

# BHJ Products, Inc.

## Parts List & Instructions

Product Name: **Lifter Bore Hone**  
BHJ Part#: LBH-1

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### Description

The LBH-1 Lifter Bore Hone contains everything you need to make fast work of final sizing lifter bores. The rigid style hone utilizes a friction thimble and feed wedge for increasing diameter and is operated with a 1/2" drill motor. With a diameter range from .843" through .937" it will accommodate Chevrolet, Ford, Mopar and aftermarket lifter bores.

**NOTE: Success with this tool requires practice. It is strongly suggested that you develop your skill on a scrap block.**

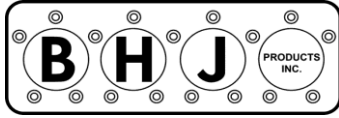
### Kit Contents:

<b>1x</b> Hone Assembly	<b>1x</b> .843 Shoe (Orange)
<b>1x</b> Coarse Standard Stone	<b>1x</b> .875 Shoe (Red)
<b>1x</b> Fine Standard Stone	<b>1x</b> .906 Shoe (Green)
<b>1x</b> Stone Shim	<b>1x</b> .937 Shoe (Yellow)
<b>1x</b> Storage Case	

### Operation

1. Use this hone with a drill that runs at 250 RPM maximum speed.
2. Always seat a new stone by running the hone in the appropriate diameter lifter bore of a scrap block. Use cutting oil or flood coolant during the honing process.
3. The stone can be fed outwards during operation by lightly grasping the knurled sleeve. We suggest over-stroking by approximately 1/2-3/4" to control bell mouthing.
4. If the stone feed wedge becomes fully advanced and all of the abrasive material on the stone has not been utilized, install the stone shim under the stone to increase its height.
5. Always install shoe with paint mark away from the u-joint end of the hone assembly.

**NOTE: Never attempt to disassemble hone as it will damage the main return spring.**



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### **Additional Shoes, Stones & Service Parts**

In addition to the shoes and stones that ship with the kit, optional parts are also available.

- Shoe sizes of 1.0", 1.032", 1.062", 1.092", 1.125", with custom sizes also available on request. Volume discounts are available for replacement shoes.
- Fine and coarse stones for high-nickel cast iron blocks. The stones included with this kit are optimal for bronze lifter bushings, OE-grade cast iron blocks and aluminum blocks. Volume discounts are available for replacement stones.
- Replacement shoe screws and stone shims are also available and are normally available for immediate shipment.

**Call BHJ at (510) 797-6780 with any questions regarding the part, setup, or operation.**