



# Notes on machining semi-finished gas pistons without recesses

Motorservice offers semi-finished pistons without recesses for the special requirements of gas engines. The crowns of these pistons can be freely formed and can therefore be machined to match your precise requirements. Information on the current range of semi-finished pistons can be found in our catalogues.



Fig. 2: Non-machined gas pistons without recesses

## Preparation

Make a note of all function-relevant dimensions before and after the machining process as reference values for comparison. To do so, measure the piston at the specified measuring points D1 and D2 (Fig. 2).

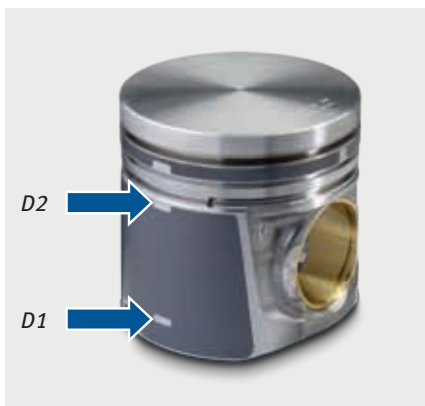


Fig. 1: Measuring points on the piston

## Machining the semi-finished gas piston

- Use suitable abrasives for alloys with a silicone content > 10%.
- Use a suitable tensioning device which will not impair the piston contours and the surface coating.
- Seal off any cooling channels, if present.
- When machining, the component must be sufficiently cool and lubricated.

## After the machining and before the installation of the piston

- 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 dimensions with the values which were measured before the machining process.

- Check the piston protrusion after installing the piston. Observe the manufacturer's instructions for the maximum piston protrusion for standard applications.
- Observe the general notes on the correct installation of pistons. These can be found in the KOLBENSCHMIDT piston catalogue (item no. 50 003 945).
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### Attention:

Pistons without machined piston crowns may not be installed in engines.