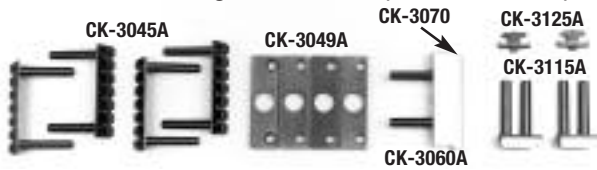
Diameter Range: 3.0"-5.0" (76,2-127,0 mm)



Diameter Range: 3.0"-4.125" (76,2-104,7 mm)



Diameter Range: 4.125"-5.0" (104,7-127,0 mm)



### CK-3000 Standard Hone Set

Part No.	Supplied with CK-3000	Description
CK-1823A	1	Tapered Locking Screw (Not shown)
CK-3005A	1	Standard Head and Tube Assembly
CK-3042A	4	Stone Shim, 1/4" (6,35 mm) (1 per package)
CK-3120	-	Alignment Guide Shoe and Screw Set (2 shoes per set) (Included in C-2715A and C-3115A)
CK-3125A	4	Clamp (1 per package)
CK-3105A	1	Shim Rack
CK-3090A	1	Centering Guide (Includes CK-3070)
CK-2650A	1	Main Guide (Includes CK-3070)
CK-3070	-	1 Guide Shoe and 1 Screw Set (Included in CK-3050A, CK-3060, and CK-3090A)
CK-3093A	1	Centering Guide Shim (Used with CK-3090A)
CK-3075	1 set	Guide Shim Set
CK-3035A	2 sets	Master Stoneholder Set (2 per set)
CK-3050A	1	Main Guide (Includes CK-3070)
CK-2715A	1 set	Alignment Guide Set (2 per set) Range: 3.0"-3.75" (76,2-95,2 mm)
CK-3115A	1 set	Alignment Guide Set (2 per set) Range: 3.25"-5.0" (82,5-127,0 mm)
CK-3045A	2 sets	Master Stoneholder Set (2 per set)
CK-3049A	2 sets	Stone Shim Set 7/16" (11,1 mm) (2 per set)
CK-3060A	1	Main Guide (Includes CK-3070)

### CK-3075 Shim Kit

(Included with CK-3000 Hone Head)



Kit Includes:

Part No.	Qty.	Description
CK-3071A	8	Guide & Stone #1
CK-3072A	8	Guide & Stone #2
CK-3073A	8	Guide & Stone #3
CK-3074A	4	Guide & Stone #7
CK-3076A	4	Guide & Stone #11
CK-3077A	4	Guide & Stone #15
CK-3078A	4	Guide & Stone #19

Applicable to CK-3000 and CK-2600 Hone Heads.

### Accessories

(Not included with CK-3000)

#### CK-3040A Standard Storage Rack

For orderly storage of Stoneholders and Alignment Guides.  
Shipping Weight: 3-1/2 lbs. (1,59 kg)  
(Used also with CK-2600 Hone Head.)



#### CK-3155A Setting Gage

Indicates shims required to set Guides and Stones to cylinder diameter. Also used to adjust Alignment Guides.  
Shipping Weight: 3-1/2 lbs. (1,59 kg)  
(Used also with CK-2000 and CK-2600 Hone Heads.)



#### CK-3355A Stone Inserter



Changes Stones easily in seconds. Includes mounting bracket.  
Shipping Weight: 7-1/2 lbs. (3,40 kg)  
(Used also with CK-2000 and CK-2600 Hone Heads.)

#### CK-3373A Spring Retainer

Holds the CK-3372 slide in position during stone insertion or removal.  
Also used on the CK-4355A inserter.



#### CK-3570 Hard Guide Shoe

For long life in high production shops. Recommended for use if honing with diamonds.  
Shipping Weight: 1/2 lb. (.22 kg) (Not recommended with 400 grit or finer stone sets.)

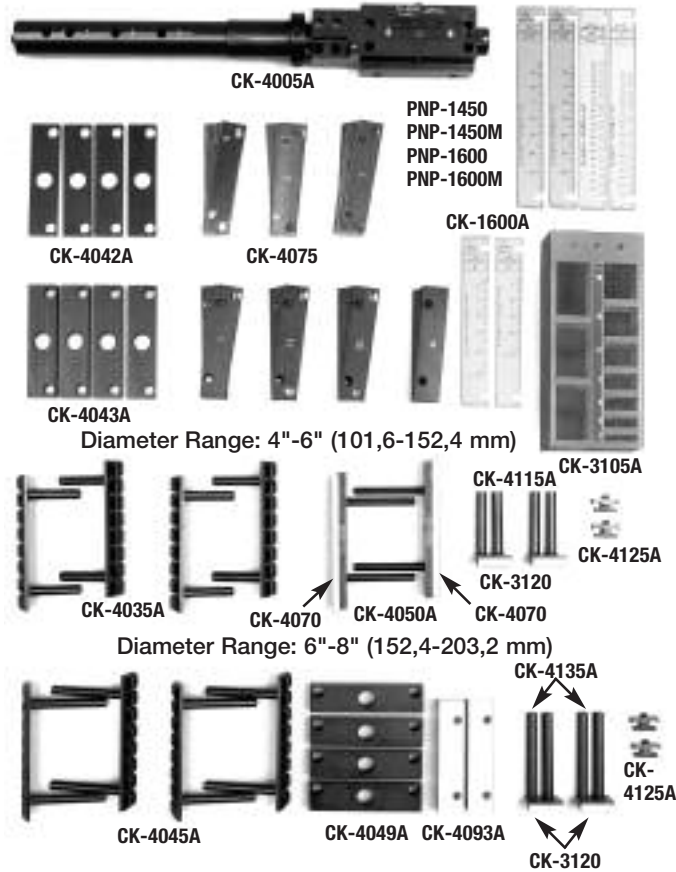


# SV/CV/CK Accessories & Supplies

## CK-4000 Large Hone Head Range: 4.00" to 8.000" I.D. (102 mm to 203 mm)

### Basic Parts

Diameter Range: 4"-8" (101,6-203,2 mm)



### CK-4000 Large Hone Set

Part No.	Supplied with CK-4000	Description
CK-1823A	1	Tapered Locking Screw (Not shown)
CK-4005A	1	Large Head and Tube Assembly
CK-4042A	4	Stone Shim, 1/4" (6,35 mm) (1 per package)
CK-4043A	4	Stone Shim, 1/2" (12,7 mm) (1 per package)
CK-3105A	1	Shim Rack
CK-4125A	4	Clamp (1 per package)
CK-1450A	1	Graduated Stroke Plate, for 4-1/2" (114,3 mm) stones (CK-10 Machines)
CK-1600A	1	Graduated Stroke Plate, for 6" (152,4 mm) stones (CK-10 Machines)
PNP-1450M	1	Graduated Stroke Plate, metric version of PNP-1600
PNP-1600	1	Graduated Stroke Plate, for 6" (152,4 mm) stones (CV-616 Machines)
PNP-1600M	1	Graduated Stroke Plate, metric version of PNP-1600
CK-4075	1 set	Guide Shim Set
CK-4035A	2 sets	Master Stoneholder Set (2 per set)
CK-4050A	2	Main and Centering Guide (Includes CK-4070)
CK-4070	-	1 Guide Shoe & 1 Screw Set (Included with CK-4050A)
CK-4115A	1 set	Alignment Guide Set (2 per set) (Includes CK-3120)
CK-3120	-	1 Guide Shoe and 1 Screw Set (2 per set) (Included with CK-4115A and CK-4135A)
CK-4045A	2 sets	Master Stoneholder Set (2 per set)
CK-4049A	2 sets	Stone Shim Set, 3/4" (19,0 mm) (2 per set)
CK-4093A	2	Main & Centering Guide Shims (1 per package)
CK-4135A	1 set	Alignment Guide Set (2 per set) (Includes CK-3120)

### CK-4075 Shim Kit

(Included with CK-4000 Hone Head)



Kit Includes:

Part No.	Qty.	Description
CK-4071A	8	Guide & Stone #1
CK-4072A	8	Guide & Stone #2
CK-4073A	8	Guide & Stone #3
CK-4074A	4	Guide & Stone #7
CK-4076A	4	Guide & Stone #11
CK-4077A	4	Guide & Stone #15
CK-4078A	4	Guide & Stone #19

### Accessories

(Not included with CK-4000)

#### CK-4040A Large Storage Rack

For orderly storage of Stoneholders and Alignment Guides.

Shipping Weight: 10 lbs. (4,54 kg)



#### CK-4155A Setting Gage

Indicates shims required to set Guides and Stones to cylinder diameter. Also used to adjust Alignment Guides.

Shipping Weight: 3-1/2 lbs. (1,59 kg)



#### CK-4355A Stone Inserter

Changes stones easily in seconds. Includes mounting bracket.

Shipping Weight: 9-1/2 lbs. (4,31 kg)



#### CK-3373A Spring Retainer

Holds the CK-4372 slide in position during stone insertion or removal.

Also used on the CK-3355A inserter.



#### CK-4570 Hard Guide Shoe

For long life in high production shops. Recommended for use if honing with diamonds. Shipping Weight: 1/2 lb. (.22 kg) (Not recommended with 400 grit or finer stone sets.)



# SV/CV/CK Accessories & Supplies

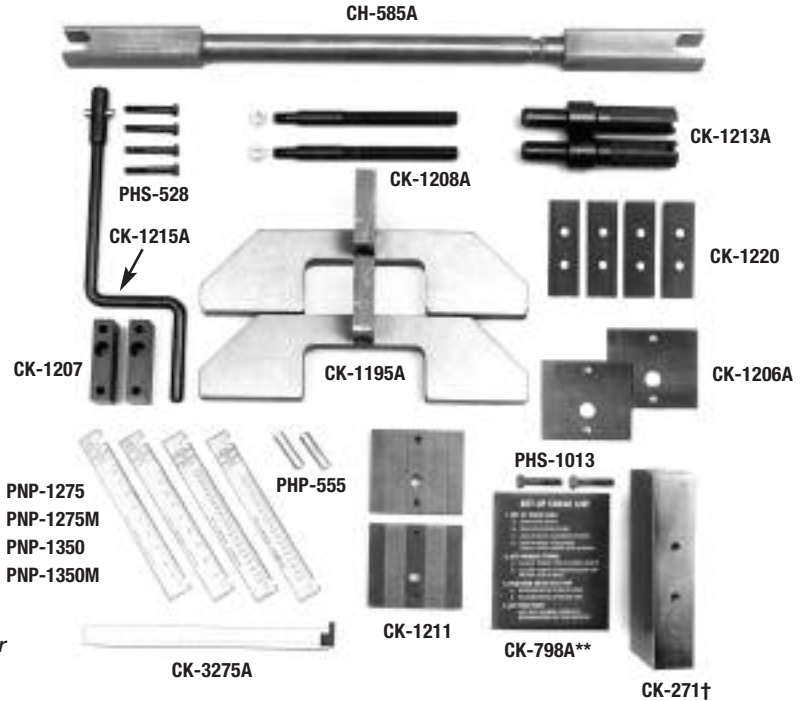
## CK-1200 Clamp Kit for CV-616

The CK-1200 clamp kit consists of all parts to configure the CV-616 cradle to engine block work.

Shipping Weight: 97 lbs. (44,1 kg).

**Kit Includes:**

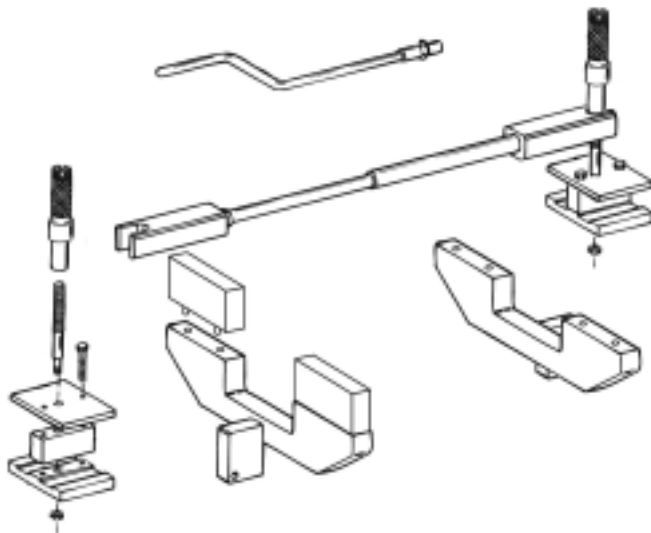
Part No.	Description
CH-585A	Clamp Bar Set
PHS-528	Bolts, 3/8-16 x 2-1/2" hex head cap screw
CK-1206A	Lower Plate
CK-1211	Upper Plate
CK-1207	Blocks
CK-1220	Riser Blocks
PHP-555	Groove Pin
CK-1195A	Cross Bar Assembly
CK-1213A	Clamp Nut, Knurled
CK-1208A	Stud
PHN-107	Lock Nut
CK-1215A	Crank Assembly
CK-3275A	Hook Rule, Inch and Metric Scale
PNP-1275	Stroke Scale, 2-3/4" Stone Length
PNP-1275M	Stroke Scale, 69,8 mm Stone Length
PNP-1350	Stroke Scale, 3-1/2" Stone Length
PNP-1350M	Stroke Scale, 88,9 mm Stone Length
PHS-1013*	Hex Head Cap Screws (2)



\*Included in CK-1200 Clamp Kits. Required on CV-616 after serial number 4357. Not required on previous machines.

†CK-798A Instruction Plate and CV-271 Weight Block not included in kit. Available separately.

## SV-6200 Clamp Kit for SV-10



**Kit Includes:**

Part No.	Qty.	Description
SV-6200		Clamp Kit (includes:)
CH-590	1	Outside Clamp Bar
CH-585	1	Inside Clamp Bar
CK-1195	2	Cross Bar Assy
CK-1220	4	Riser Block
CK-1215A	1	Crank Assembly
CK-1213A	2	Clamp Nut
CK-1206A	2	Plate and Block Kit (includes:)
CK-1206	2	Lower Plate
CK-1207	2	Block
CK-1211	2	Top Clamp Plate
PHS-528	4	Screw (3/8-16 x 2-1/2 HHCS)
CK-1208	2	Stud (with:)
PHN-107	2	Locknut (9/16-18)
CK-3275	1	Hook Rule
ISV-620	1	Instruction

# SV/CV/CK Accessories & Supplies

## Tooling for Resizing High-Silicon Aluminum Alloy Blocks

Porsche, Mercedes Benz, Honda, BMW

High silicon aluminum die-cast blocks do not require a steel or cast iron liner in the cylinder bore. Pure particles of silicon, about .001" (0,03 mm) in diameter, are dispersed in the aluminum alloy. To achieve a proper surface finish, the cylinders should be prepared so piston and rings contact only silicon. Silicon is very hard, so there will be very little wear in the cylinder bore. The aluminum's function is merely to "hold" the silicon particles which actually form the wall.

Excessively scored or worn cylinders can be reconditioned to accept oversize pistons. A special "Conditioning" operation is needed to remove aluminum from and between the silicon particles so the wall will be a silicon wall.

Tooling required:

Part No.	Description
MB-30	Honing Oil
C30-F85	Felt Set
C30-J55	Stones
AN-30	Silicon Compound
AN-35	Storage Box
C30-J84	Stones
CK-3035A	Master Holder Set, Stones
CK-3130A	Master Holder Set, Felts
C30-C03-81	Polishing Stones

## CK-234A Gear Set

Replacement fiber planetary gear set for the SV-10, CV-616 and CK-10 handwheel assembly.



## CV-110 Fiber Mats for CV-616, CK-10, CH-100, CK-21 and SV-10

These mats remove the coarse swarf produced during honing before it enters the machine sump. They extend the time between cleaning the machine sump and also extend filter and pumping system life. Five to the std. package. Measures 53" x 34" (134 x 86 cm)



## CK-448A Gearbox Oil

CK-448A is a sulphur-free gearbox lubricant used in the SV-10, CV-616 and LBB-1810 transmission case. Quart (.95 liter). *Note: Use of 90 wt. hypoid lubricant will cause premature gearbox wear and is not recommended.*



## CK-1436A Cover and Glass

For CK/CV load meter. *Shipping Weight: 1/2 lb. (.22 kg)*



## CK-1442A Replacement Amber Lens

For Dwell Light.



## CK-1444A Replacement Bulb



For Motor On and Dwell Indicator Lights.

## CV-616 Replacement Belts

Part No.	Description
CK-252A	Timing Belt
CK-192A	Flat Belt
CK-209A	"V" Belt, Upper
CK-498A	"V" Belt, Lower
CK-1267A	"V" Belt, Blower



## SV-10 Replacement Belts

PDB-341 Stroker Belt  
PDB-342 Drive Belt

## FL6X Portable Tool Adapter for CV-616, CK-21 and SV-10



For use on applications larger than 8" in diameter or for parts with keyways, where standard CV/CK tooling will not work. Order MPS and AN hone heads separately-  
Special order-

Call Sunnen for availability.

