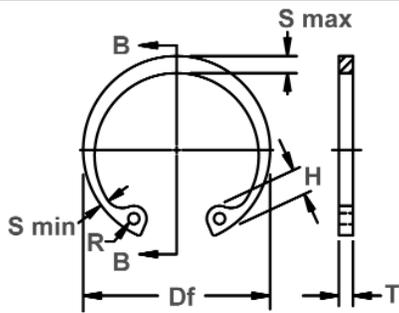




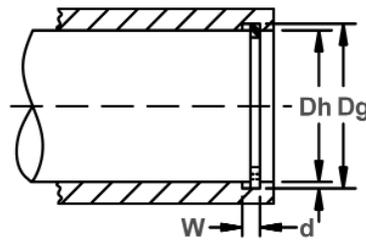
HO Housing Rings

Axially Assembled, Internal

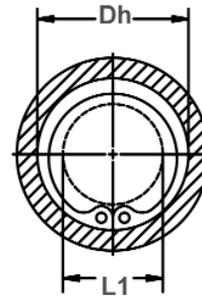
Once installed in the groove of a housing/bore, the portion of the ring protruding from the groove (also called a "shoulder") holds an assembly in place.



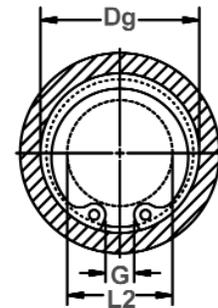
Free Diameter & Ring Measurements with Section B-B



Housing Diameter & Groove Dimensions



Clearance Diameter Compressed in Housing



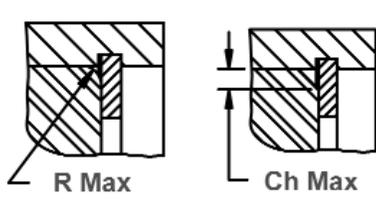
Clearance Diameter & Gap Width Released in Groove

