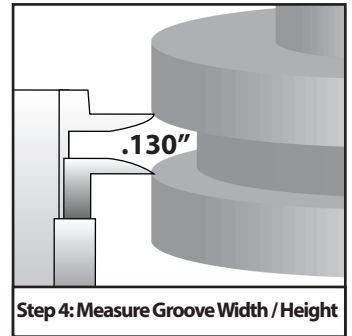
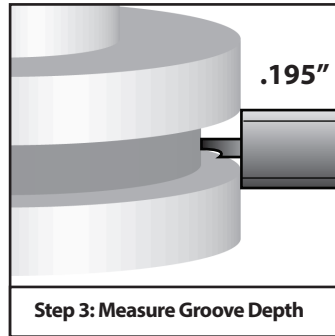
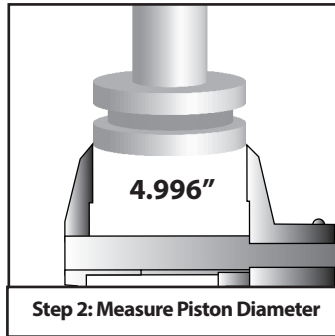
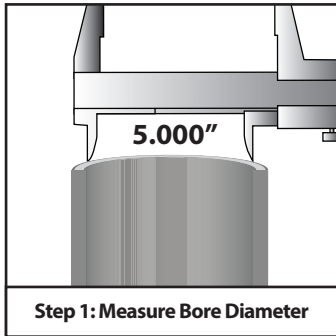


Proper Piston Seal Groove Measurement

Example Part # : AS800E-80P for 5.00" Bore



Calculate:

Diametrical Clearance = .004"

$$\text{Bore Diameter (5.00") - Piston Diameter (4.996")}$$

$$5.00" - 4.996" = .004"$$

Radial Gap = .002"

$$\text{Divide Diametrical Clearance (.004") by 2}$$

$$.004" / 2 = .002"$$

Gland Depth = .197"

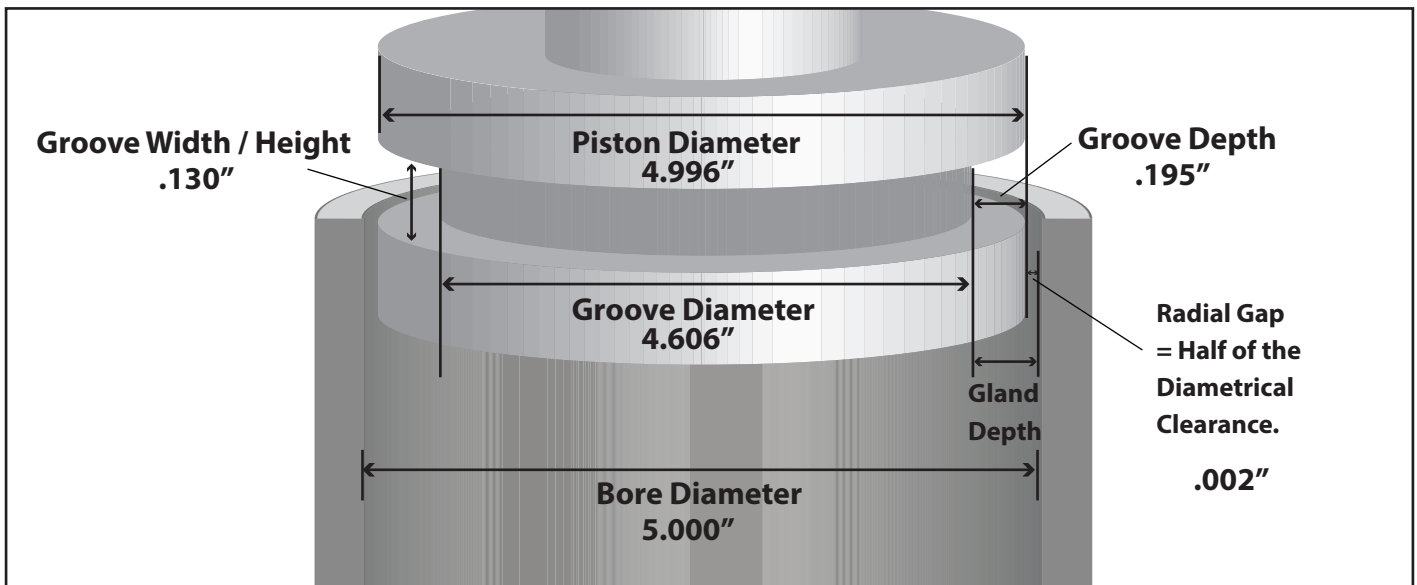
$$\text{Radial Gap (.002") + Groove Depth (.195")}$$

$$.002" + .195" = .197"$$

Groove Diameter = 4.606"

$$\text{Piston Diameter (4.996") - Groove Depth x 2 (.195" x 2 = .390")}$$

$$4.996" - .390" = 4.606"$$



Measuring Tips

- **Multipiece Piston Seal**
Groove Width / Height will be larger than actual seal. Can range from 2-13%.
- **U-Cup Piston Seals**
Groove Width / Height should be at least 10% larger than seal.
- **Failure to account for the radial gap between piston and bore will lead to reduced seal performance.**

