

1		2		3		4	
REVN.	NO. OF PLACES	CHANGE/ECN NO.				SIGNATURE & DATE	
						REVISED	APPROVED

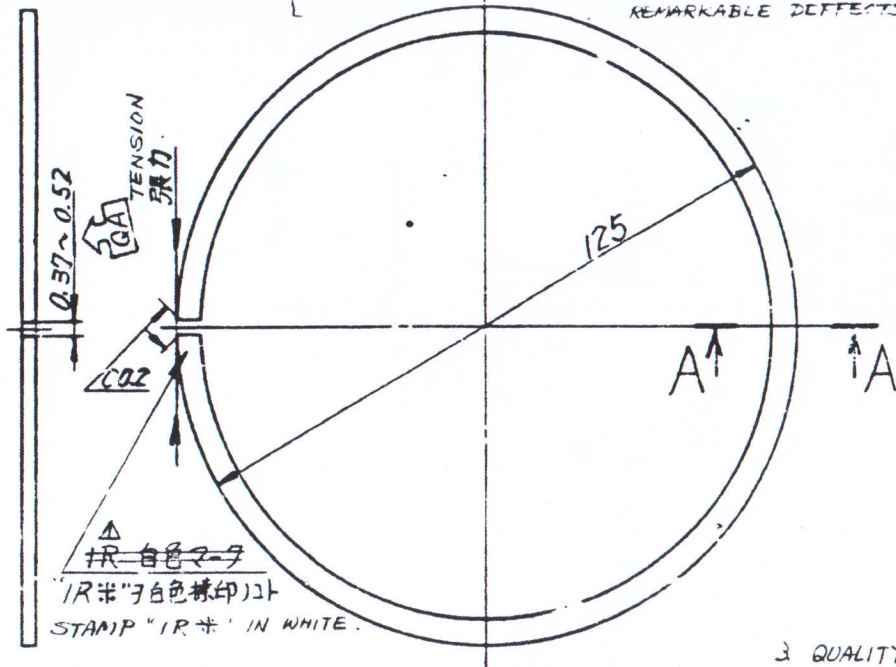
**NOTE:-**

THIS PART IS SAME AS PISTON RING ASSY. 6150312033.  
IT CONSISTS OF 03 PARTS.

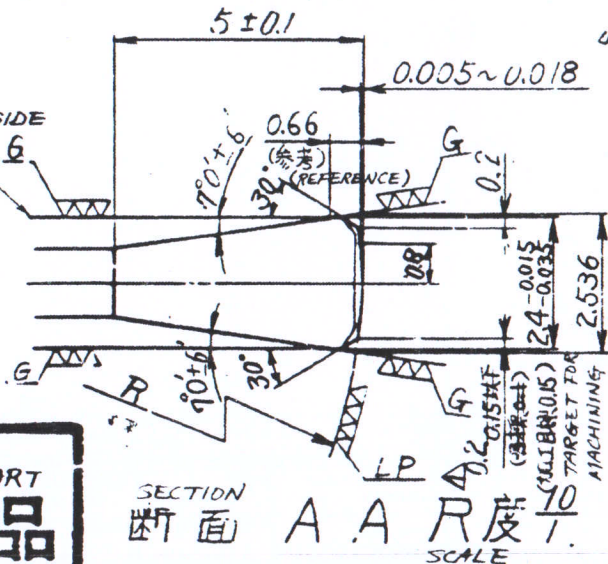
PART NO.	DESCRIPTION
01	30Z3180215 RING TOP
02	30Z3180678 RING SECOND
03	30Z3180167 RING OIL

