



Honing Reactions

RPM-Reciprocation-Feed Pressure

Increase RPM

1. Makes abrasives act harder
2. Will obtain finer finish
3. Abrasive will stop cutting if increase too much

Increase Reciprocation

1. Makes abrasives act softer
2. Will obtain courser finish
3. Will decrease abrasive life

Increase Feed Pressure

1. Makes abrasives act softer
2. Will increase abrasives aggressiveness and not glaze
3. Will remove stock quicker
4. Will increase torque
5. Will generate more heat
6. Will give courser finish

Decrease RPM

1. Makes abrasives act softer
2. Will obtain courser finish
3. Will increase abrasives aggressiveness and not glaze
4. Will increase torque

Decrease Reciprocation

1. Abrasive will act harder
2. Will give finer surface finish
3. Will decrease a abrasive's ability to stay sharp and not glaze
4. Will remove stock slower if too slow

Decrease Feed Pressure

1. Will cause abrasives to act harder
2. Will decrease a abrasives ability to Stay sharp and not glaze
3. Will remove stock more slowly
4. Will decrease torque
5. Will contribute to better geometry
6. Will decrease wear on machine
7. Will generate less heat
8. Will generate less noise
9. Will give finer surface finish
10. Will increase cycle time