

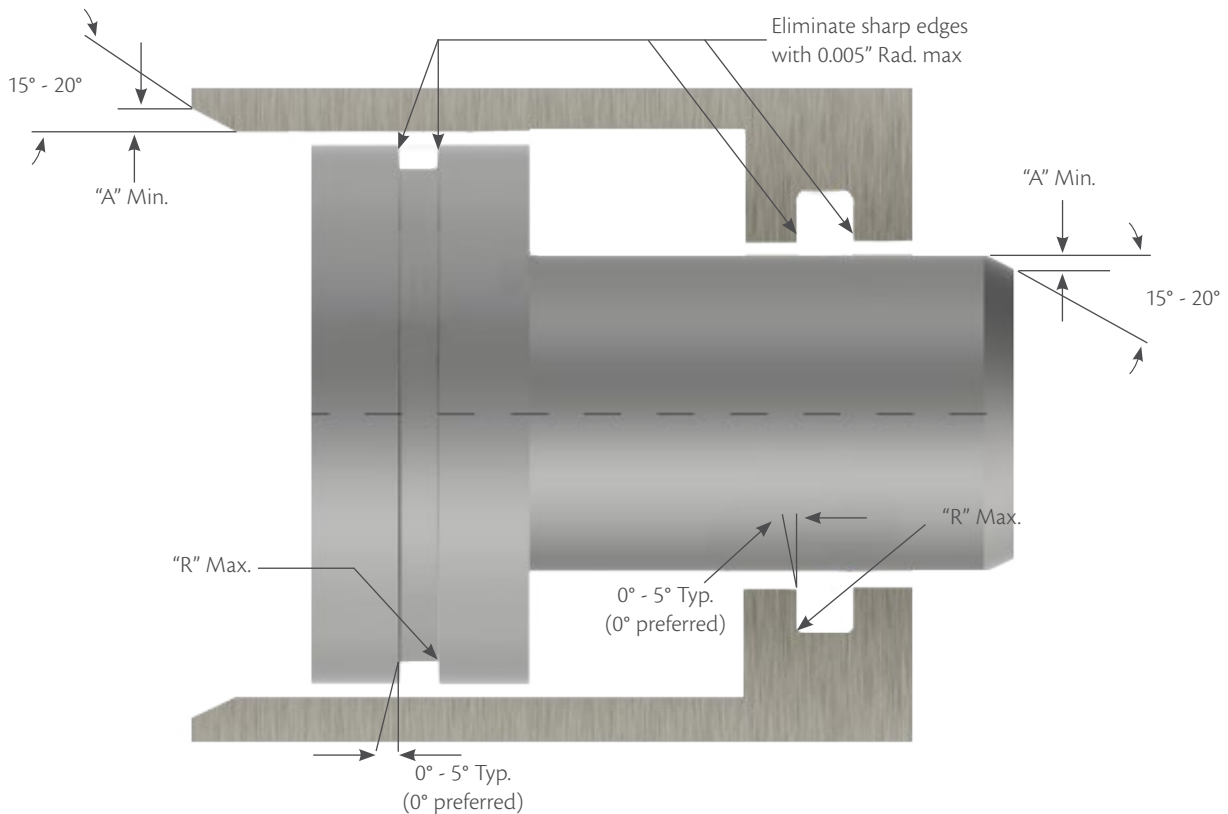
General Hardware Guidelines

Hi Tech Seals recommends adhering to the following tolerances, surface finishes, leading edge chamfers, and dimensions to allow ease of installation and prevent damage to the seal during assembly.

Installation Chamfer, Gland Radius, and Taper

Seal C/S	A Dimension	R Dimension
1/16	0.035	0.003
3/32	0.050	0.015
1/8	0.050	0.015
5/32	0.070	0.015
3/16	0.080	0.015
7/32	0.080	0.015
1/4	0.080	0.015
9/32	0.085	0.015
5/16	0.085	0.015
11/32	0.085	0.015
3/8	0.090	0.015
13/32	0.095	0.015
7/16	0.105	0.030
15/32	0.110	0.030
1/2	0.120	0.030
17/32	0.125	0.030

Seal C/S	A Dimension	R Dimension
9/16	0.130	0.030
19/32	0.135	0.040
5/8	0.145	0.040
21/32	0.150	0.040
11/16	0.160	0.040
23/32	0.165	0.040
3/4	0.170	0.040
25/32	0.180	0.060
13/16	0.185	0.060
27/32	0.190	0.060
7/8	0.200	0.080
29/32	0.205	0.080
15/16	0.215	0.080
32/32	0.220	0.080
1	0.225	0.080



General Hardware Guidelines

Surface Finish

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Application	Thermoplastic and Rubber Seals		PTFE Seals	
	Dynamic Surfaces	Static Surfaces	Dynamic Surfaces	Static Surfaces
Cryogenics	-	-	4 µin (0.1 µm) Maximum	8 µin (0.2 µm) Maximum
Helium Gas Hydrogen Gas Freon	3 to 10 µin (0.08 to 0.25 µm)	12 µin (0.3 µm) Maximum	6 µin (0.15 µm) Maximum	12 µin (0.3 µm) Maximum
Air Nitrogen Gas Argon Natural Gas Fuel (Aircraft and Automotive)	3 to 12 µin (0.08 to 0.3 µm)	16 µin (0.4 µm) Maximum	8 µin (0.2 µm) Maximum	16 µin (0.4 µm) Maximum
Water Hydraulic Oil Crude Oil Sealants	3 to 12 µin (0.08 to 0.3 µm)	32 µin (0.8 µm) Maximum	12 µin (0.3 µm) Maximum	32 µin (0.8 µm) Maximum