1		2		3		4	
A		B		C		D	
E		F		G		H	
I		J		K		L	
M		N		O		P	
Q		R		S		T	
U		V		W		X	
Y		Z		AA		AB	
AC		AD		AE		AF	
AG		AH		AI		AJ	
AK		AL		AM		AN	
AO		AP		AQ		AR	
AS		AT		AU		AV	
AW		AX		AY		AZ	
BA		BB		BC		BD	
BE		BF		BG		BH	
BI		BJ		BK		BL	
BM		BN		BO		BP	
BQ		BR		BS		BT	
BU		BV		BW		BX	
BY		BZ		CA		CB	
CC		CD		CE		CF	
CG		CH		CI		CJ	
CK		CL		CM		CN	
CO		CP		CQ		CR	
CS		CT		CU		CV	
CW		CX		CY		CZ	
DA		DB		DC		DD	
DE		DF		DG		DH	
DI		DJ		DK		DL	
DM		DN		DO		DP	
DQ		DR		DS		DT	
DU		DV		DW		DX	
DY		DZ		EA		EB	
EC		ED		EE		EF	
EG		EH		EI		EJ	
EK		EL		EM		EN	
EO		EP		EQ		ER	
ES		ET		EU		EV	
EW		EX		EY		EZ	
FA		FB		FC		FD	
FE		FF		FG		FH	
FI		FJ		FK		FL	
FM		FN		FO		FP	
FQ		FR		FS		FT	
FU		FV		FW		FX	
FY		FZ		GA		GB	
GC		GD		GE		GF	
GG		GH		GI		GJ	
GK		GL		GM		GN	
GO		GP		GQ		GR	
GS		GT		GU		GV	
GW		GX		GY		GZ	
HA		HB		HC		HD	
HE		HF		HG		HH	
HI		HJ		HK		HL	
HM		HN		HO		HP	
HQ		HR		HS		HT	
HU		HV		HW		HX	
HY		HZ		IA		IB	
IC		ID		IE		IF	
IG		IH		II		IJ	
IK		IL		IM		IN	
IO		IP		IQ		IR	
IS		IT		IU		IV	
IW		IX		IY		IZ	
JA		JB		JC		JD	
JE		JF		JG		JH	
JI		JJ		JK		JL	
JM		JN		JO		JP	
JQ		JR		JS		JT	
JU		JV		JW		JX	
JY		JZ		KA		KB	
KC		KD		KE		KF	
KG		KH		KI		KJ	
KK		KL		KM		KN	
KO		KP		KQ		KR	
KS		KT		KU		KV	
KW		KX		KY		KZ	
LA		LB		LC		LD	
LE		LF		LG		LH	
LI		LJ		LK		LL	
LM		LN		LO		LP	
LQ		LR		LS		LT	
LU		LV		LW		LX	
LY		LZ		MA		MB	
MC		MD		ME		MF	
MG		MH		MI		MJ	
MK		ML		MO		MP	
MQ		MR		MS		MT	
MU		MV		MW		MX	
MY		MZ		NA		NB	
NC		ND		NE		NF	
NG		NH		NI		NJ	
NK		NL		NO		NP	
NQ		NR		NS		NT	
NU		NV		NW		NX	
NY		NZ		OA		OB	
OC		OD		OE		OF	
OG		OH		OI		OJ	
OK		OL		OM		ON	
OO		OP		OQ		OR	
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PA		PB		PC		PD	
PE		PF		PG		PH	
PI		PJ		PK		PL	
PM		PN		PO		PP	
PQ		PR		PS		PT	
PU		PV		PW		PX	
PY		PZ		QA		QB	
QC		QD		QE		QF	
QG		QH		QI		QJ	
QK		QL		QM		QN	
QO		QP		QQ		QR	
QS		QT		QU		QV	
QW		QX		QY		QZ	
RA		RB		RC		RD	
RE		RF		RG		RH	
RI		RJ		RK		RL	
RM		RN		RO		RP	
RQ		RR		RS		RT	
RU		RV		RW		RX	
RY		RZ		SA		SB	
SC		SD		SE		SF	
SG		SH		SI		SJ	
SK		SL		SM		SN	
SO		SP		SQ		SR	
SS		ST		SU		SV	
SW		SX		SY		SZ	
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UW		UX		UY		UZ	
VA		VB		VC		VD	
VE		VF		VG		VH	
VI		VJ		VK		VL	
VM		VN		VO		VP	
VQ		VR		VS		VT	
VU		VV		VW		VX	
VY		VZ		WA		WB	
WC		WD		WE		WF	
WG		WH		WI		WJ	
WK		WL		WM		WN	
WO		WP		WQ		WR	
WS		WT		WU		WV	
WW		WX		WY		WZ	
XA		XB		XC		XD	
XE		XF		XG		XH	
XI		XJ		XK		XL	
XM		XN		XO		XP	
XQ		XR		XS		XT	
XU		XV		XW		XZ	
YA		YB		YC		YD	
YE		YF		YG		YH	
YI		YJ		YK		YL	
YM		YN		YO		YP	
YQ		YR		YS		YT	
YU		YV		YW		YZ	
ZA		ZB		ZC		ZD	
ZE		ZF		ZG		ZH	
ZI		ZJ		ZK		ZL	
ZM		ZN		ZO		ZP	
ZQ		ZR		ZS		ZT	
ZU		ZV		ZW		ZX	
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FY		FZ		GA		GB	
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GG		GH		GI		GJ	
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HE		HF		HG		HH	
HI		HJ		HK		HL	
HM		HN		HO		HP	
HQ		HR		HS		HT	
HU		HV		HW		HX	
HY		HZ		IA		IB	
IC		ID		IE		IF	
IG		IH		II		IJ	
IK		IL		IM		IN	
IO		IP		IQ		IR	
IS		IT		IU		IV	
IW		IX		IY		IZ	
JA		JB		JC		JD	
JE		JF		JG		JH	
JI		JJ		JK		JL	
JM		JN		JO		JP	
JQ		JR		JS		JT	
JU		JV		JW		JX	
JY		JZ		KA		KB	
KC		KD		KE		KF	
KG		KH		KI		KJ	
KK		KL		KM		KN	
KO		KP		KQ		KR	
KS		KT		KU		KV	
KW		KX		KY		KZ	

