

ISO 6621-2:2020-03 (E)

Internal combustion engines - Piston rings - Part 2: Inspection measuring principles

Contents		Page
Foreword		iv
Introduction		v
1	Scope	1
2	Normative references	1
3	Terms and definitions	1
4	Measuring principles	5
4.1	General measuring conditions	5
4.2	Characteristics and measuring principles	6
4.2.1	Ring width	6
4.2.2	Radial wall thickness, a_1	8
4.2.3	Total free gap m, p	8
4.2.4	Closed gap, s_1	9
4.2.5	Tangential force, F_t (in Newton)	10
4.2.6	Diametral force, F_d (in Newton)	15
4.2.7	Ovality, U (in millimetres)	16
4.2.8	Point deflection, W (in millimetres)	17
4.2.9	Light tightness (percentage of ring circumference)	17
4.2.10	Taper on peripheral surface (in micrometres or degrees)	18
4.2.11	Barrel on peripheral surface, t_2, t_3 (in millimetres)	18
4.2.12	Land width, h_4, h_5 (in millimetres)	20
4.2.13	Land offset (in millimetres)	21
4.2.14	Plating/coating thickness (in millimetres)	21
4.2.15	Nitrided case depth (in millimetres)	22
4.2.16	Keystone angle (in degrees)	22
4.2.17	Obliqueness (in degrees)	24
4.2.18	Twist (in millimetres)	25
4.2.19	Unevenness T_e, T_u	26
4.2.20	Helix (axial displacement of gap ends) (in millimetres)	27
4.2.21	Free flatness (in millimetres)	27
4.2.22	Surface roughness R_a, R_z (in micrometers)	28
4.2.23	Circumferential waviness – Bottom side face (in micrometers)	28
Bibliography		30