## PF-244A Gasket for Canister Lid

## CK-3410A Lamp and Bracket Assembly

The CK-3410A is equipped with an 8' long cord with moulded on ground plug. It is offered in 115 volt, single phase only and will plug into any standard 3-wire convenience outlet. The unit is supplied with a clamp for attachment to the control station arm. (Takes 100 watt maximum incandescent bulb; bulb not included.) *Shipping Weight: 7 lbs. (3,18 kg)*



## CV-1010 Mandrel Adapter for use on CV-616, CK-10, CK-21 or SV-10



The CV-1010 adapts standard mandrels in applications where the standard hone heads do not apply. Minimum diameter .75" (19 mm). Mandrel not included. *Shipping Weight: 7-1/2 lbs. (3,41 kg)*

## Stroke Scale Plates for CV-616 Cylinder King

Part No.	Stone Length
PNP-1275	3/4" (69,8 mm)
PNP-1350	1/2" (88,9 mm)
PNP-1450	1/2" (114,3 mm)
PNP-1600	6" (152,4 mm)
CV-1285 (not shown)	9" (228,6 mm)



For metric, add "M" to the part number.

# SV/CV/CK Accessories & Supplies

## Honing Stone Sets for Use With the CV/CK

	For Diameter Range		Used with Master Holder Set	Order These Stone Sets		Stone Length		Applications
	inches	mm		Roughing	Finishing	inches	mm	
Midget Hone Head 6 sets per box	2.0-2.7	50,8-68,6	CK-2035A	EEU-129	EEU-522	2-3/4	60,8	Hard Blocks
	2.0-2.7	50,8-68,6	CK-2035A	EEU-141	EEU-531	2-3/4	60,8	Standard Type Blocks
	2.0-2.7	50,8-68,6	CK-2035A	EEU-141	C20-J65-91*	2-3/4	60,8	Alum. Cylinders (Special Finish Stones)
	2.4-2.7	60,9-68,6	CK-2035A	EAU-129	EAU-522	2-3/4	60,8	Hard Blocks
	2.4-3.0	60,9-76,2	CK-2035A	—	C24-A45	3	76,2	Base Finishing before Plateau Honing
	2.4-2.7	60,9-68,6	CK-2035A	EAU-141	EAU-531	2-3/4	60,8	Standard Type Blocks
	2.4-2.7	60,9-68,6	CK-2035A	EAU-141	C24-J65-91*	2-3/4	60,8	Alum. Cylinders (Special Finish Stones)
	2.4-3.0	60,9-76,2	CK-2035A	—	C24-A45	3	76,2	Base Finishing before Plateau Honing
	2.7-3.0	68,6-76,2	CK-2045A	EAU-129	EAU-522	2-3/4	60,8	Hard Blocks
	2.7-3.0	68,6-76,2	CK-2045A	EAU-141	EAU-531	2-3/4	60,8	Standard Type Blocks
Junior Hone Head 6 sets per box	2.6-3.5	66,0-88,9	CK-2635A	EMN-123	EMN-525	3-1/2	88,9	Cylinders with Ports
	2.6-3.5	66,0-88,9	CK-2635A	EMU-123	EMU-518	2-3/4	60,8	Hard Blocks and Sleeves
	2.6-3.5	66,0-88,9	CK-2635A	EMU-133	EMU-525	2-3/4	60,8	Standard Type Blocks
	2.75-3.5	69,8-88,9	CK-2635A	EKN-123	EKN-525	3-1/2	88,9	Cylinders with Ports
	2.75-3.5	69,8-88,9	CK-2635A	—	EKN-512	3-1/2	88,9	Special Applications
	3.0-3.5	76,2-88,9	CK-2635A	—	EHU-412	2-3/4	60,8	Base Finishing before Plateau Honing
	3.0-3.5	76,2-88,9	CK-2635A	EHN-116	EHN-512	3-1/2	88,9	VW, Mercedes, High Nickel Race Blocks
	3.0-3.5	76,2-88,9	CK-2635A	EHN-123	EHN-518	3-1/2	88,9	Air Cooled Cylinders
	3.0-3.5	76,2-88,9	CK-2635A	EHN-133	EHN-525	3-1/2	88,9	Special Applications
Standard Hone Head 6 sets per box	3.0-4.125	76,2-104,8	CK-3035A	EKU-133	EKU-525	2-3/4	60,8	Standard Type Blocks
	3.25-4.125	82,5-104,8	CK-3035A	—	AHU-425	2-3/4	60,8	Aircraft Type Cylinders
	3.25-4.125	82,5-104,8	CK-3035A	—	AHU-425-01A	2-3/4	60,8	Aircraft Type (Hard Tip)
	3.25-4.125	82,5-104,8	CK-3035A	EHN-123	EHN-518	3-1/2	88,9	Air Cooled Cylinders
	3.25-4.125	82,5-104,8	CK-3035A	EHU-123	EHU-518	2-3/4	60,8	Hard Blocks and Sleeves
	3.25-4.125	82,5-104,8	CK-3035A	EHN-116	EHN-512	3-1/2	60,8	Hard Blocks and Sleeves
	3.25-4.125	82,5-104,8	CK-3035A	—	EHU-412	2-3/4	60,8	Base Finishing before Plateau Honing
	3.25-4.125	82,5-104,8	CK-3035A	EHU-133	EHU-525	2-3/4	60,8	Standard Type Blocks
	3.25-4.125	82,5-104,8	CK-3035A	—	JHU-525*	2-3/4	60,8	Aluminum Blocks, Alum. Cylinders
	3.25-4.125	82,5-104,8	CK-3035A	—	JHU-623*	2-3/4	60,8	High Nickel Race Blocks, Alum. Cylinders
	3.25-4.125	82,5-104,8	CK-3035A	—	JHU-625*	2-3/4	60,8	Alum. Cylinders (Special Finish Stones)
	3.25-4.125	82,5-104,8	CK-3035A	—	JHU-818*	2-3/4	60,8	High Nickel Race Blocks, Alum. Cylinders
	3.25-4.125	82,5-104,8	CK-3035A	—	JHU-820*	2-3/4	60,8	Alum. Cylinders (Special Finish Stones)
	3.25-4.125	82,5-104,8	CK-3035A	—	C30-C03-81*	2-3/4	60,8	Polishing
	4.125-5.0	104,8-127,0	CK-3045A	—	AHU-425	2-3/4	60,8	Aircraft Type Cylinders
	4.125-5.0	104,8-127,0	CK-3045A	EHN-123	EHN-518	3-1/2	88,9	Air Cooled Cylinders
	4.125-5.0	104,8-127,0	CK-3045A	EHU-123	EHU-518	2-3/4	60,8	Hard Blocks and Sleeves
	4.125-5.0	104,8-127,0	CK-3045A	EHN-116	EHN-512	3-1/2	60,8	Hard Blocks and Sleeves
	4.125-5.0	104,8-127,0	CK-3045A	—	EHU-412	2-3/4	60,8	Base Finishing before Plateau Honing
	4.125-5.0	104,8-127,0	CK-3045A	EHU-133	EHU-525	2-3/4	60,8	Standard Type Blocks
	4.125-5.0	104,8-127,0	CK-3045A	—	JHU-525*	2-3/4	60,8	Aluminum Blocks, Alum. Cylinders
	4.125-5.0	104,8-127,0	CK-3045A	—	JHU-623*	2-3/4	60,8	High Nickel Race Blocks, Alum. Cylinders
	4.125-5.0	104,8-127,0	CK-3045A	—	JHU-625*	2-3/4	60,8	Alum. Cylinders (Special Finish Stones)
4.125-5.0	104,8-127,0	CK-3045A	—	JHU-818*	2-3/4	60,8	High Nickel Race Blocks, Alum. Cylinders	
4.125-5.0	104,8-127,0	CK-3045A	—	JHU-820*	2-3/4	60,8	Alum. Cylinders (Special Finish Stones)	
4.125-5.0	104,8-127,0	CK-3045A	—	C30-C03-81*	2-3/4	60,8	Polishing, Plateau Honing	
Large Hone Head 1 set per box	4.0-6.0	101,6-152,4	CK-4035A	JUA-222	JUA-520	6	152,4	Hard Cylinders with Ports
	4.0-6.0	101,6-152,4	CK-4035A	JUG-222	JUG-520	4-1/2	114,3	Hard Cylinders
	4.0-6.0	101,6-152,4	CK-4035A	EUA-107	EUA-510	6	152,4	Cylinders with Ports
	4.0-6.0	101,6-152,4	CK-4035A	—	C40-A45	6	152,4	Base Finishing before Plateau Honing
	4.0-6.0	101,6-152,4	CK-4035A	EUG-113	EUG-514	4-1/2	114,3	Standard Type Blocks
	6.0-8.0	152,4-203,2	CK-4045A	EUA-107	EUA-510	6	152,4	Cylinders with Ports
	6.0-8.0	152,4-203,2	CK-4045A	—	C40-A45	6	152,4	Base Finishing before Plateau Honing
	6.0-8.0	152,4-203,2	CK-4045A	EUG-113	EUG-514	4-1/2	114,3	Standard Type Blocks
	6.0-8.0	152,4-203,2	CK-4045A	JUA-222	JUA-520	6	152,4	Hard Cylinders with Ports
6.0-8.0	152,4-203,2	CK-4045A	JUG-222	JUG-520	4-1/2	114,3	Hard Cylinders	

\*For special honing applications, contact the Sunnen Customer Service Department.

# SV/CV/CK Accessories & Supplies

## Stone Sets for High Performance Engines Honed on Sunnen CV-616, CK-10 and SV-10



These Stone Sets are available for producing specific finishes for high performance engines. Contact Customer Service, Sunnen Products Co. for full details. As a general rule, however, on standard cast iron blocks the following surface finish will be produced:

Stone Set	Approx. Surface Finish	
	Microinches Ra	Micrometers Ra
EHU-412	47-52	1,1-1,3
EHN-512	40-48	1,0-1,2
JHU-525	30-36	,75-,91
JHU-623	20-25	,50-,63
JHU-818	7-14	,18-,35
C30-C03-81	3-5	,07-,12

The surface finishes listed above were produced by honing a late model 350 cid Chevy small block. Finishes may vary due to variations in cast iron alloys, feed rates and honing oil used.

*Note: Some stones can be used for different diameter ranges, depending upon which Master Holder Set is used. Once a stone is inserted into the master holder, it must not be removed until replacement is necessary.*

Other abrasives are available for special applications. Call Customer Service, Sunnen Products Co. for information.



## PHT Plateau Honing Tool

CV/CK Hone Head	For Diameter Range		Abrasive Sets (320 GRIT)
	Inches	mm	
Midget	2.00-2.40	50,8-60,9	C20-PHT-732
	2.30-2.90	58,4-73,7	C24-PHT-732
Junior	2.90-3.40	73,7-86,4	C30-PHT-731
Standard	3.10-5.00	78,7-127,0	C30-PHT-731
Large	4.00-6.00	101,6-152,4	C40-PHT-731
	6.00-8.00	152,4-203,2	C40-PHT-731

## AN-980 Chamfering Cone



Chamfers the sharp edges of cylinders for safe piston and ring installation. Handles all diameter cylinders or sleeves. Unit consists of tapered neoprene cone covered by long-lasting replaceable abrasive cone (plus a spare). Easy to use with 1/4" (6,3 mm) or larger drill.

*Shipping Weight: 1-1/2 lbs. (.68 kg)*

6 Replacement Cones in Package: Order AN-994A

*Shipping Weight: 1 lb. (.45 kg)*

AN-980 Replacement Parts

AN-991A Extension

AN-986A Rubber Cone

## How to Read Grit Size

The first numeral in the stone code designates the grit size. As shown in the examples below, the "1" in EEU-129 designates that the grit size is 70, as the "8" in JHU-820 designates a 400-grit stone.

Part No.	Description
100 Series	(example: EEU-129) - 70 grit
200 Series	(example: JUA-222) - 80 grit
400 Series	(example: EHU-412) - 150 grit
500 Series	(example: EHU-525) - 220 grit
600 Series	(example: JHU-625) - 280 grit
800 Series	(example: JHU-820) - 400 grit
CO Series	(example: C30-C03-81) - 600 grit

## CK-3030A Diamond Stone Master Holder Set



*Note: Diamond stone master holders are available for the CK-2000 and CK-4000 hone heads. Write for bulletin #P-3404 and P-3405 or call Customer Service, Sunnen Products Co. for information.*

## Sunnen Cylinder Reconditioning-Diamond Tooling CV, CK or SV Applications

The following parts are required for use with Sunnen Diamond Stones using the CV-616 or CK-10 with the hone heads listed as follows:

### Standard Hone Head

Part No.	Description
CK-3000	Hone Head Range 3.000" to 5.000" (76,2-127,0 mm)
CK-3030A	Stone Holder Set-Range 3.300" to 4.625" (83-117,5 mm)
CK-3570	Hard Guide Shoe
PNP-1275	Standard Stroke Scale Plate
CK30-DM100	Stone Set-Roughing

### Junior Hone Head

Part No.	Description
CK-2600	Hone Head Range 2.600" to 3.500" (66,0-88,9 mm)
CK-3030A*	Stone Holder Set-Range 3.000" to 4.300" (76,2-109,2 mm)
CK-3570	Hard Guide Shoe
PNP-1275	Standard Stroke Scale Plate
CK30-DM100	Stone Set-Roughing

*\*Note: One-eighth inch will have to be ground off of each pin, and customer must make this alteration to meet the range.*

*Special Instructions: The CK-3030A ranges as shown for each hone head are what control the diameter range in which the diamond stones, using this tooling, can be used.*

*Order CK-1860A Thrust Bearing for Super Abrasive Honing. The Standard Bearing will fail prematurely under these loads.*

*Use a Feed Rate which doesn't peg the Load Meter.*

*For Metal Bond Super Abrasive use in the Large Hone Head, call Customer Service, Sunnen Products Co.*

*Use of hardened guide shoes is recommended when using diamond stone sets.*

*†CK-3570 must be mounted on the CK-3050A Main Guide Holder*

*Note: For Diamond Abrasives for Rottler and K-Line hone heads see page 28.*



# SV-300 Series Vertical Honing Machine

## Tooling and Abrasives

### GHSS-2440 Hone Head

Range: 2.44"–2.83" (62,0 mm–71,8 mm)

Part No.	Qty.	Description
F504-3	2	Retaining Spring For Stones
G14C251-1A	6	Stoneholder: .250" (6 mm) High Range: 2.44"–2.58" (62–66 mm)
G14C251-2A	6	Stoneholder: .312" (8 mm) High Range: 2.56"–2.70" (65–69 mm)
G14C233-1A	6	Stoneholder: .375" (9,5 mm) High Range: 2.69"–2.83" (68 mm–72 mm)
PHSM613	1	Stoneholder Clamp Plate Screw: Use with GHG14C251 Series Stoneholders
PHSM402	1	Stoneholder Clamp Plate Screw: Use with GHG14C233 Series Stoneholders
G17B382	1	Expansion Screw
F475-37	2	Thrust Washer
F475-38	1	Thrust Bearing
F505-3	2	Shear Pin Ref: 1/8" Dia. x 1/2" Long
F310-17	1	Universal Joint
G18C234	1	Driveshaft
F439-37	1	Universal Joint Boot
F512-1	2	Univ. Joint Boot Tie Strap
GH-80049		Truing Grit (70 Grit)
GH-50		Spring Tool

### GHSS-2800 Hone Head

Range: 2.80"–3.56" (71,2 mm–90,4 mm)

Part No.	Qty.	Description
GHF504-2	2	Retaining Spring For Stones
GHG14C233-1	6	Stoneholder: .375" (9,5 mm) High Range: 2.80"–3.06" (71–76 mm)
GHG14C233-4	6	Stoneholder: .500" (12,7 mm) High Range: 3.05"–3.31" (77–84 mm)
GHG14C233-3	6	Stoneholder: .625" (16 mm) High Range: 3.30"–3.56" (84–90 mm)
PHSM402	1	Stoneholder Clamp Plate Screw
GHG17B382	1	Expansion Screw
GHF475-37	2	Thrust Washer
GHF475-38	1	Thrust Bearing
GHF505-3	2	Shear Pin Ref: 1/8" Dia. x 1/2" Long
GHF310-17A	1	Universal Joint
GHG18C233	1	Driveshaft
GHF439-36	1	Universal Joint Boot
GHF512-1	2	Univ. Joint Boot Tie Strap
GH-80049		1pt. Truing Grit (70 Grit)
GH-50		Spring Tool

**NOTE FOR ALL HONE HEADS: Universal joint area must be packed with mobil grease #28 before boot is in place. Sunnen Part #SML-100.**

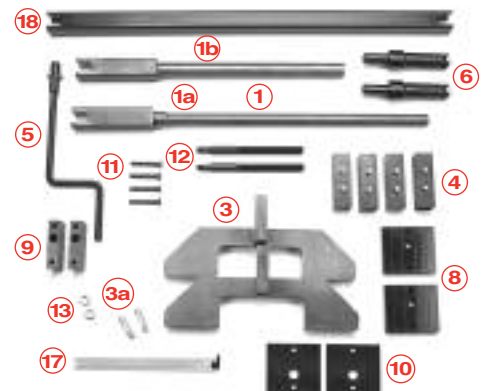
### GHSS-3410 Hone Head

Range: 3.41"–4.44" (86,6 mm–112,7 mm)

Part No.	Qty.	Description
GHF-504-1	2	Retaining Spring For Stones
GHG14C233-7	8	Stoneholder: .447" (11,3 mm) High Range: 3.41"–3.69" (87–94 mm)
GHG14C233-8	8	Stoneholder: .582" (15 mm) High Range: 3.68"–3.96" (93–101 mm)
GHG14C233-9	8	Stoneholder: .717" (18 mm) Range: 3.95"–4.23" (100–107 mm)
GHG14C233-10	8	Stoneholder: .852" (21,6 mm) High Range: 4.22"–4.44" (107–113 mm)
PHSM402	1	Stoneholder Clamp Plate Screw Ref: 5.0 x 8 x 16 mm SHCS
GHG17B341	1	Expansion Screw
GHF475-31	2	Thrust Washer
GHF475-30	1	Thrust Bearing
GHG20A177	1	Spacer
GHF505-3	2	Shear Pin Ref: 1/8" Dia. x 1/2" Long
GHG15A167	1	Universal Block
GHF310-16	1	Universal Joint
GHG18C222	1	Driveshaft
GHF439-27	1	Universal Joint Boot
PHSM623	8	Butt. HD. Cap Screw Ref: 4,0 x 7 x 8 mm B.H.C.S
GH-80049		Truing Grit (70 Grit)
GH-50		Spring Tool

### CK-6200 Clamp Kit for CK-21 includes:

Item No.	Part Number	Qty.	Description	Item No.	Part Number	Qty.	Description
1	CH-585A	1	Clamp Bar Assembly (includes 1a, 1b)	7	CK-1206A	1	Plate and Block Assembly (Pkg. of 1 includes 8, 9, 10, 11)
1a	CH-585	1	Clamp Bar, Inside	8	CK-1206	1	Plate, Lower
1b	CH-590	1	Clamp Bar, Outside	9	CK-1207	1	Block
3	CK-1195A	2	Cross Bar Assembly	10	CK-1211	1	Clamp Plate, Top
3a	PHP-555	1	Pin, Groove	11	PHS-528	2	Screws, 3/8-16 x 2-1/2", Hex Hd. Cap
4	CK-1220	4	Block, Riser	12	CK-1208A	2	Stud (Pkg. of 1 includes 13)
5	CK-1215A	1	Crank Assembly	13	PHN-107	2	Locknut (Flexloc #31FK-918)
6	CK-1213A	2	Clamp Nut (Pkg. of 1)	17	CK-3275A	1	Hook Rule (Inch and Metric Scales)
				18	CK-1237	1	Bar



Note: Guide pot automated rollover fixtures (for SV-310) are available for production engine rebuilders. Call customer service, 1-800-772-2878, for information.

