



DIESEL MARINE INTERNATIONAL L.L.C. DMI (Dubai)

SCOPE OF WORK FOR THE RECONDITIONING OF: Piston Crowns (General)

Piston crown (General) standard *full* reconditioning procedure.

1. Removing of all accessories
2. Grit blasting and cleaning
3. Visual inspection, magnaflux crack detection
4. Pre-machining, welding and final machining of the ring groove area and combustion face, incl. crack repair
5. Repair of cracks, which are running through from the combustion face to the cooling water space/ cooling water bores (option)
6. Welding of combustion face with an Inconel 625 layer (option at additional cost)
7. Stress relieving (performed after every welding operation)
8. Sleeving of the telescopic pipe holes (if applicable)
9. Double chrome plating of the ring grooves, incl. final grinding to original dimensions
10. Internal cleaning of cooling water bores (if applicable)
11. Final inspection, incl. hydraulic test
12. Certification by any required classification society (option at additional cost)
13. Fitting of removed and/or renewed accessories
14. Rust protection
15. Packing and transport (option at additional cost)

Guarantee:

- Deliveries are subject to 'Diesel Marine International L.L.C. General Terms and Conditions of Sale and Delivery'
- DMI (Dubai) guarantees fully reconditioned piston crowns it supplies against material and manufacturing defects for a period of 12 months or 5000 hours in operation. For partially reconditioned piston crowns, DMI (Dubai) guarantees its conducted scope of work for a period of 12 months or 5000 hours in operation.