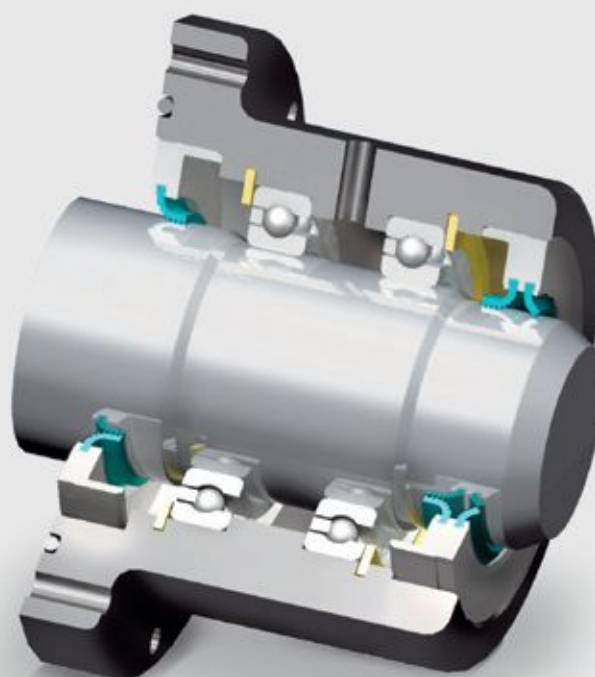


# Turcon® Varilip® PDR





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Trelleborg Sealing Solutions is a major international sealing force, uniquely placed to offer dedicated design and development from our market-leading product and material portfolio: a one-stop-shop providing the best in elastomer, thermoplastic, PTFE and composite technologies for applications in aerospace, industrial and automotive industries.

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ISO 9001:2000

ISO/TS 16949:2002

The information in this brochure is intended to be for general reference purposes only and is not intended to be a specific recommendation for any individual application. The application limits for pressure, temperature, speed and media given are maximum values determined in laboratory conditions. In application, due to the interaction of operating parameters, maximum values may not be achieved. It is vital therefore, that customers satisfy themselves as to the suitability of product and material for each of their individual applications. Any reliance on information is therefore at the user's own risk. In no event will Trelleborg Sealing Solutions be liable for any loss, damage, claim or expense directly or indirectly arising or resulting from the use of any information provided in this brochure. While every effort is made to ensure the accuracy of information contained herewith, Trelleborg Sealing Solutions cannot warrant the accuracy or completeness of information.

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## ■ Introduction

Turcon® Varilip® PDR rotary shaft seals extend the boundaries imposed by elastomer radial shaft seals, utilizing advanced materials and design techniques to provide optimum sealing performance for each application. The outcome is a superior sealing solution, which retains a compact seal envelope.

Standard elastomeric rotary shaft seals have a limited application range with respect to temperature, surface speed, media compatibility, pressure or a combination of these due to the inherent limitations of the various elastomer grades. Furthermore they only have a limited suitability for applications with inadequate lubrication.

Turcon® Varilip® PDR rotary shaft seals are characterized in particular by the low friction and their stick-slip-free running, reducing the temperature generation and permitting higher peripheral speeds.

Turcon® has the characteristic of inherent memory, whereby a distorted Turcon® component will attempt to recover to the profile it had during the sintering cycle of its manufacturing process. This feature is used to provide the necessary radial loading of the sealing lip onto the shaft, negating the requirement for the energizing spring present in elastomeric seal designs.

## ■ Description

Turcon® Varilip® PDR seals are constructed from only two parts – a precision manufactured metal body and a mechanically retained Turcon® sealing element. Unlike seals with pressed metal cases, a gasket is not required to provide sealing between the lip and casing. This is provided by the mechanical retention of the lip, improving both the chemical resistance and temperature range of the sealing system.

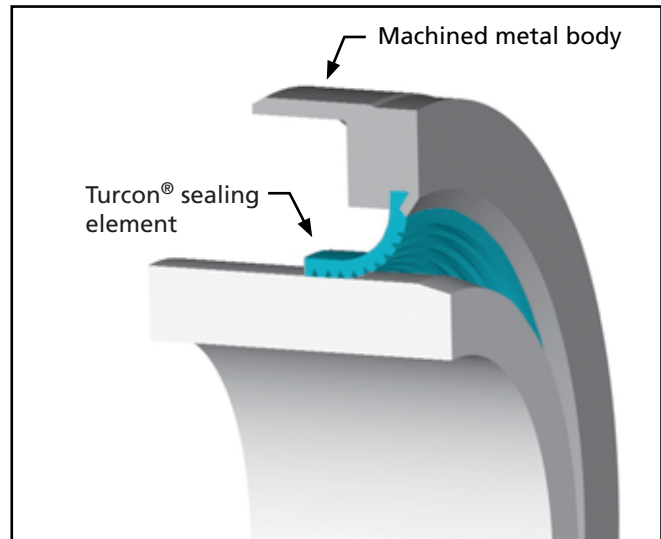


Figure 1: Turcon® Varilip® PDR seal

Where required, the Turcon® Varilip® PDR seal is available with a hydrodynamic feature on the Turcon® sealing lip. This provides a positive displacement of the fluid as a result of the shaft rotation to give improved sealing in applications where the shaft only rotates in a single direction. The feature also increases the flexibility of the lip, which allows a wider contact band between the Turcon® lip and the shaft and helps to reduce shaft load and associated wear temperature.

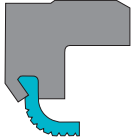
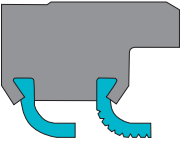
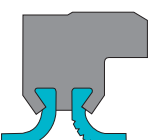
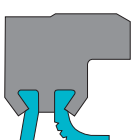
The mechanical retention of the Turcon® provides a robust product which also eliminates the sometimes environmentally hazardous process of bonding the Turcon® to a metal or elastomer substrate.



## ■ Turcon® Varilip® PDR Product Range

Turcon® Varilip® PDR seals are produced as one of five basic design styles, detailed in Table I below.

Table I: Seal configurations

| Seal                                                                                                     | Description                                                                                                                                                                                                                                                                                                                                                                       |
|----------------------------------------------------------------------------------------------------------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|
| <p>Type A/Type 1</p>    | <p>Type A - is a single lip seal suitable for use in standard industrial applications up to a pressure of 0.5 MPa (73 psi) where an elastomer radial shaft seal would be unable to withstand the temperature, friction, medium or poor lubrication. Allows sealing at surface speeds up to 90 m/s (17,721 ft/min) with sufficient cooling and lubrication of the sealing lip.</p> |
| <p>Type B/Type 3</p>    | <p>Type B - is the preferred choice for applications in which high seal integrity is demanded or where contaminated media are to be sealed. This type offers a back-up sealing lip to provide secondary sealing. Pressure limit is 0.5 MPa (73 psi).</p>                                                                                                                          |
| <p>Type C/Type 4</p>   | <p>Type C - can be used for applications involving higher pressures for which a simple elastomer radial shaft seal can no longer be considered. Due to reinforcement of the sealing lip, pressures up to 1 MPa (145 psi) are possible, e.g. as pump, shaft or rotor seals.</p>                                                                                                    |
| <p>Type D/Type 5</p>  | <p>Type D - can be subjected to pressure from both sides. Pressure differential of up to 0.5 MPa (73 psi) is permissible. The separation of two different media using a single seal is possible.</p>                                                                                                                                                                              |
| <p>Type G/Type 6</p>  | <p>Type G is similar to Type D but has a non-contacting environmental sealing element rather than a full lay-down lip. This provides effective sealing against the ingress of dust and dirt into the system while also ensuring torque and resulting power consumption are kept to a minimum.</p>                                                                                 |



## Turcon® Varilip® PDR – Special designs

Apart from the standard range, Turcon® Varilip® PDR seals are available as special designs to satisfy the demands of specific applications and can accommodate non-standard housing and shaft sizes. Figures 2 to 5 show some of the special designs available.

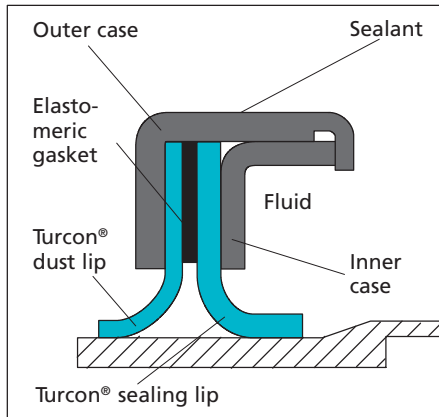


Figure 2: Clamped design

Suited to high volume applications with excessive housing tolerance

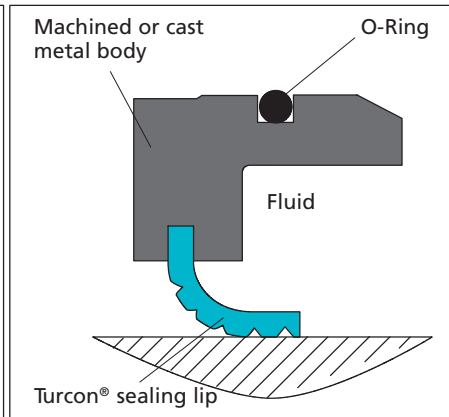


Figure 3: O-Ring design

For low interference fits in the housing

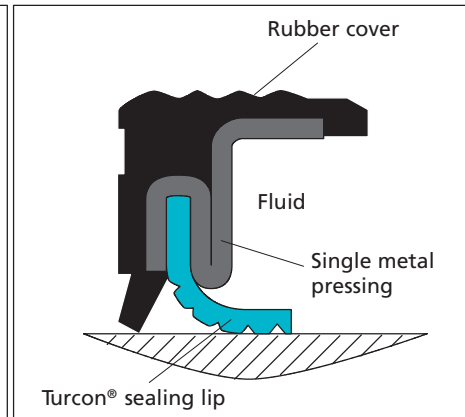


Figure 4: Single shell design

Rubber cover for poor housing surface finish at low press-in loads.

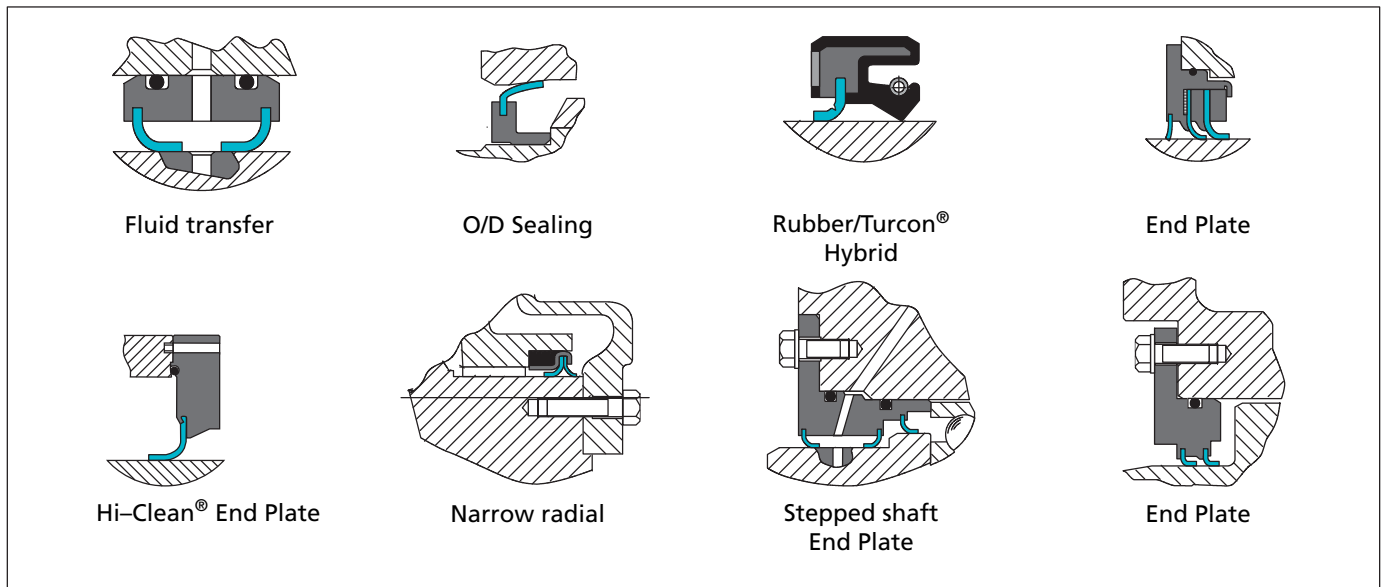


Figure 5: Variants



## ■ Materials

### Sealing lip

An important factor for the proper function of rotary shaft seals is the material used for the sealing lip. For this reason, Trelleborg Sealing Solutions has developed a range of specially modified materials on the basis of the proven Turcon® materials. Particular importance is attached to the optimization of friction and wear properties, while providing excellent sealing performance, even at high peripheral speeds.

Table II gives the materials available for use in Turcon® Varilip® PDR seals. Additional compounds have been developed for specific applications and these are available on request.

Table II Sealing Element Materials

| Material,<br>Applications,<br>Properties                                                                                                                                                                                                                                             | Code | Operating temp. |             | Mating<br>surface<br>hardness                                          | MPa/psi<br>max.   |
|--------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|------|-----------------|-------------|------------------------------------------------------------------------|-------------------|
|                                                                                                                                                                                                                                                                                      |      | °C              | °F          |                                                                        |                   |
| <b>Turcon® T25</b><br>Standard material with exceptional wear and friction characteristics.<br>For lubricated running, e.g. oil, grease<br>Glass fiber, lubricant<br>Color: Gray                                                                                                     | T25  | -60 to +200     | -76 to +392 | Min. 55 HRc<br>At low pressure and up to 4 m/s (788 fpm)<br>min.45 HRc | 2 MPa<br>290 psi  |
| <b>Turcon® T40</b><br>For all lubricating and non-lubricating fluids, especially water.<br>Used for medium hard shafts in applications where there is risk of shaft wear.<br>Carbon fiber<br>Color: Gray                                                                             | T40  | -60 to +200     | -76 to +392 | Min. 30 HRc                                                            | 2 MPa<br>290 psi  |
| <b>Turcon® T78</b><br>Particularly good running behavior permits use with dry running or poor lubrication and in conjunction with soft shaft surfaces, e.g. Stainless Steel shafts in food, pharmaceutical and chemical industries.<br>Aromatic polymer.<br>Color: Tan or dark brown | T78  | -60 to +200     | -76 to +392 | Min. 170 HB                                                            | 0.2 MPa<br>29 psi |
| <b>Turcon® M83</b><br>Specially designed for dry-running applications. Particularly good results in applications for the semicon industry. Can also be used lubricated.<br>Glass fiber, pigment<br>Color: Yellow                                                                     | M83  | -60 to +200     | -76 to +392 | Min. 55 HRc                                                            | 2 MPa<br>290 psi  |

Other Turcon® materials are available by using the relevant material code when ordering.  
FDA compliant materials available on request.

### Metal body

Turcon® Varilip® PDR seals are available with a preferred material choice of Stainless Steel 304L. Other materials such as Stainless Steel 316L and Zinc-Plated Mild Steel are available within the standard range. Table III shows the codes for these materials. Other specialized materials are available on request. It should be noted that any material other than Stainless Steel 304L will result in extended lead-time due to stocking and / or additional process issues.

Table III Metal Body Materials

| Code | Material                 |
|------|--------------------------|
| 1    | Stainless Steel 304      |
| 2    | Stainless Steel 316      |
| 3    | Unavailable              |
| 4    | Mild Steel (Zinc Plated) |
| 5    | Aluminium                |

Highlighted materials are preferred.



## ■ Technical Data

### Speed

The graph in Figure 6 shows the superior surface speed capability of Turcon® Varilip® PDR compared to elastomeric shaft seals.

The operating speed directly impacts the temperature generated by the seal and is an important factor when considering the requirements for the sealing system.

