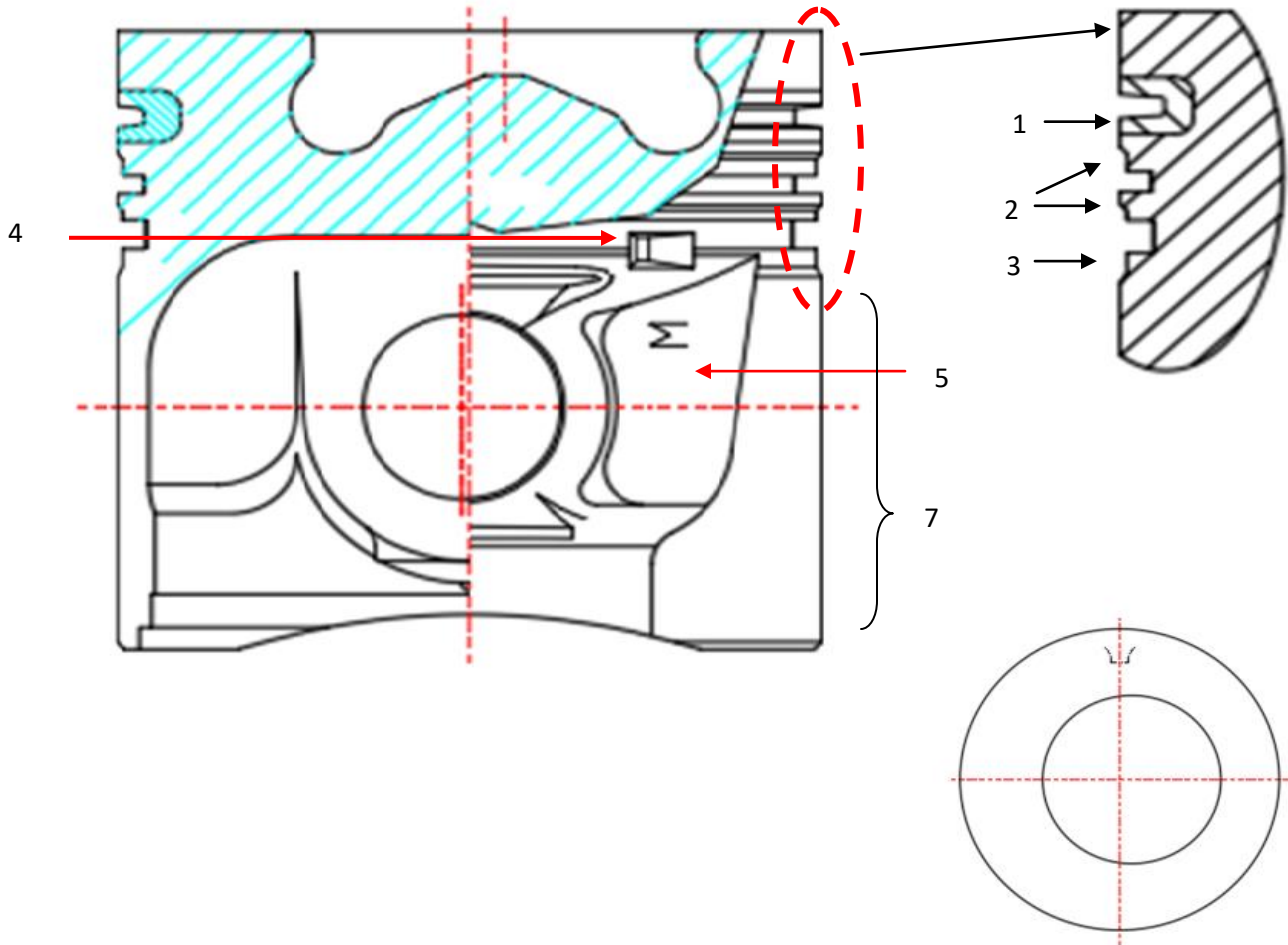


Technical Bulletin – MAHINDRA DI 3200/ BOLERO LTC Piston Set

USHA is pleased to introduce Mahindra DI 3200/ Bolero LTC Piston set. This piston is suitable for Mahindra DI 3200/ Bolero M2Di vehicles.



