SURFACE ROUGHNESS		Ra	Rmax
Sliding Surface	ØD	≤0.2 μm	≤2.0 μm
Groove Base	Ød	≤1.6 μm	≤6.3 μm
Groove Flanks	B	≤3.2 μm	≤16 μm

Note: It is recommended to have 50% to 90% of the working surface material contact area value.

INSTALLATION
We recommend using special assembly tool (See section; Hydraulic Sealing Elements General Installation Information). It is very important that the assembly tools must be of soft material and have no sharp edges. Before installation the sealing element must be oiled with system oil.

NOTES
For special applications that require high temperatures or resistance to chemicals, piston seal can be manufactured with special mixture PTFE and FKM. The permissible sealing gap values of K752 piston seal for rotating application is given in the below table.

K752 is a two piece double-acting sealing set which consists of one special mixture PTFE profile ring and an o-ring as energizing element.

PRODUCT ADVANTAGES
• Can be used at high pressures and low peripheral speeds
• Low friction, free of stick-slip
• Simple groove design and low axial housing heights
• Long service life
• High sliding speed
• Wide range of temperature and chemicals depending on the o-ring material
• Minimum static and dynamic friction coefficient for a minimum energy loss and operating temperature

APPLICATION
Mobile hydraulics, grippers and rotary joints.

PERMISSIBLE SEALING GAP			
B (mm)	**Smax (mm)**		
	100 bar	200 bar	300 bar
2.2	0.15	0.10	0.075
3.2	0.20	0.15	0.10
4.2	0.20	0.15	0.10
6.3	0.30	0.20	0.15
8.1	0.30	0.20	0.15

Note: The largest sealing gap value occurring on the non-pressurized side of the seal is vital for the function of the seal and in this respect it is quite important to use the S value lower than the above indicated numbers.

MATERIAL		CODE
NBR	70 SHORE A	NB7001
PTFE		PT6003

OPERATING CONDITIONS			
MEDIA	Mineral oils (DIN 51524)	HFA and HFB	HFC
TEMPERATURE	-30°C +105°C	+5°C +60°C	-30°C +60°C
PRESSURE	≤300 Bar	≤300 Bar	≤300 Bar
PERIPHERAL SPEED	≤5.0 m/sec	≤5.0 m/sec	≤5.0 m/sec

Note: The above data are maximum values and cannot be used at the same time.