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(54) **MONOBLOC PISTON FOR DIESEL ENGINES**

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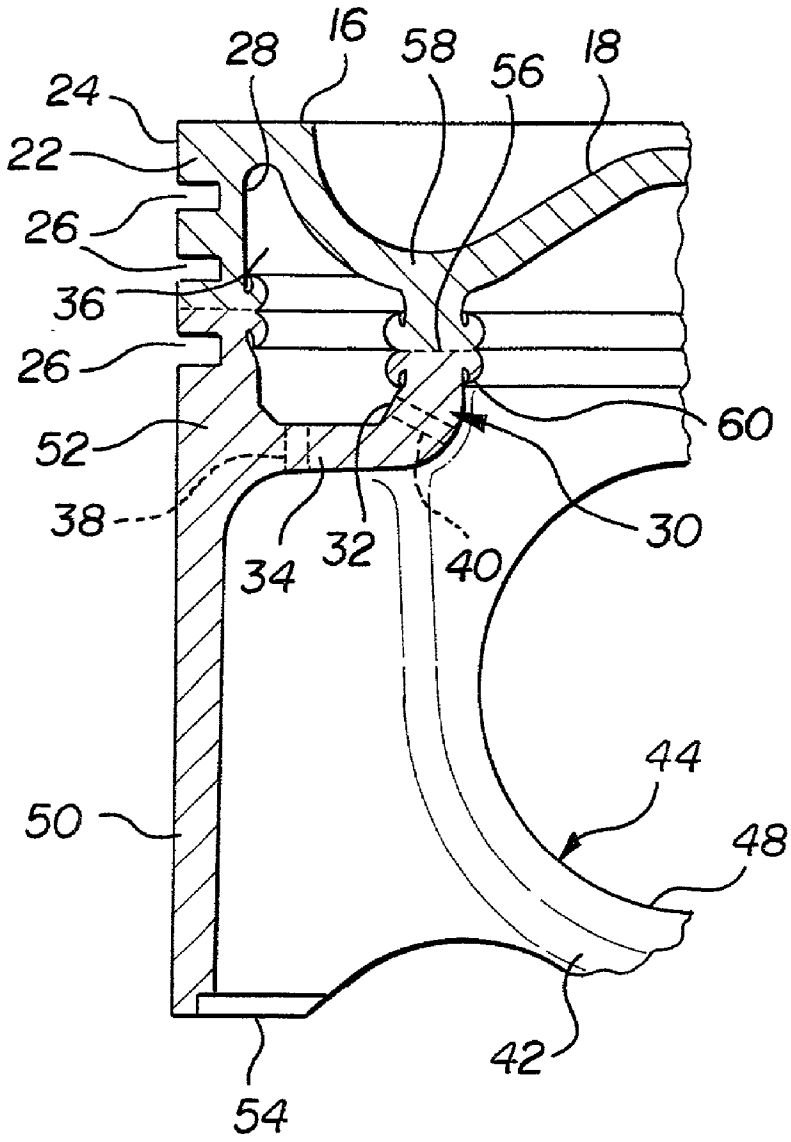
(57) **ABSTRACT**

A steel monobloc piston for diesel engines is formed with a relatively short piston skirt whose lower edge resides below the axis of the pin bores of the piston, but located at or above a lowest tangent point of the pin bores. The piston body preferably has a closed oil cooling gallery and the skirt is preferably joined at its upper end to an outer wall of the piston in which a plurality of ring grooves are formed.



