

# ISO 18669-2:2025-02 (E)

## Internal combustion engines - Piston pins - Part 2: Inspection measuring principles

### Contents

Page

Foreword	iv
<b>1 Scope</b>	<b>1</b>
<b>2 Normative references</b>	<b>1</b>
<b>3 Terms and definitions</b>	<b>2</b>
<b>4 Measurement principles</b>	<b>4</b>
4.1 General measuring conditions	4
4.2 Characteristics and measurement principles	4
4.2.1 Outside diameter, $d_1$	4
4.2.2 Cylindricity of the outside diameter, $d_1$	5
4.2.3 Circularity of the outside diameter, $d_1$	5
4.2.4 Circumferential waviness	5
4.2.5 Edge drop-off, $b, c$	6
4.2.6 Inside diameter, $d_2, d_4$	6
4.2.7 Concentricity of inside diameter (ID) relative to outside diameter (OD)	6
4.2.8 Length, $l_1$	6
4.2.9 Gauge length, $l_5$	7
4.2.10 Runout of the end faces, $s$	7
4.2.11 End face concavity, $h_1$ , and end face step, $h_2$	7
4.2.12 End face diameter, $d_6$	8
4.2.13 Outside-edge profile	8
4.2.14 Inside chamfer, $t_1$	8
4.2.15 Tapered bore diameter, $d_3$	8
4.2.16 Tapered bore angle, $\alpha$	8
4.2.17 Runout tapered bore, $e$	8
4.2.18 Roughness	9
4.2.19 Carburised and nitrided case depth	9
4.2.20 Core hardness	9
4.2.21 Peripheral surface hardness	10
4.2.22 Volume change	10
4.2.23 Material defects	10
4.2.24 Residual magnetism	12
4.2.25 Visual defects	12
4.2.26 Grinder burn	12
4.2.27 Streaks on bore surface	12
<b>Bibliography</b>	<b>13</b>