TM 9-3419-225-10

DEPARTMENT OF THE ARMY TECHNICAL MANUAL

OPERATOR'S MANUAL

HONING MACHINE HORIZONTAL BENCH MOUNTING 0.480 TO 3.000 INCH WORKING CAPACITY RANGE, 1 SPINDLE, 1/3 HORSEPOWER AC, 115-VOLT 60 CYCLE SINGLE PHASE (AMMCO TOOLS INC. MODEL 2500) (3419-812-1591)

This copy is a reprint which includes current pages from Change 1

HEADQUARTERS, DEPARTMENT OF THE ARMY

MAY 1965

AMMCO MODEL 2500 WET HONING MACHINE SET-UP, MAINTENANCE AND OPERATING INSTRUCTIONS

CONTENTS **PAGE**

Honing-What It Is 3

Set-Up and Maintenance 3

Lubrication 5

Stone Came 5

Correct Way to Dress Stones 7

General Operating Instructions 9

Honing with Short Stone Honing Heads 9

Honing with Long Stone Honing Heads 10

Honing Connecting Rods 11

Rod Fits and Finishes 11

Honing Pistons 13

Piston Fits and Finishes 13

Honing Spindles and Other In-Line Holes 14

Honing Blind End Holes 14

Press-Fit Rods 14

CONTENTS **PAGE**

Precision Plug Gage and Pilot Set Instruction 15

Model 2600 Wet Honing Machine Part List 16
Front View illustration 16
Side View illustration 16
Section through Spindle Illustration 16

Long Stone Honing Head Parts List 17

No 1800 Honing Head Part List 17

No 2450 Honing Head Parts List 17

No 1250 Honing Head Parts List 18

No 2750 Honing Head Parts List 19

No 1500 Blind Hole Honing Head Parts List 19

No 1550 Blind Hole Honing Head Parts List 19

Model 2700 Heavy Duty Wet Honing Machine Parts List 21

MILITARY SPECIFICATION MIL-H-14253A
FSN 3419-812-1591

AMMCO 2500 HONING MACHINE
HORIZONTAL WET-DRY TYPE

SPECIFICATIONS

PHYSICAL CHARACTERISTICS

1. MACHINE ACCURACY:
   A. Rounds, -.0002 for Range of .480 to 1.000 in.
   B. Final Surface, -16(RMS) Micro-inches (on Grey Iron)

2. RANGE:
   A. Thru Holes..... 480 to 3.000 inches
   B. Blind or Step Cylinders..... 1.125 to 2.062 inches

3. SPINDLE SPEEDS (Infinitely Variable)..... 380 to 740 RPM

4. TYPE HONING..... Wet or Dry

5. COOLANT CAPACITY .....3 Gallons

6. SPINDLE DRIVE MOTOR .....1/3 H.P., 115 Volt, 60 Cycle, Single Phase

7. COOLANT PUMP MOTOR..... 115 Volt, 60 Cycle, Single Phase

8. MACHINE DIMENSIONS:
   Length .....36" Maximum
   Width.....32" Maximum
   Height..... 26" Above Bench

9. MACHINE WEIGHT..... 203 lbs.
   (not including spare parts and accessories)