

# Valve Guide Sizing

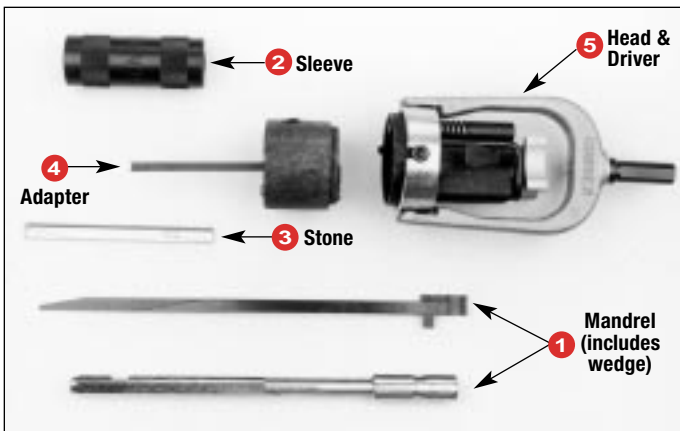
## Sunnen HONALL®

- Produces straight, round holes
- Fast setup
- Easy-to-use



### P-190 Valve Guide Hone Set

Available to cover most popular sizes. See chart below.  
A 3/8" drill (200 rpm) is recommended for driving power.



### Ordering Information

The head and driver are interchangeable with the adapters. Only one head and driver is required. Mandrels are available to cover all popular sizes. Please select the parts desired from photograph and order from the chart for the range desired. We recommend that an adapter be purchased for each mandrel. This saves change-over time going from one mandrel to another.

Additional Mandrel Sizes Available - Call Sunnen Customer Service Department.

### AN-1075 Speed Control Unit

Furnished with on/off switch, fuse, AC cord and grounded AC outlet plug. Reduces rpm when used with AC/DC drill motors and motors (brush-type only) where ampere rating is 15 amps or less.



| Nominal Fractional Size (inches) | Range inches | Range mm   | 1 Mandrel     | 2 Sleeve | 3 Stone | 4 Adapter   | 5 Head & Driver         |
|----------------------------------|--------------|------------|---------------|----------|---------|-------------|-------------------------|
| 3/16                             | .185-.190    | 4,7 - 4,8  | BL6-185CS     | S-185    | L6-J67  | Order both: | P-180<br>200 rpm<br>max |
| -                                | .195-.200    | 4,9 - 5,1  | BL6-195CS     | S-195    | L6-J67  | PSK6-A      |                         |
| 7/32                             | .215-.220    | 5,5 - 5,6  | BL6-215CS     | S-215    | L6-J67  | LN-3087C    |                         |
| 15/64                            | .235-.240    | 6,0 - 6,1  | BL6-235CS     | S-235    | L6-J67  | †           |                         |
| -                                | .255-.260    | 6,5 - 6,6  | BL8-255AS     | S-255    | L8-J67  | PK8-A       |                         |
| 17/64                            | .270-.275    | 6,8 - 7,0  | BL8-270AS     | S-270    | L8-J67  | PK8-A       |                         |
| 5/16*                            | .308-.316    | 7,8 - 8,0  | LG-308M       | S-308    | LG-13   | PK10-A      |                         |
| 11/32*                           | .339-.347    | 8,6 - 8,8  | LG-339M       | S-339    | LG-13   | PK10-A      |                         |
| 23/64                            | .354-.362    | 9,0 - 9,2  | BL10-354AS    | S-354    | LG-13   | PK10-A      |                         |
| 3/8*                             | .370-.385    | 9,4 - 9,8  | LH-370M       | S-370    | LH-13   | PK12-A      |                         |
| 13/32                            | .400-.416    | 10,2 -10,6 | LH-400M       | S-400    | LH-13   | PK12-A      |                         |
| 7/16*                            | .432-.447    | 11,0 -11,4 | LH-432M       | S-432    | LH-13   | PK12-A      |                         |
| 15/32                            | .463-.479    | 11,8 -12,2 | BL12-463AS    | S-463    | LH-13   | PK12-A      |                         |
| 1/2                              | .495-.526    | 12,6 -13,4 | LJ-495M       | S-495    | LJ-13   | PK16-A      |                         |
| 35/64                            | .526-.557    | 13,4 -14,1 | LJ-526M       | S-526    | LJ-13   | PK16-A      |                         |
| 9/16                             | .557-.588    | 14,1 -14,9 | LJ-557M       | S-557    | LJ-13   | PK16-A      |                         |
| 5/8                              | .619-.650    | 15,7 -16,5 | LJ-619M       | S-619    | LJ-13   | PAK16-A     |                         |
| 21/32                            | .650-.681    | 16,5 -17,3 | LJ-650M       | S-650    | LJ-13   | PAK16-A     |                         |
| 11/16                            | .681-.713    | 17,3 -18,1 | LJ-681M       | S-681    | LJ-13   | PAK16-A     |                         |
| 3/4                              | .744-.775    | 18,9 -19,7 | BAL20-744LA** | S-744    | LM-13   | PAK20-A     |                         |

\*P-190 Valve Guide Honing Set consists of 1 each mandrel and sleeve for the popular 5/16", 11/32", 3/8", and 7/16" sizes; also includes PK10-A, PK12-A, P-180, AN-1105A Storage Box, and 6 each LG-13 and LH-13 Stones. Shipping Weight: 8 lbs.

\*\*Replaceable shoe type mandrel. Replacement shoe Part No. LA-C (2 required).

†Remove the LN-3087A stone retainer (standard part supplied with the PSK6-A adapter) and replace with the LN-3087C. The LN-3087C must be ordered separately.

AN-1105A Storage Box available for convenient storage of tooling.