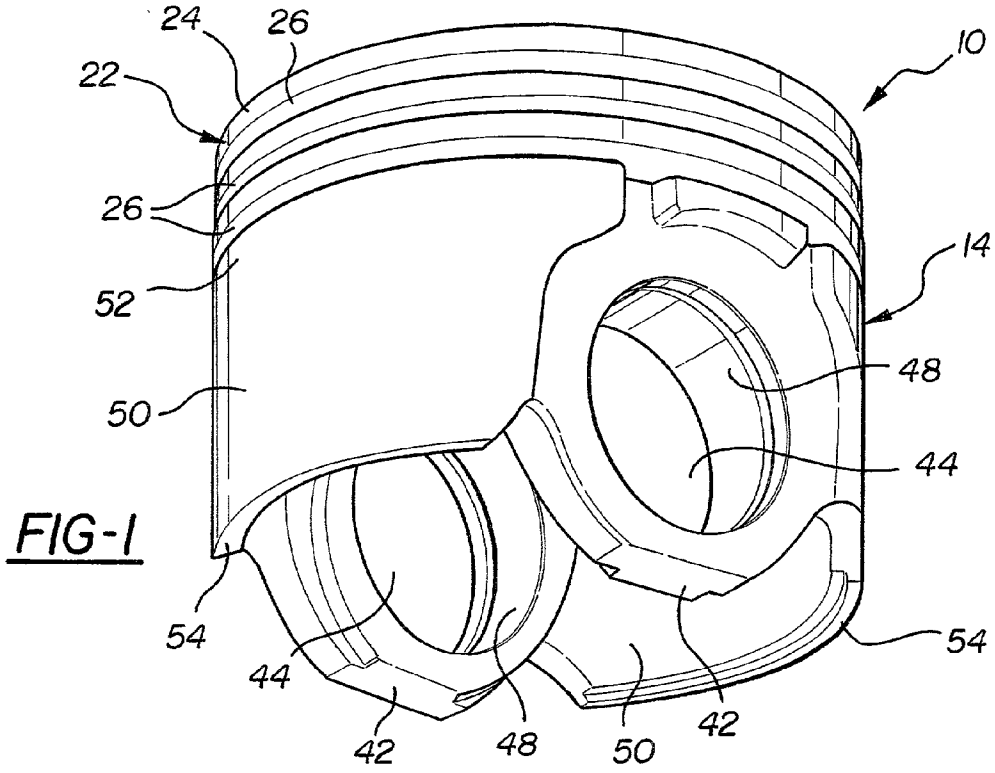

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FIG-1

FIG-2

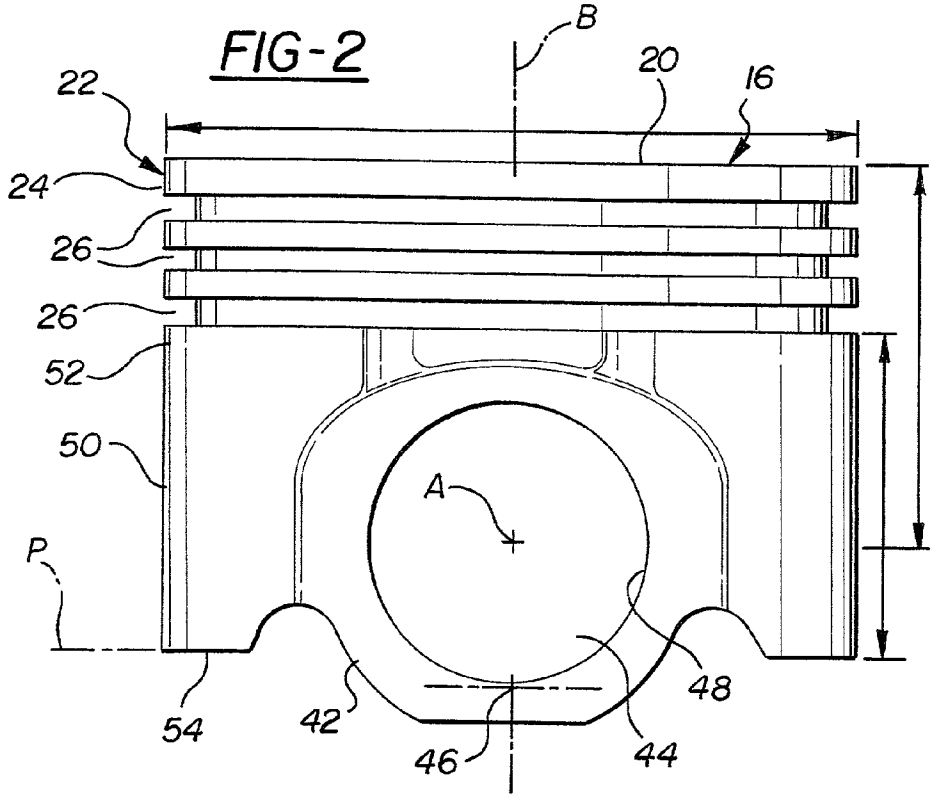
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FIG-3