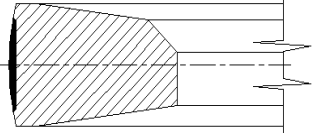
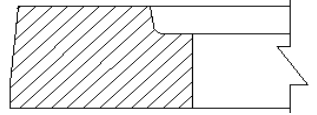
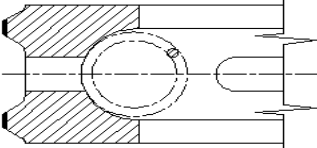
Special features of the piston are as follows:-

| Sl. no. | Special features | Benefits to customer |
|---------|---|--|
| 1 | HIGH NICKEL WEAR RESISTANT RING CARRIER (RCP): Top groove of this piston is made of high nickel wear resistant ring carrier insert, which is manufactured as per latest centrifugal casting process. | <ul style="list-style-type: none"> • Longer life of piston due to better wear resistance of top groove. |
| 2 | STEP CUT IN 1st & 2nd RING LAND: Provides perfect seating of rings on the bottom flank of grooves. | <ul style="list-style-type: none"> • Helps in reducing blow-by. • Helps in reducing oil consumption. |

| | | |
|---|---|--|
| 3 | "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 on skirt. No piston seizure in extreme limits of normal working conditions. |
| 4 | QUICK OIL RETURN SLOTS (QORS): Two nos. of quick oil Return slots (QORS) are provided for each piston window above the pin bore, half in groove & half in window. | <ul style="list-style-type: none"> Quick drainage of oil and hence lower oil consumption. |
| 5 | AS CAST HYDRODYNAMIC WINDOW: New hydrodynamic 'as cast' window designed by our collaborator, not only provides more space for oil drainage, but also provides more skirt area for better piston ring guidance. | <ul style="list-style-type: none"> Faster oil drainage due to more space helps in reducing oil consumption. Better guidance to rings help in reducing oil consumption. |
| 6 | PISTON SURFACE COMPLETELY BONDERISED | <ul style="list-style-type: none"> Helps in preventing oxidation of piston and improves adhesion performance. |
| 7 | SKIRT COATED WITH NEW "D-10" COATING | <ul style="list-style-type: none"> D-10 permanent coating provides better wear resistance & initial lubrication to avoid piston scuffing. |
| 8 | MEASURING POINTS ON THE SKIRT: Two points on both sides of the skirt. | <ul style="list-style-type: none"> Provided for easy diameter verification. |

| TECHNICAL DATA- MAHINDRA DI 3200/BOLERO LTC PISTON | | USHA CODE→ L08 |
|--|-------------|-------------------------------------|
| Nominal bore diameter | mm | 88.90 |
| Piston diameter | STD Size mm | 88.81 |
| Recommended piston-liner clearance | mm | 0.090 |
| Compression height | mm | 51.35 |
| Total height | mm | 84.35 |
| Piston pin- pin bore clearance | mm | +0.004 to +0.015 (Clearance fit) |

PISTON RINGS- This piston is designed to match with existing USHA **Mahindra DI Bolero LTC SSTR**
R/S. Technical details of Bolero LTC SSTR ring set are as under :-

| TECHNICAL DATA- MAHINDRA DI 3200/BOLERO LTC RINGS | | | | | | |
|--|----------------------------------|----------------------|------------|--------|----------------------------------|---|
| Ring | Ring Configuration | Axial Thickness (mm) | Closed Gap | | Surface Treatment | Cross-Section |
| | | | (mm) | (Thou) | | |
| Top | Spl. Steel Keystone Inside Bevel | 3.00 | 0.20-0.40 | 8-16 | Inlaid Chrome & Parkerised |  |
| Second | Taper I.D Step | 2.50 | 0.80-1.00 | 32-40 | Parkerised |  |
| Oil Ring | HTCR | 4.00 | 0.25-0.50 | 10-20 | Lands Chrome Plated & Parkerised |  |

- ❖ This piston set and ring set is suitable for Mahindra DI 3200 series engines and goes into various Mahindra vehicles sporting M2Di engine listed below :

M2Di Engine sporting Models :- BMT Plus DI, Bolero Pickup DI, Thar DI, Bolero Camper M2Di, Bolero XL/New DI/Plus, BMT DI, Scorpio M2Di.