The actual limiting speed will depend on the temperature, pressure, media, lubrication properties, heat dissipation and the shaft condition.

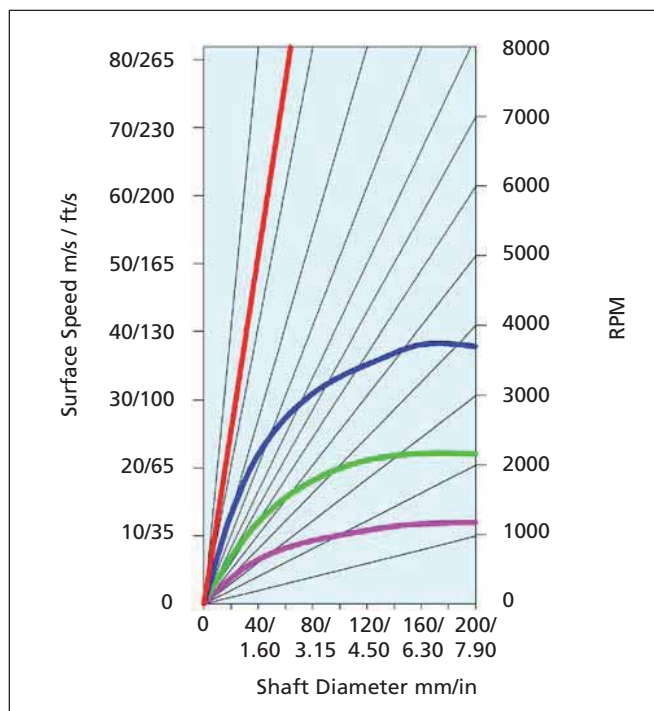


Figure 6: Surface speed as a function of shaft diameter and RPM

Table IV: Surface Speed

| General recommended maximum surface speed |  |         |               |
|-------------------------------------------|--|---------|---------------|
| Turcon® Varilip® PDR                      |  | 100 m/s | 19,680 ft/min |
| Fluoroelastomer                           |  | 38 m/s  | 7,500 ft/min  |
| Silicone                                  |  | 38 m/s  | 7,500 ft/min  |
| Polyacrylic                               |  | 22 m/s  | 4,320 ft/min  |
| Nitrile                                   |  | 12 m/s  | 2,340 ft/min  |

Speed capability depends on application conditions

### Temperature

All Turcon® Varilip® PDR seals are capable of outstanding high and low temperature performance compared to elastomeric materials.

Unlike other PTFE lip seals the Turcon® Varilip® PDR seal is not limited in its temperature performance by the presence of an elastomer gasket. This gives it excellent temperature range capability.

The temperatures in Figure 7 are general working limits of the seal material, and in all cases the effective limit for a rotary shaft seal application would be much lower.

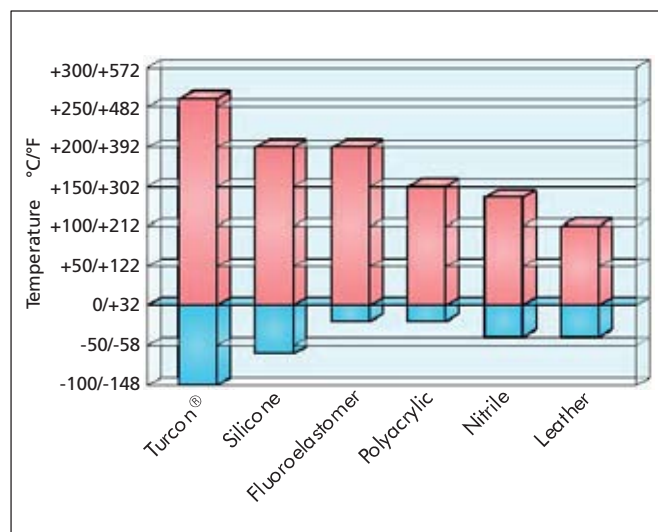


Figure 7: Maximum and minimum temperatures for different materials

Table V: Temperature

| General recommended minimum / maximum temperature |                 |                |
|---------------------------------------------------|-----------------|----------------|
| Filled PTFE                                       | -100 to +260° C | -148 to +500°F |
| Fluoroelastomer                                   | -20 to +200° C  | -4 to +392° F  |
| Silicone                                          | -60 to +200° C  | -76 to +392°F  |
| Polyacrylic                                       | -20 to +150° C  | -4 to +300°F   |
| Nitrile                                           | -40 to +135° C  | -40 to +275°F  |
| Leather                                           | -40 to +100° C  | -40 to +212°F  |



## Pressure

Turcon® Varilip® PDR Types A, B, D and G are suitable for pressures up to 0.5 Mpa (73 psi). Turcon® Varilip® PDR Type C provides a double sealing lip design for pressures up to 1 Mpa (145 psi).

Pressure heavily influences the contact force between the Turcon® lip and the shaft and consequently the heat generation. This must be taken into consideration when selecting the appropriate seal type.

Turcon® Varilip® PDR seals can remain leak tight when exposed to pressurization during static shaft conditions.

## Fluid resistance

Turcon® consists of fully substituted carbon-carbon chains and the resulting carbon-fluorine bonds are among the strongest known in organic chemistry. The outstanding physical and chemical properties of Turcon® can be attributed to these strong bonds.

Turcon® Varilip® PDR seals are resistant to mineral acids, bases, common organic fluids and solvents. They are also unaffected by oxidation, ultraviolet radiation or ozone, making them ideally suited for use in the chemical industry and applications requiring exposure to the atmosphere.

A particular benefit of Turcon® Varilip® PDR seals is a resistance to oil additives and biofuels, which have an adverse effect on many elastomers. Using Turcon® shaft seals allows the increased use of additives and a longer oil service life.

Many Turcon® materials have been successfully tested in 20 percent Fluorine gas at temperatures in excess of 250°C (482°F).

## Lubrication starvation

Turcon® Varilip® PDR shaft seals have the capability to run without lubrication for longer periods of time compared with elastomer shaft seals without adversely affecting their ultimate life. This not only allows them to be used in applications where the lubrication may be intermittent as a result of start up or other operating factors, but also allows their use as effective dirt, dust and powder seals.

**Note:** Higher speeds and pressure capabilities can be achieved through the use of custom designs. Please consult your local Trelleborg Sealing Solutions sales office.



## Power consumption

One of the key features of Turcon® Varilip® PDR is its low friction, resulting in very low power consumption.

Figure 8 shows the running torque for a 40mm (1.73 in) shaft diameter Turcon® Varilip® PDR seal.

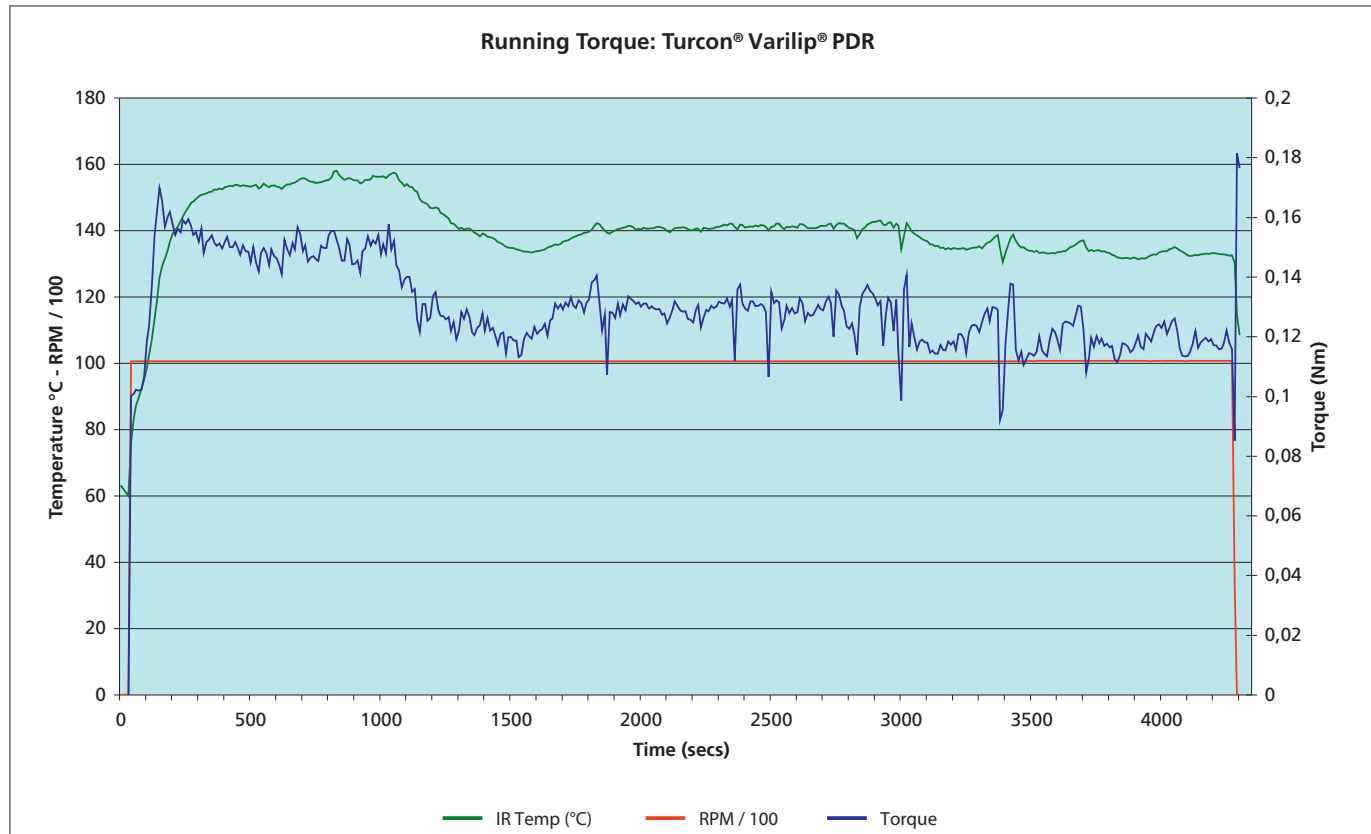


Figure 8: Running torque for Turcon® Varilip® PDR seal

Reduced torque can be achieved through custom designs but may reduce leak tightness.

**Note:** Results may vary according to application and conditions.



## Endurance



Turcon® Varilip® PDR rotary shaft seals can provide extended service life compared with elastomer shaft seals. As with any seal, however, the life of a Turcon® Varilip® PDR seal depends on the specific operating parameters.

PTFE is an inherently stable material and does not suffer from aging or degradation as with elastomers.

## Eccentricity

The graph in Figure 9 shows the maximum recommended operating envelope for silicone, nitrile, polyacrylic and fluoroelastomer seals. Turcon® Varilip® PDR seals have a specific lip design to minimize the risk of leakage and increased wear rates. Therefore the levels of eccentricity should be kept within the limits shown. In order to achieve a uniform radial load of the sealing lip on the shaft, the best possible coaxiality, or static offset should be maintained between the housing bore and the shaft, as shown in Figure 10.

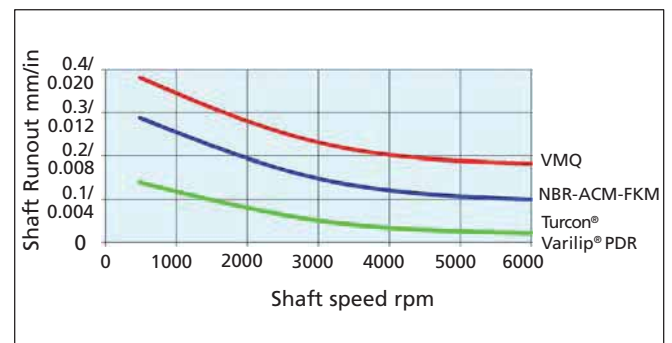


Figure 9: Dynamic eccentricity capability

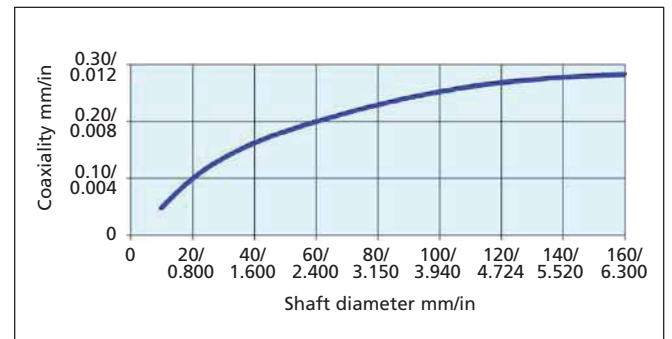


Figure 10: Coaxial tolerance capability



## Leakage expectation

The hydrodynamic feature available on Turcon® Varilip® PDR helps to ensure improved leak tightness compared to other PTFE lip seals. Note that seals with hydrodynamic features must be used only in one direction.

The following graphs (Figures 11 and 12) show the results obtained from 200 hour tests. These tests compared the leakage performance of the Turcon® Varilip® PDR seal against two competitors' PTFE lip seals. The results obtained are shown below.

Figure 11 details the leakage rate measured at regular intervals throughout the test. Figure 12 plots a cumulative graph to indicate total leakage. It can be noted that the Turcon® Varilip® PDR outperforms the two competitor seals with regard to leakage performance.

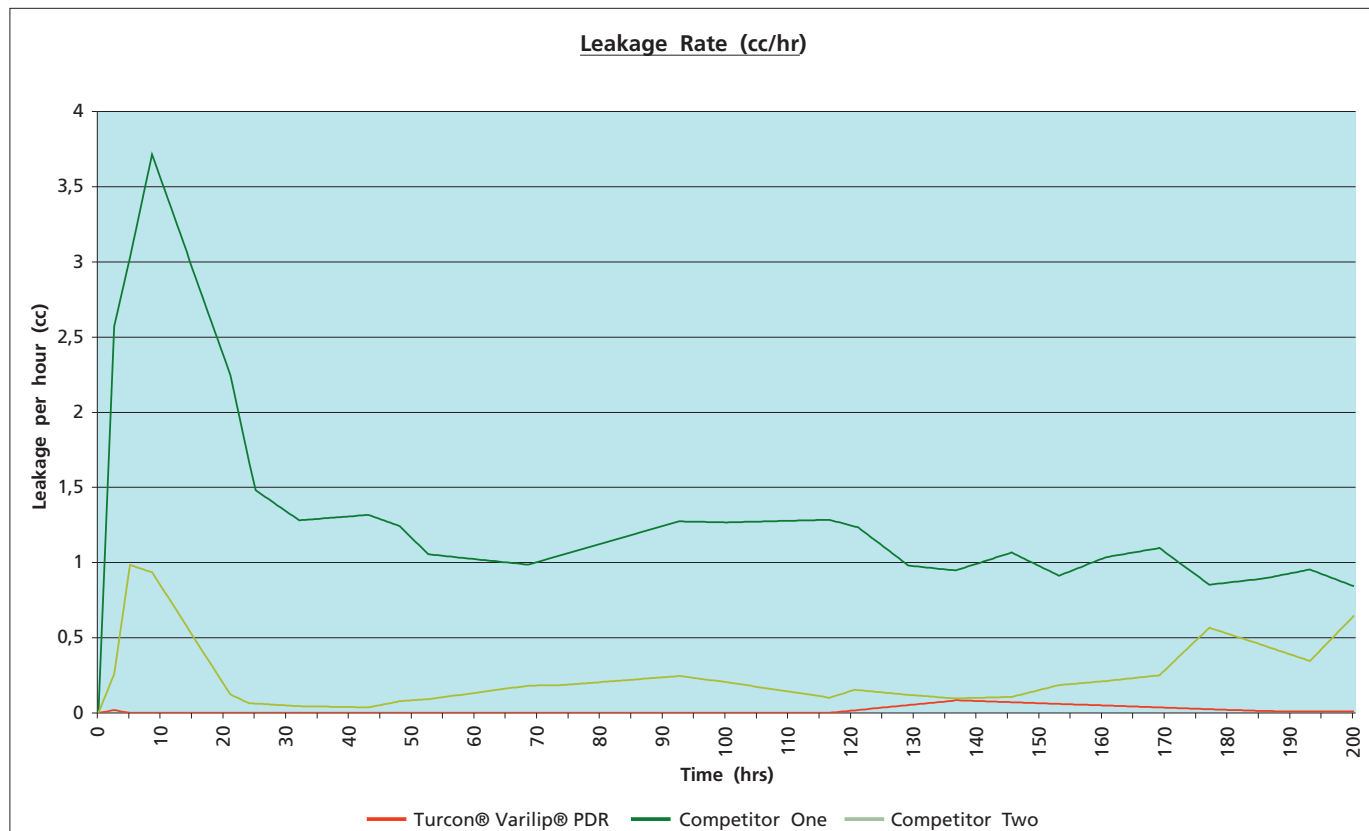


Figure 11: Leakage rate per hour monitored over 200 hour tests (average results)

Turcon® Varilip® PDR seals sometimes need a short bedding-in period before optimal sealing is provided depending on shaft topography. Once the run band is established, wear rates slow to provide good seal life.