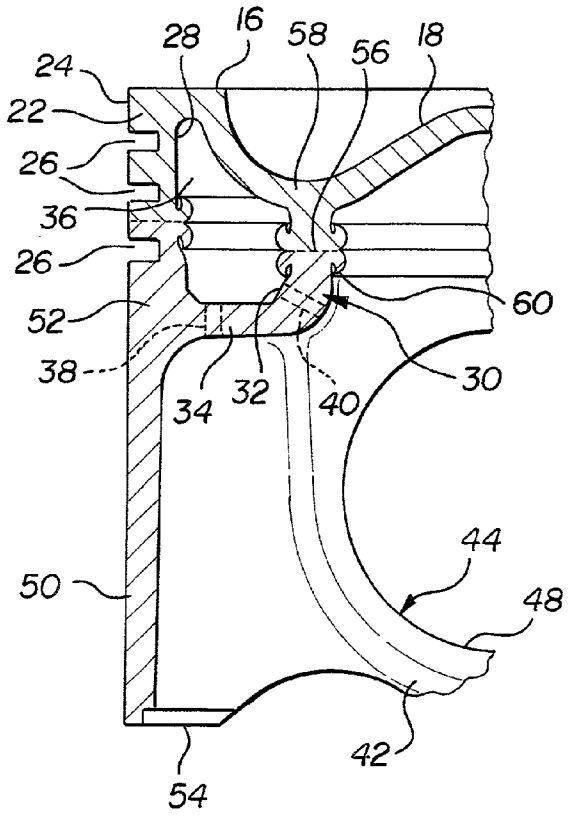
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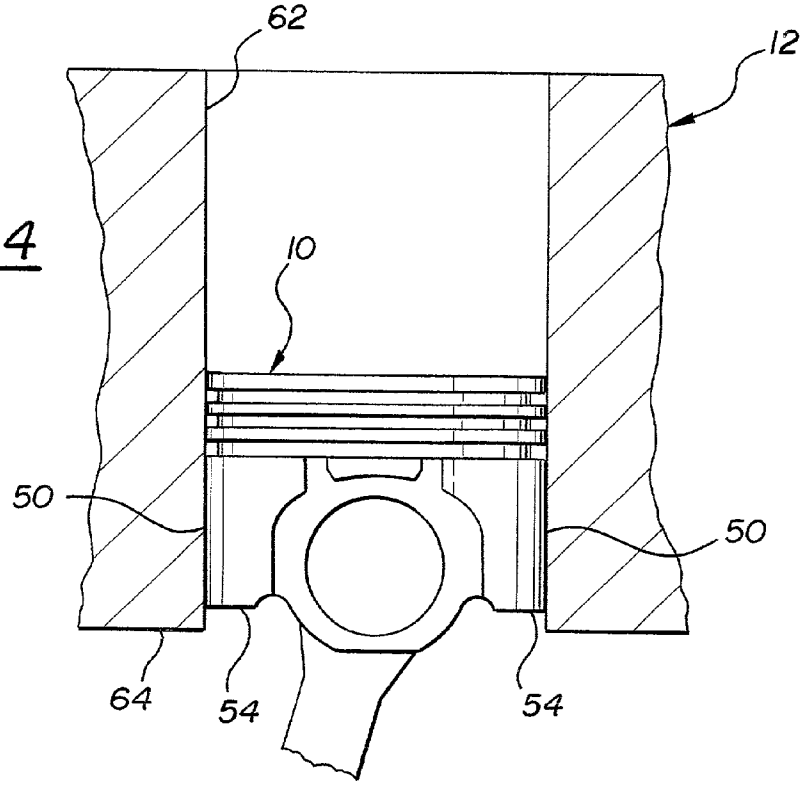
FIG-4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MONOBLOC PISTON FOR DIESEL ENGINES

BACKGROUND OF THE INVENTION

[0001] 1. Technical Field

[0002] This invention relates generally to monobloc pistons for diesel engine applications in which the piston skirt is formed as one integral piece with the piston body, and more particularly to the construction of the piston skirt.