APPEARANCE SHALL BE WELL FINISHED AND FREE FROM RESIDUAL MILL SCALE, TOOL MARK, FLAKES, SCRATCHES, RUST, BLOWHOLES, OIL MARK, AND OTHER REMARKABLE DEFECTS.



STAMPED SIDE  
捺印側 6.



VITAL PART  
重要部品

SECTION  
断面

A.A 尺度  $\frac{90}{1}$   
SCALE

1. THIS PART SHALL BE USED AS THE FIRST PRESSURE RING FOR THE ENGINE HAVING  $\phi 125$  BORE.

1. ボアφ125 エンジンノォ1 圧力ソングトシテ使用スル.

## 2リング仕様

## 2. RING SPEC.

APPLY HARD CHROME PLATING OF  $Q1 \sim 0.25$  THICK. AFTER LIQUID HONING FINISH, CONDUCT LAPPING USL TO MAKE SURE OF THE SMOOTH FITTING ON THE CIRCUMFERENCE.

(1)	TENSION 張力 : W	1.75 ~ 2.15 kg
(2)	CLEARANCE OF JOINT WHEN FREE 自由時ノ合口スキマ	ABOUT 約 13.5
(3)	BAR STOCK HARDNESS 素材 硬度	HRC 25 ~ 38
(4)	ECCENTRICITY BETWEEN I.D. AND O.D. 内外径ノ偏心	MAX. 0.1 以下ノコト.
(5)	SURFACE TREATMENT 表面処理	滑動面 底寸 0.1 ~ 0.25ノ硬質クロムメッキ施行 液体ホーニング仕上げ 外周シリコンコート シムヲ施行ノコト ソノ他 パーカライジング PARKERIZING
→ 外觀ハ仕上面ガ良好テ黒反残リ、荒目残リ、傷割レ		
(6)	ワビ、巣、油焼ケ、ソノ他 看シメ点ガナイコト:	

3.ピストンリングノ品質ハKES 06 163.231Aニヨル.

