

INTERNAL COMBUSTION ENGINES - PISTON RINGS - INSPECTION MEASURING PRINCIPLES

This document is equivalent to ISO Standard 6621/2.

1. SCOPE AND FIELD OF APPLICATION:

Differences, where they exist, are shown in Appendix A.

This document defines the measuring principles to be used for measuring piston rings. It applies to piston rings up to and including 200 mm diameter for reciprocating internal combustion engines.

These inspection measuring principles may also be used for piston rings for compressors working under analogous conditions.

**S. A. E.
LIBRARY**

SAE Technical Board Rules provide that: "This report is published by SAE to advance the state of technical and engineering sciences. The use of this report is entirely voluntary, and its applicability and suitability for any particular use, including any patent infringement arising therefrom, is the sole responsibility of the user."

SAE reviews each technical report at least every five years at which time it may be reaffirmed, revised, or cancelled. SAE invites your written comments and suggestions.

2. REFERENCE:SAE
DESIGNATIONISO*
EQUIVALENT

INTERNAL COMBUSTION ENGINES - PISTON RINGS

J1588

6621/1

Vocabulary

J1589

6621/2

Measuring principles

J1590

6621/3

Material specifications

J1591

6621/4

General specifications

J1996

6621/5

Quality requirements

INTERNAL COMBUSTION ENGINES - PISTON RINGS

J1997

6622/1

Rectangular rings

J1998

6622/2 TR

Rectangular rings with narrow ring width

J1999

6623

INTERNAL COMBUSTION ENGINES - PISTON RINGS -
SCRAPER RINGS

INTERNAL COMBUSTION ENGINES - PISTON RINGS

J2000

6624/1

Keystone rings

J2001

6624/2 TR

Half keystone rings

J2002

6625

INTERNAL COMBUSTION ENGINES - PISTON RINGS -
OIL CONTROL RINGS

J2003

6626

INTERNAL COMBUSTION ENGINES - COIL SPRING
LOADED OIL CONTROL RINGS

J2004

6627 TR

INTERNAL COMBUSTION ENGINES -
EXPANDER/SEGMENT OIL CONTROL RINGS

ISO 468

SURFACE ROUGHNESS

ISO 1302

TECHNICAL DRAWINGS

*TR refers to Technical Report

3. MEASURING PRINCIPLES:

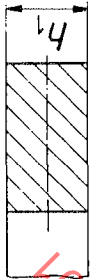
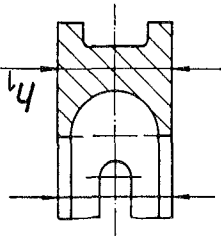
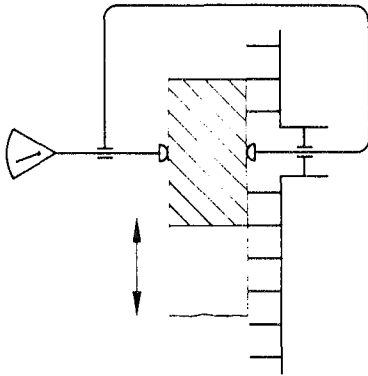
3.1 General Measuring Conditions: The following general notes are applicable to all measuring principles unless otherwise specified:

- a. The ring shall rest on the datum surface in the free or open condition. No additional force shall be applied to load the ring on the datum surface;
- b. Certain measurements are made with the ring in the closed condition in a gauge of nominal cylinder bore diameter. When orientated rings are measured in this way, they shall be so placed that the top is towards the datum surface;
- c. Measurements shall be made using instruments with a resolution not to exceed 10% of the tolerance of the dimension being measured.

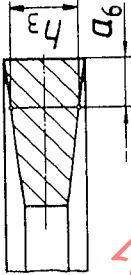
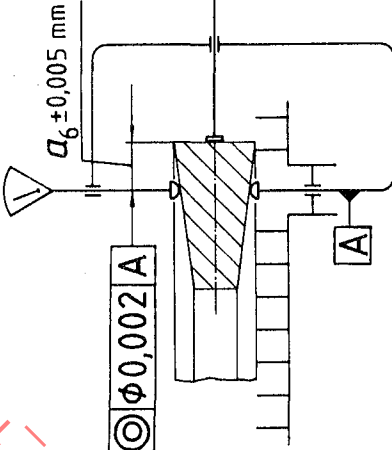
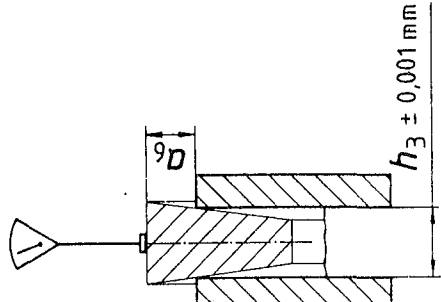
SAENORM.COM : Click to view the full PDF of J1589-199001

