



## Honing Spindle Speed

Spindle speeds are decided by the following factors:

1. Material Specifications
2. Bore Diameter
3. Abrasive Size
4. Surface Finish

### Guidelines

<b>Material</b>	<b>Hardness</b>	<b>Surface Feet per Minute</b>
Steel	Mild	120-150
Steel	Hardened	80-100
Cast Iron	Mild	160-180
Cast Iron	Hardened	90-110

Surface Feet Conversion: See Chart

Increase RPM = Abrasive act Harder, finish is finer

Decrease RPM = Abrasives act Softer, finish is courser

Reciprocation: 60-90 Feet per minute

Increase Reciprocation = Abrasives act Softer, finish is rougher

Decrease Reciprocation = Abrasives act Harder, finish is finer