# SV-300 Series Vertical Honing Machine

## Accessories and Supplies

Hone Head	Diameter Range		Holder Set Part #	# Per Set	Stone Sets (.....) = Abrasive Spec	Available Abrasive Spec <sup>2</sup>		PHT Brush 1 Per Box (.....) =PHT Spec	Available PHT Specs
	Inches	mm							
GHSS-1480	1.48-1.56	37,59-39,62	N/A	6	GH258-1-(.....)	Plan for 2 week delivery of abrasives		Not Available	231 = (80 GRIT) 731 = (320 GRIT) *THESE SIZES ARE NOT IN STOCK AT TIME OF PRINTING
	1.56-1.64	39,62-41,66	N/A	6	GH258-2-(.....)	GMG55 GMG85	NMG37 NMG65 NMG85 NMG05	Not Available	
	1.64-1.72	41,66-43,69	N/A	6	GH258-3-(.....)			GH258-3-PHT-(...)	
	1.72-1.80	43,69-45,72	N/A	6	GH258-4-(.....)			GH258-4-PHT-(...)*	
	1.80-1.88	45,72-47,75	N/A	6	GH258-5-(.....)			GH258-5-PHT-(...)	
	1.88-1.96	47,75-49,78	N/A	6	GH258-6-(.....)			GH258-6-PHT-(...)*	
GHSS-1950	1.95-2.16	49,53-54,86	N/A	6	GH258-3-(.....)			GMG55	NMG37
	2.11-2.32	53,59-58,93	N/A	6	GH258-5-(.....)	GMG85	NMG65	GH258-5-PHT-(...)	
	2.27-2.48	57,69-62,99	N/A	6	GH258-7-(.....)		NMG85 NMG05	GH258-7-PHT-(...)	
GHSS-2440 <sup>1</sup>	2.44-2.58	61,97-65,53	GHG14C251-241A	6	GH236-(.....)-E			GH251-1-PHT-(...)	231 = (80 GRIT) 331 = (120 GRIT) 531 = (180 GRIT) 731 = (320 GRIT)
	2.56-2.70	65,02-68,58	GHG14C251-242A	6				GH251-2-PHT-(...)	
	2.69-2.83	68,32-71,88	GHG14C233-281A	6				GH233-1-PHT-(...)	
GHSS-2800 <sup>1</sup>	2.80-3.06	71,12-77,72	GHG14C233-281A	6	GH236-(.....)-E			GH233-1-PHT-(...)	231 = (80 GRIT) 331 = (120 GRIT) 531 = (180 GRIT) 731 = (320 GRIT)
	3.05-3.31	77,47-84,07	GHG14C233-284A	6				GH233-4-PHT-(...)	
	3.30-3.56	83,82-90,42	GHG14C233-283A	6				GH233-3-PHT-(...)	
GHSS-3410 <sup>1</sup>	3.68-3.96	86,61-93,72	GHG14C233-347A	8	GH233-(.....)-E			GH233-7-PHT-(...)	231 = (80 GRIT) 331 = (120 GRIT) 531 = (180 GRIT) 731 = (320 GRIT)
	3.41-3.69	93,47-100,58	GHG14C233-348A	8				GH233-8-PHT-(...)	
	3.95-4.23	100,33-107,44	GHG14C233-349A	8				GH233-9-PHT-(...)	
	4.22-4.44	107,18-112,77	GHG14C233-3410A	8				GH233-10-PHT-(...)	
GH4SS-3410 <sup>1</sup>	3.41-3.69	86,61-93,72	GHG14C233-347A	4	GH234-(.....)-E			GH233-7-PHT-(...)	231 = (80 GRIT) 331 = (120 GRIT) 531 = (180 GRIT) 731 = (320 GRIT)
	3.68-3.96	93,47-100,58	GHG14C233-348A	4				GH233-8-PHT-(...)	
	3.95-4.23	100,33-107,44	GHG14C233-349A	4				GH233-9-PHT-(...)	
	4.22-4.44	107,18-112,77	GHG14C233-3410A	4				GH233-10-PHT-(...)	
GHSS-4410 <sup>1</sup>	4.41-4.73	112,01-120,14	GHG14C233-348A	8	GH233-(.....)-E			GH233-8-PHT-(...)	231 = (80 GRIT) 331 = (120 GRIT) 531 = (180 GRIT) 731 = (320 GRIT)
	4.68-5.00	118,87-127,00	GHG14C233-349A	8				GH233-9-PHT-(...)	
	4.95-5.27	125,73-133,85	GHG14C233-3410A	8				GH233-10-PHT-(...)	
	5.22-5.54	132,58-140,71	GHG14C233-4411A	8				GH233-11-PHT-(...)	
GHTS-2440 Two Stage	2.44-2.60	62-66	N/A	4	GT-62	GMG35	NMG37		331 = (120 GRIT) 731 = (320 GRIT)
	2.55-2.75	64,8-69,85	N/A	or	GT-71	GMG55	NMG57		
	2.74-2.94	69,6-74,67	N/A	6†	GT-76	GMG75	NMG85		
	2.93-3.13	74,42-79,5	N/A		GT-81	GMG85	NMG05		
	3.12-3.28	79,25-83,31	N/A		GT-86	RMG05			
GHTS-2800 Two Stage	2.80-3.00	71,12-76,20	N/A	4	GT-71	GMG35	NMG37	GH269-1-PHT-(...)* GH269-2-PHT-(...)* GH269-3-PHT-(...)* GH269-4-PHT-(...)*	331 = (120 GRIT) 731 = (320 GRIT) *THESE SIZES ARE NOT IN STOCK AT TIME OF PRINTING
	2.99-3.19	75,95-81,03	N/A	or	GT-76	GMG55	NMG57		
	3.18-3.38	80,77-85,85	N/A	6†	GT-81	GMG75	NMG85		
	3.37-3.57	85,60-90,68	N/A		GT-86	GMG85 RMG05	NMG05		
GHTS-3410 Two Stage	3.41-3.68	86,61-93,47	N/A	6	GH261-1-(.....)	GMG35	NMG65	GH261-1-PHT-(...) GH261-2-PHT-(...) GH261-3-PHT-(...) GH261-4-PHT-(...)	331 = (120 GRIT) 731 = (320 GRIT) *THESE SIZES ARE NOT IN STOCK AT TIME OF PRINTING
	3.67-3.94	93,22-100,08	N/A	6	GH261-2-(.....)	GMG55	NMG85		
	3.93-4.20	99,82-106,68	N/A	6	GH261-3-(.....)	GMG75 GMG85	NMG05		
	4.19-4.44	106,43-112,78	N/A	6	GH261-4-(.....)	RMG95 RMG05 RMG005			

Note: each hone head purchase includes all master holders for the total diameter range of the hone head.

Contact Customer Service for Available Abrasive Combinations.

†Please specify 4 or 6 stone set. GT-62-86, 4 or 6 stone set available.

# Specialized SV/CV/CK Tooling

## Tooling Required for Honing Nikasil Cylinders with SV/CV/CK Tooling

Diameter Range - 3.300–4.625 (83–117,5 mm)

### CK-3030A Diamond Stone Master Holder Set



### Roughing Stones

HP28DM95 (2 Required)

### Finishing Stones

HP28DM05 (2 Required)

*Note: Use Sunnen standard CK-3070 Bronze Guide Shoes when honing Nikasil Cylinders.*

For deglazing Nikasil Cylinders in CK/CV/SV machine, use Sunnen Stone #EHU-412.

For deglazing Nikasil Cylinders with portable tools, use Sunnen Stone. G25A43 (2.5" - 2.7")  
 M27A43 (2.7" - 4.1")  
 N37A43 (3.5" - 5.5")  
 W47A43 (4.1" - 21.0")

## Tooling Required for Honing Dart Blocks

CK/CV Type Machines	Portable Tooling
C30-A25	N37-A25
C30-A55	N37-A55
C30-J65	N37-J65
C30-J85	MM33-J85
CK-3570 Hard Guide Shoe*	
CK-3070-NY3X Delron Guide Shoe	

*\*Noted as Titanium Guide Shoe in Dart Literature. Recommendation from Dart Machinery.*

## Sunnen Diamond Abrasives for Rottler Hone Head

Part No.	Description
D37201-P640-4	Set of 4, 320 grit (GMG75)
D38201-P640-4	Set of 4, 400 grit (GMG85)
D38021-P640-4	Set of 4, 500 grit (GMB95)

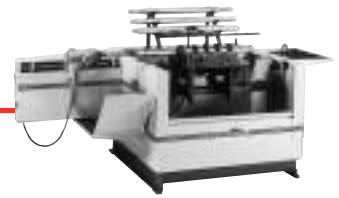
## Sunnen Diamond Abrasives for K-Line Hone Head

Part No.	Description
D37201-N671-6	Set of 6, 320 grit (GMG75)
D38201-N671-6	Set of 6, 400 grit (GMG85)
D60021-N671-6	Set of 6, 500 grit (GMB95)

Note: Special Order - Contact Customer Service for availability.

# CH-100 Line Honing Machine

Accessories and Supplies for  
CH-100, CHV-31, CH-20 and CH-40



## Complete Hone Units

Hone Unit	Approx. Ship. Weight		Diameter Range		Stone Length	Comments	Stones (5 per box) Ship Wt. 1-1/4 lbs. (.57 kg) per box	Shoes (10 per box) Ship Wt. 2 lbs. (.9 kg) per box	Bronze Shoes for Prod. use
	lbs.	kg	inches	mm					
8RY-2400G	27.5	12,5	2.400-2.700	61-69	27"	Hone Unit includes 1 set of 8 stones and 16 shoes	RY24-J49	RG-D	RG-B
8RY-2700G	31.2	14,2	2.700-3.000	69-77	27"		RY24-J49	RG-D	RG-B
10RY-1800F	34	15,4	1.800-2.100	46-54	24.375"	Hone Unit includes 1 set of 10 stones and 20 shoes	RY18-J49	RF-D	RF-B
10RY-2100F	45	20,4	2.100-2.400	54-61	24.375"		RY18-J49	RF-D	RF-B
10RY-2400G	40	18,1	2.400-2.700	61-69	33.750"		RY24-J49	RG-D	RG-B
10RY-2700G	45	20,4	2.700-3.000	69-77	33.750"		RY24-J49	RG-D	RG-B
10RY-3000H	50	22,6	3.000-3.500	77-89	33.750"	Hone Unit includes	RY24-J49	RH-D	RH-B
10RY-4500H	60	27,2	4.500-5.000	115-127	33.750"		RY24-J49	RH-D	RH-B
15RY-3500H	85	38,5	3.500-4.000	89-102	50.625"	1 set of 15 stones and 30 shoes	RY24-J49	RH-D	RH-B
15RY-4000H	105	47,6	4.000-4.500	102-115	50.625"		RY24-J49	RH-D	RH-B
15RY-4500H	120	54,4	4.500-5.000	115-127	50.625"	Hone Unit includes	RY24-J49	RH-D	RH-B
10RY-5000H	70.5	32,0	5.000-5.500	127-140	33.750"	1 set of 10 stones and 20 shoes	RY24-J49	RH-D	RH-B
10RY-5500H	80.5	36,6	5.500-6.000	140-152	33.750"		RY24-J49	RH-D	RH-B
10RY-6000H	97.0	44,1	6.000-6.500	152-165	33.750"	Hone Unit includes	RY24-J49	RH-D	RH-B
10RY-6500H	113.5	51,6	6.500-7.000	165-178	33.750"		RY24-J49	RH-D	RH-B
15RY-5000H	107.0	48,6	5.000-5.500	127-140	50.625"	1 set of 15 stones and 30 shoes	RY24-J49	RH-D	RH-B
15RY-5500H	122.0	55,4	5.500-6.000	140-152	50.625"		RY24-J49	RH-D	RH-B
15RY-6000H	147.0	66,8	6.000-6.500	152-165	50.625"	Hone Unit includes	RY24-J49	RH-D	RH-B
15RY-6500H	172.0	78,2	6.500-7.000	165-178	50.625"		RY24-J49	RH-D	RH-B

Special mandrels available on request. Call Customer Service, Sunnen Products Co., for price and availability.

## CH-36 Storage Rack

Free-standing unit provides convenient storage for six Hone Units. Top tray holds wrenches, honing stones, etc. Rack bottom catches oil runoff from mandrels. Sturdy, heavy steel construction. (Hone Units must be ordered separately.)



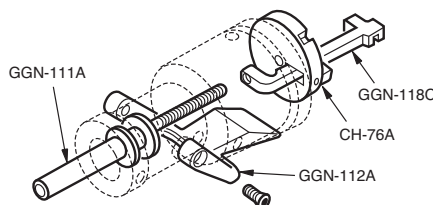
## CH-46 Storage Rack

The CH-46 is a compact mandrel storage rack designed to conveniently mount over the drain pan of the CH-100 Horizontal Hone. It accommodates three 8 or 10 stone mandrels up to 3.0" (76,2 mm) diameter.



## Replacement Parts for CH-75A Hone Driver

Part No.	Description
GGN-111A	Feed screw with washer
GGN-118C	Feed link
CH-76A	Mandrel drive plate with set screws
GGN-112A	Stone release lever with screws



## Softer Stones for Line Honing Aluminum Blocks

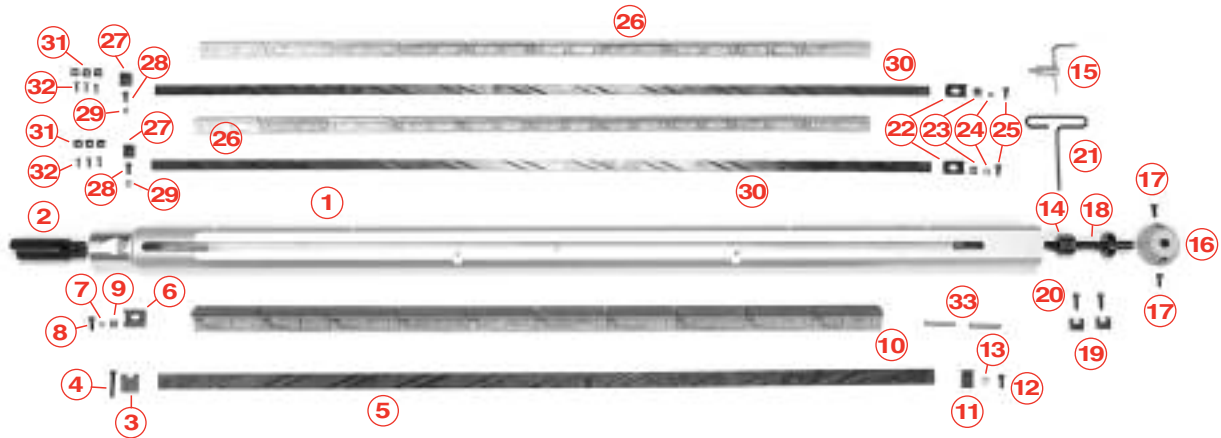


Blocks manufactured of aluminum require an abrasive with a softer bond. Softer stones allow honing without the problem of "loading" often experienced when honing this soft material.