3.2 Characteristics and Measuring Principles:

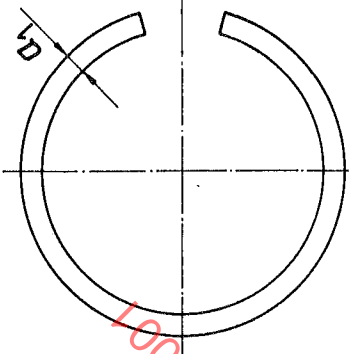
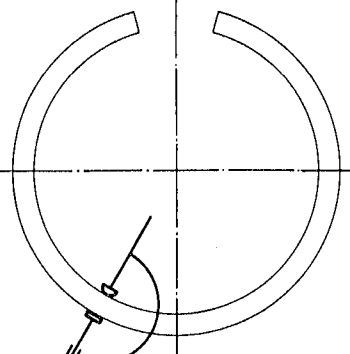
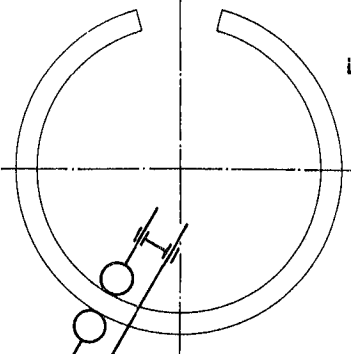
Sub-clause	Characteristics of the ring	Symbol
	Principal characteristics of the ring	
3.2.1	Ring width	
	a) parallel sided rings	h_1
	b) keystone rings	h_3, a_6
3.2.2	Radial wall thickness	a_1
3.2.3	Total free gap	m, p
3.2.4	Closed gap	s_1
3.2.5	Tangential force	F_t
3.2.6	Diametral force	F_d
	Characteristics of ring shape	
3.2.7	Ovality or circularity	U
3.2.8	Point deflection	W
3.2.9	Light tightness	—
	Associated with peripheral surface	
3.2.10	Taper on periphery	—
3.2.11	Barrel on periphery	t_2, t_3, h_8
3.2.12	Land width	h_4, h_5
3.2.13	Land offset	—
3.2.14	Coating/inlay thickness	—
	Associated with sides	
3.2.15	Keystone angle	—
3.2.16	Obliqueness	—
3.2.17	Twist	—
3.2.18	Unevenness	Te_r, Te_u
	Other	
3.2.19	Helix (axial displacement of butt ends)	—
3.2.20	Free flatness	—
3.2.21	Surface roughness	R_a, R_z

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.1 Ring width (in millimeters) a) Parallel sided rings, h_1	The distance between the sides, at any particular point perpendicular to the datum surface (see figures 1 and 2).	Measure with spherical measuring probes each of radius $1,5 \pm 0,05$ mm, exerting a measuring force of approximately 1 N (see figure 3). In the case of slotted oil rings, the measurement shall be made between the slots and not across them (see figure 2).	 Figure 1  Figure 2  Figure 3

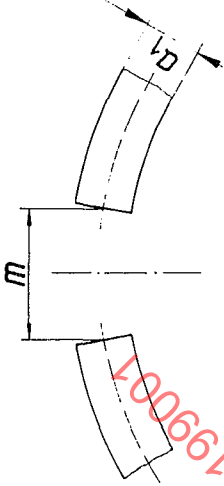
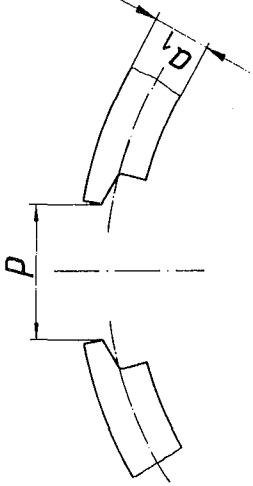
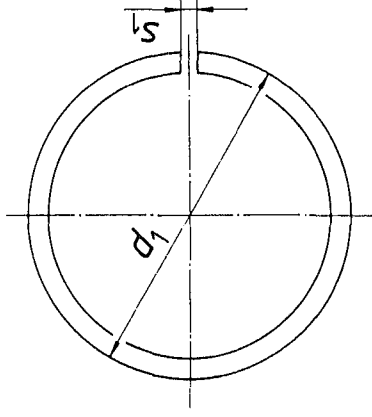
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
b) Keystone rings, h_3	The distance between the sides at a specified distance a_6 from the peripheral surface (see figure 4).	a) Method A This method determines h_3 (see figure 4) for a specified value of a_6. Measure with spherical measuring probes each of radius $1,5 \pm 0,05$ mm exerting a measuring force of approximately 1 N (see figure 5). If the measuring equipment is set up with parallel gauges instead of keystone gauges the use of spherical measuring probes will give rise to an error as follows : for 6° keystone angle : 0,004 mm for 15° keystone angle : 0,026 mm. To obtain the correct measured width of the keystone ring the above values shall be deducted from the measured values. Values of a_6 are given in ISO 6624/1. b) Method B This method determines a_6 for a specified width h_3 (see figure 4). Measure with a flat face probe exerting a measuring force of approximately 1 N. The ring shall be placed between two sharp edged circular discs which are spaced apart at the specified gauge width h_3 (see figure 6). Values of h_3 are given in ISO 6624/1.	Figure 4  Figure 5  Figure 6 