RING NO.	HOUSING DIAMETER			GROOVE SIZE			RING SIZE & WEIGHT				CLEARANCE DIA.			THRUST LD.(lbs.) Sqr. corner abutment			
	Dh DEC	Dh FRAC	Dh mm	DIAMETER		WIDTH		DEPTH	FREE DIAMETER	THICKNESS***	Wght. Per 1000 Pcs.	Compressed in housing	Re-released in groove	Ring Safety Factor of 4	Groove Safety Factor of 2		
				Dg	Tol.	W	Tol.	d	Df	Tol.						T	Tol.
HO-25	.250	1/4	6.4	.268	±.001	.020	+.002	.009	.280		.015		.08	.115	.133	426	190
HO-31	.312	5/16	7.9	.330	.0015*	.020	-.000	.009	.346		.015		.11	.173	.191	538	240
HO-37	.375	3/8	9.5	.397	±.002	.029		.011	.415		.025		.25	.204	.226	1066	350
HO-43	.438	7/16	11.1	.461	.002*	.029		.012	.482		.025		.37	.23	.254	1238	440
HO-45	.453	29/64	11.5	.477		.029		.012	.498		.025		.43	.25	.274	1299	460
HO-50	.500	1/2	12.7	.530		.039		.015	.548	+.010	.035		.70	.26	.290	2010	510
HO-51	.512	-	13.0	.542	±.002	.039		.015	.560	-.005	.035		.77	.27	.300	2060	520
HO-56	.562	9/16	14.3	.596	.004*	.039		.017	.620		.035		.86	.275	.305	2253	710
HO-62	.625	5/8	15.9	.665		.039		.020	.694		.035		1.0	.34	.380	2507	1050
HO-68	.688	11/16	17.5	.732		.039		.022	.763		.035		1.2	.40	.440	2741	1280
HO-75	.750	3/4	19.0	.796		.039	+.003	.023	.831		.035		1.3	.45	.490	3045	1460
HO-77	.777	-	19.7	.825		.046	-.000	.024	.859		.042		1.7	.475	.520	4618	1580
HO-81	.812	13/16	20.6	.862		.046		.025	.901		.042		1.9	.49	.540	4872	1710
HO-86	.866	-	22.0	.920	±.003	.046		.027	.961		.042		2.0	.54	.590	5177	1980
HO-87	.875	7/8	22.2	.931	.004*	.046		.028	.971		.042		2.1	.545	.600	5227	2080
HO-90	.901	-	22.9	.959		.046		.029	1.000	+.015	.042		2.2	.565	.620	5430	2200
HO-93	.938	15/16	23.8	1.000		.046		.031	1.041	-.010	.042	±.002	2.4	.61	.670	5684	2450
HO-100	1.000	1	25.4	1.066		.046		.033	1.111		.042		2.7	.665	.730	6039	2800
HO-102	1.023	-	26.0	1.091		.046		.034	1.136		.042		2.8	.69	.755	6141	3000
HO-106	1.062	1-1/16	27.0	1.130		.056		.034	1.180		.050		3.7	.685	.750	7562	3050
HO-112	1.125	1-1/8	28.6	1.197		.056		.036	1.249		.050		4.0	.745	.815	8019	3400
HO-118	1.181	-	30.0	1.255		.056		.037	1.319		.050		4.3	.79	.860	8526	3700
HO-118	1.188	1-3/16	30.2	1.262	±.004	.056		.037	1.319		.050		4.3	.80	.870	8526	3700
HO-125	1.250	1-1/4	31.7	1.330	.005*	.056		.040	1.388	+.025	.050		4.8	.875	.955	8932	4250
HO-125	1.259	-	32.0	1.339		.056		.040	1.388	-.020	.050		4.8	.885	.965	8932	4250
HO-131	1.312	1-5/16	33.3	1.396		.056		.042	1.456		.050		5.0	.93	1.01	9440	4700
HO-137	1.375	1-3/8	34.9	1.461		.056		.043	1.526		.050		5.1	.99	1.07	9846	5050
HO-137	1.378	-	35.0	1.464		.056	+.004	.043	1.526		.050		5.1	.99	1.07	9846	5050
HO-143	1.438	1-7/16	36.5	1.528		.056	-.000	.045	1.596		.050		5.8	1.06	1.15	10353	5500
HO-145	1.456	-	37.0	1.548		.056		.046	1.616		.050		6.4	1.08	1.17	10455	5700
HO-150	1.500	1-1/2	38.1	1.594		.056		.047	1.660		.050		6.5	1.12	1.21	10708	6000
HO-156	1.562	1-9/16	39.7	1.658		.068		.048	1.734		.062		8.9	1.14	1.23	13906	6350
HO-156	1.575	-	40.0	1.671		.068		.048	1.734		.062		8.9	1.15	1.24	13906	6350
HO-162	1.625	1-5/8	41.3	1.725	±.005	.068		.050	1.804	+.035	.062		10.0	1.15	1.25	14413	6900
HO-165	1.653	-	42.0	1.755	.005*	.068		.051	1.835	-.025	.062	±.003	10.4	1.17	1.27	14718	7200
HO-168	1.688	1-11/16	42.9	1.792		.068		.052	1.874		.062		10.8	1.23	1.33	15022	7450
HO-175	1.750	1-3/4	44.4	1.858		.068		.054	1.942		.062		10.3	1.26	1.36	15580	8050
HO-181	1.812	1-13/16	46.0	1.922		.068		.055	2.012		.062		11.5	1.34	1.38	16139	8450

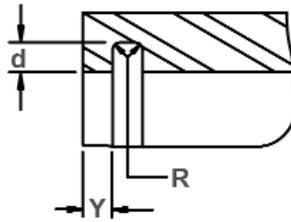
* F.I.M. (FULL INDICATOR MOVEMENT)- MAXIMUM ALLOWABLE DEVIATION OF CONCENTRICITY BETWEEN GROOVE & HOUSING.

† BASED ON HOUSINGS/SHAFTS MADE OF COLD ROLLED STEEL. FOR AN EXPLANATION OF FORMULAS USED TO DERIVE THRUST LOAD AND OTHER PERFORMANCE DATA CONTACT THE ROTOR CLIP ENGINEERING DEPARTMENT.

