

# MANDRELS for KART ENGINES

## type CY48

Diameter mm 37,9-60,3 (1.49-2.37)



### Mandrels type CY48 with LONG stone (150 mm – 5.90”).

These lifetime mandrels are specifically designed to work cylinders with radial holes very large as kart cylinders. Stone support and guide-shoe are of proper length to produce straight, round and accurate holes.

The abrasive and guide shoes length make easier the cylinder kept and **consequently the use of this mandrel.**

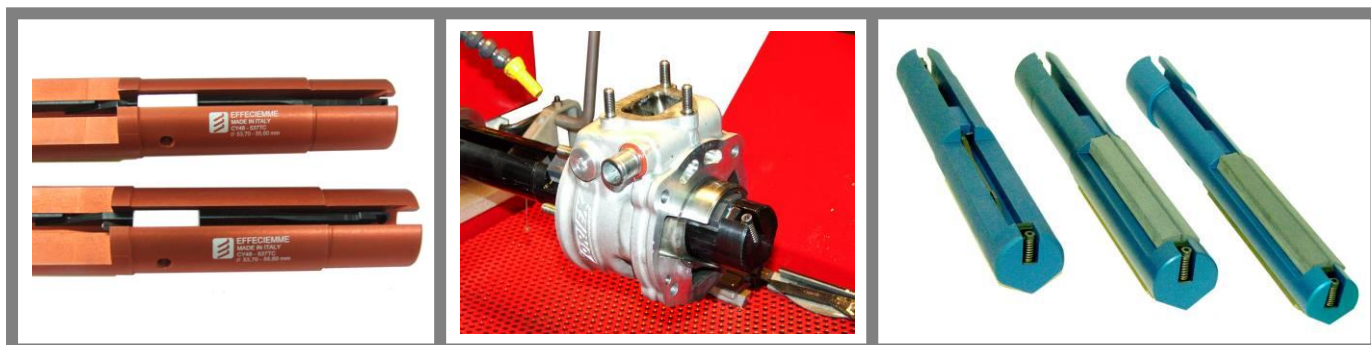
The best technical situation is to have a mandrel for each diameter to work. To find the mandrel that you need, be sure that the bore diameter of the cylinder to work in included between the size of the hone. The diameter for the mainly diffuse capacity are: - Ø 42 mm (1.653”) for 60cc - Ø 50 mm (1.968”) for 100cc - Ø 54 mm (2.125”) for 125cc - Ø 59 mm (2.322”) for 250cc.



SIZE - DIAMETER		HONE MANDREL	STONE LENGHT		DIAM. REF.		REF. CAPACITY
mm	inches		mm	in	mm	in	
37,90 – 39,70	1.49 – 1.56	CY48 – 379TB	100 (*)	3.93 (*)			
39,40 – 41,30	1.55 – 1.62	<b>CY48 – 394TB</b>			40	1.57	50cc
41,00 – 42,90	1.61 – 1.68	<b>CY48 – 410TB</b>			42	1.65	60cc
42,60 – 44,50	1.67 – 1.75	CY48 – 426TB					
44,20 – 46,00	1.74 – 1.81	CY48 – 442TB					
45,80 – 47,60	1.80 – 1.87	CY48 – 458TB					
47,40 – 49,20	1.86 – 1.93	<b>CY48 – 474TB</b>			150	5.90	47
48,90 – 50,80	1.92 – 2.00	<b>CY48 – 489TB</b>	50	1.96			100cc
50,60 – 52,40	1.99 – 2.06	<b>CY48 – 506TC</b>	52	2.04			100cc
52,10 – 54,00	2.05 – 2.12	CY48 – 522TC					
53,70 – 55,60	2.11 – 2.18	<b>CY48 – 537TC</b>	54	2.12			125cc
55,30 – 57,20	2.17 – 2.25	CY48 – 553 TC					
56,90 – 58,70	2.24 – 2.31	CY48 – 569 TC					
58,50 – 60,30	2.30 – 2.37	<b>CY48 – 585 TC</b>	59	2.32	250cc		

(\*) see page 2

### Photo Gallery:



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## ABRASIVES and DIAMOND STONES

### > Engines with cast iron cylinders of 60cc, 100cc and 125cc

All our hones for kart, use Sunnen abrasive supports that are proposed as ABRASIVE KITS. So, the **ABRASIVE KITS** included stone supports with **the same specifications used in production and on race by some ENGINE BUILDERS.**



Abrasive Kit for CY48  
Stone Length = 150 mm (5.90")

The kits are of two types with final suffix "F" or "L" and the mean:  
→ final suffix "F": means Finishing that is a silicon carbide abrasive for finishing with grit 400  
→ final suffix "L" means Lapping, that is an *special mixture abrasive for lapping* with grit 800

So, the abrasive kit composition is the following:  
1x abrasive support for Medium Finishing  
1x abrasive support for Finishing or Lapping

### > Engines with Nickel-Plated cylinders (*nikasil*®):

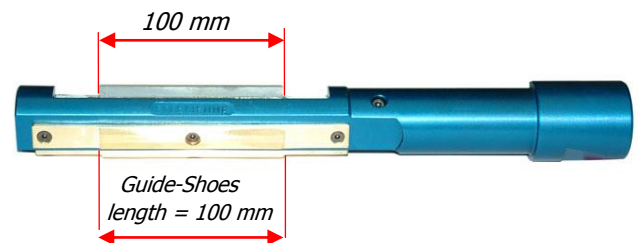
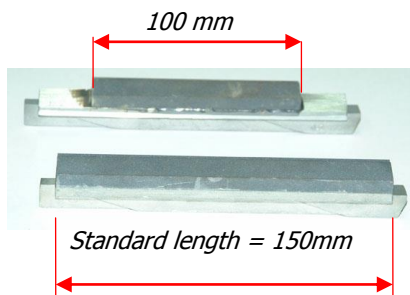


Because of the remarkable hardness obtained with nickel treatment, the working with above mentioned abrasives is not possible, so it is necessary to use the **Diamond Stones**. The DIAMOND stones supplied by us are built with **Resin Bond Diamond Strip** and are available usually in two specifics: **D267** (roughness) **D330** (finishing). Also the **DIAMOND STONE for NICKEL-PLATED cylinders are those usually used by some ENGINE BUILDERS.** The Diamond Stone is provided individually or included in a kit composed by two supports:

1x Stone support for Roughness (silicon carbide abrasive)  
1x diamond stone for finishing (**D330**) or roughness (**D267**).  
**Available diamond stone with different grit size.**

### > Length Modify for cast iron cylinders of 60cc

For short cylinders (as 60cc) is advisable to modify the abrasive and guide-shoes, shortening the length at 100 mm , 3.93" (see images below)



## ACCESSORIES

### > Truing Sleeves



Truing Sleeve

All our mandrels are delivered with the relatives Truing Sleeves in cast Iron, to obtain a perfect alignment between the stones and guides-shoes. More the alignment is accurate, easier will be the working to obtain the desired result.. The hole of the Truing Sleeve is that of Diameter of Reference of the capacity:

→ Ø 42 mm (1.65") for 60cc  
→ Ø 50 mm (1.96") for 100cc

→ Ø 54 mm (2.12") for 125cc  
→ Ø 59 mm (2.32") for 250cc

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DEALER