[0003] 2. Related Art

[0004] Monobloc pistons for diesel engine applications are known wherein the piston skirt is formed as an integral portion of the piston body, as opposed as being articulated. Such pistons are known to have piston skirts that are of such length and/or are positioned such that the lower edge of the skirt extends well below the bottom of the pin bosses to provide the desired support and guidance to the piston as it reciprocates within the cylinder of the engine. Such low lying skirts, however, can extend outside of the cylinder liner at bottom dead center position of the piston and can lead to scuffing of the piston skirt and/or liner due to the sudden change in load and direction as the piston returns upwardly in the cylinder. In addition, the low lying skirt interferes with the location of oil injection nozzles which direct cooling oil up into the piston, requiring the skirt to be notched in the area of the nozzle to provide clearance. Examples of such monobloc pistons are disclosed in U.S. Pat. Nos., 4,161,165 and 4,286,505, as well as published international application WO 9620340. The piston disclosed in the latter publication has a short, low lying piston skirt which is uncoupled from the ring belt and, due to the wide gap between the bottom of the ring belt and the top of the skirt as well as the low, remote positioning of the skirt, transfers some of the piston guidance duties to the ring lands near the top of the piston, which is less efficient and could cause damage to the ring lands as well as decrease the performance of the piston.

[0005] U.S. Pat. No. 4,704,950 discloses a high performance automotive piston for gasoline engines which is manufactured entirely of aluminum and would be unsuitable for high compression diesel applications to which the present invention is directed.

[0006] It is an object of the present invention to provide a monobloc piston for diesel engines that overcomes or greatly minimizes the deficiencies of the prior art pistons described above.

SUMMARY OF THE INVENTION AND ADVANTAGES

[0007] A piston for diesel engines constructed according to a presently preferred embodiment of the invention comprises a piston body fabricated of steel having an outer wall and a closed oil gallery. A pair of pin bosses have axially aligned pin bores and a lowest tangency point of the pin bores. The piston body has a skirt that is formed as one piece with the pin bosses and is coupled at its upper end to the outer wall so as to form a continuous extension of the outer wall. The piston skirt has a lower edge spaced below the pin bore axis, but located at or above the lowest tangency point of the pin bores.

[0008] The invention also contemplates a diesel engine which includes an engine block having at least one cylinder bore and a monobloc piston disposed in the cylinder bore having a piston body fabricated of steel and including a pair of pin bosses with aligned pin bores disposed about a pin bore axis and having a lowest tangent point to the pin bores. A piston skirt is formed as one piece with the pin bosses and has a lower edge disposed below the pin bore axis at or above the lowest tangent point of the pin bores.

[0009] The invention has the advantage of providing a steel monobloc piston for diesel engine applications fitted with a short skirt made of the same steel material of such size and location relative to the remainder of the piston body to provide efficient guidance to the piston during reciprocation in the cylinder bore to reduce loading on the ring lands due to its high location relative to the pin bores. The high location of the lower edge of the skirt prevents the skirt from extending from the bottom of the cylinder bore at bottom dead center of the piston, and thus minimizes or eliminates scuffing of the skirt caused by a sudden change in load or direction when the piston returns upwardly. The relatively high location of the lower edge of the skirt also provides ample clearance for the oil jet nozzles, eliminating the need for clearance notches in the lower edge of the skirt so as to present a continuous, non-interrupted lower leading edge of the skirt which is stronger and easier to manufacture than notched skirts.

[0010] The overall reduction and the height of the skirt further has the advantage of simplifying the manufacture of forged steel pistons. The shorter length enables production of a relatively thinner, more uniform thickness skirt wall as compared to forged skirts of greater length which are generally thicker due to the required draft angle to enable forging of the piston skirt.

THE DRAWINGS

[0011] These and other features and advantages of the present invention will become more readily appreciated when considered in connection with the following detailed description and appended drawings, wherein:

[0012] **FIG. 1** is a bottom perspective view of a piston constructed according to the invention;

[0013] **FIG. 2** is a side elevation view of the piston of **FIG. 1**;

[0014] **FIG. 3** is a fragmentary elevation view like **FIG. 2**, but shown partly in section; and

[0015] **FIG. 4** is a schematic, fragmentary sectional view of a diesel engine shown equipped with the piston of FIGS. **1-3**.