Application	Stone Number
10RY-1800F 10RY-2100F	RY18-J45
8RY-2400G thru 15RY-6500F	RY24-J45

Shipping Weight: 1-1/4 lbs. (.57 kg) per box

# CH-100 Accessories & Supplies



Typical RY Hone Unit

## Honing Unit Repair Parts\*

Item No.	Description	Part Number (Quantity required shown in parentheses-order by packages where applicable.)										
		8-Stone Hone Units*		10-Stone Hone Units*				15-Stone Hone Units*				
		8RY-2400G	8RY-2700G	10RY-1800F	10RY-2100F	10RY-2400G	10RY-2700G	10RY-3000H	10RY-4500H	15RY-3500H	15RY-4000H	15RY-4500H
1	Mandrel Body											
2	Coupling	RY-101A	RY-101A	None	None	RY-101A	RY-101A	RY-101A	RY-102A	RY-102A	RY-102A	RY-102A
3	Wedge Block (Stone) with Screw	RY-106A PG-762	RY-106A PG-762	None	None	RY-106A PG-762	RY-106A PG-762	RY-107A PHS-579	RY-108A PHS-624	RY-107A PHS-579	RY-108A PHS-624	RY-108A PHS-624
4	Wedge (Stone)	8H-RY24-ST	8H-RY24-ST	10G-RY18-ST	10G-RY18-ST	10H-RY24-ST	10H-RY24-ST	10H-RY24-ST	10H-RY24-ST	15H-RY24-ST	15H-RY24-ST	15H-RY24-ST
6	Tension Block with Washer	RY-119A CRG-868	RY-119A CRG-868	RY-219A	RY-219A	RY-119A CRG-868	RY-119A CRG-868	RY-119A CRG-868	RY-119A CRG-868	RY-119A CRG-868	RY-119A CRG-868	RY-119A CRG-868
7	Washer	CRG-868	CRG-868	None	None	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868
8	Screw	P-144	P-144	PG-609	PG-609	P-144	P-144	P-144	P-144	P-144	P-144	P-144
9	Nut	RY-114	RY-114	RY-214	RY-214	RY-114	RY-114	RY-114	RY-114	RY-114	RY-114	RY-114
10	Stone Assembly (pkg. of 5)	RY24-J49 (8)	RY24-J49 (8)	RY18-J49 (10)	RY18-J49 (10)	RY24-J49 (10)	RY24-J49 (10)	RY24-J49 (10)	RY24-J49 (10)	RY24-J49 (15)	RY24-J49 (15)	RY24-J49 (15)
11	Retainer Block with Screw	RY-118A P-144	RY-118A P-144	RY-218A PG-609	RY-218A PG-609	RY-118A P-144	RY-118A P-144	RY-118A P-144	RY-118A P-144	RY-118A P-144	RY-118A P-144	RY-118A P-144
12	Screw	P-144	P-144	PG-609	PG-609	P-144	P-144	P-144	P-144	P-144	P-144	P-144
13	Washer	CRG-868	CRG-868	None	None	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868
14	Wedge Adjusting Nut	RY-144A	RY-144A	RY-244A	RY-244A	RY-144A	RY-144A	RY-144A	RY-144A	RY-144A	RY-144A	RY-144A
15	Wrench	LN-5785A	LN-5785A	LN-5785A	LN-5785A	LN-5785A	LN-5785A	LN-5785A	LN-5785A	LN-5785A	LN-5785A	LN-5785A
16	End Cap with Screws	RY-161A PHS-747	RY-162A PHS-747	RY-261A PG-981	RY-261A PG-981	RY-161A PHS-747	RY-162A PHS-747	RY-163A PHS-582A	RY-166A PHS-582A	RY-164A PHS-582A	RY-165A PHS-582A	RY-166A PHS-582A
17	Screws	PHS-747	PHS-747	PG-981	PG-981	PHS-747	PHS-747	PHS-582A	PHS-582A	PHS-582A	PHS-582A	PHS-582A
18	Adjusting Screw	RY-147A	RY-147A	RY-247A	RY-247A	RY-147A	RY-147A	RY-147A	RY-147A	RY-147A	RY-147A	RY-147A
19	Wedge Block (Shoe) (pkg. of 1) with Screw	RY-172A(2) P-144	RY-172A(2) P-144	RY-272A(2) PG-609A	RY-273A(2) PG-981	RY-172A(2) P-144	RY-172A(2) P-144	RY-173A(2) AG-128	RY-174A(2) PHS-579	RY-173A(2) AG-128	RY-174A(2) PHS-579	RY-174A(2) PHS-579
20	T-Wrench	PWM-11A	PWM-11A	PWM-9A	PWM-9A	PWM-11A	PWM-11A	PWM-11A	PWM-11A	PWM-11A	PWM-11A	PWM-11A
22	Tension Block (pkg. of 1) with Nut	RY-116A(2) RY-114A	RY-116A(2) RY-114A	RY-216A(2) RY-214A	RY-216A(2) RY-214A	RY-116A(2) RY-114A	RY-116A(2) RY-114A	RY-119A(2) RY-114A	RY-119A(2) RY-114A	RY-119A(2) RY-114A	RY-119A(2) RY-114A	RY-119A(2) RY-114A
23	Nut	RY-114A	RY-114A	RY-214A	RY-214A	RY-114A	RY-114A	RY-114A	RY-114A	RY-114A	RY-114A	RY-114A
24	Washer			None	None							
25	Screw	AG-178	AG-178	PG-2342A	PG-2342A	AG-178	AG-178	P-144	P-144	P-144	P-144	P-144
26	Shoe (pkg. of 10)	RG-D(16)	RG-D(16)	RF-D(20)	RF-D(20)	RG-D(20)	RG-D(20)	RH-D(20)	RH-D(20)	RH-D(30)	RH-D(30)	RH-D(30)
27	Retainer Block (pkg. of 1) with Screw	RY-117A(2) AG-178	RY-117A(2) AG-178	RY-217A(2) PG-2342	RY-217A(2) PG-2342	RY-117A(2) AG-178	RY-117A(2) AG-178	RY-118A(2) P-144	RY-118A(2) P-144	RY-118A(2) P-144	RY-118A(2) P-144	RY-118A(2) P-144
28	Screw	AG-178	AG-178	PG-2342	PG-2342	AG-178	AG-178	P-144	P-144	P-144	P-144	P-144
29	Washer	CRG-868	CRG-868	None	None	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868	CRG-868
30	Wedge (Shoe) (pkg. of 1)	8G-RY24-SH (2)	8G-RY24-SH (2)	10F-RY18-SH (2)	10F-RY18-SH (2)	10G-RY24-SH (2)	10G-RY24-SH (2)	10H-RY24-SH (2)	10H-RY24-SH (2)	15H-RY24-SH (2)	15H-RY24-SH (2)	15H-RY24-SH (2)
31	Wedge Retainer (pkg. of 3) with Screws	RY-141A(6) PHS-662	RY-141A(6) PHS-662	RY-241A(6) PHS-544	RY-241A(6) PHS-544	RY-141A(6) PHS-662	RY-141A(6) PHS-662	RY-141A(6) PH-662	RY-141A(6) PHS-662	RY-141A(9) PHS-662	RY-141A(9) PHS-662	RY-141A(9) PHS-662
32	Screws	PHS-662	PHS-662	PHS-544	PHS-544	PHS-662	PHS-662	PH-662	PHS-662	PHS-662	PHS-662	PHS-662
33	Setting Gage Pin	PHP-511A(2)	PHP-512A(2)	PHP-511A(2)	PHP-511A(2)	PHP-511A(2)	PHP-512A(2)	PHP-512A(2)	RY-187A(2)	RY-184A	RY-186A	RY-187A
Not Shown	Concentric Sleeve	None	None	LN-570A	None	None	None	None	None	None	None	None

\*For units not listed, call Sunnen Customer Service.

# CH-100 Accessories & Supplies

## Honing Unit Replacement Parts

Honing Unit	Centering Pins	"T" Hex Wrench	Adjustment Key
8RY-2400G	PHP-511	PWM-11	LN-5785 All Mandrels
8RY-2700G	PHP-512	PWM-11	
10RY-1800F	PHP-511	PWM-9	
10RY-2100F	PHP-511	PWM-9	
10RY-2400G	PHP-511	PWM-11	
10RY-2700G	PHP-512		
10RY-3000H	PHP-512		
10RY-4500H	RY-187		
15RY-3500H	RY-184		
15RY-4000H	RY-186		
15RY-4500H	RY-187		
10RY-5000H	RY-188		
10RY-5500H	RY-189		
10RY-6000H	RY-190		
10RY-6500H	RY-192		
15RY-5000H	RY-188		
15RY-5500H	RY-189		
15RY-6000H	RY-190		
15RY-6500H	RY-192		

## Replacement Parts for CH Drill Motors

Drill Motor Part No.	Part Description	Part No.
CH-158	Brush Set	CH-158-1A
Rockwell		
CH-168	Brush Set	CH-168-2A
CH-178	Trigger Switch	CH-178-8A
Milwaukee		
CH-705	Brush Set	CH-726-A
Milwaukee	Trigger Switch	CH-760-A

## CH-455 Cradle Assembly

Shipping Weight: 256 lbs. (116,4 kg)



## CH-525 Oil Control Assembly

Shipping Weight: 12 lbs. (5,4 kg)



## CH-650 Hone Support

The CH-650 Hone Support is intended to be used with Sunnen CH-100 Horizontal Hone. It is designed to aid operator in loading and unloading of heavy hone units.



## CH-20/CH-40 Horizontal Hone Driver Kit



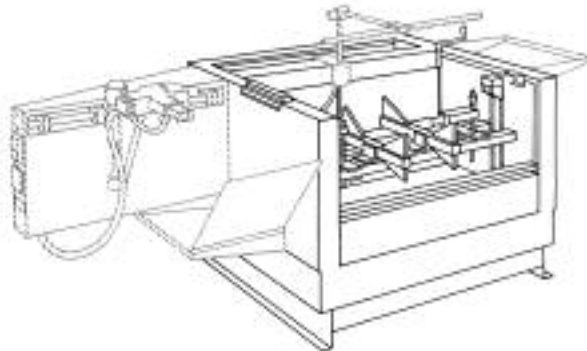
For the shop that is short on available floor space, line honing capability may be added to an existing CV-616 or CK-10 by ordering the CH-20 or CH-40 Horizontal Hone Driver Kit. For older Red or Vista Green machines, order CH-20 kit and specify color. Honing units, CH-455 Cradle Assembly, and CH-525 Oil Control Assembly must be ordered separately.

### Available Kits:

Part No.	Description
CH-20K	115v, 60 Hz (specify Red or Vista Green)
CH-20A	220v, 50 Hz (specify Red or Vista Green)
CH-40K	115v, 60 Hz (Pearl Gray)
CH-40A	220v, 50 Hz (Pearl Gray)

Shipping Weight: 280 lbs. (127,3 kg)

## CH-50 Conversion Kit



For customers who have their CV-616 or CK-10 set up for line honing we offer the CH-50 Conversion Kit to convert their line honing setup into a CH-100 line honing machine.

The CH-50 Conversion Kit includes everything needed to convert to a CH-100 except electricals. The customer will have to provide all switches and receptacles.

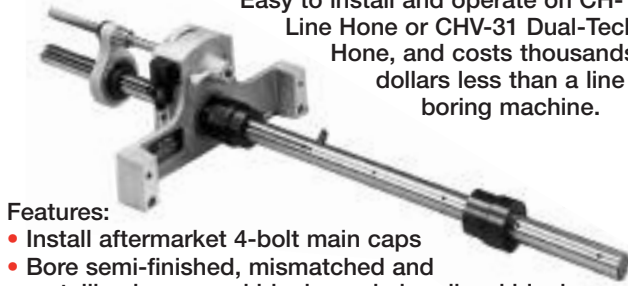
Conversion Kits available in Pearl Gray, Vista Green or Red. Please specify when ordering. Contact Customer Service, Sunnen Products for pricing and delivery.

Note: The CH-455 Cradle will no longer be required and cannot be returned for credit.

# CH-100 Accessories & Supplies

## PLB-100 Line Boring Attachment

Easy to install and operate on CH-100 Line Hone or CHV-31 Dual-Tech Hone, and costs thousands of dollars less than a line boring machine.



### Features:

- Install aftermarket 4-bolt main caps
- Bore semi-finished, mismatched and metallized caps and blocks and also diesel blocks
- Cuts thrust faces with special cutter
- 1-1/2" (38,1 mm) hard chrome bar with tool bit holes on 5" (127,0 mm) centers-length 48" (1220 mm)
- Boring range 1.800-5.250" (45,7-133,3 mm)
- Lightweight, 15 lbs. (6,8 kg) plus bar

## Optional Centering Rings

For other engines. These optional rings are stepped to provide two sizes per ring. Example: The standard set PLB-235 will fit a small and big block Chevrolet.



Part No.	Description
PLB-2941/3192	2.9412"-2.9425", 3.1922"-3.1930" Fits Ford 351, 352, 427, 428, 351M, 351W, 400, 429.
PLB-240	2.4906"-2.4916", 2.8406"-2.8415" Fits 400 small block Chevrolet and small journal pre-1968 283, 327, 302 Chevrolet.
PLB-3438/3188	3.438"-3.439", 3.1880"-3.189" Fits Pontiac 350, 389, 400, 428, 455; Oldsmobile 350N, 400, 425, 455; Buick 400, 430, 455, 265, 301, 350, 400.
PLB-2692/2817	2.6925"-2.6935", 2.8175"-2.8185" Fits Chrysler, Plymouth 340, 318, 301, 273, 383.
PLB-3002/2942	3.0025"-3.003", 2.9425"-2.9435" Fits Chrysler, Plymouth 360, 170, 198, 225, 413, 426, 440.












Note: Sizes may be combined on special order. Call Customer Service, Sunnen Products Co.

## PLB-1200 Cam Boring Attachment 1-1/4" Boring Bar

Turn your present line hone into a cam boring machine for V6 and V8 blocks. The PLB-1200 allows you to install oversize bearings and roller bearings in performance blocks. Boring Range: 2.000 to 2.750 in. (50,8-69,85 mm)

Part No.	Description
PLB-1200	Cam Boring Attachment (includes the following):
PLB-1400	Cam Boring Stand
PLB-1300	PLB-100 Mounting Adapter
PLB-1260	Stud Drive Shaft
PLB-1235	Adjustable Bushings (Pkg. of 2)
PLB-1275	Adjustable Tool Bit
PLB-1280	Adj. Pilot Lock Tool
PLB-1290	Adj. Pilot Lock Tool
PLB-1210	Boring Bar Assembly
PLB-1560A	Micrometer (for setting tool bits)
	<b>Tooling Required for 2.250"-2.750" (57,15-69,88 mm)</b>
PLB-2400A	Blade Set
PLB-1295	Tool Bit

## Ordering Information

	Part No.	Description
	PLB-100*	Line Boring Attachment
	PLB-500	Adjustable Centering Rings (set of two) includes blades for range from 2.400"-3.000" (60,9-76,2 mm)
	PLB-3000 PLB-3600 PLB-4200 PLB-4800	Blade Set range: 3.000"-3.600" (76,2-91,4 mm) 3.600"-4.200" (91,4-106,6 mm) 4.200"-4.800" (106,6-121,9 mm) 4.800"-5.400" (121,9-137,2 mm)
	PLB-349	Carbide Tipped Cutter 1.800"-2.450" (45,7-62,2 mm)
	PLB-350* PLB-351 PLB-352 PLB-353	Indexable Carbide Cutters with insert, screw and wrench: 2.450"-3.000" (62,2-76,2 mm) 3.000"-3.650" (76,2-92,7 mm) 3.650"-4.300" (92,7-109,2 mm) 4.300"-4.950" (109,2-125,7 mm)
	PLB-354*	Universal Cutter, 3.000" (76,2 mm) long for chamfering
	PLB-355*	Chevrolet Thrust Face Cutter, brazed carbide tip
	PLB-356	3/8" (9,5 mm) Wide Thrust Face Cutter with brazed carbide tip for all thrust faces, except Chevrolet.
	GAS1K-1	Kit contains five carbide indexable inserts, screws and one wrench
	GAS1K-1	Insert Screw
	TB907A	Package of 5 carbide indexable inserts
	LN-570A*	Concentric Sleeve. Adapts boring bar to CH-75A Hone Driver.
	PM-1500A	Micrometer Setting Gage Range: 1.500"-4.125" (38,1-104,8 mm)
	PWMM-3 PWMM-5	Hex T Wrenches .118" (3 mm) for setting tool bits .197" (5 mm) for feed collar bind bolt
See optional centering rings on this page	PLB-235	Centering Rings for small block and big block Chevrolet
Not pictured	PLB-600A PLB-6800	Thrust Cutter Attachment Blade Set 6.8"-7.4"

\*Standard equipment with PLB-100. Shipped in 2 pieces. Bar: 33 lbs. (73 kg). Housing: 37 lbs. (81,4 kg).