**Note:** Results may vary according to application and conditions.

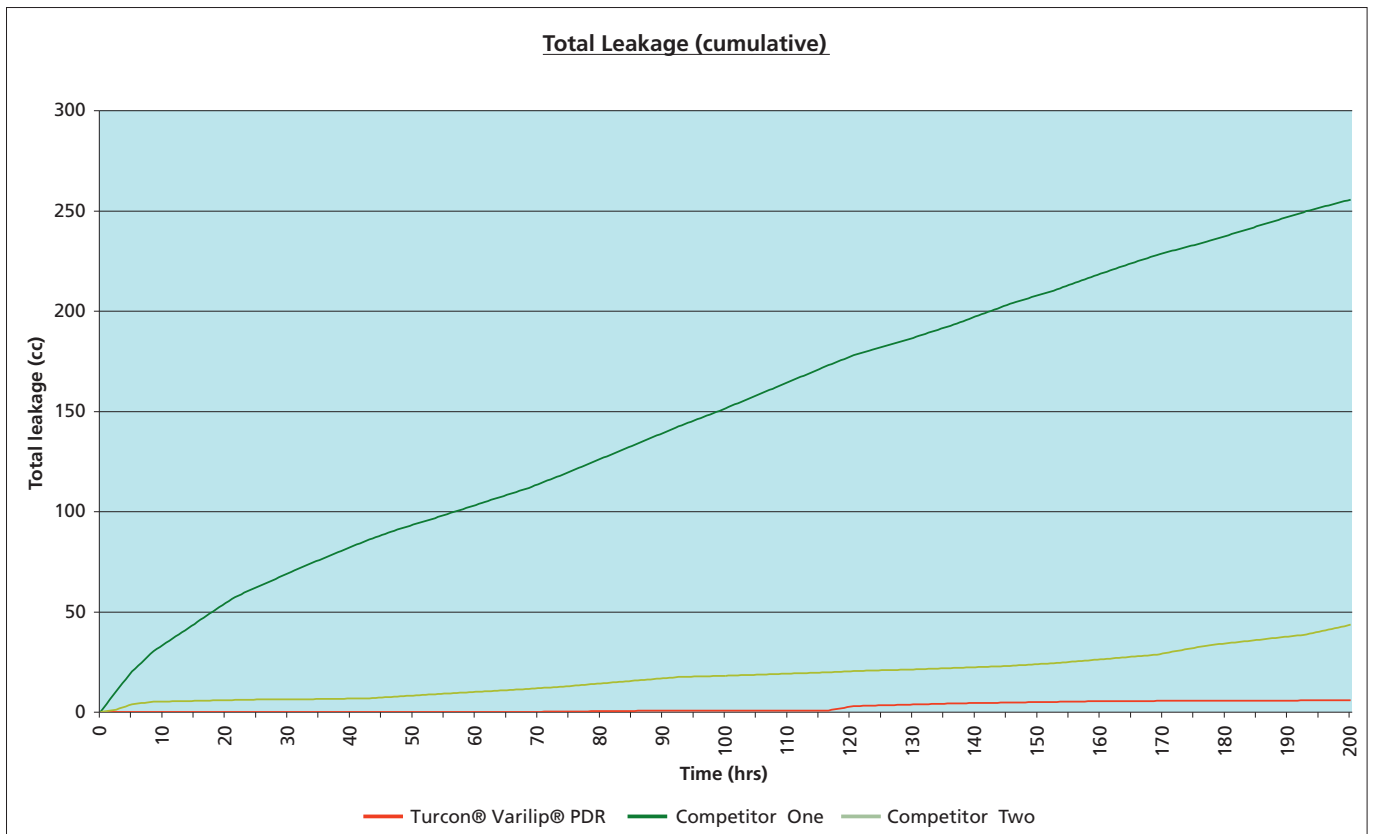


Figure 12: Total leakage (cumulative) monitored over 200 hour tests (average results)

**Note:** Results may vary according to application and conditions.



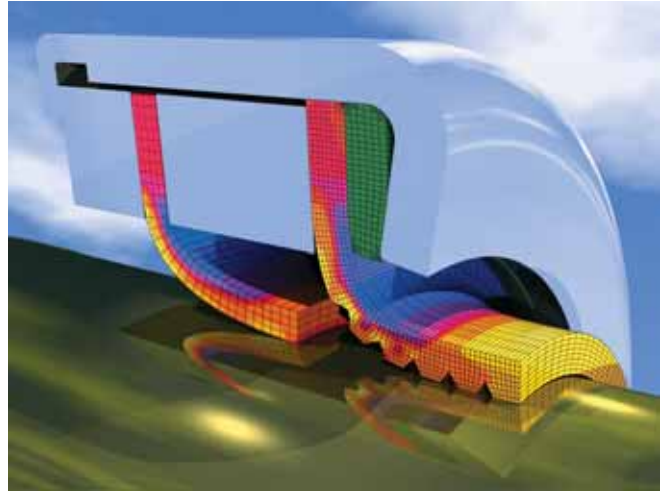
### Heat generation considerations

All Turcon® Varilip® PDR seals are designed to contact the shaft surface during operation. The contact force between the sealing lip and the shaft will depend on the seal design used and the application details, but in all cases a temperature increase due to the presence of the seal can be expected. Where this increase is likely to be significant, consideration should be given to methods of reducing the level of generated heat. This can be achieved through increases in localized cooling, improved lubrication and efficient heat transfer and dissipation mechanisms.

### Shaft wear

Turcon® Varilip® PDR seals are designed to contact the shaft surface during operation and a seal contact band will be evident in the majority of applications. With correct seal specification and operating conditions, shaft wear should be limited to a light polishing, but factors such as over pressure, contamination, eccentricity or insufficient shaft hardness can result in more significant wear.

As part of the system design, consideration should be given to the level of shaft wear permissible within a set operating period, and therefore the benefits of measures intended to reduce the rate of wear, such as shaft coatings, can be analyzed in relation to their additional cost.





## ■ Design Guidelines

### Housing

Turcon® Varilip® PDR seals are designed to meet global standards, including ISO 6194/1 and ISO 16589. (See tables X and XI).

Turcon® Varilip® PDR seals require an interference fit with the housing bore to provide both adequate sealing of this interface and to ensure that the seal remains in place when subjected to pressure, axial movement and induced torsion produced by the relative rotary motion of shaft to housing bore. The bore should be machined with an H8 diametric tolerance as reproduced in table VI below. System design should also ensure that Turcon® Varilip® PDR seals are not pushed into bores that may have been previously scored by the assembly of another component, (such as a bearing), selecting a larger seal outer diameter if necessary.

For Turcon® Varilip® PDR seals the bore should have a surface finish of 0.8µm (32 µin) Ra maximum. In cases where the housing bore is split resulting in an axial joint crossing the seal outer diameter, and in cases where meeting these surface finish requirements is not possible, it is recommended that a proprietary sealant or adhesive is used.

Alternatively a custom solution can be prepared employing a rubber covering or O-Ring for OD sealing.

Table VI: Housing Installation Data Table

| Bore diameter |        |     |        | Tolerance |                        |
|---------------|--------|-----|--------|-----------|------------------------|
| Over          |        | To  |        | H8 [mm]   | x10 <sup>-3</sup> [in] |
| mm            | in     | mm  | in     |           |                        |
| 10            | 0.394  | 18  | 0.787  | +.027 -0  | 0.0011                 |
| 18            | 0.787  | 30  | 1.181  | +.033 -0  | 0.0013                 |
| 30            | 1.181  | 50  | 1.969  | +.039 -0  | 0.0015                 |
| 50            | 1.969  | 80  | 3.150  | +.046 -0  | 0.0018                 |
| 80            | 3.150  | 120 | 4.724  | +.054 -0  | 0.0021                 |
| 120           | 4.724  | 180 | 7.087  | +.063 -0  | 0.0025                 |
| 180           | 7.087  | 250 | 9.843  | +.072 -0  | 0.0028                 |
| 250           | 9.843  | 315 | 12.402 | +.081 -0  | 0.0032                 |
| 315           | 12.402 | 400 | 15.748 | +.089 -0  | 0.0035                 |

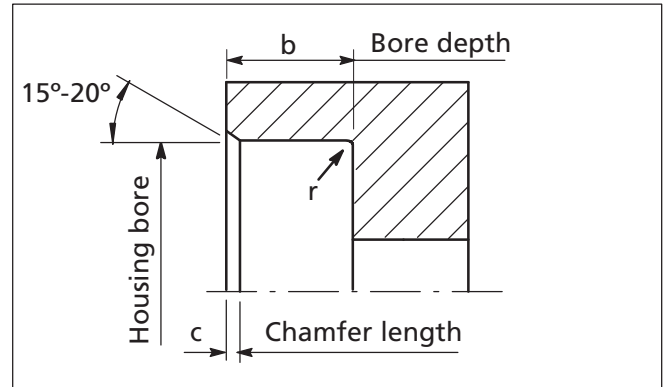


Figure 13: Housing design schematic

Table VII: Housing Design Data

| Seal width           | Up to 10 [mm]<br>/0.394 in            | Over 10 [mm]<br>/0.394 in             |
|----------------------|---------------------------------------|---------------------------------------|
| Min. bore depth (b)  | b + 0.5 (0.0197 in )                  | b + 1.0 (0.0394 in )                  |
| Chamfer length (c)   | 0.70 to 1.00<br>(0.028 in to 0.04 in) | 1.20 to 1.50<br>(0.047 in to 0.06 in) |
| Max. corner rad. (r) | 0.40 (0.0157 in)                      | 0.40 (0.0157 in)                      |

### Shaft

This should be machined to an h11 tolerance or better, reproduced in Table VIII. The surface finish should be prepared by plunge grinding to avoid any machining leads that may act with the shaft rotation to facilitate leakage.

The recommended surface finish for Turcon® Varilip® PDR seals is 0.2 to 0.4 µm (8-16 µin) Ra.



Table VIII: Shaft Installation Data

| Shaft diameter [mm] |        |     |        | Tolerance |             |
|---------------------|--------|-----|--------|-----------|-------------|
| Over                |        | To  |        | h11 [mm]  | h11[in]     |
| mm                  | in     | mm  | in     |           |             |
| 6                   | 0.236  | 10  | 0.394  | +0 -0.090 | +0 - 0.0035 |
| 10                  | 0.394  | 18  | 0.787  | +0 -0.110 | +0 - 0.0043 |
| 18                  | 0.787  | 30  | 1.181  | +0 -0.130 | +0 - 0.0051 |
| 30                  | 1.181  | 50  | 1.969  | +0 -0.160 | +0 - 0.0063 |
| 50                  | 1.969  | 80  | 3.15   | +0 -0.190 | +0 - 0.0075 |
| 80                  | 3.15   | 120 | 4.724  | +0 -0.220 | +0 - 0.0087 |
| 120                 | 4.724  | 180 | 7.087  | +0 -0.250 | +0 - 0.0098 |
| 180                 | 7.087  | 250 | 9.843  | +0 -0.290 | +0 - 0.0114 |
| 250                 | 9.843  | 315 | 12.402 | +0 -0.320 | +0 - 0.0126 |
| 315                 | 12.402 | 400 | 15.748 | +0 -0.360 | +0 - 0.0142 |

A shaft hardness in excess of 55 HRC is generally recommended for Turcon® Varilip® PDR, although lower values are permissible depending on the pressure, speed and sealing lip material used (refer to materials section).

Titanium shafts should be avoided unless nitrided. Shafts with good chrome, nickel or zinc plating, properly finished, are acceptable. Certain ceramic coatings can also be used, although some grades have been proven to result in an aggressive wear of the sealing lip due to their open structure. In certain applications it may not be possible to provide a shaft with the necessary hardness, surface finish and corrosion resistance. Fitting a wear sleeve onto the shaft can solve this problem by providing the local hardness and surface requirement without affecting the main shaft. If wear should occur, only the sleeve need then be replaced. The surface finish of the sleeve should be as outlined above and consideration should be given to adequate heat dissipation and effective sealing of the interface between the wear sleeve and the shaft.





## ■ Installation Requirements

When installing Turcon® Varilip® PDR seals, careful handling is important in order to avoid damaging the sealing lip. If the seal is installed from the back, radii or lead-in chamfers must be machined on the end of the shaft. This must also be free from burrs, sharp corners or rough machining marks, as shown in Figure 14.

When installing the seal with the lip against the shaft end, a lead-in chamfer is required whose smallest diameter is smaller than the unstressed diameter of the sealing lip as shown Figure 15. Table IX shows guide values for this.

It is recommended that as shallow an angle as practical be adopted within the range given.

Table IX: Shaft lead-in chamfer (ref. figures 14-16)

| d1 [mm]   | d1 [in]  | d1-d2 [mm] | d1-d2[in] |
|-----------|----------|------------|-----------|
| < 10      | 0.4      | 1.5        | 0.06      |
| 10 – 20   | -0.4-0.8 | 2.0        | 0.08      |
| 20 – 30   | 0.8-1.2  | 2.5        | 0.10      |
| 30 – 40   | 1.2-1.6  | 3.0        | 0.12      |
| 40 – 50   | 1.6-2.0  | 3.5        | 0.14      |
| 50 – 70   | 2.0-2.8  | 4.0        | 0.16      |
| 70 – 95   | 2.8-3.7  | 4.5        | 0.18      |
| 95 – 130  | 3.7-5.1  | 5.5        | 0.22      |
| 130 – 240 | 5.1-9.4  | 7.0        | 0.28      |
| 240 – 300 | 9.4-11.8 | 11.0       | 0.43      |

Preferable is the use of an installation cone, as shown in Figure 16, where the seal can be fitted onto the cone before being located on the shaft to ensure correct orientation of the sealing lip.