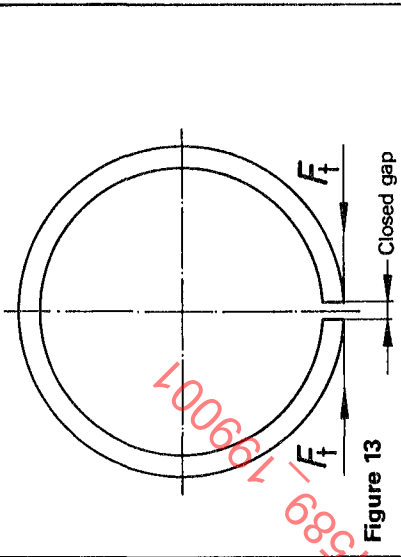
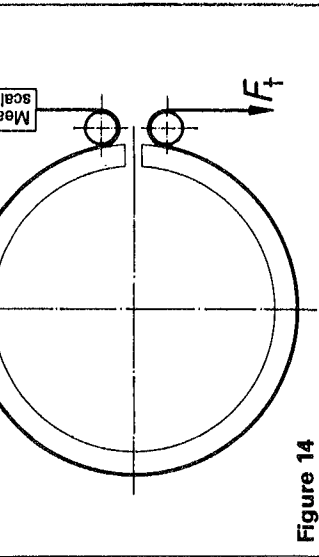
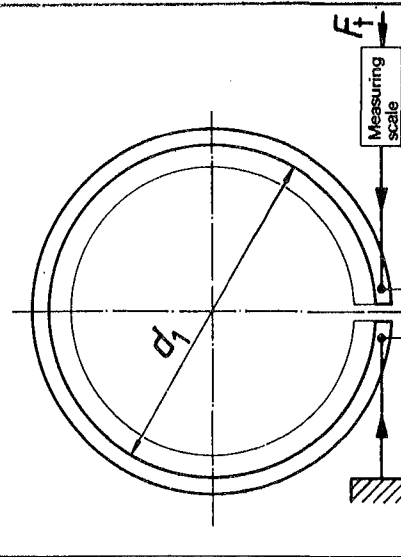
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.2 Radial wall thickness, a_1 (in millimeters)	The radial distance between the periphery and the inside surface of the ring (see figure 7).	a) Measure radially between a flat measuring surface on the periphery and a spherical measuring surface of radius approximately 4 mm on the inside surface, and using a measuring force of 3 to 10 N (see figure 8). b) Measure radially between cylindrical inserts or rollers of radius approximately 4 mm and with a measuring force of 3 to 10 N. The length of the rollers shall be greater than the ring width (see figure 9).	 Figure 7
			 Figure 8
			 Figure 9

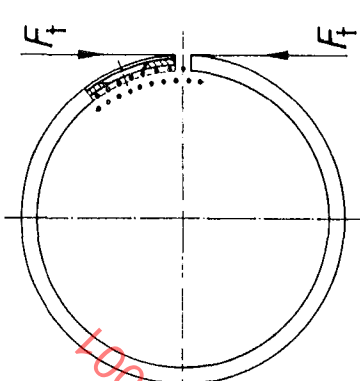
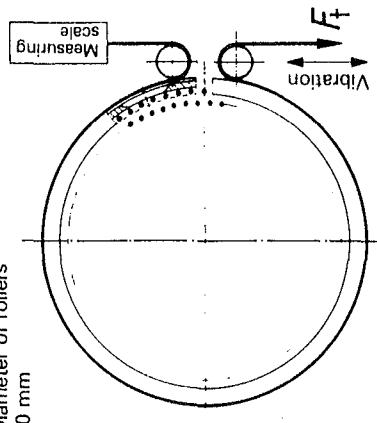
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.3 Total free gap m, p (in millimeters)	The chordal distance between the butt ends of the ring in a free, unstressed state, measured at the centreline of the radial wall thickness (see figure 10). For rings with an internal notch for a peg, the total free gap is defined by the chordal distance marked as p in figure 11.	Measure with a steel rule to the nearest 0,25 mm	 Figure 10  Figure 11
3.2.4 Closed gap, s_1 (in millimeters)	The gap at the butt ends of the ring, measured at the narrowest point of the gap, which the ring would have when fitted in a gauge of nominal cylinder bore size (see figure 12). The closed gap s_1 is related to the nominal diameter d_1.	Measure in a bore gauge of nominal diameter using a wedge gauge or feeler gauges and using a measuring force of approximately 1 N (see figure 12). The diameter of the bore gauge shall comply with the following deviations from the nominal ring diameter : Tolerance : $+ 0,001 \quad d_1$ $\quad \quad \quad 0$ Correction shall be made for any deviation of the bore gauge from the nominal ring diameter.	 Figure 12

This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.5 Tangential force, F_t (in Newtons) a) For single-piece rings	The force necessary to maintain the ring at the closed gap condition by means of a tangential pull on the ends of a circumferential metal tape or hoop (see figure 13).	a) Tape method (see figure 14) The encircling steel tape of thickness 0,08 to 0,10 mm is carried round 10 mm diameter rollers set 20 mm apart (see figure 14). In tightening the tape, the ring is closed to the point where the butt ends touch and then opened to the closed gap dimension previously measured. The ring force is then read off from the precision measuring scale. The gap of the ring shall be symmetrically disposed between the rollers.	 Figure 13 Diameter of rollers 10 mm
		b) Hoop method (see figure 15) The ring is placed in a correctly sized hoop with its gap aligned to the gap of the hoop. The hoop is then closed in a precision loading machine until the loading pins are at a predetermined distance apart at which point the hoop is precisely at the cylinder bore diameter appropriate to the ring (see figure 15). The force is then read off from the display.	 Figure 14 Diameter of rollers 10 mm  Figure 15