3 QUALITY OF PISTON RING SHALL CONFORM TO KES 06.163.23 - A.

4材質ハ Spec NO. ES1119, KPR3 (RIK24)

4. MATERIAL SHALL CONFORM TO SPEC. NO. ES 1119, KPR? (RIK 24).

下り量: 0~0.076

E. 二軸差:  $\Delta -0.6 \sim 0$

5. AMOUNT OF KEYSTONE DROP :  $C \sim 0.076$

6 DIFFERENCE BETWEEN TWO AXES :  $-0.6 \sim 0$

302 3180215

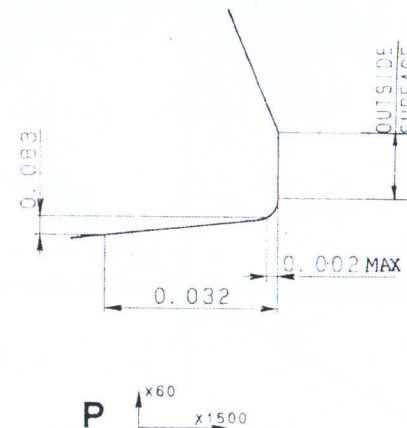
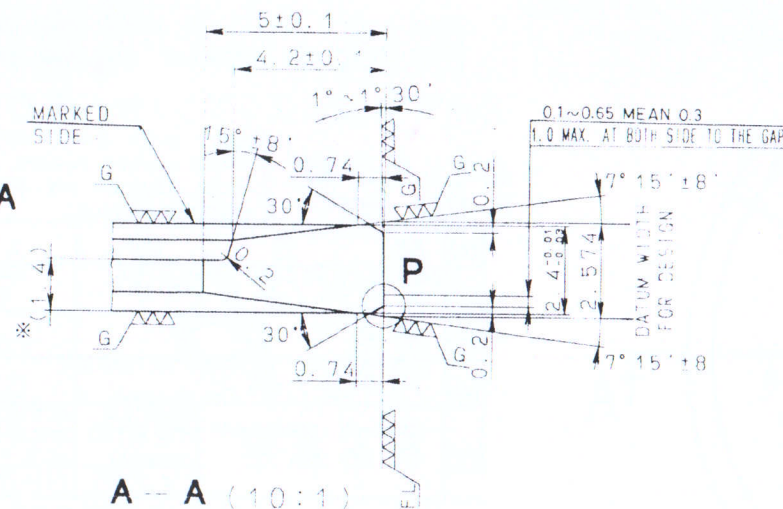
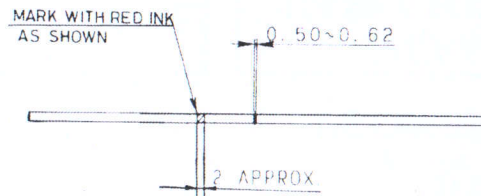
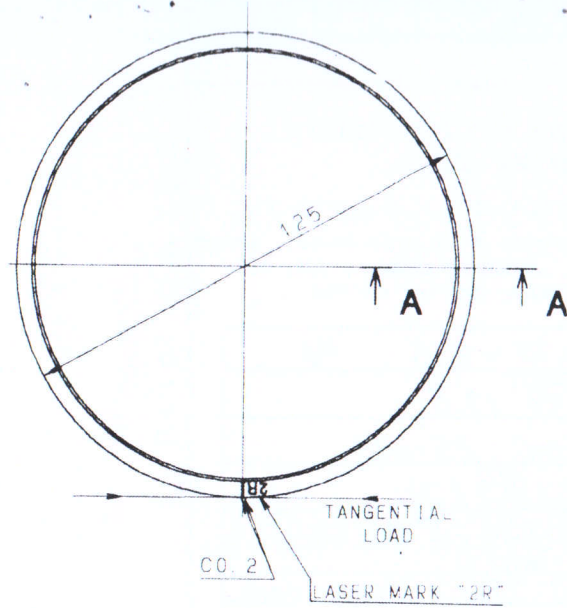
部品符号	品名	材 質	1個分の 調 数	備 考
SYM	PARTS NAME	MATERIAL	QTY/SET	REMARKS

三角法		重量 WEIGHT (kg)		熱処理 HEAT TREATMENT		硬化度 CASE DEPT	
3PD 100 ED		0.03		POSITION			
本重 王付		造材 模図 製圖 写真		DATE		PART NAME	
量 小 長		A-E		05.1.31		RING	
製番 PRODUCTION NO		尺量 SCALE		サイズ SIZE		寸法 P	
1		1		3		S	

H	MATERIAL	67125	6
	SCA)SDU125	67125	6
	適用機種		
	APPLICATION		0"
	材質 MATERIAL		
	國中參照		
	SEE DRAWING		
	或請向本廠洽詢		

