

Action code: AT FIRST OPPORTUNITY

New procedure for honing of cylinder liners

SL2021-710/JNN

March 2021

Concerns

Owners and operators of
MAN four-stroke engines.

Type:

Marine: L16/24, L21/31, L27/38,
L23/30H, L28/32H

Stationary: L16/24S, L21/31S, L27/38S,
L23/30S, L28/32S, V28/32H, V28/32S

Propulsion: L21/31, L27/38, L23/30A,
L28/32A, V28/32A

Dual Fuel: L23/30DF, L28/32DF

Attachments:

Work card M5060135-12, Inspection
and honing of cylinder liner

Dear Sir or Madam

By this service letter we would like to draw your attention to the attached new working card for the newly released honing procedure in connection with reconditioning of cylinder liners.

Introduction of new standards for cylinder liner honing has been necessary in order to comply with the increasing demands towards lower emissions and reduced lube oil consumption.

New requirements to the surface smoothness has led to the development of new honing methods. Thus, the previous standard with one set of honing stones and in-situ honing is no longer recommended.

The machining procedure is changed to a four-step honing procedure with various types of honing stones to obtain correct honing pattern and sufficient smoothness of the liner surface.

Please see next page for further information.

Yours faithfully




Mikael C. Jensen
Vice President
Head of Engineering
Two Stroke Business



Henrik Møller Hansen
Senior Manager,
Production Support



Work step	Set-up and mode of honing operation MAN Energy Solutions 			
	Honing Stone Type	Settings		
		Speed	Pressure	Stroke
1	Diamond Stone No: 11373-30-07 + Brush Remove wear edge in the top	25 m/min	50 %	NONE
2	Diamond Stone No: 11373-30-07 Rough honing the entire running surface	25 m/min	50 %	AUTO
3	Ceramic Stone No: 11373-20-39 Creating surface structure	25 m/min	50 %	AUTO
4	Ceramic Stone No: 11373-20-36 Creating final plateau honing	25 m/min	25 %	AUTO

In order to ensure throughout cleaning and removal of abrasive particles from the liner surface after the honing procedure, we recommend to perform the honing with the liner dismantled from the engine frame. This will prevent contamination of the lube oil sump with abrasive particles.

Our PrimeServ Academy in Holeby offers further information on the honing procedure.

With the above update, the honing brush previously delivered with the engine’s standard tools will no longer be included in the standard tool set.



The honing brush is no longer supplied with the standard tool set for the engine.

If you have any questions to this service letter please contact your local PrimeServ agent or our PrimeServ department by e-mail to

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