



The Flex-Hone® Tool is a resilient, flexible honing tool with globules of raw grain abrasive in a resin bond. The Flex-Hone Tool will produce a controlled surface finish depending on the grit and abrasive type used. The Flex-Hone Tool is also excellent for deburring cross-holes and producing an edge break. The Flex-Hone Tool has a wide variety of applications in the automotive and industrial fields.

The Flex-Hone Tool is available in Silicon Carbide, Aluminum Oxide, Zirconia Alumina, Boron Carbide, Tungsten Carbide and Levigated Alumina. Grain sizes of 20 grit to 800 grit are available in most abrasive types.

The Flex-Hone Tool is available in diameters from 4mm (.157") to 914mm (36")

Instructions:

1. Use a 10-30 weight or Flex-Hone Oil, except when honing hydraulic brake cylinders. When honing hydraulic brake cylinders use the hydraulic brake fluid as a honing lubricant.
2. Have the Flex-Hone Tool rotating upon entry and removal from the cylinder.
3. Recommended RPM range for this Flex-Hone Tool is 500 to 1200 RPM. Do not use air tools or high speed motors.
4. Use 60-120 strokes per minute depending on RPM. Final stroking may be accelerated to develop a 45 degree cross-hatch angle.
5. Honing time should be approximately 20-45 seconds per cylinder.
6. Do not use solvents for honing or cleaning.
7. Clean cylinders after honing with warm or hot water and detergent using a brush, and then oil the cylinder.

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Caution:

Safety goggles or full face shields **MUST BE WORN** by all OPERATORS and OTHERS IN THE AREA while operating Flex-Hone Tools. Comply with the requirements of ANSI Z87.1 "Occupational Eye and Face Protection."

