


**SI 1511**

 For technical personnel only!  
 1/1

# SERVICE INFORMATION

## NOTES ON MACHINING GAS PISTONS WITHOUT RECESSES

### PREPARATION

Make a note of all functionally relevant dimensions to act as reference values for a comparison before and after the machining process. To do so, measure the piston at the specified measuring points D1 and D2 (Fig. 1). Measure the piston before and after machining at the same ambient conditions, e.g. the same temperature.



Fig. 1: Measuring points on the piston

Item no.	Engine	Piston design	Connecting rod support
41495600*	E2876xxxxx	Without cooling channel	Trapezoidal connecting rod
41499600*	E2842xxxxx E2848xxxxx	Without cooling channel	Parallel connecting rod
40822600*	E2676xxxxx	With cooling channel	Trapezoidal connecting rod
42136600*	E083xxxxx	Without cooling channel	Trapezoidal connecting rod
42139600*	MTU 400 MDE B / E 30xx	Without cooling channel	Trapezoidal connecting rod



### NOTE

Installation and initial start-up only to be performed by qualified personnel!

\* Important note: The piston may not be installed without machining the piston crown!

### MACHINING

- Use suitable abrasives for alloys with a silicon content > 10%.
- Use a suitable tensioning device that will not impair the piston contours and the surface coating.
- The component must be sufficiently cooled and lubricated when being machined.

### AFTER MACHINING THE PISTON BUT BEFORE INSTALLATION

- Clean the machined piston, including all oil channels.
- Measure the piston at the specified measuring points D1 and D2 (Fig. 1) in the same ambient conditions as before the machining. Compare the measurements with the values obtained prior to machining the piston.
- Check the piston protrusion after installing the piston. Observe the manufacturer's instructions for the maximum piston protrusion for standard applications.
- Follow the engine manufacturer's instructions.
- Observe the general notes on the correct installation of pistons.

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