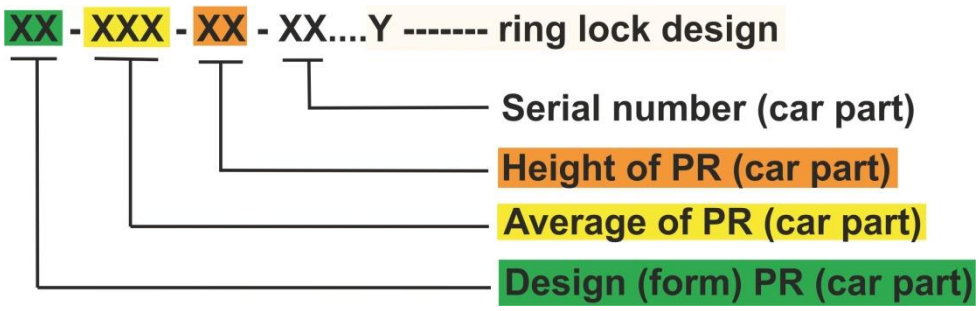
Numbering of piston ring drawing

5.1 Number creation in PR (piston ring) drawing and car part

The number of PR drawing and car part has this basic scheme:



5.1.1 Design (kind) of PR

Combination of two numbers strongly provided, which are intended kind of PR including coating of work area – range 10 – 99
Meanings of single numeral codes is written in next list:

10 to **12** – sealing ring rectangular without coating on work area (without chrome and molybdenum)

13 – vacant

14 – sealing ring rectangular with chromic coating on work area

15 – sealing ring rectangular with chromic coating on work area which is made to notch

16, 17 – sealing ring rectangular with molybdenum coating on work area

18 – sealing ring rectangular with other coating on work area

19 – vacant

20 to **22** – sealing ring half trapeziodal and trapeziodal without coating on work area (without chrome and molybdenum)

23 – vacant

24, 25 – sealing ring half trapeziodal and trapeziodal with chromic coating on work area

26, 27 – sealing ring half trapeziodal and trapeziodal with molybdenum coating on work area

28 – sealing ring half trapeziodal and trapeziodal with other coating on work area

29 – steel sealing ring half trapeziodal and trapeziodal with nitrided or chromic or molybdenum coating on work area

30 to **32 –** sealing ring rectangular with taper work area, without coating on work area (without chrome or molybdenum)

33 – vacant

34, 35 – sealing ring rectangular with taper work area and with chromic coating on work area

36, 37 – sealing ring rectangular with taper work area and with molybdenum coating on work area

38 – sealing ring rectangular with taper work area and with other coating on work area

39 – vacant

40 to **42 –** wiper ring fitted with taper work area combination (E, NN, NM by ČSN ISO 6621-4). Chromic coating on work area.

43 – vacant

44, 45 – wiper ring fitted with taper work area combination (E, NN, NM by ČSN ISO 6621-4) without coating on work area (without chrome and molybdenum)

46, 47 - wiper ring fitted with taper work area combination (E, NN, NM by ČSN ISO 6621-4). Molybdenum coating on work area.

48 - wiper ring fitted with taper work area combination (E, NN, NM by ČSN ISO 6621-4). Other coating on work area.

49 – vacant

50 – wiper ring with cutting, rectangular

51 – wiper ring with cutting, skewed

52 – wiper ring with cutting, skewed imbricated

53 – vacant

54 – wiper ring with cutting, chromic coating on work area

55 to 59 – vacant

60 – wiper ring rectangular with helical expander

61 – wiper ring skewed with helical expander

62 – wiper ring skewed imbricated with helical expander

63 – vacant

64, 65 – wiper ring with helical expander, with chromic coating on work area

66 – vacant

67 – lamellar wiper ring type NIFLEX; MINIFLEX

68 – lamellar wiper ring type VF 3, PC 98

69 – steel wiper ring with helical expander and with nitrided coating on work area

70 – steel wiper ring without coating on work area (without chrome, molybden, nitrid)

71 to **73 –** vacated

74 – steel ring with chromic coating on work area

75 – vacant

76 – steel ring with molybdenum coating on work area

77, 78 – vacant

79 – steel ring with nitrided coating on work area

80 to 89 – vacated

90 – helical expander for rectangular wiper ring with helical expander (see 60)

91 – helical expander for skewed wiper ring with helical expander (see 61)

92 – helical expander for skewed imbricated wiper ring with helical expander (see 62)

93 – vacant

94, 95 – helical expander for wiper ring with helical expander and with chrome coating on work area (see 64, 65)

96 – vacant

97 – spring and lamination for wiper ring (see 67). Resolution between lamination and spring is made by number which indicates the height of PR.

98 – spring and lamination for lamellar wiper ring (see 68). Resolution between lamination and spring is made by number which indicates the height of PR.

- for expample – average of PR =75,5 mm; height of PR = 3 mm:

  PR number - 68-075-30-01,

Spring number - 98-075-30-01,

Lamination number - 98-075-05-01

99 – helical expander for steel wiper ring with helical expander and with nitrided coating on work area

NA – determined for cooperative edit of PR and other products

NN – cooperative production in workshop

Type of car part

00 – vacant

01 – personal car parts

02 – truck parts

03 – tractor parts

04 – vacant

05 – products of industrial format number 550 directed by MAX system

06 and **07** – vacant

08 – piston ring – intermediate product

09 – preparation for intermediate tray of PR – manufactured like PR

5.1.2 Average of PR and car part

These three digits show average of PR like this: (example)

Ø 18 mm – 018

Ø 98,43 mm – 098

Ø 103,18 mm – 103

Average of part is also showed with car part. In support plate measurement is showed the biggest size.

5.1.3 Height of PR and car part

These two digits show height of PR like this: (example)

height 0,5 mm – 05

height 1 mm – 10

height 1,5 mm – 15

height 2,385 mm – 23

height 3,947 mm – 39

height 4 mm – 40

For height which is lower then 10 mm is showen 00.

Height (lenght) of part will be also showed in car parts.

5.1.4 Serial number

Series of numbers are chronologically sequenced.

Design of ring lock

P = lock with front ensure

Z = lock with internal ensure

H = H lock

T = straight sealing PR