DETAILED DESCRIPTION

[0016] A piston constructed according to the invention is shown generally at **10** in FIGS. **1-3** and is shown installed as part of a diesel engine **12** in **FIG. 4**.

[0017] The piston **10** includes a piston body **14** having a top wall **16** formed with a combustion bowl or crater **18** extending downwardly from a top surface **20** of the top wall **16**.

[0018] The piston body **14** includes an outer annular wall or ring belt **22** having an outer surface **24** formed with a plurality of ring grooves **26** for receiving piston rings (not

shown). The outer wall **22** includes an annular inner surface **28** facing radially inwardly of the piston body **14** opposite the outer surface **24**.

[**0019**] The piston body **14** includes an annular inner wall **30** extending downwardly from the combustion bowl **18** having a radially outwardly facing annular surface **32** spaced radially inwardly from the inner surface **28** of the outer wall **22**.

[**0020**] The piston body **14** preferably includes a bottom wall **34** which extends between and interconnects the lower end regions of the outer wall **22** and inner wall **30** in spaced relation to the top wall **16**. The top wall **16** and outer wall **22** and inner walls **30** bound an annular cooling chamber or gallery **36** for receiving cooling oil which is preferably closed at the bottom by the bottom wall **34**. By "closed", it is not meant that the gallery is entirely self contained, but includes provision for openings and passages for introducing oil into and draining oil from the gallery **36**. A representative oil inlet opening **38** is shown in **FIG. 3**, as is a representative oil drainage passage **40** according to convention. The bottom wall **34** is formed as one piece with the lower regions of the outer wall **22** and inner wall **30** and serves, in addition to closing the gallery **36**, as a structural web or bridge between the outer and inner walls **22**, **30**.

[**0021**] The piston body **14** includes a pair of pin bosses **42**. The pin bosses **42** are formed of one piece with the inner wall **30** and preferably extend downwardly from the bottom wall **34** and are set radially inwardly from the outer surface **24** of the outer wall **22**. The pin bosses **42** are formed with pin bores **44** which receive a wrist pin (not shown) for connecting the piston **10** to a connecting rod (not shown) of the engine **12**. The pin bores **44** are aligned about a common pin bore axis A, which represents a center line of the pin bores with respect to a longitudinal axis B of the piston body **14**. The pin bores **14** have a lowest tangent point **46**, which represents the lowest part of the pin bores **44** in the longitudinal direction, with the tangency point **46** determined by passing a plane P through the piston body **14** perpendicular to the longitudinal axis B which contains the lowest point of the pin bore surfaces **48** of the pin bores **44**, as illustrated in **FIG. 2**.

[**0022**] The piston body **14** includes a piston skirt **50** that is formed as one piece with the pin bores **44**, such that the piston body **14** has a monobloc structure with a fixed skirt, rather than a separate skirt articulated to the pin bosses by the wrist pin (not shown). The skirt **50** is further preferably formed with an upper end region **52** coupled directly to the outer wall **22**, such that the piston skirt **50** is formed as continuous downward extension of the outer wall **22** below the bottom wall **34**. As such, the piston skirt **50** is also interconnected as one piece with the bottom wall **34**, as illustrated best in **FIG. 3**.

[**0023**] The piston skirt **50** has a lower, marginal free edge **54** which defines the lowest part of the skirt **50** in the longitudinal direction of the piston body **14**. According to the invention, the location of the lower edge **54** is such that is provides a relatively short piston skirt **50** as compared to conventional piston skirts. Particularly, the lower edge **54** of the piston skirt **50** is disposed at a location which is below the level of the pin bore axis A but which is at or above the lowest tangent point **46** of the pin bores **44**, and more preferably above the lowest tangent point **46**.

[**0024**] In addition to the longitudinal relationship of the lower edge **54** of the piston skirt **50** relative to the pin bores **44**, the piston body **14** has the following dimensional ratios: H/D=0.5-0.75, A/D=0.3-0.6, and A/H=0.7-1.2, where H is the compression height of the piston body **14** measured between the top surface **20** of the piston body and the axis A of the pin bores **44**, D equals the piston diameter and A equals the axial length between the lowest ring groove **26** and the lower edge **54** of the piston skirt **50**, as shown best in **FIG. 2**.