# CH-100 Accessories & Supplies

## MBK-75 Main Bearing Cap Knurler

The Sunnen MBK-75 knurls main bearing caps that have become loose. Knurling ends of the caps increases their width up to .010" (0,25 mm). Tightening the fit ensures exact location of caps.

With the MBK-75 you can line hone and line bore and be sure the bore will stay straight and round when the caps are removed for installing bearings and crankshaft.

Handles caps from small 4 and 6 cylinder cars to large diesel blocks. Easy to set up.



### Specifications

Length: 17.25" (438 mm). Width: 10.25" (260 mm).  
Height: 13" (330 mm).

Shipping Weight: 88 lbs. (39,6 kg)

Part No.	Description
MBK-90A	Replacement roller
MBK-91A	Replacement bolt and nut

## CCG-100 Cap Checker

Checks the height of main bearing caps referenced from the parting line.



## Camshaft Bore Honing on Overhead Cam Cylinder Heads

For the small shop with limited requirements, mandrels may be special ordered to allow honing various O.H.C. cylinder heads. Call Customer Service, Sunnen Products Co. for details and information.



Cylinder head being honed on CH-100 Honing Machine with a hand fed Porta-Hone.

## OHC Line Hone Mandrel

Part No.	Description
7PL-1031M*	For VW Rabbit, Omni, Horizon, Ford 2.5 and 4.6 1.021"-1.094" (25,9-27,8 mm) Extended Range with 1/8" Shim-1.219" (31,0 mm)
7PL-1312M*	For Mitsubishi 3.0, Chrysler 2.2 and 2.5, Isuzu, Toyota 4 and 5 ME, Mazda GLC, Nissan Z24-Z28, Mitsubishi 2.6 1.292"-1.375" (32,8-34,9 mm) Extended Range with 1/8" Shim-1.500 (38,1 mm)
WB-D	Guide Shoes (2/box)
P28-J27	Stones (12-Roughing)
P28-J47	Stones (12-General Purpose)
P28-J67	Stones (12-Finishing)

See Product Bulletin P-5501A thru P-5505A for more OHC Mandrel Selections.

\*Recommend using with GGN-150 Mandrel Driver and AN-87 Yoke adapter in CH-100 Line Hone Machine.



# Portable Hones & Accessories

## Sunnen Portable Cylinder Hones

### Recommended Stone Sets for Sunnen SNJ-10 Portable Hone

Diameter Range	Stone Sets		
	SNJ1-	SNJ2-	SNJ3-
	1.250"–1.437" 31,75–36,50 mm	1.418"–1.604" 36,02–40,74 mm	1.580"–1.770" 40,13–45,00 mm
Deburring in Rough Bores, All Materials	SNJ1-A47	SNJ2-A47	SNJ3-A47
Fast Stock Removal in Bored, Ground or Deburred Holes in the following materials:			
Aluminum or Bronze	SNJ1-J45	SNJ2-J45	SNJ3-J45
Soft Brass	SNJ1-J63	SNJ2-J63	SNJ3-J63
Cast Iron	SNJ1-J45	SNJ2-J45	SNJ3-J45
Soft Steel	SNJ1-A45	SNJ2-A45	SNJ3-A45
Hard Steel (First Choice)	SNJ1-A45	SNJ2-A45	SNJ3-A45
Hard Steel (if A45 does not cut)	SNJ1-A43	SNJ2-A43	SNJ3-A43
Very Hard Steel) (if A43 does not cut)	SNJ1-J63	SNJ2-J63	SNJ3-J63
Fine Finishing in the following materials:			
Aluminum or Bronze	SNJ1-J87	SNJ2-J87	SNJ3-J87
Soft Brass	SNJ1-J85	SNJ2-J85	SNJ3-J85
Cast Iron	SNJ1-J87	SNJ2-J87	SNJ3-J87
Soft Steel	SNJ1-J87	SNJ2-J87	SNJ3-J87
Hard Steel	SNJ1-J85	SNJ2-J85	SNJ3-J85

Note: All stone sets must be ordered separately. See page 36 for Plateau Honing Tools.

Select stone sets desired on next page.

- The fastest and most accurate (to one-half thousandth) portable hone for cylinder reconditioning in cars, trucks, tractors and stationary engines.
- The only method that maintains alignment of the original bore.
- Reconditions cylinder bore with less stock removal than other methods—assures longer block life.
- Produces any finish specified by engine and ring manufacturers.
- Recommended for fast seating of chrome or moly rings.
- Correct stone length.
- Fast stock removal—up to five thousandths (0,13 mm) per minute.
- Can be set up in a few minutes—no studs to remove.
- All cylinder hones include AN-1105A molded storage box.

### SNJ-10 Portable Hone

Range: 1.250"-1.770" (31,5 mm-45,0 mm)  
The SNJ-10 Portable Hone is recommended for sizing and finishing small holes in parts too heavy or awkward to stroke on a honing machine.

Includes a 2" (50,88 mm) drive shank and 12" (304,8 mm) extension.

Shipping Weight: Approx. 5 lbs. (2,3 kg)



# Portable Hones & Accessories

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## SN-75 Midget Portable Cylinder Hone

Range: 1.75"-2" (44-51 mm)  
Recommended for small compressors, outboard motors and similar small bore engines.

Includes 2" (50,8 mm) drive shank and 12" (304,8 mm) extension.



*Note: All stone sets must be ordered separately.*  
*Shipping Weight: Approx. 5 lbs. (2,3 kg)*

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## JN-95 Junior Portable Cylinder Hone

Range: 2"-2.6" (50,8-66 mm)  
Ideal for outboard motors, motorcycle and similar small bore engines within its range.

Includes 2" (50,8 mm) drive shank and 12" (304,8 mm) extension.



*Note: All stone sets must be ordered separately.*

Stone Set Range:  
2.0"-2.2" (50,8-55,9 mm)  
2.2"-2.4" (55,9-60,9 mm)  
2.4"-2.6" (60,9-66,0 mm)

*Shipping Weight: Approx. 5 lbs. (2,3 kg)*

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## AN-111 Standard Portable Cylinder Hone

Range: 2.5"-7" (63-178 mm)  
Shipped with roughing and medium finishing stone sets, (M27J17, M27J55) for range 2.7"-4.1" (69-104 mm).  
Stone sets available for complete range 2.5"-7" (63-178 mm).

Includes 12" (304,8 mm) drive shank.



*Note: All stone sets must be ordered separately.*  
*Shipping Weight: Approx. 9 lbs. (4,1 kg)*

---

## AN-112 Standard Portable Cylinder Hone

Same as AN-111 except does not include any stone sets.

Includes 2" (50,8 mm) drive shank and 12" (304,8 mm) extension.



*Note: All stone sets must be ordered separately.*  
*Shipping Weight: Approx. 7 lbs. (3,2 kg)*

---

## AN-815 Heavy-Duty Cylinder Hone

Range: 2.5"-15" (63-381 mm)  
Recommended for truck and stationary engines with cylinder bores 2.5"-15" (63-381 mm).  
Equipped with heavy-duty universal joint, 6" (152 mm) drive shank and 12" (304,8 mm) shank extension.



*Note: Order stone sets, master holder sets and stone supports separately.*  
*Shipping Weight: Approx. 9 lbs. (4,1 kg)*

*Note: See chart on page 36 for Stone Sets.*

# Portable Honers & Accessories

So that we may better serve all of our customers, Sunnen has consolidated our parts numbering system. This allows us to offer the highest quality tooling and abrasives at the lowest possible price. This catalog has both the "old" numbers and the new numbers, so that you can make the transition.

Please be assured, only the part number has changed. The part you order is the same quality Sunnen part that you have come to depend on for the industry standard engine building honing equipment.

## Stone Sets for Sunnen Portable Cylinder Honers




For Use in Cylinder Hone Models	Diameter Range		When Used In	Old Roughing Stone Set (70 Grit)	New Roughing Stone Set (70 Grit)	Old Finishing Stone Set (150 Grit)	New Finishing Stone Set (150 Grit)	Old Med. Finish Stone Set (220 Grit)	New Med. Finish Stone Set (220 Grit)	Old Fine Finish Stone Set (280 Grit)	New Fine Finish Stone Set (280 Grit)	Extra Fine Finish Stone Set (400 Grit)	Polishing Stone Set (600 Grit)	Stone Length		
	inches	mm		in	mm											
SN Midget	1.75-2.0	44-51	Cast Iron	SN-100	S18-J17	SN-200	S18-J45	SN-300*	S18-J55	SN-500	S18-J65	S18-J87	S18-C05*	4	102	
JN Junior	2.0-2.2	51-56	Cast Iron Hardened Sleeves	JN-100 JN-130	T20-J17 T20-J11	JN-200 JN-230	S20-J45 T20-J43	JN-300 -	T20-J55 -	JN-500 JN-530	T20-J65 T20-J63	T20-J87 T20-J85	T20-C05* T20-C05*	4 4	102 102	
	2.2-2.4	56-61	Cast Iron Hardened Sleeves	JN-101 JN-131	U22-J17 U22-J11	JN-201 JN-231	U22-J45 U22-J43	JN-301 -	U22-J55 -	JN-501 JN-531	U22-J65 U22-J63	U22-J87 U22-J85	U22-C05* U22-C05*	4 4	102 102	
	2.4-2.6	61-66	Cast Iron Hardened Sleeves	JN-102 JN-132	V24-J17 V24-J11	JN-202 JN-232	V24-J45 V24-J43	JN-302 -	V24-J55 -	JN-502 JN-532	V24-J65 V24-J63	V24-J87 V24-J85	V24-C05* V24-C05*	4 4	102 102	
AN Standard and Heavy Duty	2.5-2.7	63-70	Cast Iron	AN-115	G25-J17	AN-215	G25-J45	G25-J55*	G25-J55*	AN-515	G25-J65	G25-J87	G25-C05*	4	102	
	2.7-4.1	69-104	Cast Iron Short C. Iron Cyls.	AN-100 AN-100-71	M27-J17 M27-J17-71	AN-200 AN-200-71	M27-J45 M27-J45-71	AN-300 AN-300-71	M27-J55 M27-J55-71	AN-500 AN-500-71	M27-J65 M27-J65-71	M27-J87 -	MM33-C05U -	4 2- <sup>19</sup> / <sub>16</sub>	102 71	
			Deutsch Diesel Cyls. VW Air Cooled Cyls. Harley Davidson Chilled Iron Liners	AN-100-F	M27-J45	-	-	-	-	-	-	-	-	-	4	102
			Hardened Sleeves Steel	AN-130 -	M27-J11 -	AN-230 AN-200A	M27-J43 M27-A45	- -	- -	AN-530 AN-500A	M27-J63 M27-A65	M27-J85 M27-J87	MM33-C05† MM33-C05†	4 4	102 102	
	3.5-5.5	89-139	Cast Iron Short C. Iron Cyls.	AN-101 AN-101-71	N37-J17 N37-J17-71	AN-201 AN-201-71	N37-J45 N37-J45-71	AN-301 AN-301-71	N37-J55 N37-J55-71	AN-501 AN-501-71	N37-J65 N37-J65-71	N37-J87 -	NN40-C05† -	4 2- <sup>19</sup> / <sub>16</sub>	102 71	
			Hardened Sleeves Steel	AN-131 -	N37-J11 -	AN-231 AN-201A	N37-J43 N37-A45	- -	- -	AN-531 AN-501A	N37-J63 N37-A65	N37-J85 N37-J87	NN40-C05† NN40-C05†	4 4	102 102	
4.7-15.0 ‡	119-381 ‡	Cast Iron Hardened Sleeves Steel	AN-106 AN-136 -	W47-J17 W47-J11 -	AN-206 AN-236 AN-206A	W47-J45 W47-J43 W47-A45	AN-306 -	W47-J55 -	AN-506 AN-536 AN-506A	W47-J65 W47-J63 W47-A65	W47-J87 W47-J85 W47-J87	WW51-C05† WW51-C05† WW51-C05†	4 4 4	102 102 102		
AN Keyway	2.5-3.3	64-84	Ported Cylinders	GY25-J15*	-	GY25-J45	-	-	-	GY25-J65	-	GY25-J85	GY25-C05*	4	102	
	3.3-4.2	84-107	Ported Cylinders	MY33-J15*	-	MY33-J45	-	-	-	MY33-J65	-	MY33-J85	MY33-C05*	4	102	
	4.0-5.6	102-142	Ported Cylinders	NY40-J15*	-	NY40-J45	-	-	-	NY40-J65	-	NY40-J85	NY40-C05*	4	102	
	4.5-6.0	114-152	Ported Cylinders	WY51-J15	-	WY51-J45	-	-	-	WY51-J85	-	WY51-J85	WY51-J95*	4	102	
Approximate Surface Finish in Microinches (Ra)	Cast Iron		120	-	45	-	32	-	20	-	8	3	-	-		
	Hardened Sleeves		55	-	30	-	20	-	12	-	5	2	-	-		
	Steel		-	-	32	-	20	-	20	-	7	3	-	-		

\*Special, two week after receipt of order.

‡Range on these sets as follows: MM33-3.3"-4.2"(84-107 mm), NN40-4.0"-5.6" (102-142 mm), WW51-4.5"-9.2" (114-234 mm).

†Use this series of Stone Sets with Master Holder Sets and Stone Support (order below). Shipping Weight of all Stone Sets approximately 1-1/4 lbs. (1/2 kg) per set.

## Stone Supports and Master Holder Sets

For Use In All AN Model Cylinder Honers	Single Length Master Holder Sets			Stone Supports	Double Length Master Holder Sets				
		For range 4.7"-15.0" (119-381 mm). One required for each range shown. Order stone sets separately.			To provide stability and prevent chatter, stone supports must be used in diameters above 6.0" (152 mm). For use with both single length and double length Master Holder Sets.			For range 4.7"-15.0" (119-381 mm). Uses two sets of stones in line for 8.0" (203 mm) stone length. One required for each range shown. Order stone sets separately.	
	Range	Part Number	Ship Wt. 3 lbs (1,4 kg)	Part Number	Ship Wt. 2-1/2 lbs. (1,1 kg)	Range	Part Number	Ship Wt. 5 lbs (2,3 kg)	
inches	mm					inches	mm		
4.7-7.0	119-178	AN-355		Not required		4.7-7.0	119-178	AN-855	
6.0-9.0	152-229	AN-365		AN-260		6.0-9.0	152-229	AN-865	
8.0-12.0	203-305	AN-375		AN-280		8.0-12.0	203-305	AN-875	
11.0-15.0	279-381	AN-385		AN-290		11.0-15.0	279-381	AN-885	

## PHT Plateau Honing Tools

Hone Body	For Diameter Range		Abrasive Sets * (320 GRIT)
	inches	mm	
SNJ	1.50-1.69	38,1-42,9	SNJ1-PHT-732
	1.67-1.86	42,4-47,2	SNJ2-PHT-732
	1.75-1.94	44,4-49,3	SNJ3-PHT-732
	1.91-2.10	48,5-53,3	SNJ4-PHT-732
	2.08-2.27	52,8-57,6	SNJ5-PHT-732
SN	2.15-2.40	54,6-60,9	SN-PHT-732

Hone Body	For Diameter Range		Abrasive Sets * (320 GRIT)
	inches	mm	
JN	2.40-2.60	60,9- 66,0	JN0-PHT-732
	2.60-2.80	66,0-71,1	JN1-PHT-731
	2.80-3.00	71,1-76,2	JN2-PHT-731
AN Standard and Heavy-Duty AN-60	2.98-3.78	75,7-96,0	GG-PHT-732
	3.78-4.68	96,0-118,9	MM-PHT-731
	4.48-6.08	113,8-154,4	NN-PHT-731
	4.98-9.68	126,5- 245,9	WW-PHT-731

# Portable Hones & Accessories

## Honing Aluminum Alloys

### UN-60 Universal Honing Stand

- Convenient, easy-to-use, will not damage cylinder wall
- Supports weight of drill and cylinder hone
- Has adjustable stroking stop

Shipping Weight: 20 lbs. (9,1 kg)

Part No.	Description
UN-30A	Strap and Buckle
UN-36A	Strap only
UN-37	Buckle only
UN-38	Hanger Rod Assembly



### High-Silicon Aluminum Alloy

Such as Porsche, Mercedes, Honda and Vega.



Note: Sunnen MAN-845 or MB-30 is MANDATORY when honing ALL aluminum.

### Tooling Required When Honing High Silicon Aluminum Blocks

- AN-111, AN-112 or AN-815 Cylinder Hone
- AN-80 Quick Coupler
- AN-1060 Heavy Duty Drill Motor
- UN-60 Universal Honing Stand
- MM33-J63 Roughing Stone Set
- MM33-J85 Finishing Stone Set
- MM33-CO5 Polishing Stone Set
- MM33-FO5 Felt Set
- AN-30 Sunnen Silicon Compound
- AN-35 Storage Box
- GA-2125 or GR-2125 Dial Bore Gage
- MAN-845 Honing Oil

### ANR-275 Remote Feed Heavy-Duty Cylinder Hone

Range: 2.5" -15" (63 mm-381 mm)



Must be used in a machine or honing rig. Illustration shows the ANR-275 Portable Hone assembled with Stone Support, Single Length Master Holder Set, Stone Set and 3" (76 mm) Drive Shank. 4" (104 mm) stone length or 8" (203 mm) stone length when two sets of stones are used with Double Length Master Holder Set.

