

# GHA TOOLS

## Multi stone honing tools using Delapena vertical stone sets

Delapena vertical tooling heads have been adapted to be used on horizontal honing machines. This gives the user an alternative honing option on smaller diameters (25-79mm) and capability to hone bores above the range of the Delapena mandrel tooling (>79mm).

Tool heads use standard vertical tooling stones sets (see Vertical Tooling Catalogue).



### Midget - GHA-281

**Diameter Range 25.4 - 38.1mm (1.00 - 1.50")**

Head locates in the spindle nose and the linear feed mechanism expands the stones.

**Stone types** (see Delapena vertical tooling catalogue);

**26**      Ø25.4 - 31.7mm (1.00 - 1.25")

**27**      Ø31.7 - 38.1mm (1.25 - 1.50")



### Minor - GHA-283

**Diameter Range 38.1 - 55.8mm (1.50 - 2.20")**

Head locates in the spindle nose and the linear feed mechanism expands the stones.

**Stone types** (see Delapena vertical tooling catalogue);

**28**      Ø38.1 - 44.4mm (1.50 - 1.75")

**29**      Ø44.4 - 50.8mm (1.75 - 2.00")



### Junior - GHA-285

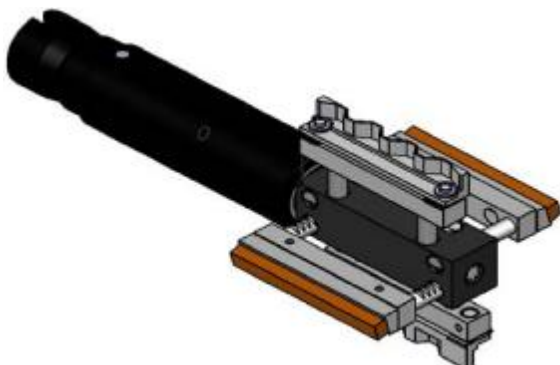
**Diameter Range 50.8 - 68.3mm (2.00 - 2.69")**

Head locates in the spindle nose and the linear feed mechanism expands the stones.

**Stone types** (see Delapena vertical tooling catalogue);

**T**      Ø50.8 - 55.8mm (2.00 - 2.20")

**U**      Ø55.8 - 60.9mm (2.20 - 2.40")



### Standard - GHA-287

**Diameter Range > 65.0mm - (>2.56") #**

Head locates in the spindle nose and the linear feed mechanism is converted via a helical adaptor to rotational feed movement in the hone head to expand the stones. When fitting new stone sets the square hone body must be removed from the assembly.

**Stone types** (see Delapena vertical tooling catalogue);

**G**      Ø65.0 - 99.0mm (2.56 - 3.90")

**M**      Ø68.0 - 107.0mm (2.68 - 4.21")

**# Please note that the maximum honing diameter will depend on the application. Please contact Delapena for advice.**