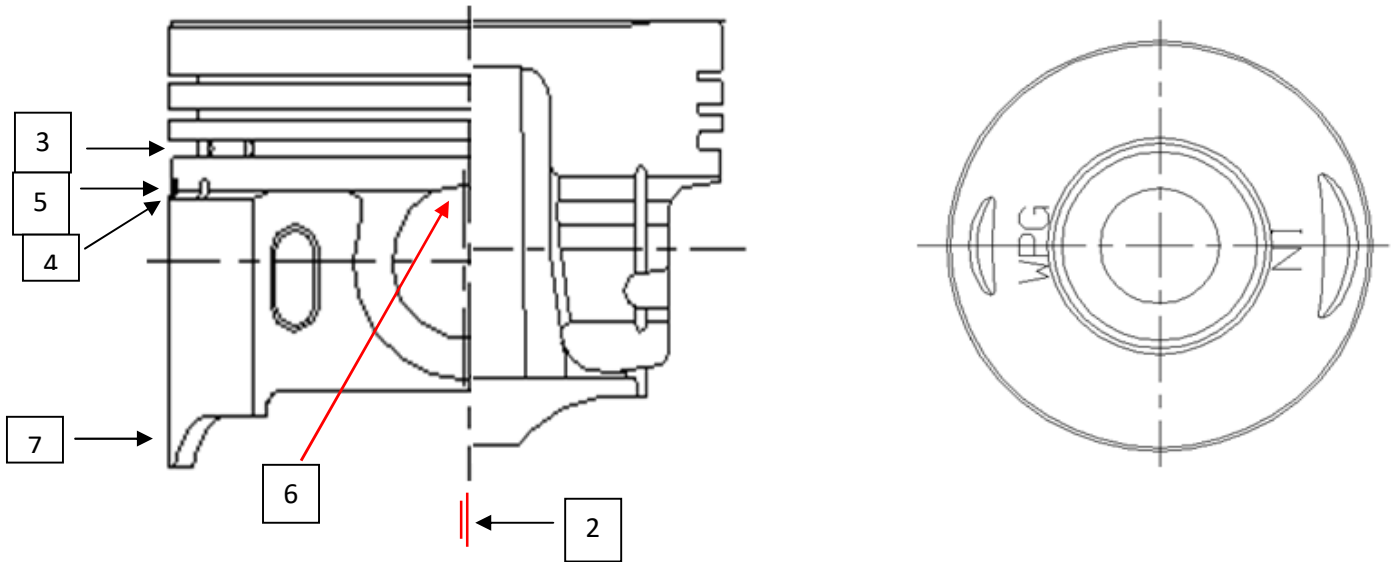


TECHNICAL BULLETIN- HONDA ACTIVA 110cc HET - PISTON ASSEMBLY

USHA is pleased to introduce HONDA ACTIVA 110cc HET piston assembly in our range of two wheeler assemblies.

This piston assembly has following special features:

PISTON:



Unique features of USHA HONDA ACTIVA 110cc HET piston are as follows:

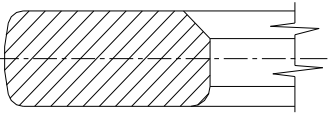
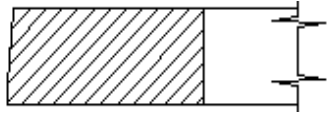
S.No.	SPECIAL FEATURES	BENEFITS TO CUSTOMERS
1)	AS CAST CROWN: This piston has as cast crown i.e. no machining is done on crown of piston (except button). As cast crown has better grain structure which increases the strength, heat resistance etc. of piston crown.	<ul style="list-style-type: none"> Increased piston life.
2)	PISTON- PIN BORE OFFSET: This Piston is provided with a piston pin bore offset to avoid piston slap. Piston pin bore offset means that the centre line of piston is slightly offset from the centre line of pin bore. Due to this offset, piston tilts at TDC smoothly & prevents slapping with liner.	<ul style="list-style-type: none"> Reduced engine noise.
3)	OIL HOLES IN OIL RING GROOVE	<ul style="list-style-type: none"> Faster drainage of excess oil. Lesser oil consumption.
4)	"J"- CUT: This piston has been provided with a unique "J" cut below the oil ring groove area.	<ul style="list-style-type: none"> "J" cut provides all time lubrication to piston skirt area. No piston seizure in extreme limits of normal working conditions.
5)	OIL HOLES BELOW OIL RING GROOVE	<ul style="list-style-type: none"> Low oil consumption. Faster drainage of excess oil.

6)	PIN BORE BROACHING	<ul style="list-style-type: none"> To improve lubrication of pin-pin bore.
7)	SLIPPER DESIGN: Slipper design in skirt helps in reducing piston weight & provides better guidance to the piston movement.	<ul style="list-style-type: none"> Improved fuel efficiency. Better guidance to rings. Low noise during engine working.

TECHNICAL DATA- HONDA ACTIVA 110cc HET PISTON		
		USHA CODE→ S37
Nominal Bore Diameter	mm	50.00
Piston Diameter	STD Size mm	49.9875
Recommended Piston-Liner Clearance	mm	0.0125
Compression Height	mm	18.50
Total Height	mm	34.50
Piston Pin- Pin Bore Clearance	mm	+0.00 to +0.008 (Clearance Fit)

PISTON RINGS:

HONDA ACTIVA 110cc HET pistons are provided with unique design HPVENT ring set for low oil & fuel consumption. The technical details of HPVENT ring set are as under:-

TECHNICAL DATA- HONDA ACTIVA 110 cc HET RINGS						
Ring	Ring Configuration	Axial Thickness (mm)	Closed Gap		Surface Treatment	Cross Section
			(mm)	(Thou)		
Top	HPIBGN	0.8	0.10-0.25	4-10	Gas Nitrided	
Second	TSS	0.8	0.10-0.25	4-10	Parkerised	
Oil Ring	RIKVENT	1.5	0.20-0.70 (Rails)	8-28	Chrome Plated/ Parkerised	