125 - Top Ring - 30Z3180125 (6151-31-2310-2)



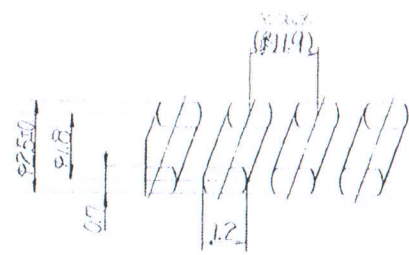
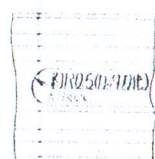
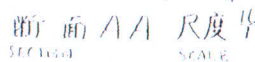
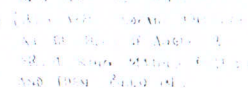
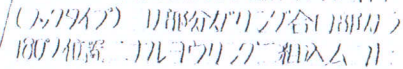
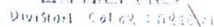
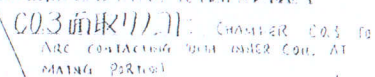


1. THIS PART TO BE USED FOR THE SECOND COMPRESSION RING.
2. THIS DRAWING SHOWS THE CLOSED CONDITION.  
FREE GAP TO BE 14.8 APPROX.
3. OUTSIDE SURFACE TO BE CHROMIUM PLATED WITH THICKNESS 0.10~0.25. FINISHED BY WET HONING.  
AND LAPPED TO CONTACT WIDTH.
4. RAW MATERIAL HARDNESS TO BE HRC25~38.
5. APPLY PARKERIZING TREATMENT EXCEPT OUTSIDE SURFACE.
6. ECCENTRICITY OF I.D. & O.D. TO BE 0.1 MAX.
7. TANGENTIAL LOAD REQUIRED TO CLOSE TO SPECIFIED GAP TO BE 1.55~2.15 kg.
8. MATERIAL TO BE ES1119 KPR2A.  
(RIK20A BY RIKEN CO. OR EQUIVALENT)
9. DISPERSION OF RAW HARDNESS IN ONE RING TO BE HRC4. MAX.
10. QUALITY OF PISTON RING TO CONFORM TO B OF KES06.163.23.E
11. SUNKEN AMOUNT OF KEYSTONE TO BE 0~0.1.
12. TWIST ANGLE TO BE 11°~35°. (AT OPPOSITE SIDE TO THE GAP)  
ADJUSTED BY \* MARKED DIMENSION.
13. CIRCULARITY TO BE 0~0.6.

IMPORTANT PART

SL. NO.	PART NO.	NAME OF PART	QTY./ ASSLY.	MATERIAL	REMARKS
General Tolerance To SKES-04-052-0		Remove all burrs and break sharp edges.		Unspecified finish	
All dimensions are in mm, Unless specified. Do not scale the drawing. If in doubt, ask.		MATERIAL SEE NOTE		HEAT TREATMENT SEE NOTE	
DESIGN REF. 6151.31.2320/01		Wt. of part (Kgs.) 0.03		PORTION CASE DEPTH	
APPROVED		SIGNATURE		DATE	
REVIEWED/CHECKED		SIGNATURE		DATE	
DRAWN		SIGNATURE		DATE	
Bharat Earth Movers Ltd., Engine Division, Mysore.			SHEET		DWG. NO.
			307 3180		

125-2<sup>nd</sup> Ring- 3073180678 (6151.31-2320)



ファイル詳細 尺度<sup>10)</sup>

2141. 25 Cou. SCALE:

SPECIFICATION OF CON  
 2. IN USE OF 15. 10/20/20

END 0019146 006 00192146  
2025

●●●  
重要部品

三角法	重量 WEIGHT (kg)	熱処理 HEAT TREATMENT	酸化層の深さ CASE DEPTH
3rd ANGLE			
主面 主位 前位 側位 後面 後面	年月	製造年 MONTH DATE	品名 PART NAME
(1) 原 / 底 / 底 / 底		83.8.4	RING
製造 PRODUCTION NO.	尺数 SCALE	サイズ SIZE	表面の処理面 SURFACE (THICKNESS)
		2	

26-51-2231

125-oil Ring- 30 Z3180167 ~~16~~