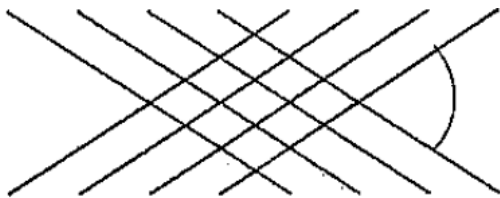




Pistons Cylinder Honing Recommendations

For use with piston rings, we recommend plateau honing with a cylinder bore cross hatch angle of 35-40 degrees.

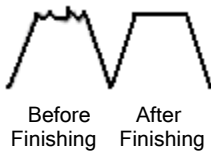


35 – 40 Deg.

To reach this roughness, the manufacturers of honing machines and accessories recommend using for a gray cast iron engine block and Nikasil cylinders.

- Conventional stones #220 - #280 grit or
- Diamond stones #325 - #550 grit

After honing with either the conventional or diamond stone, the same manufacturers suggest to finish your honing by smoothing the surface with a fine grit conventional abrasive (#400 - #600 grit) or to sweep the bores with a flexible brush or a nylon bristle plateau honing tool. This is necessary to get rid of jagged peaks and folded or torn material.



Important Note:

Be sure to confirm with your honing equipment manufacturer that the recommended stone grit will produce the following Rz and Ra roughness recommendations.

*Rz = 59 - 138 μ in [=1.5 – 3.5 μ m] or
Ra = 15 - 35 μ in [=0.4 – 0.9 μ m]*
