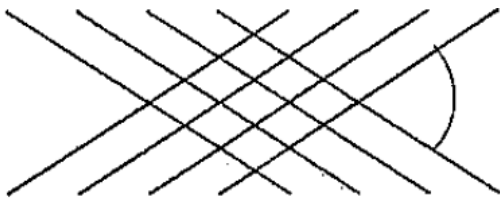




CP Pistons Cylinder Honing Recommendations For CPN & CPN2

For use with our CPN and CPN2 piston rings, we recommend plateau honing with a cylinder bore cross hatch angle of 35-40 degrees.

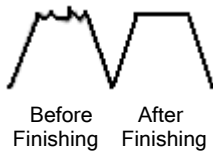


35 – 40 Deg.

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.

$Rz = 59 - 138 \mu \text{ in } [=1.5 - 3.5 \mu \text{m}]$ or
 $Ra = 15 - 35 \mu \text{ in } [=0.4 - 0.9 \mu \text{m}]$

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