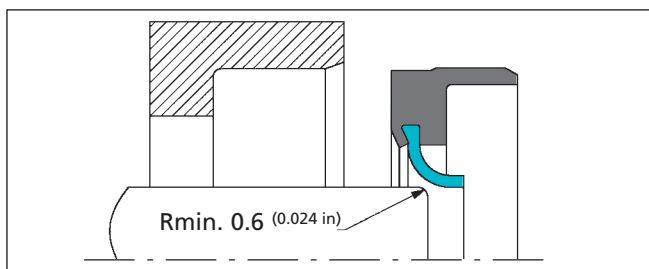


Figure 14: Installation of the sealing lip with the back to the shaft for pressurized application

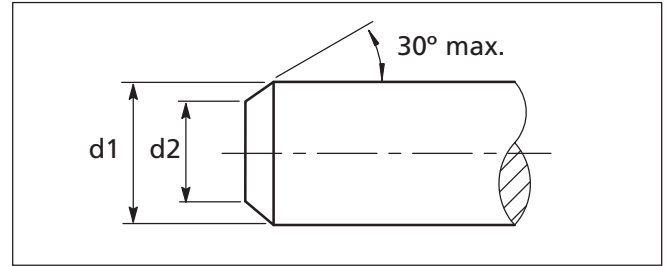


Figure 15: Shaft lead-in chamfer

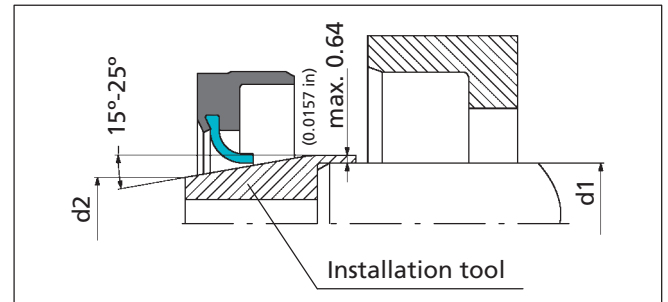


Figure 16: Fitting the sealing lip using an installation tool

Fitting should be performed in a swift movement to limit the time that the lip is formed above shaft size, therefore reducing lip recovery needed.

## ■ Packaging

Single and low quantities of Turcon® Varilip® PDR seals will be supplied in a blister pack with an individual transport mandrel. This mandrel will pre-form the element to above its free diameter, but below the intended shaft diameter. This assists in ease of installation, while also ensuring the element is not over-formed or damaged in transit.

Larger quantities of Turcon® Varilip® PDR seals will be supplied in a tube-and-end cap configuration.

## ■ Storage

Turcon® Varilip® PDR seals do not require any special storage conditions, unlike elastomer seals which must be kept away from sunlight and elevated temperatures to avoid rubber degradations.

Turcon® Varilip® PDR seals are not subject to shelf life.



## ■ Fitting Instructions

Investigation of premature failures has shown that a significant proportion are a result of inappropriate installation techniques. However, by observing the following guidelines, such failures can be avoided:

- Assembly sleeves and fitting tools should be regularly checked for signs of damage.
- When supplied on mandrels the seals should not be removed from the mandrel until immediately prior to fitting. Seals supplied on cardboard mandrels should be removed in the direction such that the spiral paper overlay of the mandrel is not lifted.
- Turcon® Varilip® PDR seals should be assembled on the shaft in a non-lubricated (dry) condition to avoid contamination of the hydrodynamic feature (if present).
- Care should be taken not to damage the outer diameter surface of the seal.
- Seals should be pressed squarely into the housing with the pressing-in force applied as close as possible to the outside diameter of the seal.
- If the seal contains a hydrodynamic feature on the sealing lip, ensure that it is correctly oriented in relation to the shaft's direction of rotation.
- Normal practice is to install the seal with the lip facing the medium to be sealed (the seal is reversed only when it becomes more important to exclude a medium than to retain it).
- Proprietary sealants or adhesives may be used for improved sealing of the outer diameter in critical applications or for seal retention purposes.

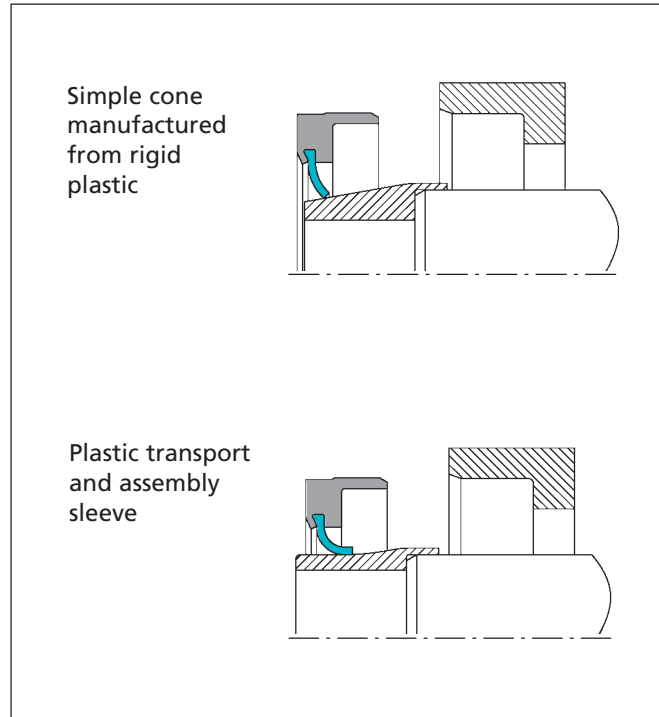


Figure 17: Assembly techniques

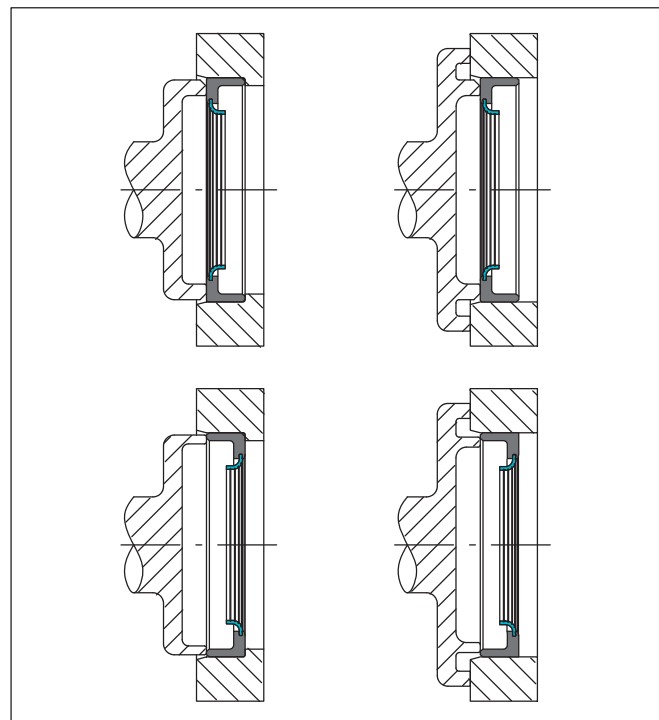


Figure 18: Assembly techniques



## ■ Installation Recommendations

The following diagrams show installation recommendations in respect to seal retention under pressure conditions.

### Post installation recommendations:

If painting, be sure to mask the seal. Avoid getting paint on the lip or the shaft where the lip rides. Also, mask any vents or drain holes so they will not become clogged. Be sure to remove masks before operating unit.

If paint is to be baked, or the mechanism is otherwise subjected to heat, seals should not be heated to temperatures higher than their materials can tolerate.

In cleaning or testing, do not subject seals to any fluids or pressures other than those for which the seals have been specified.

Extraction features such as tapped holes, internal threads or simple grooves can be included in custom PDR designs.

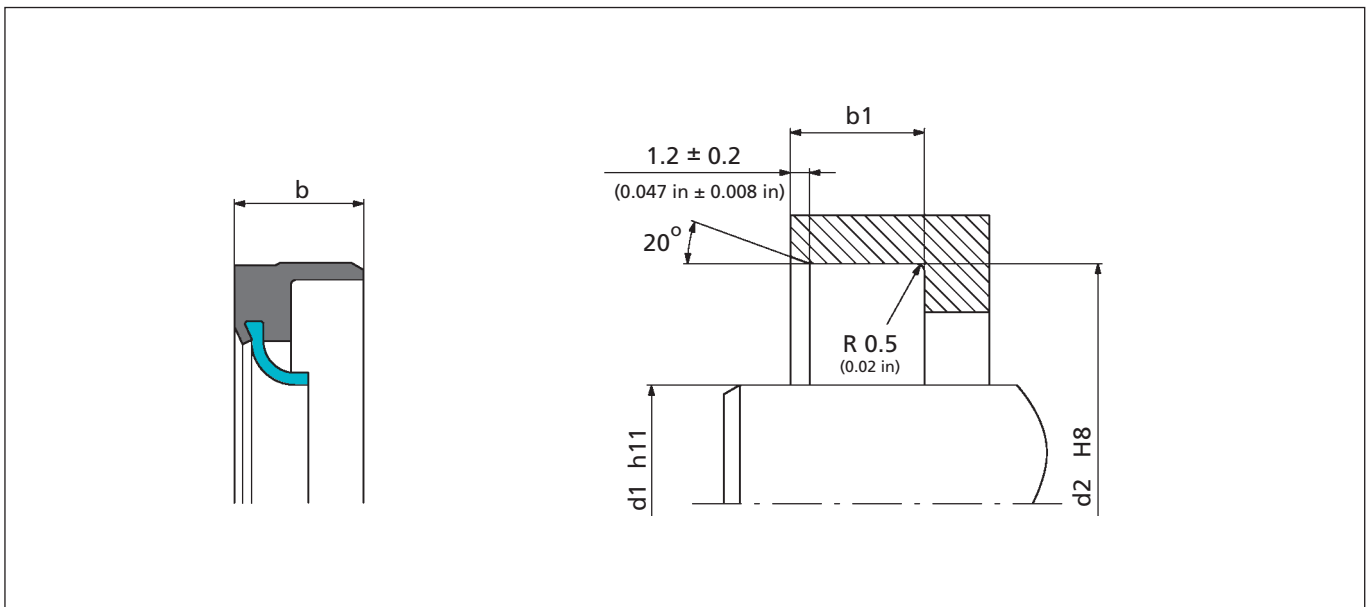


Figure 19: Installation drawing for pressure up to 0.5 MPa (73 psi)

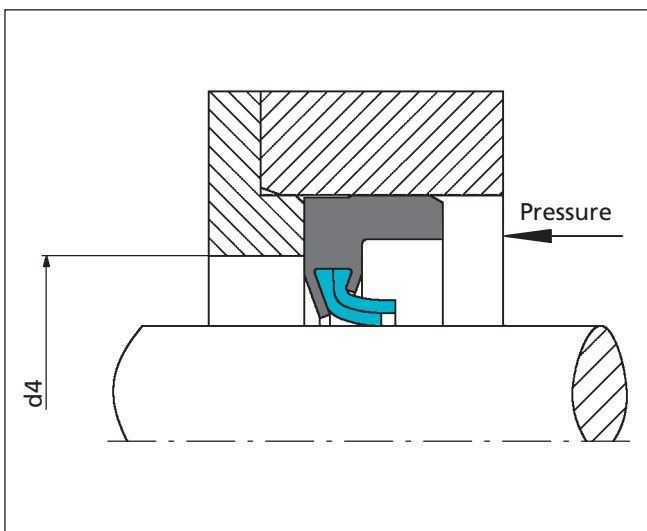


Figure 20: Installation for pressure from 0.5 MPa (73 psi) up to 1 MPa (145 psi)

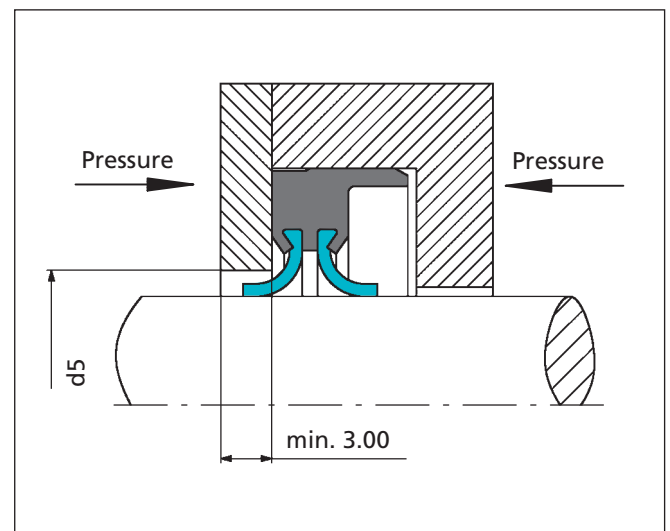


Figure 21: Installation type for fluid separation at pressures up to 0.5 MPa (145 psi)



## Turcon® Varilip® PDR Size Ranges

Table X: Turcon® Varilip® PDR Metric Size Range

| d1 [mm]   | Sizes     |                    | b [mm]<br>TJB | TSS Part No.     | b1 min<br>[mm]    | d4 max<br>[mm] | d5 min<br>[mm] |
|-----------|-----------|--------------------|---------------|------------------|-------------------|----------------|----------------|
|           | d2 [mm]   | b [mm]<br>exc. TJB |               |                  |                   |                |                |
| 6         | 16        | 7                  | 10            | TJ_1_0060        | 7.3 / 10.3        | 10             | 9.6            |
| 6         | 22        | 7                  | 10            | TJ_2_0060        | 7.3 / 10.3        | 10             | 9.6            |
| 7         | 22        | 7                  | 10            | TJ_1_0070        | 7.3 / 10.3        | 11             | 10.6           |
| 8         | 22        | 7                  | 10            | TJ_1_0080        | 7.3 / 10.3        | 12             | 11.6           |
| 8         | 24        | 7                  | 10            | TJ_2_0080        | 7.3 / 10.3        | 12             | 11.6           |
| 9         | 22        | 7                  | 10            | TJ_1_0090        | 7.3 / 10.3        | 13             | 12.6           |
| 9         | 24        | 7                  | 10            | TJ_2_0090        | 7.3 / 10.3        | 13             | 12.6           |
| 9         | 26        | 7                  | 10            | TJ_3_0090        | 7.3 / 10.3        | 13             | 12.6           |
| 10        | 22        | 7                  | 10            | TJ_1_0100        | 7.3 / 10.3        | 14             | 13.6           |
| 10        | 24        | 7                  | 10            | TJ_2_0100        | 7.3 / 10.3        | 14             | 13.6           |
| <b>10</b> | <b>25</b> | <b>7</b>           | <b>10</b>     | <b>TJ_3_0100</b> | <b>7.3 / 10.3</b> | <b>14</b>      | <b>13.6</b>    |
| 10        | 26        | 7                  | 10            | TJ_4_0100        | 7.3 / 10.3        | 14             | 13.6           |
| 11        | 22        | 7                  | 10            | TJ_1_0110        | 7.3 / 10.3        | 15             | 14.6           |
| 11        | 26        | 7                  | 10            | TJ_2_0110        | 7.3 / 10.3        | 15             | 14.6           |
| 12        | 22        | 7                  | 10            | TJ_1_0120        | 7.3 / 10.3        | 16             | 15.6           |
| 12        | 24        | 7                  | 10            | TJ_2_0120        | 7.3 / 10.3        | 16             | 15.6           |
| <b>12</b> | <b>25</b> | <b>7</b>           | <b>10</b>     | <b>TJ_3_0120</b> | <b>7.3 / 10.3</b> | <b>16</b>      | <b>15.6</b>    |
| 12        | 28        | 7                  | 10            | TJ_4_0120        | 7.3 / 10.3        | 16             | 15.6           |
| 12        | 30        | 7                  | 10            | TJ_5_0120        | 7.3 / 10.3        | 16             | 15.6           |
| 14        | 24        | 7                  | 10            | TJ_1_0140        | 7.3 / 10.3        | 18             | 17.6           |
| 14        | 28        | 7                  | 10            | TJ_2_0140        | 7.3 / 10.3        | 18             | 17.6           |
| 14        | 30        | 7                  | 10            | TJ_3_0140        | 7.3 / 10.3        | 18             | 17.6           |
| 14        | 35        | 7                  | 10            | TJ_4_0140        | 7.3 / 10.3        | 18             | 17.6           |
| 15        | 26        | 7                  | 10            | TJ_1_0150        | 7.3 / 10.3        | 19             | 18.6           |
| <b>15</b> | <b>30</b> | <b>7</b>           | <b>10</b>     | <b>TJ_2_0150</b> | <b>7.3 / 10.3</b> | <b>19</b>      | <b>18.6</b>    |
| 15        | 32        | 7                  | 10            | TJ_3_0150        | 7.3 / 10.3        | 19             | 18.6           |
| 15        | 35        | 7                  | 10            | TJ_4_0150        | 7.3 / 10.3        | 19             | 18.6           |
| 16        | 28        | 7                  | 10            | TJ_1_0160        | 7.3 / 10.3        | 20             | 19.6           |
| 16        | 30        | 7                  | 10            | TJ_2_0160        | 7.3 / 10.3        | 20             | 19.6           |
| 16        | 32        | 7                  | 10            | TJ_3_0160        | 7.3 / 10.3        | 20             | 19.6           |
| 16        | 35        | 7                  | 10            | TJ_4_0160        | 7.3 / 10.3        | 20             | 19.6           |

Sealing lips may, in some cases, protrude beyond the edge of the seal body.

Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



| d1 [mm]   | Sizes     |                    | b [mm]<br>TJB | TSS Part No.     | b1 min<br>[mm]    | d4 max<br>[mm] | d5 min<br>[mm] |
|-----------|-----------|--------------------|---------------|------------------|-------------------|----------------|----------------|
|           | d2 [mm]   | b [mm]<br>exc. TJB |               |                  |                   |                |                |
| 17        | 28        | 7                  | 10            | TJ_1_0170        | 7.3 / 10.3        | 21             | 20.6           |
| 17        | 30        | 7                  | 10            | TJ_2_0170        | 7.3 / 10.3        | 21             | 20.6           |
| 17        | 32        | 7                  | 10            | TJ_3_0170        | 7.3 / 10.3        | 21             | 20.6           |
| 17        | 35        | 7                  | 10            | TJ_4_0170        | 7.3 / 10.3        | 21             | 20.6           |
| 17        | 40        | 7                  | 10            | TJ_5_0170        | 7.3 / 10.3        | 21             | 20.6           |
| <b>18</b> | <b>30</b> | <b>7</b>           | <b>10</b>     | <b>TJ_1_0180</b> | <b>7.3 / 10.3</b> | <b>22</b>      | <b>21.6</b>    |
| 18        | 32        | 7                  | 10            | TJ_2_0180        | 7.3 / 10.3        | 22             | 21.6           |
| 18        | 35        | 7                  | 10            | TJ_3_0180        | 7.3 / 10.3        | 22             | 21.6           |
| 18        | 40        | 7                  | 10            | TJ_4_0180        | 7.3 / 10.3        | 22             | 21.6           |
| 20        | 30        | 7                  | 10            | TJ_1_0200        | 7.3 / 10.3        | 24             | 23.6           |
| 20        | 32        | 7                  | 10            | TJ_2_0200        | 7.3 / 10.3        | 24             | 23.6           |
| <b>20</b> | <b>35</b> | <b>7</b>           | <b>10</b>     | <b>TJ_3_0200</b> | <b>7.3 / 10.3</b> | <b>24</b>      | <b>23.6</b>    |
| 20        | 40        | 7                  | 10            | TJ_4_0200        | 7.3 / 10.3        | 24             | 23.6           |
| 20        | 47        | 7                  | 10            | TJ_5_0200        | 7.3 / 10.3        | 24             | 23.6           |
| 22        | 32        | 7                  | 10            | TJ_1_0220        | 7.3 / 10.3        | 26             | 25.6           |
| <b>22</b> | <b>35</b> | <b>7</b>           | <b>10</b>     | <b>TJ_2_0220</b> | <b>7.3 / 10.3</b> | <b>26</b>      | <b>25.6</b>    |
| 22        | 40        | 7                  | 10            | TJ_3_0220        | 7.3 / 10.3        | 26             | 25.6           |
| 22        | 47        | 7                  | 10            | TJ_4_0220        | 7.3 / 10.3        | 26             | 25.6           |
| 24        | 35        | 7                  | 10            | TJ_1_0240        | 7.3 / 10.3        | 28             | 27.6           |
| 24        | 37        | 7                  | 10            | TJ_2_0240        | 7.3 / 10.3        | 28             | 27.6           |
| 24        | 40        | 7                  | 10            | TJ_3_0240        | 7.3 / 10.3        | 28             | 27.6           |
| 24        | 47        | 7                  | 10            | TJ_4_0240        | 7.3 / 10.3        | 28             | 27.6           |
| 25        | 35        | 7                  | 10            | TJ_1_0250        | 7.3 / 10.3        | 29             | 28.6           |
| 25        | 40        | 7                  | 10            | TJ_2_0250        | 7.3 / 10.3        | 29             | 28.6           |
| 25        | 42        | 7                  | 10            | TJ_3_0250        | 7.3 / 10.3        | 29             | 28.6           |
| <b>25</b> | <b>47</b> | <b>7</b>           | <b>10</b>     | <b>TJ_4_0250</b> | <b>7.3 / 10.3</b> | <b>29</b>      | <b>28.6</b>    |
| 25        | 52        | 7                  | 10            | TJ_5_0250        | 7.3 / 10.3        | 29             | 28.6           |
| 26        | 37        | 7                  | 10            | TJ_1_0260        | 7.3 / 10.3        | 30             | 29.6           |
| 26        | 42        | 7                  | 10            | TJ_2_0260        | 7.3 / 10.3        | 30             | 29.6           |
| 26        | 47        | 7                  | 10            | TJ_3_0260        | 7.3 / 10.3        | 30             | 29.6           |
| 28        | 40        | 7                  | 10            | TJ_1_0280        | 7.3 / 10.3        | 32             | 31.6           |
| <b>28</b> | <b>47</b> | <b>7</b>           | <b>10</b>     | <b>TJ_2_0280</b> | <b>7.3 / 10.3</b> | <b>32</b>      | <b>31.6</b>    |
| 28        | 52        | 7                  | 10            | TJ_3_0280        | 7.3 / 10.3        | 32             | 31.6           |

Sealing lips may, in some cases, protrude beyond the edge of the seal body.

Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



# Turcon® Varilip® PDR

| Sizes     |           |                    |               | TSS Part No.     | b1 min<br>[mm]    | d4 max<br>[mm] | d5 min<br>[mm] |
|-----------|-----------|--------------------|---------------|------------------|-------------------|----------------|----------------|
| d1 [mm]   | d2 [mm]   | b [mm]<br>exc. TJB | b [mm]<br>TJB |                  |                   |                |                |
| 30        | 40        | 7                  | 10            | TJ_1_0300        | 7.3 / 10.3        | 34             | 33.6           |
| 30        | 42        | 7                  | 10            | TJ_2_0300        | 7.3 / 10.3        | 34             | 33.6           |
| <b>30</b> | <b>47</b> | <b>7</b>           | <b>10</b>     | <b>TJ_3_0300</b> | <b>7.3 / 10.3</b> | <b>34</b>      | <b>33.6</b>    |
| 30        | 52        | 7                  | 10            | TJ_4_0300        | 7.3 / 10.3        | 34             | 33.6           |
| 30        | 62        | 7                  | 10            | TJ_5_0300        | 7.3 / 10.3        | 34             | 33.6           |
| 32        | 45        | 7                  | 10            | TJ_1_0320        | 7.3 / 10.3        | 36             | 35.6           |
| 32        | 45        | 8                  | 10            | TJ_2_0320        | 8.3 / 10.3        | 36             | 35.6           |
| <b>32</b> | <b>47</b> | <b>7</b>           | <b>10</b>     | <b>TJ_3_0320</b> | <b>7.3 / 10.3</b> | <b>36</b>      | <b>35.6</b>    |
| 32        | 47        | 8                  | 10            | TJ_4_0320        | 8.3 / 10.3        | 36             | 35.6           |
| 32        | 52        | 7                  | 10            | TJ_5_0320        | 7.3 / 10.3        | 36             | 35.6           |
| 32        | 52        | 8                  | 10            | TJ_6_0320        | 8.3 / 10.3        | 36             | 35.6           |
| <b>35</b> | <b>47</b> | <b>7</b>           | <b>10</b>     | <b>TJ_1_0350</b> | <b>7.3 / 10.3</b> | <b>39</b>      | <b>38.6</b>    |
| 35        | 50        | 7                  | 10            | TJ_2_0350        | 7.3 / 10.3        | 39             | 38.6           |
| 35        | 50        | 8                  | 10            | TJ_3_0350        | 8.3 / 10.3        | 39             | 38.6           |
| 35        | 52        | 7                  | 10            | TJ_4_0350        | 7.3 / 10.3        | 39             | 38.6           |
| 35        | 52        | 8                  | 10            | TJ_5_0350        | 8.3 / 10.3        | 39             | 38.6           |
| 35        | 55        | 8                  | 10            | TJ_6_0350        | 8.3 / 10.3        | 39             | 38.6           |
| 35        | 62        | 7                  | 10            | TJ_7_0350        | 7.3 / 10.3        | 39             | 38.6           |
| 36        | 47        | 7                  | 10            | TJ_1_0360        | 7.3 / 10.3        | 40             | 39.6           |
| 36        | 50        | 7                  | 10            | TJ_2_0360        | 7.3 / 10.3        | 40             | 39.6           |
| 36        | 52        | 7                  | 10            | TJ_3_0360        | 7.3 / 10.3        | 40             | 39.6           |
| 36        | 62        | 7                  | 10            | TJ_4_0360        | 7.3 / 10.3        | 40             | 39.6           |
| 38        | 52        | 7                  | 10            | TJ_1_0380        | 7.3 / 10.3        | 42             | 41.6           |
| 38        | 55        | 7                  | 10            | TJ_2_0380        | 7.3 / 10.3        | 42             | 41.6           |
| 38        | 55        | 8                  | 10            | TJ_3_0380        | 8.3 / 10.3        | 42             | 41.6           |
| 38        | 58        | 8                  | 10            | TJ_4_0380        | 8.3 / 10.3        | 42             | 41.6           |
| 38        | 62        | 7                  | 10            | TJ_5_0380        | 7.3 / 10.3        | 42             | 41.6           |
| 38        | 62        | 8                  | 10            | TJ_6_0380        | 8.3 / 10.3        | 42             | 41.6           |
| 40        | 52        | 7                  | 10            | TJ_1_0400        | 7.3 / 10.3        | 44             | 43.6           |
| 40        | 55        | 7                  | 10            | TJ_2_0400        | 7.3 / 10.3        | 44             | 43.6           |
| 40        | 55        | 8                  | 10            | TJ_3_0400        | 8.3 / 10.3        | 44             | 43.6           |
| <b>40</b> | <b>62</b> | <b>7</b>           | <b>10</b>     | <b>TJ_4_0400</b> | <b>7.3 / 10.3</b> | <b>44</b>      | <b>43.6</b>    |
| 40        | 62        | 8                  | 10            | TJ_5_0400        | 8.3 / 10.3        | 44             | 43.6           |
| 40        | 72        | 7                  | 10            | TJ_6_0400        | 7.3 / 10.3        | 44             | 43.6           |

Sealing lips may, in some cases, protrude beyond the edge of the seal body.

Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



| d1 [mm]   | Sizes     |                    | b [mm]<br>TJB | TSS Part No.     | b1 min<br>[mm]    | d4 max<br>[mm] | d5 min<br>[mm] |
|-----------|-----------|--------------------|---------------|------------------|-------------------|----------------|----------------|
|           | d2 [mm]   | b [mm]<br>exc. TJB |               |                  |                   |                |                |
| 42        | 55        | 8                  | 10            | TJ_1_0420        | 8.3 / 10.3        | 46             | 45.6           |
| 42        | 62        | 8                  | 10            | TJ_2_0420        | 8.3 / 10.3        | 46             | 45.6           |
| 42        | 72        | 8                  | 10            | TJ_3_0420        | 8.3 / 10.3        | 46             | 45.6           |
| 45        | 60        | 8                  | 10            | TJ_1_0450        | 8.3 / 10.3        | 49             | 48.6           |
| <b>45</b> | <b>62</b> | <b>8</b>           | <b>10</b>     | <b>TJ_2_0450</b> | <b>8.3 / 10.3</b> | <b>49</b>      | <b>48.6</b>    |
| 45        | 65        | 8                  | 10            | TJ_3_0450        | 8.3 / 10.3        | 49             | 48.6           |
| 45        | 72        | 8                  | 10            | TJ_4_0450        | 8.3 / 10.3        | 49             | 48.6           |
| 48        | 62        | 8                  | 10            | TJ_1_0480        | 8.3 / 10.3        | 52             | 51.6           |
| 48        | 72        | 8                  | 10            | TJ_2_0480        | 8.3 / 10.3        | 52             | 51.6           |
| 50        | 65        | 8                  | 10            | TJ_1_0500        | 8.3 / 10.3        | 54             | 53.6           |
| 50        | 68        | 8                  | 10            | TJ_2_0500        | 8.3 / 10.3        | 54             | 53.6           |
| <b>50</b> | <b>72</b> | <b>8</b>           | <b>10</b>     | <b>TJ_3_0500</b> | <b>8.3 / 10.3</b> | <b>54</b>      | <b>53.6</b>    |
| 50        | 80        | 8                  | 10            | TJ_4_0500        | 8.3 / 10.3        | 54             | 53.6           |
| 52        | 68        | 8                  | 10            | TJ_1_0520        | 8.3 / 10.3        | 56             | 55.6           |
| 52        | 72        | 8                  | 10            | TJ_2_0520        | 8.3 / 10.3        | 56             | 55.6           |
| 55        | 70        | 8                  | 10            | TJ_1_0550        | 8.3 / 10.3        | 59             | 58.6           |
| <b>55</b> | <b>72</b> | <b>8</b>           | <b>10</b>     | <b>TJ_2_0550</b> | <b>8.3 / 10.3</b> | <b>59</b>      | <b>58.6</b>    |
| 55        | 80        | 8                  | 10            | TJ_3_0550        | 8.3 / 10.3        | 59             | 58.6           |
| 55        | 85        | 8                  | 10            | TJ_4_0550        | 8.3 / 10.3        | 59             | 58.6           |
| 56        | 70        | 8                  | 10            | TJ_1_0560        | 8.3 / 10.3        | 60             | 59.6           |
| 56        | 72        | 8                  | 10            | TJ_2_0560        | 8.3 / 10.3        | 60             | 59.6           |
| 56        | 80        | 8                  | 10            | TJ_3_0560        | 8.3 / 10.3        | 60             | 59.6           |
| 56        | 85        | 8                  | 10            | TJ_4_0560        | 8.3 / 10.3        | 60             | 59.6           |
| 58        | 72        | 8                  | 10            | TJ_1_0580        | 8.3 / 10.3        | 62             | 61.6           |
| 58        | 80        | 8                  | 10            | TJ_2_0580        | 8.3 / 10.3        | 62             | 61.6           |
| 60        | 75        | 8                  | 10            | TJ_1_0600        | 8.3 / 10.3        | 64             | 63.6           |
| <b>60</b> | <b>80</b> | <b>8</b>           | <b>10</b>     | <b>TJ_2_0600</b> | <b>8.3 / 10.3</b> | <b>64</b>      | <b>63.6</b>    |
| 60        | 85        | 8                  | 10            | TJ_3_0600        | 8.3 / 10.3        | 64             | 63.6           |
| 60        | 90        | 8                  | 10            | TJ_4_0600        | 8.3 / 10.3        | 64             | 63.6           |
| 62        | 85        | 10                 | 10            | TJ_1_0620        | 10.3              | 68             | 66.4           |
| 62        | 90        | 10                 | 10            | TJ_2_0620        | 10.3              | 68             | 66.4           |
| 63        | 85        | 10                 | 10            | TJ_1_0630        | 10.3              | 69             | 67.4           |
| 63        | 90        | 10                 | 10            | TJ_2_0630        | 10.3              | 69             | 67.4           |

Sealing lips may, in some cases, protrude beyond the edge of the seal body.

Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



# Turcon® Varilip® PDR

| d1 [mm]    | Sizes      |                    | b [mm]    | TSS Part No.     | b1 min [mm] | d4 max [mm] | d5 min [mm]  |
|------------|------------|--------------------|-----------|------------------|-------------|-------------|--------------|
|            | d2 [mm]    | b [mm]<br>exc. TJB |           |                  |             |             |              |
| <b>65</b>  | <b>85</b>  | <b>10</b>          | <b>10</b> | <b>TJ_1_0650</b> | <b>10.3</b> | <b>71</b>   | <b>69.4</b>  |
| 65         | 90         | 10                 | 10        | TJ_2_0650        | 10.3        | 71          | 69.4         |
| 65         | 100        | 10                 | 10        | TJ_3_0650        | 10.3        | 71          | 69.4         |
| 68         | 90         | 10                 | 10        | TJ_1_0680        | 10.3        | 74          | 72.4         |
| 68         | 100        | 10                 | 10        | TJ_2_0680        | 10.3        | 74          | 72.4         |
| <b>70</b>  | <b>90</b>  | <b>10</b>          | <b>10</b> | <b>TJ_1_0700</b> | <b>10.3</b> | <b>76</b>   | <b>74.4</b>  |
| 70         | 95         | 10                 | 10        | TJ_2_0700        | 10.3        | 76          | 74.4         |
| 70         | 100        | 10                 | 10        | TJ_3_0700        | 10.3        | 76          | 74.4         |
| 72         | 95         | 10                 | 10        | TJ_1_0720        | 10.3        | 78          | 76.4         |
| 72         | 100        | 10                 | 10        | TJ_2_0720        | 10.3        | 78          | 76.4         |
| <b>75</b>  | <b>95</b>  | <b>10</b>          | <b>10</b> | <b>TJ_1_0750</b> | <b>10.3</b> | <b>81</b>   | <b>79.4</b>  |
| 75         | 100        | 10                 | 10        | TJ_2_0750        | 10.3        | 81          | 79.4         |
| 78         | 100        | 10                 | 10        | TJ_1_0780        | 10.3        | 84          | 82.4         |
| <b>80</b>  | <b>100</b> | <b>10</b>          | <b>10</b> | <b>TJ_1_0800</b> | <b>10.3</b> | <b>86</b>   | <b>84.4</b>  |
| 80         | 110        | 10                 | 10        | TJ_2_0800        | 10.3        | 86          | 84.4         |
| 85         | 110        | 12                 | 12        | TJ_1_0850        | 12.4        | 91          | 89.4         |
| 85         | 120        | 12                 | 12        | TJ_2_0850        | 12.4        | 91          | 89.4         |
| 90         | 110        | 12                 | 12        | TJ_1_0900        | 12.4        | 96          | 94.4         |
| <b>90</b>  | <b>120</b> | <b>12</b>          | <b>12</b> | <b>TJ_2_0900</b> | <b>12.4</b> | <b>96</b>   | <b>94.4</b>  |
| 95         | 120        | 12                 | 12        | TJ_1_0950        | 12.4        | 101         | 99.4         |
| 95         | 125        | 12                 | 12        | TJ_2_0950        | 12.4        | 101         | 99.4         |
| 100        | 120        | 12                 | 12        | TJ_1_1000        | 12.4        | 106         | 104.4        |
| 100        | 125        | 12                 | 12        | TJ_2_1000        | 12.4        | 106         | 104.4        |
| <b>100</b> | <b>130</b> | <b>12</b>          | <b>12</b> | <b>TJ_3_1000</b> | <b>12.4</b> | <b>106</b>  | <b>104.4</b> |
| <b>105</b> | <b>130</b> | <b>12</b>          | <b>12</b> | <b>TJ_1_1050</b> | <b>12.4</b> | <b>111</b>  | <b>109.4</b> |
| 105        | 140        | 12                 | 12        | TJ_2_1050        | 12.4        | 111         | 109.4        |
| 110        | 130        | 12                 | 12        | TJ_1_1100        | 12.4        | 116         | 114.4        |
| <b>110</b> | <b>140</b> | <b>12</b>          | <b>12</b> | <b>TJ_2_1100</b> | <b>12.4</b> | <b>116</b>  | <b>114.4</b> |
| 115        | 140        | 12                 | 12        | TJ_1_1150        | 12.4        | 121         | 119.4        |
| 115        | 150        | 12                 | 12        | TJ_2_1150        | 12.4        | 121         | 119.4        |
| <b>120</b> | <b>150</b> | <b>12</b>          | <b>12</b> | <b>TJ_1_1200</b> | <b>12.4</b> | <b>126</b>  | <b>124.4</b> |
| 120        | 160        | 12                 | 12        | TJ_2_1200        | 12.4        | 126         | 124.4        |
| 125        | 150        | 12                 | 12        | TJ_1_1250        | 12.4        | 131         | 129.4        |
| 125        | 160        | 12                 | 12        | TJ_2_1250        | 12.4        | 131         | 129.4        |

Sealing lips may, in some cases, protrude beyond the edge of the seal body.

Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



| d1 [mm]    | Sizes      |                    | b [mm]<br>TJB | TSS Part No.     | b1 min<br>[mm] | d4 max<br>[mm] | d5 min<br>[mm] |
|------------|------------|--------------------|---------------|------------------|----------------|----------------|----------------|
|            | d2 [mm]    | b [mm]<br>exc. TJB |               |                  |                |                |                |
| <b>130</b> | <b>160</b> | <b>12</b>          | <b>12</b>     | <b>TJ_1_1300</b> | <b>12.4</b>    | <b>136</b>     | <b>134.4</b>   |
| 130        | 170        | 12                 | 12            | TJ_2_1300        | 12.4           | 136            | 134.4          |
| 135        | 170        | 12                 | 12            | TJ_1_1350        | 12.4           | 141            | 139.4          |
| 140        | 170        | 15                 | 15            | TJ_1_1400        | 15.4           | 148            | 147            |
| 145        | 175        | 15                 | 15            | TJ_1_1450        | 15.4           | 153            | 152            |
| <b>150</b> | <b>180</b> | <b>15</b>          | <b>15</b>     | <b>TJ_1_1500</b> | <b>15.4</b>    | <b>158</b>     | <b>157</b>     |
| 160        | 190        | 15                 | 15            | TJ_1_1600        | 15.4           | 168            | 167            |
| 170        | 200        | 15                 | 15            | TJ_1_1700        | 15.4           | 178            | 177            |

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# Turcon® Varilip® PDR

Table XI: Turcon® Varilip® PDR Inch Size Range

| Sizes        |              |              |                 | TSS Part No.     | b1 min (Inch)        | d4 max (Inch) | d5 min (Inch) |
|--------------|--------------|--------------|-----------------|------------------|----------------------|---------------|---------------|
| d1 (Inch)    | d2 (Inch)    | b (Inch)     | b (Inch)<br>TJB |                  |                      |               |               |
| <b>0.438</b> | <b>0.938</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D407</b> | <b>0.288 / 0.405</b> | <b>0.595</b>  | <b>0.580</b>  |
| 0.438        | 1.063        | 0.276        | 0.393           | TJ_F_D507        | 0.288 / 0.405        | 0.595         | 0.580         |
| 0.438        | 1.188        | 0.276        | 0.393           | TJ_G_D607        | 0.288 / 0.405        | 0.595         | 0.580         |
| 0.438        | 1.313        | 0.276        | 0.393           | TJ_H_D707        | 0.288 / 0.405        | 0.595         | 0.580         |
| 0.438        | 1.438        | 0.276        | 0.393           | TJ_J_D807        | 0.288 / 0.405        | 0.595         | 0.580         |
| <b>0.500</b> | <b>1.000</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D408</b> | <b>0.288 / 0.405</b> | <b>0.657</b>  | <b>0.642</b>  |
| 0.500        | 1.125        | 0.276        | 0.393           | TJ_F_D508        | 0.288 / 0.405        | 0.657         | 0.642         |
| 0.500        | 1.250        | 0.276        | 0.393           | TJ_G_D608        | 0.288 / 0.405        | 0.657         | 0.642         |
| 0.500        | 1.375        | 0.276        | 0.393           | TJ_H_D708        | 0.288 / 0.405        | 0.657         | 0.642         |
| 0.500        | 1.500        | 0.276        | 0.393           | TJ_J_D808        | 0.288 / 0.405        | 0.657         | 0.642         |
| <b>0.563</b> | <b>1.063</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D409</b> | <b>0.288 / 0.405</b> | <b>0.720</b>  | <b>0.705</b>  |
| 0.563        | 1.188        | 0.276        | 0.393           | TJ_F_D509        | 0.288 / 0.405        | 0.720         | 0.705         |
| 0.563        | 1.313        | 0.276        | 0.393           | TJ_G_D609        | 0.288 / 0.405        | 0.720         | 0.705         |
| 0.563        | 1.438        | 0.276        | 0.393           | TJ_H_D709        | 0.288 / 0.405        | 0.720         | 0.705         |
| 0.563        | 1.563        | 0.276        | 0.393           | TJ_J_D809        | 0.288 / 0.405        | 0.720         | 0.705         |
| <b>0.625</b> | <b>1.125</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D410</b> | <b>0.288 / 0.405</b> | <b>0.782</b>  | <b>0.767</b>  |
| 0.625        | 1.250        | 0.276        | 0.393           | TJ_F_D510        | 0.288 / 0.405        | 0.782         | 0.767         |
| 0.625        | 1.375        | 0.276        | 0.393           | TJ_G_D610        | 0.288 / 0.405        | 0.782         | 0.767         |
| 0.625        | 1.500        | 0.276        | 0.393           | TJ_H_D710        | 0.288 / 0.405        | 0.782         | 0.767         |
| 0.625        | 1.625        | 0.276        | 0.393           | TJ_J_D810        | 0.288 / 0.405        | 0.782         | 0.767         |
| <b>0.688</b> | <b>1.188</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D411</b> | <b>0.288 / 0.405</b> | <b>0.845</b>  | <b>0.830</b>  |
| 0.688        | 1.313        | 0.276        | 0.393           | TJ_F_D511        | 0.288 / 0.405        | 0.845         | 0.830         |
| 0.688        | 1.438        | 0.276        | 0.393           | TJ_G_D611        | 0.288 / 0.405        | 0.845         | 0.830         |
| 0.688        | 1.563        | 0.276        | 0.393           | TJ_H_D711        | 0.288 / 0.405        | 0.845         | 0.830         |
| 0.688        | 1.688        | 0.276        | 0.393           | TJ_J_D811        | 0.288 / 0.405        | 0.845         | 0.830         |
| <b>0.750</b> | <b>1.250</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D412</b> | <b>0.288 / 0.405</b> | <b>0.907</b>  | <b>0.892</b>  |
| 0.750        | 1.375        | 0.276        | 0.393           | TJ_F_D512        | 0.288 / 0.405        | 0.907         | 0.892         |
| 0.750        | 1.500        | 0.276        | 0.393           | TJ_G_D612        | 0.288 / 0.405        | 0.907         | 0.892         |
| 0.750        | 1.625        | 0.276        | 0.393           | TJ_H_D712        | 0.288 / 0.405        | 0.907         | 0.892         |
| 0.750        | 1.750        | 0.276        | 0.393           | TJ_J_D812        | 0.288 / 0.405        | 0.907         | 0.892         |
| <b>0.813</b> | <b>1.313</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D413</b> | <b>0.288 / 0.405</b> | <b>0.970</b>  | <b>0.955</b>  |
| 0.813        | 1.438        | 0.276        | 0.393           | TJ_F_D513        | 0.288 / 0.405        | 0.970         | 0.955         |
| 0.813        | 1.563        | 0.276        | 0.393           | TJ_G_D613        | 0.288 / 0.405        | 0.970         | 0.955         |
| 0.813        | 1.688        | 0.276        | 0.393           | TJ_H_D713        | 0.288 / 0.405        | 0.970         | 0.955         |
| 0.813        | 1.813        | 0.276        | 0.393           | TJ_J_D813        | 0.288 / 0.405        | 0.970         | 0.955         |

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Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



| Sizes        |              |              |                 | TSS Part No.     | b1 min (Inch)        | d4 max (Inch) | d5 min (Inch) |
|--------------|--------------|--------------|-----------------|------------------|----------------------|---------------|---------------|
| d1 (Inch)    | d2 (Inch)    | b (Inch)     | b (Inch)<br>TJB |                  |                      |               |               |
| <b>0.875</b> | <b>1.375</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D414</b> | <b>0.288 / 0.405</b> | <b>1.032</b>  | <b>1.017</b>  |
| 0.875        | 1.500        | 0.276        | 0.393           | TJ_F_D514        | 0.288 / 0.405        | 1.032         | 1.017         |
| 0.875        | 1.625        | 0.276        | 0.393           | TJ_G_D614        | 0.288 / 0.405        | 1.032         | 1.017         |
| 0.875        | 1.750        | 0.276        | 0.393           | TJ_H_D714        | 0.288 / 0.405        | 1.032         | 1.017         |
| 0.875        | 1.875        | 0.276        | 0.393           | TJ_J_D814        | 0.288 / 0.405        | 1.032         | 1.017         |
| <b>0.938</b> | <b>1.438</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D415</b> | <b>0.288 / 0.405</b> | <b>1.095</b>  | <b>1.080</b>  |
| 0.938        | 1.563        | 0.276        | 0.393           | TJ_F_D515        | 0.288 / 0.405        | 1.095         | 1.080         |
| 0.938        | 1.688        | 0.276        | 0.393           | TJ_G_D615        | 0.288 / 0.405        | 1.095         | 1.080         |
| 0.938        | 1.813        | 0.276        | 0.393           | TJ_H_D715        | 0.288 / 0.405        | 1.095         | 1.080         |
| 0.938        | 1.938        | 0.276        | 0.393           | TJ_J_D815        | 0.288 / 0.405        | 1.095         | 1.080         |
| <b>1.000</b> | <b>1.500</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D416</b> | <b>0.288 / 0.405</b> | <b>1.157</b>  | <b>1.142</b>  |
| 1.000        | 1.625        | 0.276        | 0.393           | TJ_F_D516        | 0.288 / 0.405        | 1.157         | 1.142         |
| 1.000        | 1.750        | 0.276        | 0.393           | TJ_G_D616        | 0.288 / 0.405        | 1.157         | 1.142         |
| 1.000        | 1.875        | 0.276        | 0.393           | TJ_H_D716        | 0.288 / 0.405        | 1.157         | 1.142         |
| 1.000        | 2.000        | 0.276        | 0.393           | TJ_J_D816        | 0.288 / 0.405        | 1.157         | 1.142         |
| <b>1.125</b> | <b>1.625</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D418</b> | <b>0.288 / 0.405</b> | <b>1.282</b>  | <b>1.267</b>  |
| 1.125        | 1.750        | 0.276        | 0.393           | TJ_F_D518        | 0.288 / 0.405        | 1.282         | 1.267         |
| 1.125        | 1.875        | 0.276        | 0.393           | TJ_G_D618        | 0.288 / 0.405        | 1.282         | 1.267         |
| 1.125        | 2.000        | 0.276        | 0.393           | TJ_H_D718        | 0.288 / 0.405        | 1.282         | 1.267         |
| 1.125        | 2.125        | 0.276        | 0.393           | TJ_J_D818        | 0.288 / 0.405        | 1.282         | 1.267         |
| <b>1.250</b> | <b>1.750</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D420</b> | <b>0.288 / 0.405</b> | <b>1.407</b>  | <b>1.392</b>  |
| 1.250        | 1.875        | 0.276        | 0.393           | TJ_F_D520        | 0.288 / 0.405        | 1.407         | 1.392         |
| 1.250        | 2.000        | 0.276        | 0.393           | TJ_G_D620        | 0.288 / 0.405        | 1.407         | 1.392         |
| 1.250        | 2.125        | 0.276        | 0.393           | TJ_H_D720        | 0.288 / 0.405        | 1.407         | 1.392         |
| 1.250        | 2.250        | 0.276        | 0.393           | TJ_J_D820        | 0.288 / 0.405        | 1.407         | 1.392         |
| <b>1.375</b> | <b>1.875</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D422</b> | <b>0.288 / 0.405</b> | <b>1.532</b>  | <b>1.517</b>  |
| 1.375        | 2.000        | 0.276        | 0.393           | TJ_F_D522        | 0.288 / 0.405        | 1.532         | 1.517         |
| 1.375        | 2.125        | 0.276        | 0.393           | TJ_G_D622        | 0.288 / 0.405        | 1.532         | 1.517         |
| 1.375        | 2.250        | 0.276        | 0.393           | TJ_H_D722        | 0.288 / 0.405        | 1.532         | 1.517         |
| 1.375        | 2.375        | 0.276        | 0.393           | TJ_J_D822        | 0.288 / 0.405        | 1.532         | 1.517         |
| <b>1.500</b> | <b>2.000</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D424</b> | <b>0.288 / 0.405</b> | <b>1.657</b>  | <b>1.642</b>  |
| 1.500        | 2.125        | 0.276        | 0.393           | TJ_F_D524        | 0.288 / 0.405        | 1.657         | 1.642         |
| 1.500        | 2.250        | 0.276        | 0.393           | TJ_G_D624        | 0.288 / 0.405        | 1.657         | 1.642         |
| 1.500        | 2.375        | 0.276        | 0.393           | TJ_H_D724        | 0.288 / 0.405        | 1.657         | 1.642         |
| 1.500        | 2.500        | 0.276        | 0.393           | TJ_J_D824        | 0.288 / 0.405        | 1.657         | 1.642         |