This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
b) For multi-piece rings	The force which is necessary to maintain the ring at the closed gap condition by means of a tangential pull on the ends of a circumferential metal tape or hoop whilst vibrating the butt ends of the ring [see figure 13a)].	For the measurement of coil spring loaded rings or similar rings where the spring is supported in the inside grooved surface of the ring, the gap of the spring shall be positioned at 180° to the gap of the cast iron part. For the measurement of multi-piece steel rail oil control rings, the ring assembly shall be mounted in a carrier simulating the ring groove. The gap of the spring element is placed at 180° to the gap of the rails, both of which shall be in line. For the measurement of a ring provided with a wavy spring, or other spring which is groove root supported, the ring assembly shall be mounted in a carrier simulating the groove, the root diameter of which is equal to the mean diameter of the piston ring groove in which the ring will be used. Tolerance on carrier root diameter $\pm 0,02$ mm. The gap of the wavy spring shall be at 180° to the gap of the cast iron part. a) Tape method Identical procedures are used as for single piece rings but an appropriate vibration shall be applied to the tape loading mechanism to relieve forces of friction [see figure 14a)]. A suitable level is 40 to 50 Hz at an amplitude of 0,15 mm.	 Figure 13a)  Figure 14a)

This table is shown in ISO format. Commas represent decimal points.

Illustration of measuring principles

b) Hoop method

Identical procedures are used as for single-piece rings but an appropriate vibration shall be applied to the hoop loading mechanism to relieve all forces of friction (see figure 15a).

NOTES

1 Before tangential force measurements are made, rings must be degreased and lightly coated with thin machine oil.

2 It is recommended that closed gap measurements be made immediately prior to measuring tangential force.

3 In order to improve consistency of measurement and particularly with coil spring loaded rings which have been oxidized or phosphated it is permissible to rotate the spring forwards and backwards to smooth the surface before carrying out measurements.

4 The reproducibility of tangential force measurements has not been high in the past but current machines using tape and hoop methods give an overall reproducibility of the order of 6,5 %.

It is recommended that customer and supplier agree on a suitable factor to take account of different machines, different locations and different operators.

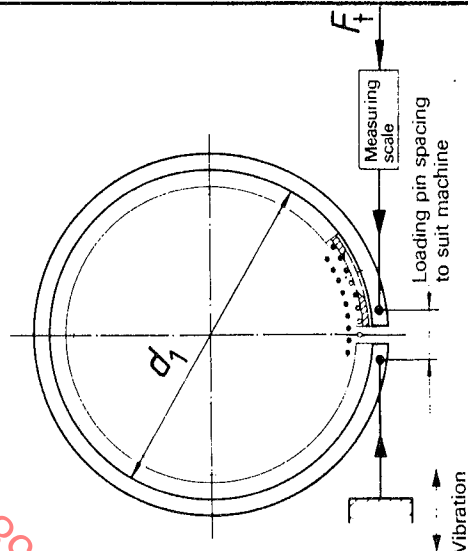
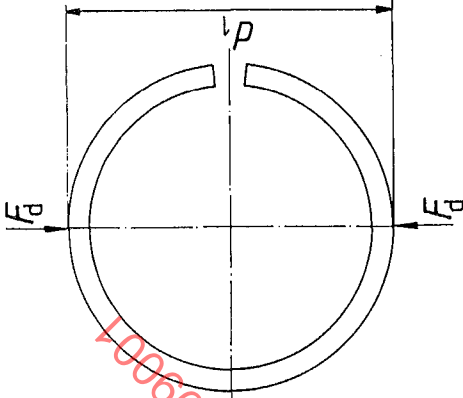
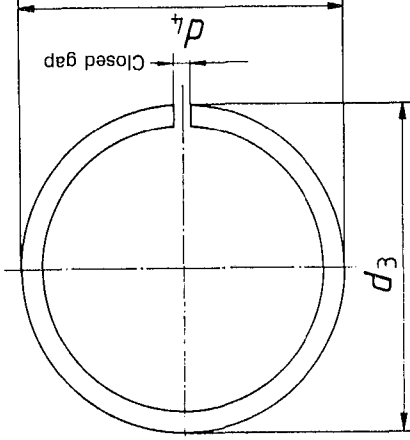
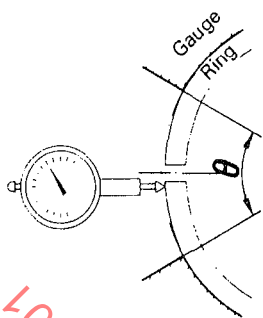
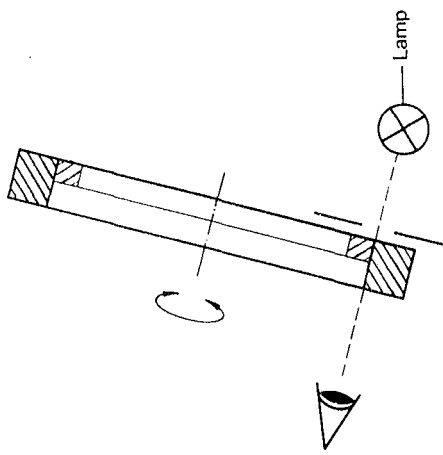