Shipping Weight: 13 lbs. (5,9 kg)

Order stone sets, master holder sets and stone supports separately.

### AN-980 Chamfering Cone

Chamfers the sharp edges of cylinders for safe piston and ring installation. Handles all diameter cylinders or sleeves. Unit consists of tapered neoprene cone covered by long-lasting replaceable abrasive cone (plus a spare). Easy to use with 1/4" (6,3 mm) or larger drill.

Shipping Weight: 1-1/2 lbs. (.68 kg)

6 Replacement Cones in package:

Order AN-994A

Shipping Weight: 1 lb. (.45 kg)

#### AN-980 Replacement Parts

Part No.	Description
AN-991A	Extension
AN-986A	Rubber Cone



# Portable Hones & Accessories

## Drive Shanks and Shaft Extensions for ANR-275 Hone

Furnished with 3" (76 mm) Drive Shank. Other shanks or extensions may be selected from the table below to make up any practical length (either drive shank can be used with any combination of extensions).

Length		Replacement Drive Shanks	Shaft Extensions	Shipping Weight	
inches	mm			lbs.	kg
3	76	AN-608A	None	1/3	,15
6	152	AN-618A	None	2/3	,30
9 <sup>1</sup> / <sub>4</sub>	235	None	ANR-741	2	,91
19	483	None	ANR-742	4	1,2
42 <sup>3</sup> / <sub>4</sub>	1086	None	ANR-744	8	3,6
72 <sup>1</sup> / <sub>4</sub>	1835	None	ANR-746	13	5,9

## GGN-150 Portable Mandrel Driver



For portable honing applications such as spindle bushings mounted on axles, and other jobs that cannot be taken to honing machine. Recommended for use with Lifetime Honing Units. For holes 3/4" (19,1 mm) I.D. and larger, where length is at least 4 times the diameter. Graduated adjustment knob advances and retracts honing stones. Use with any half-inch drill (12,7 mm) or larger, 450 rpm or less.  
Shipping Weight: 3 lbs. (1,36 kg)

## AN-1075 Speed Control Unit



Furnished with on/off switch, fuse, AC cord and grounded AC outlet plug. Reduces rpm when used with AC/DC drill motors and motors (brush-type only) where ampere rating is 15 amps or less.

Shipping Weight: 3 lbs. (1,4 kg)

## AN-1060 Drill Motor Kit (115V, 60Hz)

For Sunnen Portable Equipment and Cylinder Hones



The AN-1060 Drill Motor has a speed torque relationship that is not found in ordinary electric drills. The power unit operates at 115V, has a no-load speed of 250 rpm and a fullload speed of 165 rpm. Has a full-load amp draw of 11 amps. Supplied with quick coupler, and AN-97 and AN-87 yoke adapters.

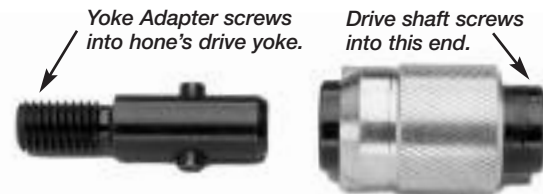
Shipping Weight: 23 lbs. (10,4 kg)

## AN-1055 Drill Motor Kit (220V, 50Hz)

(Does not come equipped with electrical plug)

### "Quick-Coupler"

Includes Yoke Adapter  
Shipping Weight: 1 lb. (.45 kg)



Two models fit all Sunnen Cylinder Hones-make cylinder honing an easier, faster operation.

Permits drill (electric or air) to be quickly coupled or uncoupled from cylinder hone. Allows operator to have both hands free for removing hone from cylinder or for stone changing operations.

AN-80 Quick-Coupler. Used with all SN, JN and standard AN model Cylinder Hones.

AN-85 Quick-Coupler. For use with AN-815 Heavy-Duty Cylinder Hones.

Extra Yoke Adapters

AN-87 For use with AN-80 Quick-Coupler.

AN-97 For use with AN-85 Quick-Coupler.

CH-85 For use with CH-75 and CH-100.

Shipping Weight: 1/2 lb. (.23 kg)

# Stone Sets for AN, ANR, GNH & GNR Honing Units

## AVAILABLE STONES:

In some cases, stones other than those recommended may hone faster or last longer. For long or repetitive production runs, it may be economical to choose a stone slightly harder or softer, coarser or finer. If the stone wears out too fast, use a harder stone; if it does not cut, use a softer stone.



		For Holes Without Keyways								For Holes With Keyways			
		General Purpose Stone Sets				Guideless Stone Sets				Keyway Stone Sets			
										Maximum Keyway Width			
										.8" (20,3 mm)	.9" (22,8 mm)	1.2" (30,4 mm)	1.4" (35,5 mm)
Grit Size		2.5"-2.7" (64-69 mm)	2.7"-4.1" (69-104 mm)	3.5"-5.5" (89-140 mm)	4.1"-6.0" (104-152 mm)*	2.5"-3.3" (64-84 mm)	3.3"-4.2" (84-107 mm)	4.0"-5.6" (102-142 mm)	4.5"-6.0" (114-152 mm)*	2.5"-3.3" (64-84 mm)	3.3"-4.2" (84-107 mm)	4.0"-5.6" (102-142 mm)	4.5"-6.0" (114-1524 mm)*
Aluminum Oxide	80 (2) Soft	G25-A23	M27-A23	N37-A23	W47-A23	GG25-A25		NN40-A25	WW51-A25	GY25-A25	MY33-A25		WY51-A23
	Hard	G25-A25	M27-A25	N37-A27	W47-A27								WY51-A25
		G25-A27	M27-A27										
	150 (4) Soft	G25-A41	M27-A43	N37-A43	W47-A43	GG25-A43	MM33-A43	NN40-A43	WW51-A43	GY25-A43	MY33-A43	NY40-A43	WY51-A43
		G25-A45	M27-A45	N37-A45	W47-A45	GG25-A45	MM33-A45	NN40-A45	WW51-A45	GY25-A45	MY33-A45	NY40-A45	WY51-A45
		G25-A47	M27-A47	N37-A47	W47-A47	GG25-A47	MM33-A47			GY25-A47	MY33-A47	NY40-A47	WY51-A47
Hard		M27-A48											
		M27-A49											
220 (5)		M27-A55	N37-A55	W47-A55									
Soft	G25-A65	M27-A65	N37-A65	W47-A63	GG25-A65					GY25-A65			WY51-A65
	Hard		M27-A67		W47-A65								
					W47-A67								

\*These stones require Master Holder Sets.

# Stone Sets for AN, ANR, GNH & GNR Honing Units

## AVAILABLE STONES:

In some cases, stones other than those recommended may hone faster or last longer. For long or repetitive production runs, it may be economical to choose a stone slightly harder or softer, coarser or finer. If the stone wears out too fast, use a harder stone; if it does not cut, use a softer stone.

		For Holes Without Keyways								For Holes With Keyways				
														
										Keyway Stone Sets				
										Maximum Keyway Width				
		General Purpose Stone Sets				Guideless Stone Sets				.8" (20,3 mm)	.9" (22,8 mm)	1.2" (30,4 mm)	1.4" (35,5 mm)	
Grit Size		2.5"-2.7" (64-69 mm)	2.7"-4.1" (69-104 mm)	3.5"-5.5" (89-140 mm)	4.1"-6.0" (104-152 mm)*	2.5"-3.3" (64-84 mm)	3.3"-4.2" (84-107 mm)	4.0"-5.6" (102-142 mm)	4.5"-6.0" (114-152 mm)*		3.3"-4.2" (84-107 mm)	4.0"-5.6" (102-142 mm)	4.5"-6.0" (114-152 mm)*	
Silicon Carbide	70 (1)	Soft G25-J15 G25-J17	M27-J17	N37-J11 N37-J13	W47-J11 W47-J13 W47-J15 W47-J17	GG25-J15	MM33-J15	NN40-J15	WW51-J15	GY25-J15		NY40-J15	WY51-J15	
		Hard		N37-J17										
	150 (4)	Soft G25-J45 G25-J47	M27-J45 M27-J47	N37-J43 N37-J45 N37-J47	W47-J43 W47-J45 W47-J47	GG25-J45	MM33-J45	NN40-J45	WW51-J45	GY25-J45 GY25-J47	MY33-J45 MY33-J47	NY40-J45	WY51-J43 WY51-J45 WY51-J47	
		Hard												
	220 (5)	Soft G25-J55	M27-J55 M27-J57	N37-J55	W47-J55									
		Hard												
	280 (6)	Soft G25-J63 G25-J65 G25-J67	M27-J63 M27-J65 M27-J67	N37-J65 N37-J67	W47-J63 W47-J65 W47-J67	GG25-J65	MM33-J63				GY25-J65 GY25-J67	MY33-J65 MY33-J67	NY40-J65	WY51-J65 WY51-J67
		Hard												
	400 (8)	Soft G25-J85 G25-J87	M27-J85 M27-J87	N37-J85 N37-J87	W47-J85 W47-J87	GG25-J85 GG25-J87	MM33-J85 MM33-J87	NN40-J85 NN40-J87	WW51-J85 WW51-J87	GY25-J85 GY25-J87	MY33-J85 MY33-J87	NY40-J85 NY40-J87	WY51-J85 WY51-J87	
		Hard												
500 (9)	Soft G25-J95	M27-J95	N37-J95	W47-J95 W47-J97	GG25-J95									
	Hard													
600 (0)		G25-C05	M27-C05	N37-C05	W47-C05	GG25-C05	MM33-C05	NN40-C05	WW51-C05					

\*These stones require Master Holder Sets.

# Portable Hones & Accessories

## SN-75 Hone



AN-26A (1/2" (12,7 mm) Chuck Required)



AN-241



SN-11



JN-23A



JN-30

Part No.	Description
SN-11	Hone Body
JN-30	Universal Joint Complete
JN-23A	Adjusting Nut and Washer
AN-26A	3" (76,2 mm) Drive Shaft
AN-241	12" (304,8 mm) Extension Assembly

## JN-95 Hone



AN-26A (1/2" (12,7 mm) Chuck Required)



AN-241



JN-11



JN-23A



JN-30

Part No.	Description
JN-11	Hone Body
JN-30	Universal Joint Complete
JN-23A	Adjusting Nut and Washer
AN-26A	3" (76,2 mm) Drive Shaft
AN-241	12" (304,8 mm) Extension Assembly

## AN-111 and AN-112 Hones



AN-26A (1/2" (12,7 mm) Chuck Required)



AN-241



AN-4



AN-3A



AN-50



AN-16

Part No.	Description
AN-4	Hone Body
AN-50	Universal Joint Complete
AN-16	Center Pinion Adjustment
AN-3A	Body Gear
AN-26A	3" (76,2 mm) Drive Shaft
AN-241	12" (304,8 mm) Extension Assembly

## AN-28 Drive Shaft

12" (304,8 mm), 7/16-14 Thread

This is an economically priced replacement drive shaft for use with the SN-75, JN-95, AN-111, and AN-112 portable hones. Supplied as standard equipment with the AN-111. Requires 1/2" (12,7 mm) chuck

Shipping Weight: 3/4 lb. (.34 kg)



## AN-815 Hone



AN-618A (5/8" (15,9 mm) Chuck Required)



AN-841



AN-604



AN-3A



AN-650



AN-16

Part No.	Description
AN-650	Universal Joint
AN-604	Hone Body
AN-16	Center Pinion
AN-3A	Body Gear Set
AN-618A	6" (152,4 mm) Drive Shaft
AN-841	12" (304,8 mm) Extension Assembly

## AN Extension Couplers

Allows assembly of two or more AN-241 or AN-841 extensions for a longer reach with SN, JN and AN portable hones.

AN-630A 7/16-14 Thd., for SN, JN, AN-111 and AN-112 portable hones.

AN-640A 5/8-11 Thd., for the AN-815.

Shipping Weight: 1/4 lb. (.11 kg)



# Portable Honers & Accessories

## Lifter Bore Honing in V-6 and V-8 Cylinder Blocks

Special mandrels are available for honing lifter bores in V-type engines. The mandrels are extended length keyway type. A keyway type mandrel is the best mandrel for this type of bore because it adds stability for this hand honing operation and also because of the typically large oil ports in the sides of the bore. The recommended power source is a 3/8" (10 mm) chuck capacity air drill with an approximate speed of 250 rpm. Honing oil is required.



### Tooling Required for Small Block Chevy

For Complete Honing Unit Order	
Part No.	Description
① AAY20-838BH-6LH	Extended Mandrel, 6" (15,2 cm) reach Diameter Range: .838"-.869" (21,29-22,07 mm)
①	Used with std. .843 dia. GM lifter
① AAYA20-869BH-6LH	Extended Mandrel, 6" (15.2 cm) reach Diameter Range: .869"-.900" (22,07-22,86 mm)
①	Used with .875 dia. Ford lifter
② Y20-W6LH	Extended Wedge
③ LN-3688A-6LH	Extended Retainer
④ P-180	Honall Head and Driver
⑤ PAK20-A	Adapter
⑥ Y20-J67	Recommended Stone

### Tooling Required for 231 Buick

For Complete Honing Unit Order	
Part No.	Description
① AAY20-869BH-675LH	Extended Mandrel, 6-3/4" (17,1 cm) reach Diameter Range: .869"-.900" (22,07-22,86 mm)
①	Used with .875 dia. Ford lifter
① AAY20-838BH-675LH	Extended Mandrel, 6-3/4" (17,1 cm) reach Diameter Range: .838"-.869" (21,29-22,07 mm)
①	Used with .843 dia. GM lifter
② Y20-W-675LH	Extended Wedge
③ LN-3688A-675LH	Extended Retainer
④ P-180	Honall Head and Driver
⑤ PAK20-A	Adapter
⑥ Y20-J67	Recommended Stone

*Note: Could be used on the V-8's but is not as stable as the shorter 6" (15,2 cm) reach mandrel.*

### Tooling Required for Tall Deck Blocks

For Complete Honing Unit Order	
Part No.	Description
① AAY20-869BH-LK7X	Extended Mandrel, 8 1/4" (20,9 cm) reach Diameter Range: .869"-.900" (22,07-22,86 mm)
①	Used with .875 dia.
① AAY20-838BH-LK7X	Extended Mandrel, 8 1/4" (20,9 cm) reach Diameter Range: .838"-.869" (21,29-22,07 mm)
①	Used with .843 dia.
① AAY20-900BH-LK7X*	Extended Mandrel, 8 1/4" (20,9 cm) reach Diameter Range: .900"-.931" (22,86-23,65 mm)
①	Used with .906 dia.
① AAY20-931BH-LK7X*	Extended Mandrel, 8 1/4" (20,9 cm) reach Diameter Range: .931"-.962" (23,65-24,43 mm)
①	Used with .937 dia.
② Y20-W-LK7X*	Extended Wedge
③ LN-3688A-LK7X*	Extended Retainer
④ P-180	Honall Head and Driver
⑤ PAK20-A*	Adapter
⑥ Y20-J67	Recommended Stone

*For other applications, call Customer Service, Sunnen Products Co.*

*Items marked with an asterisk (\*) are specials and are not shipped from stock. (If needed immediately call Customer Service, Sunnen Products Co. to check Special Products stock.)*

### Y20-NM85 Super Abrasives





# AG-Series Precision Gage

## For Pin Fitting and Rod Reconditioning

**AG-300 Range: .375"–3.375" (9,5 mm–85,7 mm)**  
**AG-400 Range: .720"–2.687" (18 mm–68 mm)**

Note: The AG-400 has fingers that are .600" longer than the AG-300 (For use with larger diameter pistons with shorter wrist pins)

### Replacement Parts For AG-300

Part No.	Description	Part No.	Description
AG-50A*	Dial Indicator	AG-438A*	Replacement Gaging Balls (package of 10) for AG-210 Standard Point Set
AG-34*	Crystal		
AG-26A*	Face Plate		
AG-299A*	Setting Fixture (with wear pads)	AG-456A*	Small Calibration Ring
PG-7A*	Plastic Cover	AG-465A*	Large Calibration Ring
		AG-450A*	Adjusting Wrench

\*These parts included with AG-300.

### Replacement Parts For AG-400

Part No.	Description	Part No.	Description
AG-50A*	Dial Indicator	AG-438A*	Replacement Gaging Balls (package of 10) for AG-210 Standard Point Set
AG-34*	Crystal		
AG-26A*	Face Plate		
AG-410A*	Setting Fixture (with wear pads)	AG-404*	Small Calibration Ring
PG-7A*	Plastic Cover	AG-465A*	Large Calibration Ring
		AG-450A*	Adjusting Wrench

\*These parts included with AG-400.

