



Honing Trouble Shooting

Condition	Correction in order of Importance
Abrasive glazing.....	2-3-5-15-13-18-11
Abrasive loading.....	2-3-15-7-17-19-11
Abrasive galling.....	2-3-7-15-9-17-19-24-11
Finish too rough.....	1-4-6-17-16-7-12
Finish too smooth.....	2-3-5-18-15-8-13
Excessive abrasive usage.....	1-4-6-16-7
Tapered stone wear.....	14-22-21-16
Slow stock removal.....	5-3-2-8-11-15-18
Excessive part heat.....	10-6-8-11-24-15-20
Part out of roundness.....	6-2-3-12-14-15-25
Part bell mouth/taper.....	26-12-14-25
Part not axially straight.....	32-14-25-33
Part being honed eccentric to OD.....	14-29-30
Bore not square to face.....	29-14-33
Washout around keyways, ports.....	6-17-28

Corrections

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|---|---|
| 1. Increase spindle RPM | 18. Use Courser grit abrasives |
| 2. Decrease spindle RPM | 19. Use less porous abrasives |
| 3. Increase reciprocation | 20. Use more porous abrasives |
| 4. Decrease reciprocation | 21. Check abrasive grade |
| 5. Increase feed rate | 22. Check tool for wear |
| 6. Decrease feed rate | 23. Trial other abrasives |
| 7. Increase coolant's base content | 24. Use more coolant |
| 8. Decrease coolant's base content | 25. Check fixture is not distorting part |
| 9. Check filtration of coolant | 26. Adjust over-run of stroke |
| 10. Check refrigeration of coolant | 27. Use guides |
| 11. Check coolant for hydraulic oil contamination | 28. Use fibre clad abrasives |
| 12. Increase run-out time | 29. Tram part face to check square to spindle |
| 13. Decrease run-out time | 30. Rotate part occasionally while honing |
| 14. Check spindle to part alignment | 31. Use light feed pressure at start of cycle |
| 15. Use softer abrasives | 32. Use longer abrasives |
| 16. Use harder abrasives | 33. Check part accuracy prior to honing |
| 17. Use finer grit abrasives | |