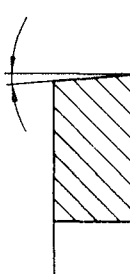
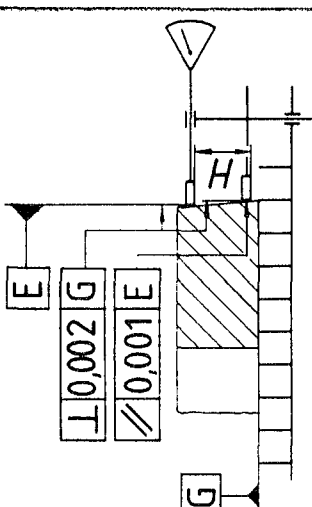
Figure 15a)

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.6 Diametral force, F_d (in Newtons) NOTE — This method is only applicable to single-piece rings.	The force, acting diametrically at 90° to the gap, necessary to maintain the ring at the nominal diameter condition measured in the direction of the force (see figure 16).	Diametral force is measured in purpose built machines which incorporate flat plates for closing the rings (see figure 16).	 Figure 16
3.2.7 Ovality or circularity, U (in millimeters) NOTE — This method is only applicable to single-piece rings.	The difference between the mutually perpendicular diameters d_3 and d_4 when the ring is drawn to closed gap within a flexible tape. It may be either positive ($d_3 > d_4$) or negative ($d_3 < d_4$) (see figure 17).	Measure, with the ring drawn to true closed gap in a flexible steel tension tape or band of thickness 0,08 to 0,10 mm using a diametral measuring device with a measuring force of not more than 1 N (see figure 17). With the ring closed within the tape it is an acceptable alternative to clamp it between plates and then remove the tape prior to measuring the diameters d_3 and d_4 . NOTE — Clamping of the ring between plates is not applicable to oil control rings with slots.	 Figure 17

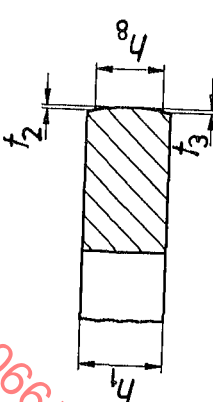
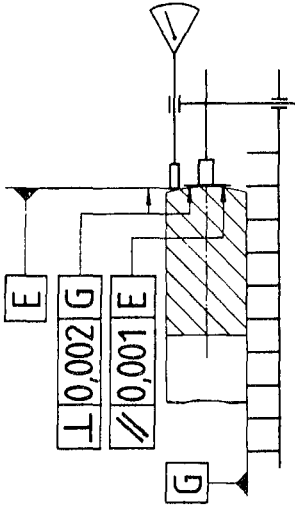
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.8 Point deflection, W' (in millimeters)	The deviation of the butt ends from the true circle when restrained in a gauge of nominal cylinder bore diameter (see figure 18).	Measure with a probe of spherical radius of 1,5 mm $\pm$ 0,05 mm with measuring force of approximately 1 N, the ring being mounted in a gauge of nominal cylinder bore diameter relieved over the gauge angle, θ, (see figure 18). The gauge angle, θ, shall be agreed between manufacturer and customer. It normally relates to port angle. The following gauge tolerances apply for this test : Angle θ : $\pm 1^\circ$ Diameter : $^{+0,001}_0 d_1$ Circularity : 0,0001 d_1 max.	 Figure 18
3.2.9 Light tightness (percentage of ring circumference)	The ability of the periphery of a ring when mounted in a gauge of nominal cylinder bore diameter to exclude the passage of light (see figure 19). A ring showing only pin-point, burry or fuzzy light shall be considered as light tight.	Measure in a gauge equipped with a suitable light source and determine the percentage of the ring circumference which will allow light to pass (see figure 19). It is permissible to rotate the ring in the gauge to remove any slight surface roughness on the periphery. Unless otherwise specified examination and measurement should be made without magnification and with normal eyesight. It is important to avoid errors of parallax and to protect the viewer against stray light penetration. Illuminance behind the ring to be 400 to 1 500 lux above the ambient conditions. The following gauge tolerances apply for this test : Diameter : $^{+0,001}_0 d_1$ Circularity : 0,0001 d_1 max.	 Figure 19

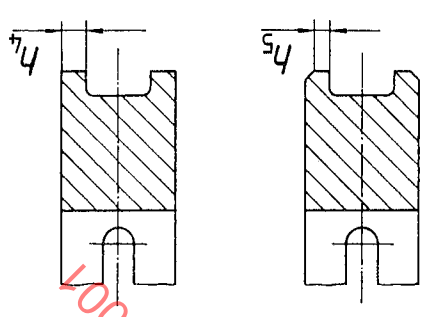
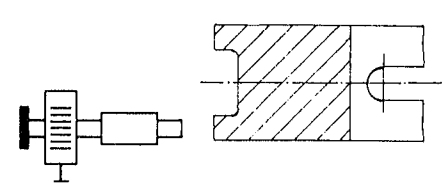
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.10 Taper on periphery (in micrometers or degrees)	Taper is the intentional deviation of the periphery from a line perpendicular to the datum surface (see figure 20).	a) Method A Measure at the back of the ring perpendicular to the datum surface using flat faced probes exerting a force of approximately 1 N (see figure 21). The measurement recorded is the difference in radial dimension of the ring peripheral surface between two points, near the top and near the bottom, distance H apart. The dimension H shall be approximately two-thirds of the total width of the ring and the recorded measurement may be converted to the taper angle in degrees or minutes. b) Method B The ring shall be mounted on a datum surface and the peripheral surface of the back of the ring graphed perpendicular to the datum surface using a profile recorder. Magnification used shall be clearly indicated. NOTE The same methods may be used to determine the unintentional taper which may be present on, for example, a nominally straight faced rectangular ring.	 Figure 20  Figure 21

