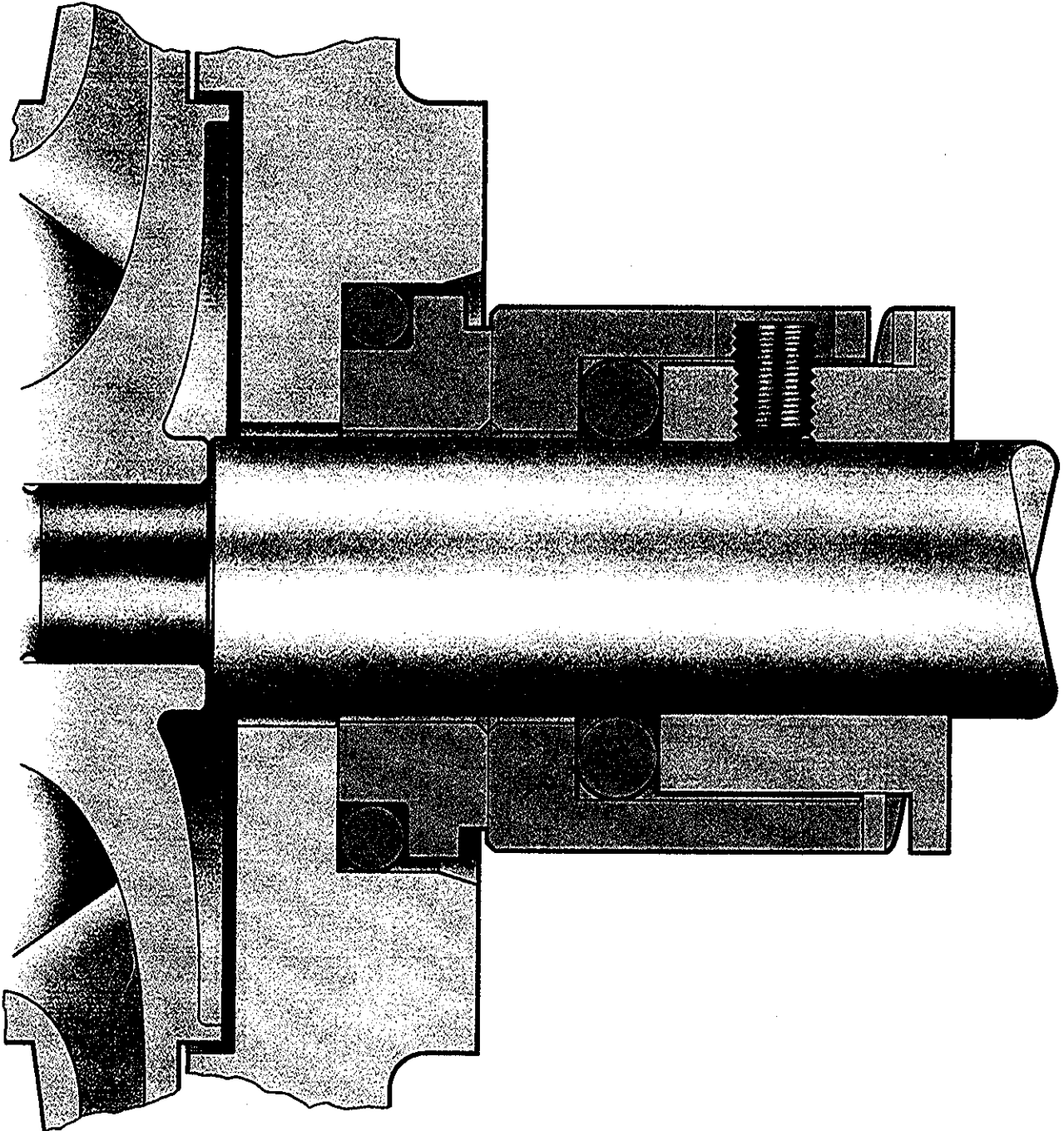
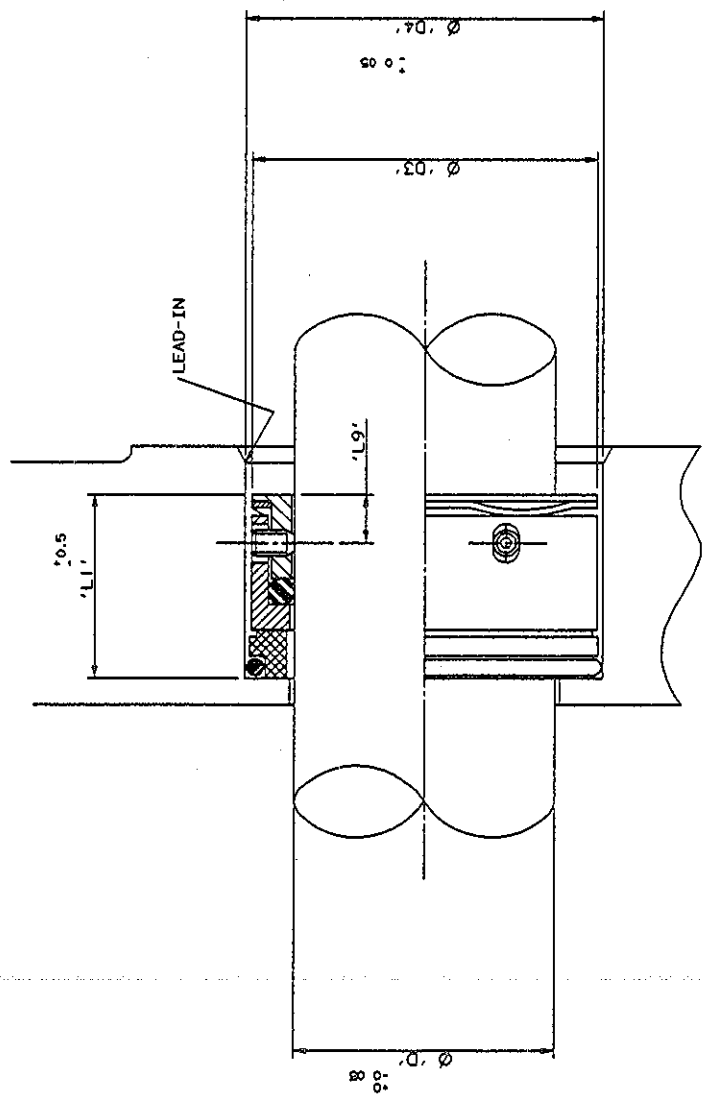