[**0025**] As shown best in **FIGS. 1 and 2**, the lower edge **54** of the piston skirt **50** is relatively smooth and continuous and free of any clearance notches for oil nozzles or the like.

[**0026**] The piston body **14** is preferably fabricated of at least two separate parts which are separately formed and then subsequently joined to one another across a joint or joints **56**. In the illustrated embodiment, the piston body **14** includes an upper part **58** and a lower part **60** which, when joined together, form the enclosed cooling gallery **36**. The joint **56** of the preferred embodiment is preferably a friction weld joint. However, the invention contemplates other approaches to joining separately formed piston parts, such as bonding, brazing, bolting, joint threads, etc. which would operate to unite the separately formed parts as a single, unified structure once joined for service as a piston body **14**. In the present embodiment, the lower part **60** includes the pin bosses **42**, piston skirt **50**, bottom wall **34**, and lower portions of the outer and inner walls **24**, **30**, with the friction weld joint **56** provided in the outer and inner walls **22**, **30**. The lower part **60** is preferably forged from steel. The upper part **60** includes the top wall **16**, the bowl **18**, and upper portions of the outer walls **22** and inner wall **30** which are joined across the joint **56** to the lower portions of the outer wall **22** and inner wall **30** to unite the structure.

[**0027**] **FIG. 4** illustrates the piston **10** described above installed in the diesel engine **12** for reciprocation within at least one associated cylinder **62** of the engine **12**. The piston **14** is illustrated in its bottom dead center position, which is the lowest point that the piston **10** travels in the cylinder **62**. It will be seen that the piston skirt **50** is contained within the cylinder **62**, such that the lower edge **52** of the skirt **50** does not extend below the lower edge **64** of the cylinder **62** in which it reciprocates.

[**0028**] Obviously, many modifications and variation of the present invention are possible in light of the above teachings. It is, therefore, to be understood that within the scope of the appended claims, the invention may be practiced otherwise than as specifically described. The invention is defined by the claims.

What is claimed is:

1. A piston for diesel engines, comprising:

a piston body fabricated of steel;

said piston body having an outer wall and a closed oil gallery;

a pair of pin bosses having pin bores formed therein, said pin bores having a common pin bore axis and a lowest tangency point;

a skirt formed as one piece with the pin bosses, said skirt coupled at an upper end to said outer wall; and

said piston skirt having a lower edge disposed below said pin bore axis and located at or above said lowest tangency point of said pin bores.

2. The piston of claim 1 wherein said piston body includes the following dimensional ratios:

(H/D)=0.5-0.75

(A/D)=0.3-0.6

(A/H)=0.7-1.2

where,

H=compression height of the piston body between a top of the piston and the axis of the pin bores,

D=piston diameter, and

A=axial length between the lowest ring groove and the lower edge of piston skirt.

3. The piston of claim 1 wherein said piston body is fabricated of at least two separate parts which are connected across at least one joint.

4. The piston of claim 3 wherein said at least one joint comprises a friction weld joint.

5. A piston for a diesel engine, comprising:

a piston body fabricated of steel;

a pair of pin bosses having aligned pin bores disposed about a pin bore axis and having a lowest tangent point of said pin bores;

a skirt formed as one piece with said pin bores and having a lower edge disposed below said pin bore axis and at or above said lowest tangent point of said pin bores.

6. A diesel engine comprising:

an engine block having at least one cylinder bore;

a monobloc piston disposed in said cylinder bore having a piston body fabricated of steel and having a pair of pin bosses with aligned pin bores disposed about a pin bore axis and having a lowest tangent point of said pin bores; and

a piston skirt formed as one piece with said pin bosses, said skirt having a lower edge disposed below said pin bore axis at or above said tangent point of said pin bores.

7. The diesel engine of claim 6 wherein said piston body includes the following dimensional ratios:

(H/D)=0.5-0.75

(A/D)=0.3-0.6

(A/H)=0.7-1.2

where,

H=compression height of the piston body between a top of the piston and the axis of the pin bores,

D=piston diameter, and

A=axial length between the lowest ring groove and the lower edge of the piston skirt.

8. The diesel engine of claim 6 wherein the cylinder has a lower edge and said lower edge of said piston skirt is disposed at or above said lower edge of said cylinder when said piston is at a lowest point of travel in said cylinder.

* * * * *