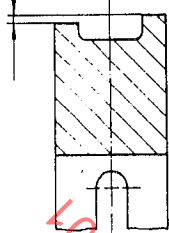
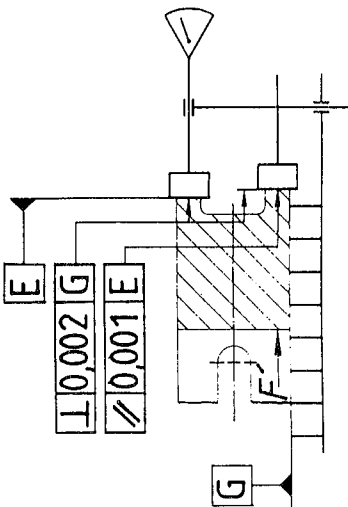
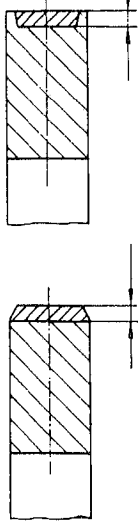
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.11 Barrel on periphery, t_2 , t_3 , h_g (in millimeters)	The barrel is the intentional convex deviation of the peripheral surface from a line perpendicular to the datum surface (see figure 22).	a) Method A Measure at the back of the ring perpendicular to the ring datum surface using flat ended probes exerting a force of approximately 1 N (see figure 23). The measurement recorded is the difference in radial dimension of the ring peripheral surface between two points, one at the peak of the barrel (at or near the center line of the ring) and the second at half gauge width $\frac{h_g}{2}$ from the peak. b) Method B The ring shall be mounted on a datum surface and the peripheral surface of the back of the ring graphed, perpendicular to the datum surface, using a profile-recorder. Magnification used shall be clearly indicated. (Recommended ratio between vertical and horizontal magnifications 10 or 25.) NOTE— The same methods may be used to determine the unintentional barrel which may be present on, for example, a nominally straight faced rectangular ring.	 Figure 22  Figure 23

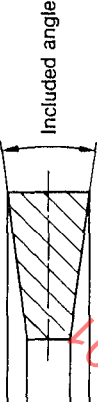
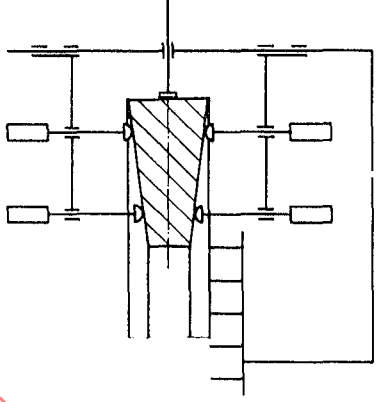
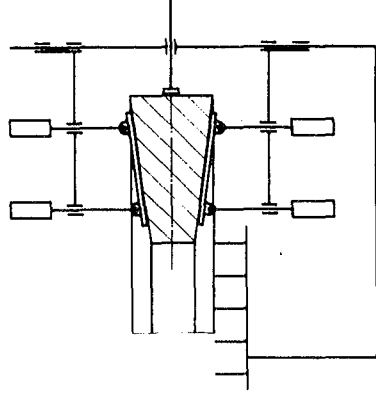
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.12 Land width, h_4, h_5 (in millimeters)	The width of the land which theoretically should be in contact with the cylinder bore (see figure 24).	a) Method A For all forms of land (sharp edge, chamfered or radiused) measure with a measuring microscope or on a projector. The measurement shall be made only on the periphery of the lands (see figure 25). b) Method B For all forms, the ring shall be mounted on a datum surface and the lands shall be graphed on a profile recorder. Magnification used shall be clearly stated. NOTE — Land offset, (see 3.2.13), can be included and obtained from this measurement at the back of the ring.	 Figure 24  Figure 25