### Calibrating Rings for Quickly Setting AG-300 Gage to Connecting Rod Size

Part No.	Size	Part No.	Size
RG-2125	2.125" (53,9 mm)	RG-2325	2.325" (59,0 mm)
RG-2225	2.225" (56,5 mm)	RG-2374	2.374" (60,3 mm)
RG-2237	2.237" (56,8 mm)	RG-2436	2.436" (61,9 mm)
RG-2239	2.239" (56,9 mm)	RG-2500	2.500" (63,5 mm)
RG-2250	2.250" (57,1 mm)	RG-2591	2.591" (65,8 mm)
RG-2275	2.275" (57,8 mm)		
RG-2100	Complete Set of 11 ring gages listed above		

### Sunnun AG-Series Precision Gage

Helps Sell Rod Reconditioning Service (Must be ordered separately – not included with honing machines.)

Dial reads directly in "tenths" (.0001").

- Checks rod journal bore for distortion.
- Assures correct size – within .0001"!
- Anyone can use it. No "feel" required!
- Measures size instantly!
- Wear-compensated gage points assure permanent accuracy!
- Assures exact fits required by today's high tech engines.

No rod should be reconditioned or pins fit without precise gaging. The only way to know the size is to measure the hole.

- Exact pin size is transferred to the AG-300 Gage with a wear-compensated setting fixture.
- Rugged construction. All moving parts are enclosed in housing. Never affected by vibration or shock.
- As shipped-Range .720"–2.687" (18–68 mm). Includes setting fixture, calibrator rings, medium and large extension point sets, accessory case, mounting bracket and instructions.

Shipping Weight: approximately 25 lbs. (11,4 kg)

### Midget Point Set AG-140 and AG-140L

Range .375"–.750" (9,5–19 mm). For checking pin fits on small bore engines. Fits AG-300 Gage without alterations. (See chart below...be sure to check serial number of gage before ordering midget point sets.) Set includes all required parts and metal storage box.



The only gage made for both clearance and press type pin fits AND THE JOURNAL END OF CON-RODS.

### Extra Large Point Set AG-340

Range 2.625"–3.375" (67–86 mm). Ideal for checking bores in large truck and tractor rods. Fits all AG-300 Gages.

Gage Point Sets	Point Sets	Part No.	Fits Gages Serial Numbers	Range
Each Midget Point Set includes all required parts & metal storage box.  These sets consist of two Gage Points and a centralizer point. Order by part number listed at right.	Midget Point Sets	AG-140 AG-140L	Under 13,000 13,000 and UP	.375"–.750" (9,5–19 mm)
	Standard Set	AG-210*	ALL GAGES	.720"–1.530" (18–39 mm)
	Medium Extension Sets	AG-620*	ABOVE 4,000–Heavy-duty type with Carbide Gage Balls	1.500"–2.250" (38–57 mm)
	Large Extension Sets	AG-630*	ABOVE 4,000–Heavy-duty type with Carbide Gage Balls	1.932"–2.687" (49–68 mm)
This set includes the AG-620 and AG-630 Point Sets. It is complete with both small and large calibration rings, adjustment wrench. Includes metal storage box.	Extra Large Extension Sets	AG-340	ALL GAGES	2.625"–3.375" (67–86 mm)
	Accessory and Point Set Kit	AG-475L*	13,000 and UP	1.500"–2.687" (38–68 mm)

# Dial Bore Gages

## Gages and Accessories



### GR-3000 Dial Bore Gage

Assembly consists of a .00001" reading indicator, probe retractor and probe retainer bushing in a reinforced nylon insulating shroud. Order GRM-3000 for .002 mm reading. Shipping Weight: 2 lbs. (1 kg)



Order 1-4 for each diameter.

- 1** Gage GR/GRM-3000
- 2** Probe
- 3** Transfer Pin
- 4** Probe Extension

Gage	Diameter Range		Probe No.	Transfer Pin No.	Max. Gaging Depth		Overall Length		Probe Ext.
	in	mm			in	mm	in	mm	
GR/GRM-3000	.054-.061	1,37-1,55	G-1055	G-2037	.43	11	6.6	167	KZ1X-3500  See Note
	.059-.075	1,50-1,90	G-1070	G-2059	.63	16	6.9	174	
	.071-.087	1,80-2,20	G-1080		.63	16	6.9	174	
	.081-.096	2,05-2,45	G-1090		.63	16	6.9	174	
	.089-.108	2,25-2,75	G-1100	G-2089	.82	21	7.1	179	
	.098-.118	2,50-3,00	G-1110		.82	21	7.1	179	
	.108-.128	2,75-3,25	G-1120		.82	21	7.1	179	
	.118-.138	3,00-3,50	G-1130		.82	21	7.1	179	
	.128-.148	3,25-3,75	G-1140		.82	21	7.1	179	
	.138-.157	3,50-4,00	G-1150		.82	21	7.1	179	
	.148-.167	3,75-4,25	G-1160	.82	21	7.1	179		
	.165-.189	4,20-4,80	G-1180	G-2264	1.53	39	7.7	195	
	.185-.209	4,70-5,30	G-1200		1.53	39	7.7	195	
	.205-.228	5,20-5,80	G-1220		1.53	39	7.7	195	
	.224-.248	5,70-6,30	G-1240		1.53	39	7.7	195	
	.244-.268	6,20-6,80	G-1260		1.53	39	7.7	195	
	.264-.287	6,70-7,30	G-1280		1.53	39	7.7	195	
	.283-.307	7,20-7,80	G-1300		1.53	39	7.7	195	
.303-.327	7,70-8,30	G-1320	1.53		39	7.7	195		
.323-.346	8,20-8,80	G-1340	1.53		39	7.7	195		
.343-.366	8,70-9,30	G-1360	1.53		39	7.7	195		
.362-.386	9,20-9,80	G-1380	1.53	39	7.7	195			
.370-.417	9,40-10,60	G-1400	G-2370	1.81	46	7.7	195		
.409-.457	10,40-11,60	G-1440		1.81	46	7.7	195		
.449-.496	11,40-12,60	G-1480		1.81	46	7.7	195		
.488-.535	12,40-13,60	G-1520		1.81	46	7.7	195		

### Probe Extension

Available for probes .323" (8,2 mm) or larger. Probe extensions are 2-1/2" (63,5 mm) long, and up to three can be assembled together. Part Number: KZ1X-3500.

NOTE: It may be necessary to order one or more KZ1X-3500 Probe extensions to reach the valve guides.

The probe extensions may be larger in diameter than the valve guide, but will not interfere with the gaging probe.

### Gage Probes and Transfer Pins

Probes and pins must be ordered separately. Diameter ranges, gaging depths and part numbers are listed in chart.





# Dial Bore Gage Setting Fixtures

## CF-540 Size Setting Adapter

Centers gage probes between parallel reference surfaces on CF-502 Setting Fixture. Serves as an "extra pair of hands" to help in nulling the gage on both the horizontal and vertical axis. Assures fast, accurate setup of the gage. Shipping Weight: 2 lbs. (1 kg)



Shown with CF-502 Setting Fixture.

## Setting Fixtures

### CF-502M (metric)

**1,37 mm–50,8 mm**

### CF-502 (inch) .054"–2.00"

For use with 3000, 4000, 6000, and 9000 Series Dial Bore Gages.

CF-502M comes with 0–51 mm micrometer head marked in .002 mm increments with precision lapped carbide anvils. Includes a ring gage checking standard and three interchangeable nests. (Use of CF-502M/CF-502 with 3000 series gage requires the purchase of CF-540 Size Setting Adapter.) Setting Master has a rugged, stress-relieved cast-iron base and may be used without removing it from its protective case. CF-502 is equipped with a 0"–2" micrometer head marked in .0001" increments.

CF-502M/CF-502 Shipping Weight: 10 lbs. (4,5 kg)



## Replacement Gage Nests For CF-502M Metric & CF502:

CF-502M	CF-550A	12,6 mm–19,1 mm
	CF-560A	18,8 mm–30,2 mm
	CF-570A	30,0 mm–50,0 mm

CF-502	CF-550A	.495"–.750"
	CF-560A	.740"–1.19"
	CF-570A	1.18"–2.00"

CF-137 Micrometer Adjusting Wrench

CF-138 Spindle Lock Knob

CF-544A Magnifier

CF-576A Calibration Ring

# Sunnen Dial Bore Gages

## GR-6245 and GR-9245 with Retractable Centralizers.

For lifter bores, cam bearing bores, hydraulic valve bodies and cylinders.  
Shipping Weight: 7 lbs. (3,2 kg)

GR-6245 diameter range: .740" to 1.190" (18,8 mm to 30,2 mm)

GR-9245 diameter range: 1.180" to 2.0" (30,0 mm to 50,8 mm)

The GR-6245 and GR-9245 dial bore gages parallel the GR-2125 and GR-2245 in function. They are ideally suited for many small bore applications-fast, easy, accurate.

For metric applications, order:  
GRM-6245-range: 18,8 to 30,2 mm.  
GRM-9245-range: 30,0 to 50,8 mm.  
Dial is marked in ,01 mm increments.



## Replacement Point Assemblies for GR-9000 Series (Includes Nut and Ball)

Part No.	Diameter Range
G-462A	#2 (1.385"-1.59")
G-462MA	#2 (35,2 mm-40,4 mm)
G-463A	#3 (1.59"-1.795")
G-463MA	#3 (40,4 mm-45,6 mm)
G-464A	#4 (1.795"-2.00")
G-464MA	#4 (45,6 mm-50,8 mm)

## Replacement Point Assemblies for GR-6000 Series (Includes Nut)

Part No.	Diameter Range	Indicators are available for gages.
G-361A	#1 (.740"-.890")	
G-361MA	#1 (18,8 mm-22,6 mm)	G795A .0001" (.003 mm)
G-362A	#2 (.89"-1.04")	
G-362MA	#2 (22,6 mm-26,4 mm)	G595A .0005" (.0127 mm)
G-363A	#3 (1.04"-1.19")	
G-363MA	#3 (26,4 mm-30,2 mm)	

## GR-2245 Gage with Retractable Centralizers

For main bearing saddle bores and cam shaft bearing bores.

Shipping Weight: 5 lbs. (2,3 kg)

Diameter range: 2" to 6" (50 to 152 mm).  
Gages holes up to 24" (60,9 cm) long.

This gage incorporates identical features and benefits of the GR-2125 with the additional reach length of 24" (60,9 cm).

For metric applications, order GRM-2245.  
Diameter range: 50 to 150 mm.  
Dial is marked in ,01 mm increments.

The GR-2245 is furnished with a storage case for accessories only.



## GA-2125 and GR-2125

For cylinders, sleeves, large con rods...many other gaging jobs.  
Shipping Weight: 7 lbs. (3,2 kg)

Diameter range: 2" to 6" (50,8 to 152,4 mm).  
Gages holes up to 12" (304 mm) long.

The GA-2125 is self-aligning in the bore, requires no centering. Lets you explore the entire cylinder from top to bottom...in seconds.

The retractable self-centering mechanism in the gaging head of the GR-2125 makes it easy to gage interrupted bores typical of 2-cycle motorcycle and marine engine applications without "hanging up". The retraction features allows precise exploration of a high performance cylinder without leaving telltale gaging marks.

- Gages are self-centering.
- Adjustable dial for easier reading.
- Dial is marked in .0005" increments.
- Carbide gaging points...for long life.
- Insulated grip eliminates "drift".
- Furnished in molded case with extension points and wrenches.

For metric models, order GAM-2125 or GRM-2125.  
Range: 50 to 203 mm. Dial marked in ,01 mm increments.

Note: Special length gages are available on a special order basis. Write for product bulletin #P-4206 or call Customer Service, Sunnen Products Co. for information.



## Replacement Point Assemblies for GA-2000/GR-2000 Series (Includes Ball and Nut)

Part No.	Diameter Range	Part No.	Diameter Range
G-610A	#1 (2"-2-3/8")	G-613A	#4 (3-1/8"-3-1/2")
G-611A	#2 (2-3/8"-2-3/4")	G-614A	#5 (3-1/2"-3-7/8")
G-612A	#3 (2-3/4"-3-1/8")	G-615A	#6 (3-7/8"-4-1/4")

Note: Sunnen 2000 Series Dial Bore Gages can be extended to 12" (304,8 mm) by adding oversize centralizer points and additional gage point extensions.

For gaging diameters in the range of 6"-12" (152,4 mm-304,8 mm) order: G-822A Gage Extension Kit. Consists of: Two Oversize Centralizer Points, G-632A #7 Gage Point Extension, G-634A #8 Gage Point Extension.

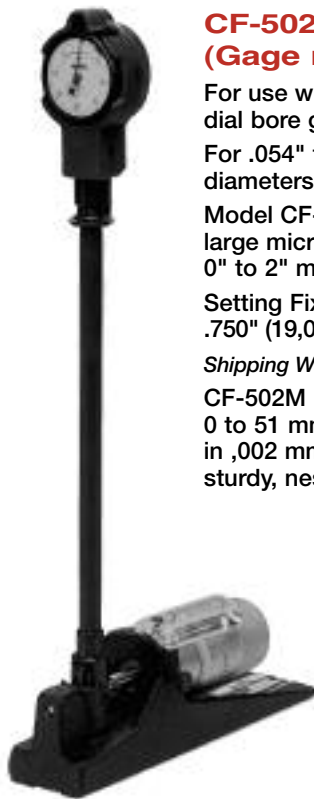
2000 Series Gages assembled with G-822A Gage extension set cannot be used with CF-1126 Setting Fixture when set for diameters above 8" (203,2 mm). Alternative methods of setting gage must be used.

Setting fixtures for Dial Bore Gages, see page 48.

# Dial Bore Gage Setting Fixtures

Sunnen's unique setting fixtures allow fast, easy setting of Sunnen dial bore gages with no need for separate micrometers and ring gages. Sizes are simply "dialed in" with the micrometer adjustment, which eliminates errors due to "feel" in setting gages.

Two models combine to cover a continuous range of .054" to 8" in .0001" increments (1,37 mm to 203 mm in .002 mm increments). Both models feature a heavy stress-relieved cast iron base, lapped carbide micrometer anvils, and built-in magnifier for fast, accurate setup.



## CF-502 Setting Fixture (Gage not included)

For use with GR-6245 and GR-9245 dial bore gages.

For .054" to 2.000" (1,4 to 50,8 mm) diameters.

Model CF-502 is equipped with a large micrometer head with range of 0" to 2" marked in .0001" increments.

Setting Fixture comes with CF-576A .750" (19,05 mm) master calibrating ring.

Shipping Weight: 13 lbs. (5,9 kg)

CF-502M Metric Setting Fixture has a 0 to 51 mm micrometer head marked in .002 mm increments. Supplied in a sturdy, nested box.



## CF-125A (Not shown)

Nest for CF-1126

## CF-140 Adapter Kit (Not shown)

This adapter kit is required for the early model CF-1000 Setting Fixture so it can be used with the Sunnen CK-3280 as well as the current GA-2125 and GR-2245 Gages.

## CF-210A Setting Standard

Setting standard for CF-1000 setting fixture.



## CF-1126 Setting Fixture (Gage not included)



For use with GA-2125, GR-2125 and GR-2245 Dial Bore Gages.

For 2" to 8" (51 to 203 mm) diameters.

The CF-1126 incorporates a tenth-reading micrometer head with precision carbide anvil. Accurate within .0001" (0,0025 mm). Ring gage checking standard included. Precision setting standards in 1" (25,4 mm) increments. Setting Master has rugged stress-relieved, cast iron base. May be used without removing from protective case.

Shipping Weight: 21 lbs. (9,5 kg)

The setting fixture itself covers the 7" to 8" (178 to 203 mm) range. In addition, the fixture is supplied with standards to cover the 2" to 6" (50 to 152,4 mm) range. Order additional setting standards to give complete 2" to 8" range as follows:

Part No.	Range
CF-220A*	2" to 3" (51 to 76 mm)
CF-230A*	3" to 4" (76 to 102 mm)
CF-240A*	4" to 5" (102 to 127 mm)
CF-250A*	5" to 6" (127 to 152 mm)
CF-260A	6" to 7" (152 to 178 mm)
CF-215A*	Ring Gage 2.000" (50,8 mm)

### \*Included with CF-1126

CF-130A	Replacement Micrometer Anvil
CF-544A	Replacement Magnifier

Fits the CF-1126 and CF-502 Setting Fixtures.

## CF-1126M Metric Setting Fixture

Metric Setting Fixture (Diameter Range 50 mm to 200 mm).

Metric Setting Standards available as follows:

Part No.	Range
CF-320A*	50 to 75 mm
CF-330A*	75 to 100 mm
CF-340A*	100 to 125 mm
CF-350A*	125 to 150 mm
CF-360A	150 to 175 mm
CF-215MA*	Ring Gage 2.007" (50,99 mm)

\*Included with CF-1126M

# PG Bore Gaging System

**Diameter Range: .090"–4.310" (2,29 mm–109,47 mm)**

The Sunnen "PG" Bore Gaging System is a unique mechanical gaging system that makes I.D. Gaging simple, reliable, and economical. Eliminates buying and maintaining costly master rings and air gage probes. Both gage and setting fixture are built for everyday use making them ideal for "in-process" inspection. Available in 00005" or .0001" (.001 mm or .0025 mm) reading scales.