# TYPE 80



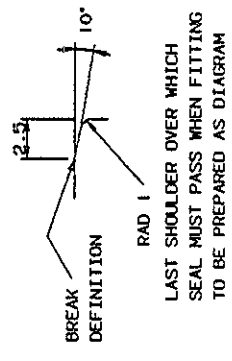
MODIFICATIONS:- ISSUE 'A' ORIGINAL ISS. 'J' REDRAWN. JM. 18.9.85 ISS. 'K', - SHAFT TOLERANCE WAS 0.05 MEMO P. MARTIN 30.1.86. REFERS. MKB. 10.3.86. ISS. 'L', - 63 - 100um INCLUSIVE SIZES REMOVED. MEMO P. RADJUSOKO 8.1.86. REFERS. MKB. 2.4.86. ISS. 'M' TOL ON 'LI' WAS 0.05 MEMO P. MARTIN 12.6.86. REFERS. JM. 26.6.86 ISS. 'N' 0168 SIZE ADDED. 11.4.88 ISS. 'P' COLUMN 'D' SIZE 5/8" WAS 16. SEAT SIZE WAS 0168. JM. 27.4.88



SEAL SIZE	SEAL CODE	D	D3	D4	LI	L9
5/8"	0158	15.87	27	28.57		
16 MM	0160	16	27	28.57	26.4	
3/4"	0190	19.05	30.3	31.75		
24 MM	0240	24	34.2	35.45		
28 MM	0280	28	40	42		
1 1/8"	0285	28.57	40	41.27	26.7	
30 MM	0300	30	40.7	42.7		7.7
1 1/4"	0317	31.75	42.5	44.45		
32 MM	0320	32	42.5	44.45		
36 MM	0360	36	46.6	47.62		
38 MM	0380	38	52	53.97		
1 3/4"	0444	44.45	58.3	60.32	29.2	
1 7/8"	0476	47.62	61.5	63.5		
50 MM	0500	50	62	63.96		
2"	0508	50.8	64.7	66.67		
1 1/8"	0539	53.97	71	73.02		
54 MM	0540	54	71	73.95	31.7	8.2
54.6MM	0546	54.6	72.6	75		
55 MM	0550	55	73	75		

REWORKED DOCUMENT

DRAWING OFFICE  
29 JUL 1983



1. REMOVE ALL SHARP EDGES ON SHAFT BEFORE FITTING SEAL.
2. SURFACE OF SHAFT ON WHICH THE SEAL IS INSTALLED MUST BE MACHINED TO 0.4 - 0.6 um Ra FINISH OR BETTER & THEN HIGHLY POLISHED.
3. LUBRICATE SHAFT & SEAL 'O' RING TO ASSIST FITTING SEAL.
4. LUBRICATE SEAL 'O' RING, SEAT & HOUSING TO ASSIST FITTING SEAL.
5. SHAFT MUST BE OF CORROSIVE RESISTANT MATERIAL WITH A HARDNESS OF 125 BRINELL MINIMUM & MACHINED TO DIMENSIONS & TOLERANCES STATED.
6. BEFORE COMPLETING SEAL INSTALLATION WIPE LAPPED SURFACE OF SEAL AND FACE PERFECTLY CLEAN
7. END OF SEAL CHAMBER & AXIS OF SHAFT MUST BE AT 90° TO EACH OTHER WITHIN 0.125 F.I.M.