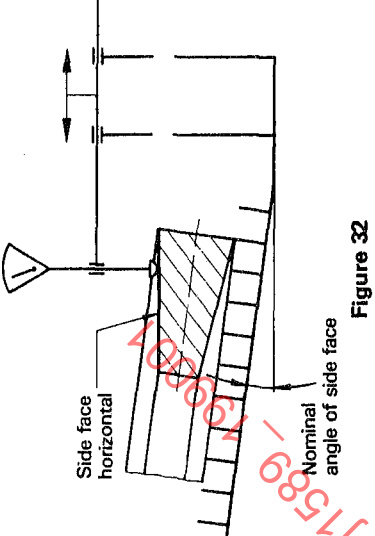
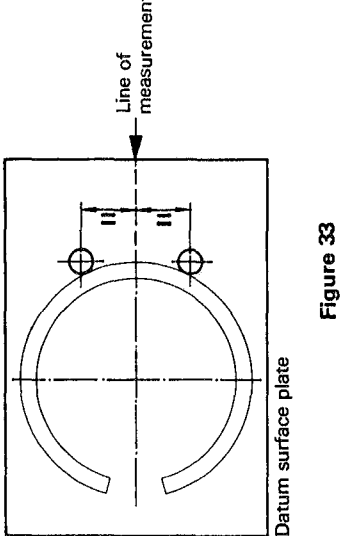
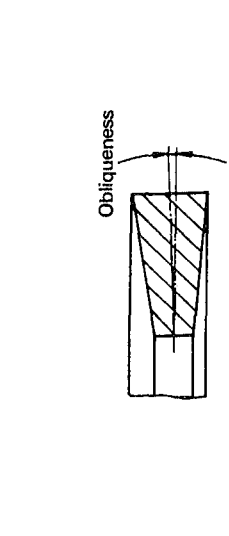
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.13 Land offset (in millimeters)	The displacement of the two peripheral surfaces of a slotted or drilled oil control ring in relation to each other in a radial direction (see figure 26).	a) Method A Measure at the back of the ring from a line perpendicular to the datum surface (see figure 26) using flat measuring probes exerting a force of approximately 1 N. The ring shall be loaded against the measuring instrument in the direction of and in the position of the force F (see figure 27). Value of force F to be in the range of 3 to 5 N. b) Method B See Method B in 3.2.12.	 Figure 26  Figure 27  Figure 28
3.2.14 Coating/inlay thickness (in millimeters)	The distance between the outer surface of the coating/inlay and the surface of the base ring material (see figure 28).	Measure non-destructively in the middle of the width of coating using a calibrated inductive thickness measuring instrument. The calibration shall be made using a master ring of equal dimension and material to the ring being tested. Specific points for measuring shall be at the back of the ring and at 15 mm from each butt end.	

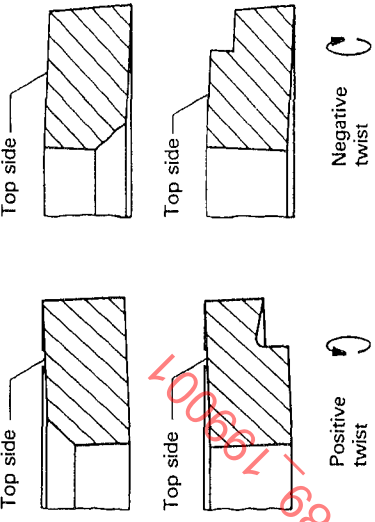
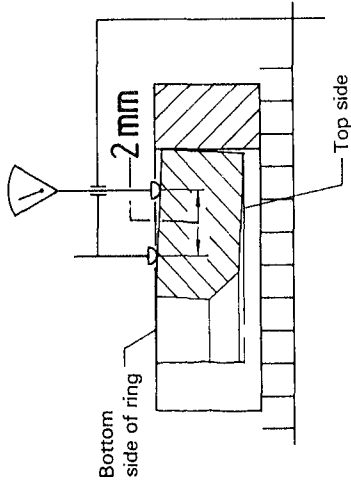
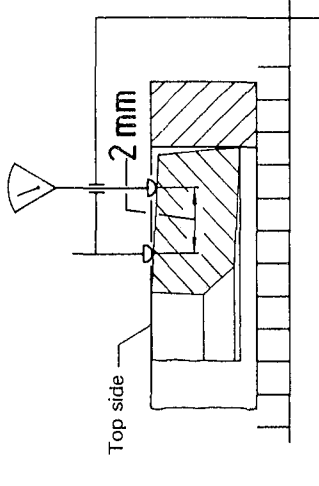
This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.15 Keystone angle (in degrees)	The angle enclosed by the two sides of the ring (see figure 29). Alternatively, the sum of both side face angles, i.e. included angle.	a) Method A Measure, in a true radial direction at the back of the ring, the difference in ring width at two points of known distance apart, using spherical probes each of radius $1,5 \pm 0,05$ mm exerting a force of approximately 1 N. The keystone angle can then be calculated as the sum of both side angles (see figure 30). b) Method B Measure, in a true radial direction at the back of the ring, the difference in ring width, using two probe systems formed as knife edges, each probe exerting a force of approximately 1 N. The keystone angle can then be calculated as the sum of both side angles (see figure 31). c) Methods C and D Both methods involve the use of a probe which traverses in a true radial direction, a known distance across the side face at the back of the ring. The probe has a spherical radius of $1,5 \pm 0,05$ mm and exerts a force of approximately 1 N. The datum surface plate on which the ring rests for measurement is provided with a location to ensure that the line of measurement is truly radial (see figure 33). 1) Method C The datum surface plate is inclined at an angle equal to the nominal side face angle of the ring and hence the contact surface of the probe traverses a path nominally parallel to the axis of motion of the probe. The probe measures any deviation of the side face from parallel and allows the actual angular deviation to be calculated. Hence the actual side face angle can be determined.	 Figure 29  Figure 30  Figure 31

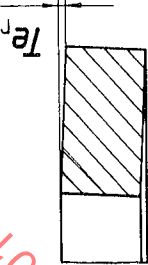
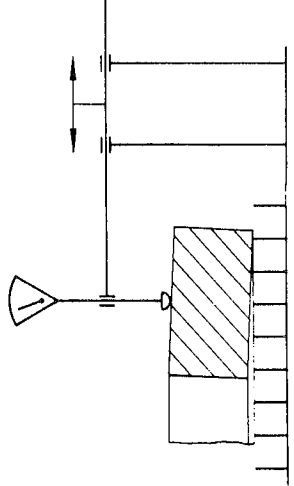
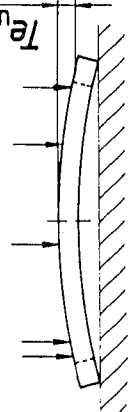
This table is shown in ISO format. Commas represent decimal points.

