

GNR Giant Portable Hone

For large diameter work on deep bores, production honing, or parts with limited access
for stone adjustment in diameters larger than 254mm (10")

I.D. Range:

254 mm – 1524 mm

10"–60"



GNR-1010 Remote-Feed Giant Hone assembled with honing stones. Will hone bores up to 304mm (12") long as shown. Order additional drive shafts for longer bores. All giant hones require 2 sets of W47 or WY51 stones to load the hone. (See Tables on page 146 for Stone sets for GNR Hones.)

The remote feed permits the operator to expand the stones at any time while the honing head is running in the bore, as well as when the hone is stopped. The operator controls the amount of stone expansion and the honing pressure by braking the feed wheel while the hone is turning. The remote feed also permits the operator to quickly retract the stones and remove the hone from the bore when the hone is stopped.

Drive Source

Drive motors of 2.2-3.7KW (3 to 5 HP) provide adequate torque to turn the hone. These hones may be driven by a rigidly mounted power source such as a radial drill press or a large lathe; 29 mm (1-1/8") chuck capacity is required.

Remote-Feed Giant Hones are equipped with two universal joints which allow the honing head to align itself with the workpiece.

Recommended RPM: To establish optimum RPM for your application, divide 1200 by bore diameter in inches.

EX: $1,200 \div 10 = 120$ (RPM).

Or, divide 30,000 by bore diameter in mm.

EX: $30,000 \div 254 = 118$ (RPM).

To Order:

Select the correct Giant Hone, drive shaft extension (for bore length 304 mm [12"] or longer and universal joint, if needed).

Remote-Feed Giant Hones

Diameter Range		Part Number	Shipping Weight	
mm	in		kg	lbs.
254-381	10-15	GNR-1010+	13,2	29.5
381-508	15-20	GNR-1510+	15,7	34.5
508-711	20-28	GNR-2010+	26,5	58.5
711-914	28-36	GNR-2810+	38,4	84.5
914-1118	36-44	GNR-3610+		
1118-1321	44-52	GNR-4410+		
1321-1524	52-60	GNR-5210+		

+ Special Order - Contact Customer Service

Additional Hone Heads Extend the Diameter Range

A complete Remote-Feed Giant Hone consists of a GNR-920 Remote-Feed Giant Drive Unit and a Giant Hone Head, as illustrated. The GNR-920 Remote-Feed Giant Drive Unit can be used with other Giant Hone Heads to extend the diameter range. Select additional Hone Heads as needed from the table below.



Giant Hone Head

GNR-920 Remote-Feed Giant Drive Unit

Additional Hone Heads

Diameter to be Honed	mm	inches	Part Number for Giant Hone Head**		Shipping Weight	
			kg	lbs.		
254-381	10-15	GNR-1025	4,1	9		
381-508	15-20	GNR-1525	6,4	14		
508-711	20-28	GNR-2025	17,3	38		
711-914	28-36	GNR-2825	29,1	64		
914-1118	36-44	GNR-3625+				
1118-1321	44-52	GNR-4425+				
1321-1524	52-60	GNR-5225+				

** These Hone Heads can be converted to complete Giant Hones at any time by purchasing GNR-920 Remote-Feed Giant Drive Unit.

+ Special Order - Contact Customer Service

Drive Shaft Extensions

Giant Hones will handle bore lengths up to 305mm (12") without Drive Shaft Extensions. When Extensions are necessary, they can be used one at a time or in multiples, making it possible to hone practically any bore length. All Drive Shaft Extensions are installed between the hone head and the feed wheel as illustrated above. The feed wheel remains outside the bore being honed, accessible for stone expansion.

Drive Shaft Extensions

Extension Length		Part Number	Shipping Weight	
mm	in		kg	lbs.
152	6	GNR-940	1,4	3
305	12	GNR-941	2,4	5
610	24	GNR-942	4,8	10.5
915	36	GNR-943	6,4	14
1220	48	GNR-944	8,2	18
1525	60	GNR-945	9,6	21
1830	72	GNR-946	10,6	23.25