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# Turcon® Varilip® PDR

| Sizes        |              |              |                 | TSS Part No.     | b1 min (Inch)        | d4 max (Inch) | d5 min (Inch) |
|--------------|--------------|--------------|-----------------|------------------|----------------------|---------------|---------------|
| d1 (Inch)    | d2 (Inch)    | b (Inch)     | b (Inch)<br>TJB |                  |                      |               |               |
| <b>1.625</b> | <b>2.125</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D426</b> | <b>0.288 / 0.405</b> | <b>1.782</b>  | <b>1.767</b>  |
| 1.625        | 2.250        | 0.276        | 0.393           | TJ_F_D526        | 0.288 / 0.405        | 1.782         | 1.767         |
| 1.625        | 2.375        | 0.276        | 0.393           | TJ_G_D626        | 0.288 / 0.405        | 1.782         | 1.767         |
| 1.625        | 2.500        | 0.276        | 0.393           | TJ_H_D726        | 0.288 / 0.405        | 1.782         | 1.767         |
| 1.625        | 2.625        | 0.276        | 0.393           | TJ_J_D826        | 0.288 / 0.405        | 1.782         | 1.767         |
| <b>1.750</b> | <b>2.250</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D428</b> | <b>0.288 / 0.405</b> | <b>1.907</b>  | <b>1.892</b>  |
| 1.750        | 2.375        | 0.276        | 0.393           | TJ_F_D528        | 0.288 / 0.405        | 1.907         | 1.892         |
| 1.750        | 2.500        | 0.276        | 0.393           | TJ_G_D628        | 0.288 / 0.405        | 1.907         | 1.892         |
| 1.750        | 2.625        | 0.276        | 0.393           | TJ_H_D728        | 0.288 / 0.405        | 1.907         | 1.892         |
| 1.750        | 2.750        | 0.276        | 0.393           | TJ_J_D828        | 0.288 / 0.405        | 1.907         | 1.892         |
| <b>1.875</b> | <b>2.375</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D430</b> | <b>0.288 / 0.405</b> | <b>2.032</b>  | <b>2.017</b>  |
| 1.875        | 2.500        | 0.276        | 0.393           | TJ_F_D530        | 0.288 / 0.405        | 2.032         | 2.017         |
| 1.875        | 2.625        | 0.276        | 0.393           | TJ_G_D630        | 0.288 / 0.405        | 2.032         | 2.017         |
| 1.875        | 2.750        | 0.276        | 0.393           | TJ_H_D730        | 0.288 / 0.405        | 2.032         | 2.017         |
| 1.875        | 2.875        | 0.276        | 0.393           | TJ_J_D830        | 0.288 / 0.405        | 2.032         | 2.017         |
| <b>2.000</b> | <b>2.500</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D432</b> | <b>0.288 / 0.405</b> | <b>2.157</b>  | <b>2.142</b>  |
| 2.000        | 2.625        | 0.276        | 0.393           | TJ_F_D532        | 0.288 / 0.405        | 2.157         | 2.142         |
| 2.000        | 2.750        | 0.276        | 0.393           | TJ_G_D632        | 0.288 / 0.405        | 2.157         | 2.142         |
| 2.000        | 2.875        | 0.276        | 0.393           | TJ_H_D732        | 0.288 / 0.405        | 2.157         | 2.142         |
| 2.000        | 3.000        | 0.276        | 0.393           | TJ_J_D832        | 0.288 / 0.405        | 2.157         | 2.142         |
| <b>2.125</b> | <b>2.625</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D434</b> | <b>0.288 / 0.405</b> | <b>2.282</b>  | <b>2.267</b>  |
| 2.125        | 2.750        | 0.276        | 0.393           | TJ_F_D534        | 0.288 / 0.405        | 2.282         | 2.267         |
| 2.125        | 2.875        | 0.276        | 0.393           | TJ_G_D634        | 0.288 / 0.405        | 2.282         | 2.267         |
| 2.125        | 3.000        | 0.276        | 0.393           | TJ_H_D734        | 0.288 / 0.405        | 2.282         | 2.267         |
| 2.125        | 3.125        | 0.276        | 0.393           | TJ_J_D834        | 0.288 / 0.405        | 2.282         | 2.267         |
| <b>2.250</b> | <b>2.750</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D436</b> | <b>0.288 / 0.405</b> | <b>2.407</b>  | <b>2.392</b>  |
| 2.250        | 2.875        | 0.276        | 0.393           | TJ_F_D536        | 0.288 / 0.405        | 2.407         | 2.392         |
| 2.250        | 3.000        | 0.276        | 0.393           | TJ_G_D636        | 0.288 / 0.405        | 2.407         | 2.392         |
| 2.250        | 3.125        | 0.276        | 0.393           | TJ_H_D736        | 0.288 / 0.405        | 2.407         | 2.392         |
| 2.250        | 3.250        | 0.276        | 0.393           | TJ_J_D836        | 0.288 / 0.405        | 2.407         | 2.392         |
| <b>2.375</b> | <b>2.875</b> | <b>0.276</b> | <b>0.393</b>    | <b>TJ_E_D438</b> | <b>0.288 / 0.405</b> | <b>2.532</b>  | <b>2.517</b>  |
| 2.375        | 3.000        | 0.276        | 0.393           | TJ_F_D538        | 0.288 / 0.405        | 2.532         | 2.517         |
| 2.375        | 3.125        | 0.276        | 0.393           | TJ_G_D638        | 0.288 / 0.405        | 2.532         | 2.517         |
| 2.375        | 3.250        | 0.276        | 0.393           | TJ_H_D738        | 0.288 / 0.405        | 2.532         | 2.517         |
| 2.375        | 3.375        | 0.276        | 0.393           | TJ_J_D838        | 0.288 / 0.405        | 2.532         | 2.517         |

Sealing lips may, in some cases, protrude beyond the edge of the seal body.

Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



| Sizes        |              |              |                 | TSS Part No.     | b1 min (Inch)        | d4 max (Inch) | d5 min (Inch) |
|--------------|--------------|--------------|-----------------|------------------|----------------------|---------------|---------------|
| d1 (Inch)    | d2 (Inch)    | b (Inch)     | b (Inch)<br>TJB |                  |                      |               |               |
| <b>2.500</b> | <b>3.000</b> | <b>0.315</b> | <b>0.393</b>    | <b>TJ_E_D440</b> | <b>0.327 / 0.405</b> | <b>2.657</b>  | <b>2.642</b>  |
| 2.500        | 3.125        | 0.315        | 0.393           | TJ_F_D540        | 0.327 / 0.405        | 2.657         | 2.642         |
| 2.500        | 3.250        | 0.315        | 0.393           | TJ_G_D640        | 0.327 / 0.405        | 2.657         | 2.642         |
| 2.500        | 3.375        | 0.315        | 0.393           | TJ_H_D740        | 0.327 / 0.405        | 2.657         | 2.642         |
| 2.500        | 3.500        | 0.315        | 0.393           | TJ_J_D840        | 0.327 / 0.405        | 2.657         | 2.642         |
| <b>2.625</b> | <b>3.125</b> | <b>0.315</b> | <b>0.393</b>    | <b>TJ_E_D442</b> | <b>0.327 / 0.405</b> | <b>2.861</b>  | <b>2.798</b>  |
| 2.625        | 3.250        | 0.315        | 0.393           | TJ_F_D542        | 0.327 / 0.405        | 2.861         | 2.798         |
| 2.625        | 3.375        | 0.315        | 0.393           | TJ_G_D642        | 0.327 / 0.405        | 2.861         | 2.798         |
| 2.625        | 3.500        | 0.315        | 0.393           | TJ_H_D742        | 0.327 / 0.405        | 2.861         | 2.798         |
| 2.625        | 3.625        | 0.315        | 0.393           | TJ_J_D842        | 0.327 / 0.405        | 2.861         | 2.798         |
| <b>2.750</b> | <b>3.250</b> | <b>0.315</b> | <b>0.393</b>    | <b>TJ_E_D444</b> | <b>0.327 / 0.405</b> | <b>2.986</b>  | <b>2.923</b>  |
| 2.750        | 3.375        | 0.315        | 0.393           | TJ_F_D544        | 0.327 / 0.405        | 2.986         | 2.923         |
| 2.750        | 3.500        | 0.315        | 0.393           | TJ_G_D644        | 0.327 / 0.405        | 2.986         | 2.923         |
| 2.750        | 3.625        | 0.315        | 0.393           | TJ_H_D744        | 0.327 / 0.405        | 2.986         | 2.923         |
| 2.750        | 3.750        | 0.315        | 0.393           | TJ_J_D844        | 0.327 / 0.405        | 2.986         | 2.923         |
| <b>2.875</b> | <b>3.375</b> | <b>0.315</b> | <b>0.393</b>    | <b>TJ_E_D446</b> | <b>0.327 / 0.405</b> | <b>3.111</b>  | <b>3.048</b>  |
| 2.875        | 3.500        | 0.315        | 0.393           | TJ_F_D546        | 0.327 / 0.405        | 3.111         | 3.048         |
| 2.875        | 3.625        | 0.315        | 0.393           | TJ_G_D646        | 0.327 / 0.405        | 3.111         | 3.048         |
| 2.875        | 3.750        | 0.315        | 0.393           | TJ_H_D746        | 0.327 / 0.405        | 3.111         | 3.048         |
| 2.875        | 3.875        | 0.315        | 0.393           | TJ_J_D846        | 0.327 / 0.405        | 3.111         | 3.048         |
| <b>3.000</b> | <b>3.500</b> | <b>0.315</b> | <b>0.393</b>    | <b>TJ_E_D448</b> | <b>0.327 / 0.405</b> | <b>3.236</b>  | <b>3.173</b>  |
| 3.000        | 3.625        | 0.315        | 0.393           | TJ_F_D548        | 0.327 / 0.405        | 3.236         | 3.173         |
| 3.000        | 3.750        | 0.315        | 0.393           | TJ_G_D648        | 0.327 / 0.405        | 3.236         | 3.173         |
| 3.000        | 3.875        | 0.315        | 0.393           | TJ_H_D748        | 0.327 / 0.405        | 3.236         | 3.173         |
| 3.000        | 4.000        | 0.315        | 0.393           | TJ_J_D848        | 0.327 / 0.405        | 3.236         | 3.173         |
| <b>3.125</b> | <b>3.625</b> | <b>0.315</b> | <b>0.393</b>    | <b>TJ_E_D450</b> | <b>0.327 / 0.405</b> | <b>3.361</b>  | <b>3.298</b>  |
| 3.125        | 3.750        | 0.315        | 0.393           | TJ_F_D550        | 0.327 / 0.405        | 3.361         | 3.298         |
| 3.125        | 3.875        | 0.315        | 0.393           | TJ_G_D650        | 0.327 / 0.405        | 3.361         | 3.298         |
| 3.125        | 4.000        | 0.315        | 0.393           | TJ_H_D750        | 0.327 / 0.405        | 3.361         | 3.298         |
| 3.125        | 4.125        | 0.315        | 0.393           | TJ_J_D850        | 0.327 / 0.405        | 3.361         | 3.298         |
| <b>3.250</b> | <b>3.875</b> | <b>0.315</b> | <b>0.393</b>    | <b>TJ_F_D552</b> | <b>0.327 / 0.405</b> | <b>3.486</b>  | <b>3.423</b>  |
| 3.250        | 4.000        | 0.315        | 0.393           | TJ_G_D652        | 0.327 / 0.405        | 3.486         | 3.423         |
| 3.250        | 4.125        | 0.315        | 0.393           | TJ_H_D752        | 0.327 / 0.405        | 3.486         | 3.423         |
| 3.250        | 4.250        | 0.315        | 0.393           | TJ_J_D852        | 0.327 / 0.405        | 3.486         | 3.423         |

Sealing lips may, in some cases, protrude beyond the edge of the seal body.

Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



# Turcon® Varilip® PDR

| Sizes        |              |              |                 | TSS Part No.     | b1 min (Inch) | d4 max (Inch) | d5 min (Inch) |
|--------------|--------------|--------------|-----------------|------------------|---------------|---------------|---------------|
| d1 (Inch)    | d2 (Inch)    | b (Inch)     | b (Inch)<br>TJB |                  |               |               |               |
| <b>3.375</b> | <b>4.000</b> | <b>0.472</b> | <b>0.472</b>    | <b>TJ_F_D554</b> | <b>0.484</b>  | <b>3.611</b>  | <b>3.548</b>  |
| 3.375        | 4.125        | 0.472        | 0.472           | TJ_G_D654        | 0.484         | 3.611         | 3.548         |
| 3.375        | 4.250        | 0.472        | 0.472           | TJ_H_D754        | 0.484         | 3.611         | 3.548         |
| 3.375        | 4.375        | 0.472        | 0.472           | TJ_J_D854        | 0.484         | 3.611         | 3.548         |
| <b>3.500</b> | <b>4.125</b> | <b>0.472</b> | <b>0.472</b>    | <b>TJ_F_D556</b> | <b>0.484</b>  | <b>3.736</b>  | <b>3.673</b>  |
| 3.500        | 4.250        | 0.472        | 0.472           | TJ_G_D656        | 0.484         | 3.736         | 3.673         |
| 3.500        | 4.375        | 0.472        | 0.472           | TJ_H_D756        | 0.484         | 3.736         | 3.673         |
| 3.500        | 4.500        | 0.472        | 0.472           | TJ_J_D856        | 0.484         | 3.736         | 3.673         |
| <b>3.625</b> | <b>4.250</b> | <b>0.472</b> | <b>0.472</b>    | <b>TJ_F_D558</b> | <b>0.484</b>  | <b>3.861</b>  | <b>3.798</b>  |
| 3.625        | 4.375        | 0.472        | 0.472           | TJ_G_D658        | 0.484         | 3.861         | 3.798         |
| 3.625        | 4.500        | 0.472        | 0.472           | TJ_H_D758        | 0.484         | 3.861         | 3.798         |
| 3.625        | 4.625        | 0.472        | 0.472           | TJ_J_D858        | 0.484         | 3.861         | 3.798         |
| <b>3.750</b> | <b>4.375</b> | <b>0.472</b> | <b>0.472</b>    | <b>TJ_F_D560</b> | <b>0.484</b>  | <b>3.986</b>  | <b>3.923</b>  |
| 3.750        | 4.500        | 0.472        | 0.472           | TJ_G_D660        | 0.484         | 3.986         | 3.923         |
| 3.750        | 4.625        | 0.472        | 0.472           | TJ_H_D760        | 0.484         | 3.986         | 3.923         |
| 3.750        | 4.750        | 0.472        | 0.472           | TJ_J_D860        | 0.484         | 3.986         | 3.923         |
| <b>3.875</b> | <b>4.500</b> | <b>0.472</b> | <b>0.472</b>    | <b>TJ_F_D562</b> | <b>0.484</b>  | <b>4.111</b>  | <b>4.048</b>  |
| 3.875        | 4.625        | 0.472        | 0.472           | TJ_G_D662        | 0.484         | 4.111         | 4.048         |
| 3.875        | 4.750        | 0.472        | 0.472           | TJ_H_D762        | 0.484         | 4.111         | 4.048         |
| 3.875        | 4.875        | 0.472        | 0.472           | TJ_J_D862        | 0.484         | 4.111         | 4.048         |
| <b>4.000</b> | <b>4.625</b> | <b>0.472</b> | <b>0.472</b>    | <b>TJ_F_D564</b> | <b>0.484</b>  | <b>4.236</b>  | <b>4.173</b>  |
| 4.000        | 4.750        | 0.472        | 0.472           | TJ_G_D664        | 0.484         | 4.236         | 4.173         |
| 4.000        | 4.875        | 0.472        | 0.472           | TJ_H_D764        | 0.484         | 4.236         | 4.173         |
| 4.000        | 5.000        | 0.472        | 0.472           | TJ_J_D864        | 0.484         | 4.236         | 4.173         |
| <b>4.125</b> | <b>4.750</b> | <b>0.472</b> | <b>0.472</b>    | <b>TJ_F_D566</b> | <b>0.484</b>  | <b>4.361</b>  | <b>4.298</b>  |
| 4.125        | 4.875        | 0.472        | 0.472           | TJ_G_D666        | 0.484         | 4.361         | 4.298         |
| 4.125        | 5.000        | 0.472        | 0.472           | TJ_H_D766        | 0.484         | 4.361         | 4.298         |
| 4.125        | 5.125        | 0.472        | 0.472           | TJ_J_D866        | 0.484         | 4.361         | 4.298         |

Sealing lips may, in some cases, protrude beyond the edge of the seal body.