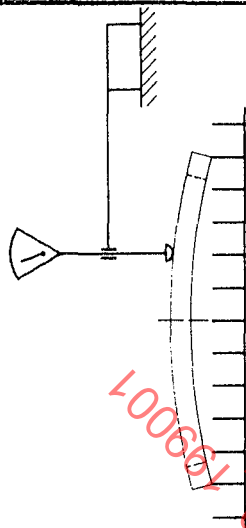
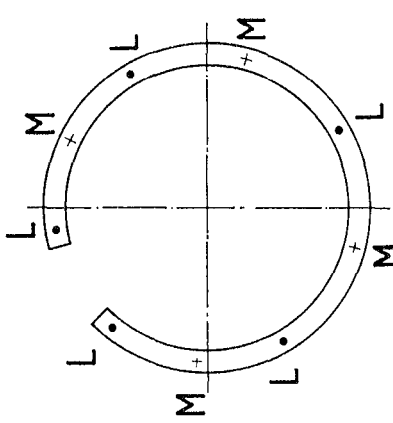
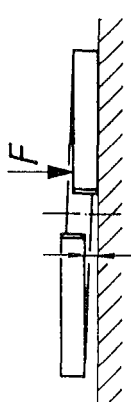
Term	Definition	Measuring principles	Illustration of measuring principles
		The ring is measured on both sides and the sum of the side face angles gives the keystone angle (see figure 32). 2) Method D The datum surface plate is parallel to the axis of motion of the probe and the ring side face lies at an angle to the datum surface equal to the side face angle of the ring. The contact surface of the probe in traversing the side face describes the full movement equivalent to the side face angle : the latter can then be calculated directly. The ring is measured on both sides and the sum of the side face angles gives the keystone angle.	 
3.2.16 Obliqueness (in degrees)	The unintentional deviation of the bisector of the keystone included angle from parallelism with the datum surface (see figure 34). Not applicable to rings with designed twist.	The measuring principles are identical with those given for keystone angle, see 3.2.15. When each side face angle is available, obliqueness is one half the difference between the two side face angles, for example, with a 15° included angle ring where one side is 7° 40' and the other is 7° 20', the obliqueness is 10'.	

This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.17 Twist (in millimeters)	The intentional torsional deviation of the section of the ring from the datum surface when the ring is restricted to nominal diameter (as in the case of asymmetrical rings such as those internally or externally stepped or bevelled) (see figure 35).	Measure, over a true radial gauge length, the deviation of the ring side from a plane parallel to the datum surface, the ring being closed to nominal diameter in a bore gauge. For nonkeystone rings, the measurement shall be made at the back of the ring on the side opposite the bevel or step, using a spherical probe of radius $1,5 \pm 0,05$ mm exerting a force of approximately 1 N (see figures 36 and 37). Twist for keystone rings is the difference in bottom side angle values measured free and confined at the back of the ring. NOTE — Twist is measured as the linear deviation in distance from the datum surface over a gauge length of 2 mm or a minimum of 60 % of the available radial thickness. See 3.2.15 for measuring keystone ring angles.	 Figure 35  Figure 36  Figure 37

This table is shown in ISO format. Commas represent decimal points.

Term	Definition	Measuring principles	Illustration of measuring principles
3.2.18 Unevenness, Te_r, Te_u (in millimeters)	Unintentional deviation of the sides of the ring from parallelism to the datum surface, i.e. twisted or dished rings (see figures 38 and 40). NOTE — Not applicable to rings with de signed twist, as covered by term 3.2.17.	a) In the radial direction Measure with a probe of spherical radius $1,5 \pm 0,05$ mm exerting a force of approximately 1 N on the upper side of the ring (see figures 39 and 42), centrally between the loaded points. The largest of the four readings is taken as the measure of unevenness.	 Figure 38  Figure 39  Figure 40

Term	Definition	Measuring principles	Illustration of measuring principles
		b) In the circumferential direction Measure with probe of spherical radius $1,5 \pm 0,05$ mm exerting a force of approximately 1 N on the upper side of the ring (see figures 41 and 42), in the middle of the ring wall and centrally between the loaded points. The difference between the greatest and the least deflection is taken as the measure of the unevenness. Loading of rings : Rings shall be loaded prior to measurement using 5 load points, one each side of the gap, one at 90°, one at 180° and one at 270°. In the case of slotted oil control rings, load points and measurement areas shall be on the nearest available bridge and not over slot areas. The following loads shall be used on each load point : For rings < 80 mm diameter : 2,5 N; > 80 mm diameter : 5,0 N.	 Figure 41  Figure 42 • Load points + Measurement points
3.2.19 Helix (axial displacement of butt ends) (in millimeters)	The displacement of the butt ends perpendicular to the datum surface (see figure 43).	The butt end of the ring already in contact with the datum surface shall be loaded or clamped with a force, F, approximately 10 N. Measure the displacement of the adjacent butt end with a measuring microscope or magnifier. The loading device or clamp shall be confined to within 15° of arc from the appropriate butt end.	 Figure 43

This table is shown in ISO format. Commas represent decimal points.