DRAWING No	ISSUE	DATE	CHK'D	APP'D
S/32095 <td>P <td>18.9.85 <td>R.B.F. <td>D.J.B. </td></td></td></td>	P <td>18.9.85 <td>R.B.F. <td>D.J.B. </td></td></td>	18.9.85 <td>R.B.F. <td>D.J.B. </td></td>	R.B.F. <td>D.J.B. </td>	D.J.B.

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TITLE:-  
INSTALLATION OF TYPE 80 SEAL WITH 'DF' SEAT  
STAINLESS STEEL VERSUS CARBON

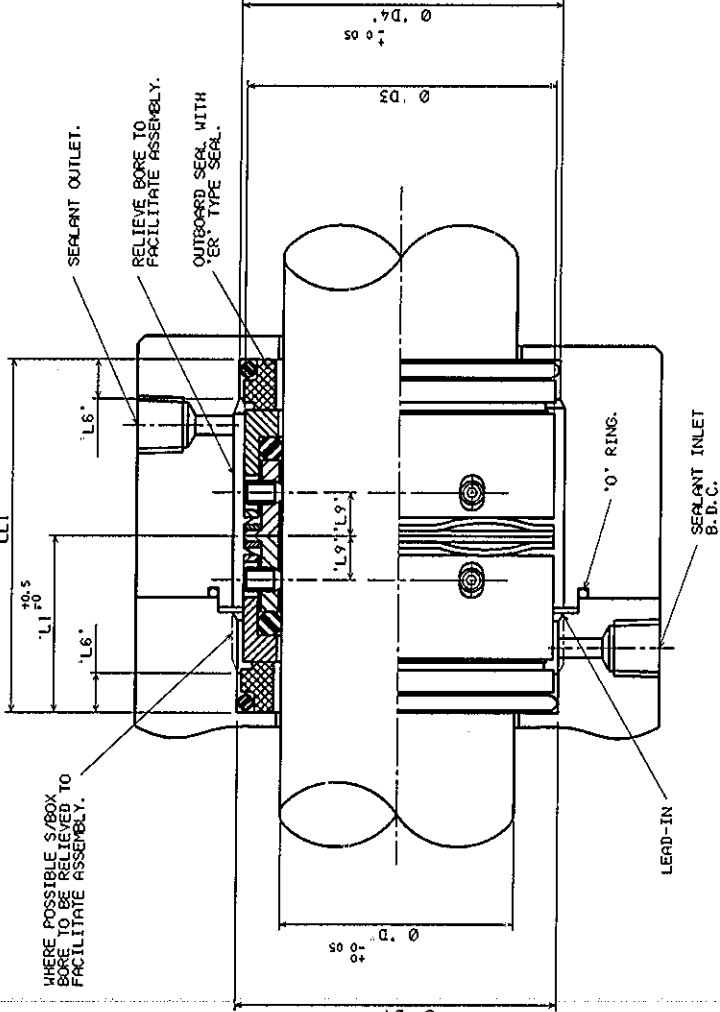
John Crane UK Ltd  
International Sealing Systems



CROSSBOW HOUSE  
40 LIVERPOOL ROAD  
SLOUGH  
RG2 4JH AND  
40X

COMPONENT CODE :-

WHERE POSSIBLE S/BOX BORE TO BE RELIEVED TO FACILITATE ASSEMBLY.



SEAL SIZE	SIZE CODE	D	D3	D4	L1	LL1	L6	L9
63 MM	0630	63	79.3	83				
2 1/2"	0635	63.5	85	88.9				
2 3/4"	0698	69.85	89	95.25	38	76.5		
2 7/8"	0730	73.03	94.8	98.43			7	10
75 MM	0750	75	96.8	100.43				
3"	0762	76.2	97	101.6				
80 MM	0800	80	99.6	104	40	80.5		
95 MM	0950	95	119	125				
100 MM	1000	100	124	130				

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3. LUBRICATE SHAFT & SEAL 'O' RINGS TO ASSIST FITTING SEALS.
4. LUBRICATE SEAT 'O' RINGS. SEAT & HOUSING TO ASSIST FITTING SEALS.
5. SHAFT MUST BE OF CORROSIVE RESISTANT MATERIAL WITH A HARDNESS OF 125 BRINELL MINIMUM & MACHINED TO DIMENSIONS & TOLERANCES STATED.
6. BEFORE COMPLETING SEAL INSTALLATION WIPE LAPPED SURFACE OF SEATS AND FACES PERFECTLY CLEAN.
7. END OF SEAL CHAMBER & AXIS OF SHAFT MUST BE AT 90° TO EACH OTHER WITHIN 0.125 F. I. M.