Sizes printed in **bold** are preferred. Sizes not stated on these tables are available on request (note this will include a tooling charge).



## ■ Ordering Information

An ordering example is shown below.

### Ordering example

Standard, Type A/Type 1  
 Shaft diameter d1 = 30 mm (1.181 in)  
 Outside diameter d2 = 47 mm (1.85 in)  
 Width b = 7 mm (0.276 in)

Table XII: TSS Part No. TJ\_3B0300

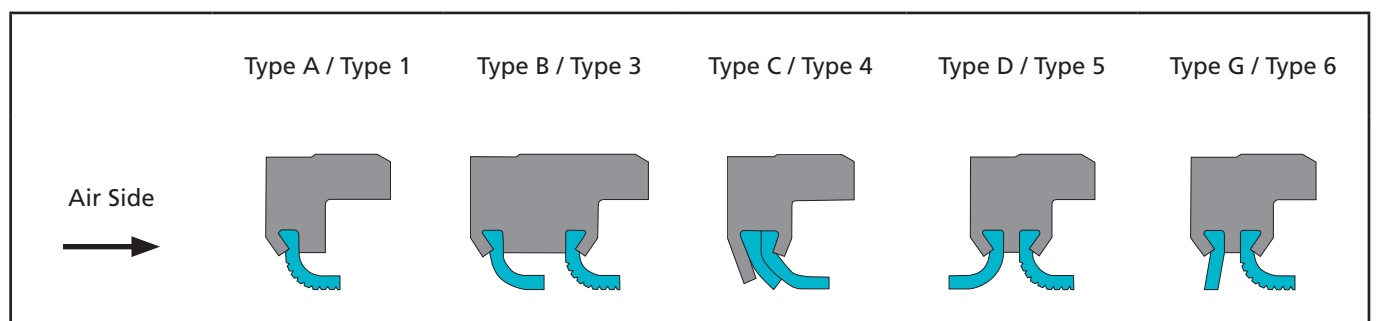
The material is selected from Table II and Table III.  
 (See page 5)

|                              |                       |
|------------------------------|-----------------------|
| TSS Article No.              | TJ A 3 B 0300 - T25 1 |
| Product Code                 |                       |
| Seal type                    |                       |
| Cross section                |                       |
| Lip Style                    |                       |
| Shaft-Ø x 10                 |                       |
| Quality Index (Standard)     |                       |
| Material code - sealing lip  |                       |
| Material code - sealing body |                       |

|                                                    |                                                                                     |
|----------------------------------------------------|-------------------------------------------------------------------------------------|
| Order as:                                          | TJA3B0300-T251                                                                      |
| Type:                                              | A, B, C, D, or G<br>1, 3, 4, 5 or 6<br>Refer to Figure 22 below                     |
| Cross Section:                                     | 1,2,3,4,5,6 or 7<br>Refer to Table of Sizes<br>(Pages 18 to 28)                     |
| Lip Style:<br>(Shaft rotation viewed from airside) | A, B, or C<br>A anti-clockwise shaft<br>B bi-directional shaft<br>C clockwise shaft |
| Shaft x 10:                                        | Refer to Table of Sizes<br>(Pages 18 to 28)                                         |
| Quality Index:                                     | - for standard parts<br>A for aerospace parts                                       |
| Lip Material:                                      | Refer to Materials section<br>(Page 5)                                              |
| Case Material:                                     | 1*                                                                                  |

\* - Other materials available on request  
 (See page 5)

Figure 22: Product Range





## ■ Engineering Action Request (EAR)

|                  |      |       |           |     |        |                |  |
|------------------|------|-------|-----------|-----|--------|----------------|--|
| Company name     |      |       |           |     |        | Agent/Salesman |  |
| Address          |      |       |           |     |        | Date           |  |
| Company products |      |       |           |     |        |                |  |
| Application      |      |       |           |     |        |                |  |
| Contacts         | Name | Title | Telephone | Fax | E-mail |                |  |
| Technical        |      |       |           |     |        |                |  |
| Purchasing       |      |       |           |     |        |                |  |

**Technical details** Where available a sample or drawing of an existing seal is helpful but insufficient for a viable design to be produced unless accompanied by the following information. Include installation drawing or scheme wherever possible.

| Shaft                                                          |                                    |          |          |                                         |                                                   |                                    |       |
|----------------------------------------------------------------|------------------------------------|----------|----------|-----------------------------------------|---------------------------------------------------|------------------------------------|-------|
| Diameter, with tolerances                                      |                                    |          |          | mm/in                                   | <input type="checkbox"/> <input type="checkbox"/> |                                    |       |
| Speed range                                                    | Maximum:                           | Typical: | Minimum: | RPM                                     |                                                   |                                    |       |
| Direction of rotation (when viewed from air/low pressure side) | Clockwise <input type="checkbox"/> |          |          | Anti-clockwise <input type="checkbox"/> | Bi-directional <input type="checkbox"/>           |                                    |       |
| Material and treatment                                         |                                    |          |          |                                         |                                                   |                                    |       |
| Surface roughness                                              |                                    |          |          | μm Rz                                   | μm Ra                                             |                                    |       |
| Hardness                                                       | HRC                                |          |          |                                         |                                                   |                                    |       |
| Dynamic eccentricity                                           | mm/in TIR                          |          |          |                                         |                                                   |                                    |       |
| Static housing-to-shaft offset                                 | mm/in to center                    |          |          |                                         |                                                   |                                    |       |
| Axial movement and frequency                                   | mm/in per                          |          |          |                                         |                                                   |                                    |       |
| Shaft type at sealing point                                    | Solid <input type="checkbox"/>     |          |          | Hollow <input type="checkbox"/>         | Sleeve <input type="checkbox"/>                   | Thickness <input type="checkbox"/> | mm/in |

| Housing                                                        |                                                                         |          |          |                                                      |                                                   |  |  |
|----------------------------------------------------------------|-------------------------------------------------------------------------|----------|----------|------------------------------------------------------|---------------------------------------------------|--|--|
| Diameter, with tolerances                                      |                                                                         |          |          | mm/in                                                | <input type="checkbox"/> <input type="checkbox"/> |  |  |
| Depth of recess                                                |                                                                         |          |          | mm/in                                                |                                                   |  |  |
| Speed range                                                    | Maximum:                                                                | Typical: | Minimum: | RPM                                                  |                                                   |  |  |
| Direction of rotation (when viewed from air/low pressure side) | Clockwise <input type="checkbox"/>                                      |          |          | Anti-clockwise <input type="checkbox"/>              | Bi-directional <input type="checkbox"/>           |  |  |
| Housing type                                                   | Axially split (split line will bisect seal OD) <input type="checkbox"/> |          |          | Homogeneous (no split line) <input type="checkbox"/> |                                                   |  |  |
| Material and treatment                                         |                                                                         |          |          |                                                      |                                                   |  |  |
| Surface roughness                                              |                                                                         |          | μm Rz    | μm Rmax                                              | μm Ra                                             |  |  |
| Hardness                                                       | HRC                                                                     |          |          |                                                      |                                                   |  |  |

| Environment                                        |                                     |                                       |                                 |
|----------------------------------------------------|-------------------------------------|---------------------------------------|---------------------------------|
| Type of fluid to be retained                       |                                     |                                       |                                 |
| Fluid level relative to shaft center line          |                                     |                                       |                                 |
| Shaft orientation during normal operation          | Horizontal <input type="checkbox"/> | Vertical <input type="checkbox"/>     |                                 |
| Any other media seal may contact                   | Dust/dirt <input type="checkbox"/>  | Water splash <input type="checkbox"/> | Other: <input type="checkbox"/> |
| Working temperature                                | °C/°F                               |                                       |                                 |
| Maximum and minimum temperatures                   | °C/°F                               |                                       |                                 |
| Maximum and minimum pressure differential          | Bar                                 |                                       | Cycle Rate                      |
| Maximum test pressure                              | Bar/psi                             |                                       |                                 |
| Is seal subject to pressure without shaft rotation | Yes <input type="checkbox"/>        | No <input type="checkbox"/>           |                                 |

**Purchasing details** Note that this information will have an effect on the design solution offered. If actual data is unknown, please use estimations.

|                                   |                                    |                                   |                                     |
|-----------------------------------|------------------------------------|-----------------------------------|-------------------------------------|
| Drawing number (if available)     |                                    |                                   |                                     |
| Would a test program be necessary | TSS <input type="checkbox"/>       | Customer <input type="checkbox"/> | No <input type="checkbox"/>         |
| Type of release                   | Aerospace <input type="checkbox"/> | Defence <input type="checkbox"/>  | Industrial <input type="checkbox"/> |
| Annual usage                      | Proportion we could expect         |                                   |                                     |
| Rate of call off                  | Supply commencement date           |                                   |                                     |
| Prototype quantity                | Date prototypes required           |                                   |                                     |

## This image shows a full page of blank graph paper. The grid consists of small, uniform squares formed by thin, light blue horizontal and vertical lines. There are no margins, text, or other markings on the page.



## This image shows a full page of blank graph paper. The grid consists of small, uniform squares formed by thin, light blue lines. There are no margins, text, or other markings on the page.



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| <b>Belgium – Dion-Valmont</b><br>(Luxembourg)                                               | +32 (0) 10 22 57 50   | <b>Brazil – São José dos Campos</b>                                                                 | +55 12 3932 7600     |
| <b>Bulgaria – Sofia</b><br>(Belarus, Romania, Ukraine)                                      | +359 (0) 2 969 95 99  | <b>Canada – Etobicoke, ON</b>                                                                       | +1 416 213 9444      |
| <b>Croatia – Zagreb</b><br>(Albania, Bosnia and Herzegovina, Macedonia, Serbia, Montenegro) | +385 (0) 1 24 56 387  | <b>Canada East – Montreal, QC</b>                                                                   | +1 514 284 1114      |
| <b>Czech Republic – Rakovník</b><br>(Slovakia)                                              | +420 313 529 111      | <b>Canada West – Langley, BC</b>                                                                    | +1 604 539 0098      |
| <b>Denmark – Copenhagen</b>                                                                 | +45 48 22 80 80       | <b>Mexico – Mexico City</b>                                                                         | +52 55 57 19 50 05   |
| <b>Finland – Vantaa</b><br>(Estonia, Latvia)                                                | +385 (0) 207 12 13 50 | <b>USA, Great Lakes – Fort Wayne, IN</b>                                                            | +1 260 482 4050      |
| <b>France – Maisons-Laffitte</b>                                                            | +33 (0) 1 30 86 56 00 | <b>USA, Midsouth – Mt. Juliet, TN</b>                                                               | +1 615 800 8340      |
| <b>Germany – Stuttgart</b>                                                                  | +49 (0) 711 7864 0    | <b>USA, Midwest – Hanover Park, IL</b>                                                              | +1 630 539 5500      |
| <b>Greece</b>                                                                               | +41 (0) 21 631 41 11  | <b>USA, Northern California – Fresno, CA</b>                                                        | +1 559 449 6070      |
| <b>Hungary – Budaörs</b>                                                                    | +36 (06) 23 50 21 21  | <b>USA, Northwest – Portland, OR</b>                                                                | +1 503 595 6565      |
| <b>Italy – Livorno</b>                                                                      | +39 0586 22 6111      | <b>USA, Southwest – Houston, TX</b>                                                                 | +1 713 461 3495      |
| <b>The Netherlands – Rotterdam</b>                                                          | +31 (0) 10 29 22 111  |                                                                                                     |                      |
| <b>Norway – Oslo</b>                                                                        | +47 22 64 60 80       | <b>Asia Pacific</b>                                                                                 | <b>Telephone</b>     |
| <b>Poland – Warsaw</b><br>(Lithuania)                                                       | +48 (0) 22 863 30 11  | <b>Asia Pacific Regional</b>                                                                        | +65 6 577 1778       |
| <b>Russia – Moscow</b>                                                                      | +7 495 982 39 21      | <b>China – Hong Kong</b>                                                                            | +852 2366 9165       |
| <b>Spain – Madrid</b><br>(Portugal)                                                         | +34 (0) 91 71057 30   | <b>China – Shanghai</b>                                                                             | +86 (0) 21 6145 1830 |
| <b>Sweden – Jönköping</b>                                                                   | +46 (0) 36 34 15 00   | <b>India – Bangalore</b>                                                                            | +91 (0) 80 3372 9000 |
| <b>Switzerland – Crissier</b>                                                               | +41 (0) 21 631 41 11  | <b>Japan – Tokyo</b>                                                                                | +81 (0) 3 5633 8008  |
| <b>Turkey – Istanbul</b>                                                                    | +90 216 569 80 84     | <b>Korea – Seoul</b>                                                                                | +82 (0) 2 761 3471   |
| <b>United Kingdom – Solihull</b><br>(Eire)                                                  | +44 (0) 121 744 1221  | <b>Malaysia – Kuala Lumpur</b>                                                                      | +60 (0) 3 9059 6388  |
| <b>Africa Regional</b>                                                                      | +41 (0) 21 631 41 11  | <b>Taiwan – Taichung</b>                                                                            | +886 4 2382 8886     |
|                                                                                             |                       | <b>Thailand – Bangkok</b>                                                                           | +66 (0) 2732 2861    |
|                                                                                             |                       | <b>Singapore</b>                                                                                    |                      |
|                                                                                             |                       | <b>and all other countries in Asia</b>                                                              | +65 6 577 1778       |
|                                                                                             |                       | <b>Middle East Regional</b><br>(Without GCC Region)                                                 | +41 (0) 21 631 41 11 |
|                                                                                             |                       | <b>Middle East GCC Region</b><br>(Bahrain, Kuwait, Oman, Qatar, Saudi Arabia, United Arab Emirates) | +91 (0) 80 2245 5157 |



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