

Flex-Hone Cylinder Honing Instructions

The Flex-Hone tool is a resilient, flexible honing tool with globules of raw grain abrasive in a resin bond. This tool is perfect for deburring and deglazing automotive, motorcycle, and ATV cylinder walls. Refer to your owner's/service manual for recommended honing instructions and intervals.

On Nikasil plated cylinders use extra caution. The goal is to simply remove the glaze and byproducts of combustion without damaging the plating. To do this, make sure an ample amount of Flex-Hone oil is used, and use minimal time honing the cylinder (5-20 seconds).

1. Safety glasses must be used. Protect yourself and anyone else in the area with the use of safety glasses.
2. Using a Flex-Hone oil is critical when honing your cylinder. Apply a generous amount of oil to the Flex-Hone and the cylinder wall.
3. Using a drill, rotate the Flex-Hone between 500 and 1200 rpm. Do not exceed 1200 rpm! Do not use air tools as they usually exceed 1200 rpm!
4. The Flex-Hone will be larger than the cylinder bore. Make sure the Flex-Hone is rotating upon the entry and the exit of the cylinder.
5. Stroke the Flex-Hone quickly in the cylinder at a rate of about 1 stroke per second (varies with rotating speed). The goal is to have a 45 degree cross-hatch angle.
6. After honing you will notice debris from the Flex-Hone on the cylinder walls and in ports. Thoroughly cleaning the cylinder is critical. Do not use solvents for honing or cleaning. Clean cylinders with warm or hot water and detergent using a soft brush. Immediately dry with a clean rag and oil cylinder to prevent corrosion.
7. Wipe the Flex-Hone with a clean rag for storage.