PG-710E Small Bore Precision Gage with PG-400E Setting Fixture



## PG-700E Small Bore Precision Gage

**Diameter Range: .090"–.379" (2,29 mm–9,63 mm)\***  
 Direct reading scale with .005" (.13 mm) range divided into increments of .00005" (.001 mm).  
 Order PG-700EM for metric applications.  
 Weight: 20.5 lbs. (9,3 kg)  
 Dimensions (without fingers):  
 10.5" H x 7.75" W x 6.5" D  
 (267 mm x 197 mm x 165 mm)

\*Covered with complete set of gaging fingers. Individual finger sets can be ordered for specific sizes. Order individual finger sets from the complete list at right.



## PG-710E Small Bore Precision Gage

Identical to PG-700 except direct reading scale is .010" (.24 mm) wide and divided into increments of .0001" (.0025 mm). Order PG-710EM for metric applications.

## Gaging Fingers for PG-700 or PG-710 Precision Gage

To order individual finger pairs, consult the table below for size ranges and part numbers.



Each pair of gaging fingers is stamped with its size range and comes nested in an impact-resistant box.

Available for sale only.

Individual Gaging Finger Shipping Weight: .5 lb. (.2 kg)

Diameter Range		Gaging Depth*		Accessory Fingers
inches	mm	inches	mm	
.090-.099	2,29-2,51	.281	7,14	PG-1090
.099-.109	2,51-2,77	.281	7,14	PG-1099
.109-.120	2,77-3,05	.281	7,14	PG-1109
.120-.132	3,05-3,35	.500	12,70	PG-1120
.132-.145	3,35-3,68	.500	12,70	PG-1132
.145-.159	3,68-4,04	.625	15,87	PG-1145
.159-.174	4,04-4,42	.625	15,87	PG-1159
.174-.190	4,42-4,83	.750	19,05	PG-1174
.190-.207	4,83-5,26	.750	19,05	PG-1190
.207-.225	5,26-5,72	.875	22,22	PG-1207
.225-.244	5,72-6,20	.875	22,22	PG-1225
.244-.264	6,20-6,71	1.000	25,40	PG-1244
.264-.285	6,71-7,24	1.000	25,40	PG-1264
.285-.307	7,24-7,80	1.250	31,75	PG-1285
.307-.330	7,80-8,38	1.250	31,75	PG-1307
.330-.354	8,38-9,00	1.500	38,10	PG-1330
.354-.379	9,00-9,63	1.500	38,10	PG-1354
Metal Storage Cabinet				PG-1418
COMPLETE SET of all Gaging Finger Pairs, including PG-1418 Metal Storage Cabinet.				PG-1401
Weight: 20 lbs. (9 kg)				

\* If bore can be measured from both ends, bore length can be double the gaging depth shown.

## Blind Hole Gaging Fingers for PG-700/PG-710 Gages

Special Blind Hole Gaging Fingers are available on special order basis. These fingers are non-adjustable and can only be used for a specific diameter size. These altered blind hole fingers can measure to within .040" (1,02 mm) of the bottom of the blind end of the bore. Recommend customer use a ring gage to set size on the gage.

How to order blind hole gaging fingers:

PG-\_\_\_\_ - \_\_\_\_ - HMOX The first \_\_\_\_ is the four-digit number of the standard gaging fingers for the diameter needed to be measured. The second \_\_\_\_ is the finished diameter of the bore to be measured, either in English or Metric units.

Examples: .2092" diameter. Order: PG-1202-2092-HMOX  
 2,89 mm diameter. Order: PG-1109-2,890-HMOX

Available 4 weeks after receipt of order.

# PG Bore Gaging System

## PG-800E Precision Bore Gage

Diameter Range: .370"–1.500"  
(9,4 mm–38,1 mm)

Direct reading scale with .005" (.13 mm) range divided into increments of .00005" (.001 mm). Overall size range is divided into two subranges .370"–.750" (9,4 mm–19,05 mm) and .750"–1.500" (19,05 mm–38,1 mm). Replaceable carbide gage points which can be rotated for long life. Size range can be increased to 2.9" (74,3 mm) by ordering PG-250 Extension Finger Set.



PG-800E

Order PG-800EM for metric applications.  
Dimensions: 10-1/2" H x 7-3/4" W x 8-3/8" D  
(267 x 197 x 213 mm)

Gaging Depth: Small Side – .968" (24,6 mm)  
Large Side – 1.656" (42,06 mm)  
With PG-250 – 1.625" (41,27 mm)

Weight: 20.25 lbs. (9,2 kg)

## PG-810E Precision Bore Gage

Identical to PG-800 except direct reading scale is .010" (.24 mm) wide and divided into increments of .0001" (.0025 mm). Order PG-810EM for metric applications.

## PG-250E Extension Finger Set



Used with the PG-800 and PG-810 Precision Bore Gages. Extends the PG-800/PG-810 measuring range from 1.500" (38,1 mm) to over 2.900" (74,3 mm) diameter. Consists of two pairs of carbide extension points which mount onto the fingers of the PG-800/PG-810. Mounting screws are permanently attached to extension points to avoid their loss.

FOR SALE OR LEASE.

### GAGE LEASING PROGRAM

Sunnen PG-700, PG-800 Series Gages, Setting Fixtures, and PG-250 Extension Fingers are also available on a unique lease plan. Leasing the Sunnen bore gaging system includes maintenance and updating by Sunnen. Contact KS & C Industries 1-800-247-7098 for complete leasing information.

Note: This program is not available outside of the United States.

## PG-400E Setting Fixture

Diameter Range: .090"–1.500" (2,29 mm–38,3 mm)



This Setting Fixture is used to set the PGE-3000, PG-800, PG-810, PG-700 and PG-710 Precision Bore Gages. Dimensional accuracy is guaranteed to be within  $\pm .000025"$  (.0006 mm) of nominal reading over the entire range of the instrument. Comes in a carrying case with a master calibrating ring traceable to the Bureau of Standards.

Order PG-400EM for metric applications.  
Weight: 6.75 lbs. (3 kg) (with carrying case and accessories)

## PG-500E Setting Fixture

(Not pictured-similar to PG-400)

Diameter Range: 1.500"–2.900" (37,7 mm–74,3 mm)

Similar to PG-400, except for higher range. Used to set PG-800 or PG-810 Precision Bore Gage when equipped with PG-250 Extension Fingers. Comes in a carrying case with a master calibrating ring traceable to the Bureau of Standards. Includes PG-2090 Auxiliary Faceplate.

Order PG-500EM for metric applications.  
Weight: 9.5 lbs. (4,3 kg) (with carrying case and accessories).

## PGE-500 Setting Fixture

Identical to PG-500E Setting Fixture. Use to set PGE-3000 Precision Bore Gage when equipped with PGE-250 Extension Fingers. Includes PGE-3167 Auxiliary Faceplate. Order PGE-500EM for metric applications.

## PG-810-Z08X Precision Bore Gage

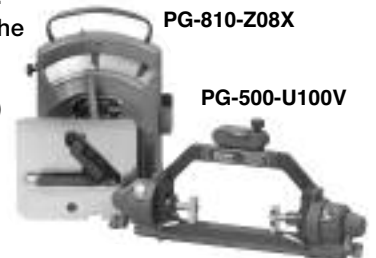
Diameter Range: 3.0"–4.5" (76,2 mm–114,3 mm)

Available for purchase only.

PG-810-Z08X is similar to the PG-810 Precision Bore Gage. Diameters 3.0"–3.750" (76,2 mm–95,25 mm) are measured on one side. Diameters 3.750"–4.5" (95,25 mm–114,3 mm) are measured on the opposite side.

Dimensions: 10-1/2" H x 7-3/4" W x 8-3/4" D  
(267 mm x 197 mm x 222 mm)

Order PG-810M-Z08X for metric applications.  
Weight: 21 lbs. (9,54 kg)



PG-810-Z08X

PG-500-U100V

# PG Bore Gaging System

## PG-500-U100X Setting Fixture for PG-810-Z08X

(Similar to PG-500 Setting Gage.)

**Diameter Range: 2.890"–4.310" (73,40 mm–109,47 mm)**

Used to set 3.0"–4.310" (76,2 mm–109,47 mm) diameter range on PG-810-Z08X.

Also used with PG-800 Series Gage with PG-250 Extension Fingers and PG-2090-AM1X Auxiliary Face Plate to set diameters 2.890"–3.0" (73,4 mm–76,2 mm). Setting size on PG-810-Z08X from 4.310"–4.5" (109,47 mm–114,3 mm) must be done utilizing ring gages or gage blocks.

Order **PG-500M-U100X** for metric applications.  
Shipping Weight: 17 lb. (7,7 kg)

**PG-810-Z08X** and **PG-500-U100X** available from stock (limited quantity available). **PG-2090-AM1X** available three weeks after receipt of order.

## PG-845 Tilting Gage Stand

A recommended accessory for the PG-810-Z08X Precision Gage.

Lets the gage faceplate support the majority of the part weight. Used also with PGE-3000, PG-800/PG-810. Attaches to MB-2370 Gage Mounting Bracket. Weight: 4.5 lbs. (2,1 kg)



## PG Bore Gaging Accessories

### Replacement Gage Points for PG-800 and PG-250

- PG-712A Point Set** Consists of three Carbide Gaging and three Mounting Screws for .740"–1.500" (18,8 mm–38,1 mm) diameter gaging fingers. Also used on non-centralizer gaging fingers on PG-250 Extension Finger Set.
- PG-714A Point Set** Consists of three Carbide Gaging and three Mounting Screws for .370"–.740" (9,4 mm–18,8 mm) diameter gaging fingers.
- PG-1007** Eccentric Centralizer with carbide ring used on both centralizer extension fingers of the PG-250 Extension Finger Set.
- PG-110A** Gage Point Removal and Installation Tool .370"–.740" (9,4 mm–18,8 mm).
- PG-90A** Gage Point Removal and Installation Tool .740"–1.500" (18,8 mm–38,1 mm).
- PG-120A** Tolerance Flag Adjusting Wrench.

### Blind Hole Gaging Points for PG-800 and PG-250

- PG-702A Blind Hole Point Set** Consists of three Points and Screws .740"–1.500" (18,8 mm–38,1 mm). Also used on non-centralizer gaging fingers on PG-250 Extension Finger Set.
- PG-704A Blind Hole Point Set** Consists of three Points and Screws .370"–.740" (9,4 mm–18,8 mm) diameter gaging fingers.
- PG-LR6X Blind Hole Centralizer** For PG-250 Extension Finger Set 1.5"-2.9" (38,1 mm–74,3 mm).

*Note: Blind hole point sets measure to within .010" (0,25 mm) of the bottom of the blind hole.*

*PG-LR6X available four weeks after receipt of order.*

# PG Bore Gaging System

## Gage Mounting Brackets

Recommended when any Sunnen Precision Bore Gage is used on a Sunnen Honing Machine. Mounting brackets reduce lost motion and fatigue and reduce runoff of honing oil.

Available for either right or left side mounting. All models adjustable for easiest access to gage.

To order, specify from chart.

**Model No.** **Description**  
**MB-1325** For Right Side of MB-1290, MBB-1290, MBB-1600, MBB-1650, or MBB-1660.  
 Weight: 10 lbs. (4,5 kg)



**Model No.** **Description**  
**MB-2370** For Left or Right Side of MBB-1650 or MBB-1660; Left Side of MBB-1670, MBB-1680, MBB-1690, MBB-1800, MBC-1800, MBC-1801, MBC-1802, MBC-1803, MBC-1804, MBC-1805.  
 Weight: 12 lbs. (5,5 kg)



**MB-1250** For Left Side of MB-1290, MBB-1290, MBB-1600.  
 Weight: 10 lbs. (4,5 kg)



**EC-7170** For Right Side of EC-3500.

## PG-2130 Flexible Hex Wrench

Use to dampen vibration when centralizing PG-400 on the PG-700/710 Precision Gage.

## PG-2110 Clip-On Auxiliary Faceplate

For PG-700/710 Precision Gage.

Additional PG Gage Faceplates.



PG-4

PG-4 Auxiliary Faceplate for PG-700/PG-710. A flat plate with ten holes designed to slip over the gaging fingers of a PG-700/PG-710. Reduces the opening size of the PG-2110 faceplate making it easier to measure thin walled parts. Hole sizes on PG-4 vary from .109"-.343" (2,77 mm-8,71 mm).



PG-5

PG-10A Auxiliary Faceplate set for PG-800/PG-810 Precision Gage. Consists of one PG-5 and PG-6 Faceplate similar to PG-4. PG-5 hole size .720" (18,3 mm), .820" (20,8 mm), and .920" (23,4 mm). PG-6 hole size .380" (9,7 mm), .430" (10,9 mm), .480" (12,2 mm), .530" (13,5 mm), .580" (14,7 mm), .630" (16,0 mm), and .680" (17,3 mm).



PG-6

## PG-25 Magnifying Glass



With spring clip. Made of 2.5x ground optical glass with a spring clip for mounting on PG-700 or PG-800 precision gage.

# Honing Oils & Coolants

## For Honing Connecting Rods on Sunnen Machines

### Mineral Base Honing Oil

CK-50-55 55 gal. drum

CK-50 is specially formulated for honing cast iron automotive and truck engine blocks and should not be used to hone other materials.

MAN-845-55 55 gal. drum

MAN-845-5 5 gal. pail

MAN-845 is formulated for general purpose automotive machine shop honing. Most commonly used.

MB-30-55 55 gal. drum

MB-30-5 5 gal. pail

MB-30 is Sunnen's multi-purpose industrial honing oil. MB-30 works on virtually any metal from aluminum to zirconium.



### MAN-C Honing Oil Concentrate



MAN-C is a honing oil concentrate, which when mixed at the proper ratios with customer supplied mineral oil, makes MAN-845 or CK-50 honing oil. The end user will save on

shipping expenses by purchasing the mineral oil locally and mixing it with MAN-C at their facility.

### SCC-205 Water Base Coolant

SCC-205 honing coolant concentrate is formulated to meet the demands of metal bond superabrasive honing.



### Filters



#### Replacement Filters

- PF-105-4 Extra Fine Filter (oil only) (Pkg. of 4)
- PF-110-4 Fine Filter (oil only) (Pkg. of 4)
- PF-104 Extra Fine Filter (oil or water) (Pkg. of 1)
- PF-160 Fine Filter (oil or water) (Pkg. of 1) (Fiberglass)
- PF-180 Course Filter (oil or water) (Pkg. of 1) (Fiberglass)

### SCC-900

#### SCC-900 Coolant Maintenance Kit

Poor housekeeping and improper coolant concentration are the major causes of coolant failure, yet simple daily maintenance will protect and prolong coolant life.

The Sunnen SCC-900 Coolant Maintenance Kit provides everything you will need to check water based coolant. Kit includes: Instruction and Record Forms, Refractometer, PH Kit, Pitcher Storage Case.

### Machine Capacities

LBB-1699 and LBB-1660  
15 Gal. Capacity

LBB-1810 and LBB-1803  
25 Gal. Capacity

EC-3500, ML-3500 and ML-5000  
32 Gal. Capacity

ML-2000  
28 Gal. Capacity

### B-200 Press Fit Lubricant

Prevents galling and reduces ram pressure.

Six spray cans per package.

Shipping Weight: 3 lbs. (1,4 kg)



### B-200L

Same lubricant as B-200 except packaged in brush applicator bottle.



# Honing Oils & Coolants

## For Honing Cylinders on Sunnen Machines

CK-50-55 55 gal. drum  
CK-50-5 5 gal. pail

CK-50 is specially formulated for honing cast iron automotive and truck engine blocks and should not be used to hone other materials.

MAN-845-55 55 gal. drum  
MAN-845-5 5 gal. pail

MAN-845 is formulated for general purpose automotive machine shop honing.

MB-30-55 55 gal. drum  
MB-30-5 5 gal. pail

MB-30 is Sunnen's multi-purpose industrial honing oil. MB-30 works on virtually any metal from aluminum to zirconium.



### MAN-C Honing Oil Concentrate



MAN-C is a honing oil concentrate, which when mixed at the proper ratios with customer supplied mineral oil, makes MAN-845 or CK-50 honing oil. The end user will save on shipping expenses by purchasing the mineral oil locally and mixing it with MAN-C at their facility.

### SCC-605

SCC-605 honing coolant concentrate is formulated to meet the demands of metal bond superabrasive honing.



### Filters



### Replacement Filters

- PF-105-4 Extra Fine Filter (oil only) (Pkg. of 4)
- PF-110-4 Fine Filter (oil only) (Pkg. of 4)
- PF-104 Extra Fine Filter (oil or water) (Pkg. of 1)
- PF-160 Fine Filter (oil or water) (Pkg. of 1) (Fiberglass)

### SCC-900

#### SCC-900 Coolant Maintenance Kit

Poor housekeeping and improper coolant concentration are the major causes of coolant failure, yet simple daily maintenance will protect and prolong coolant life.

The Sunnen SCC-900 Coolant Maintenance Kit provides everything you will need to check water based coolant. Kit includes: Instruction and Record Forms, Refractometer, PH Kit, Pitcher Storage Case.

### Machine Capacities

CK-10/CV-616/SV-10  
55 Gal. Capacity

CK-21  
63.5 Gal. Capacity

### B-200 Press Fit Lubricant



Prevents galling and reduces ram pressure.  
Six spray cans per package.  
*Shipping Weight: 3 lbs. (1,4 kg)*

### B-200L

Same lubricant as B-200 except packaged in brush applicator bottle.