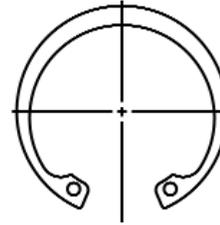
***FOR PLATED RINGS ADD .002" TO THE LISTED MAXIMUM THICKNESS. MAXIMUM THICKNESS WILL BE A MINIMUM OF .0002" LESS THAN THE LISTED GROOVE WIDTH (W) MINIMUM.



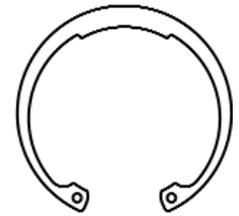
Allowable Corner Radius and Chamfer



Exploded Groove Profile & Edge Margin (Y)
Maximum bottom radii (R), .005 for ring sizes
-25 thru -100; .010 for ring sizes 102 thru 1000



Alternate Lug Design
For Larger Sizes
(Manufacturer's Option)



Alternate Design
(Manufacturer's Option)

RING NO.	LUG HEIGHT		MAXIMUM SECTION		MINIMUM SECTION		HOLE DIAMETER		GAP WIDTH Ring in Groove	ALLOWABLE CORNER RADII & CHAMFERS			MAX. LOAD w/ R max or Ch max (lbs.)	EDGE MARGIN Y	
	H	Tol.	S max	Tol.	S min	Tol.	R	Tol.		G Min	R max	Ch max			
HO-25	.065	±.003	.025	±.002	.015	±.002	.031		.047	.011	.0085	190	.027		
HO-31	.066		.033		.018		.031		.055	.016	.013	190	.027		
HO-37	.082		.040		.028		.041		.063	.023	.018	530	.033		
HO-43	.098	±.003	.049	±.003	.029	±.003	.041		.063	.027	.021	530	.036		
HO-45	.098		.050		.030		.047		.071	.027	.021	530	.036		
HO-50	.114		.053		.035		.047		.090	.027	.021	1100	.045		
HO-51	.114	±.004	.053	±.004	.035	±.004	.047	+ .010 - .002	.092	.027	.021	1100	.045		
HO-56	.132		.053				.035			.047	.095	.027	.021	1100	.051
HO-62	.132		.060				.035			.062	.104	.027	.021	1100	.060
HO-68	.132	±.005	.063	±.005	.036	±.005	.062		.118	.027	.021	1100	.066		
HO-75	.142		.070				.040			.062	.143	.032	.025	1100	.069
HO-77	.146		.074				.044			.062	.145	.035	.028	1650	.072
HO-81	.155	±.005	.077	±.005	.044	±.005	.062		.153	.035	.028	1650	.075		
HO-86	.155		.081				.045			.062	.172	.035	.028	1650	.081
HO-87	.155		.084				.045			.062	.179	.035	.028	1650	.084
HO-90	.155	±.005	.087	±.005	.047	±.005	.062		.188	.038	.030	1650	.087		
HO-93	.155		.091				.050			.062	.200	.038	.030	1650	.093
HO-100	.155		.104				.052			.062	.212	.042	.034	1650	.099
HO-102	.155	±.005	.106	±.005	.054	±.005	.062		.220	.042	.034	1650	.102		
HO-106	.180		.110				.055			.078	.213	.044	.035	2400	.102
HO-112	.180		.116				.057			.078	.232	.047	.036	2400	.108
HO-118	.180	±.006	.120	±.006	.058	±.006	.078		.226	.047	.036	2400	.111		
HO-118	.180		.120				.058			.078	.245	.047	.036	2400	.111
HO-125	.180		.124				.062			.078	.265	.048	.038	2400	.120
HO-125	.180	±.006	.124	±.006	.062	±.006	.078		.290	.048	.038	2400	.120		
HO-131	.180		.130				.062			.078	.284	.048	.038	2400	.126
HO-137	.180		.130				.063			.078	.297	.048	.038	2400	.129
HO-137	.180	±.015 - .002	.130	±.015 - .002	.063	±.015 - .002	.078		.305	.048	.038	2400	.129		
HO-143	.180		.133				.065			.078	.313	.048	.038	2400	.135
HO-145	.180		.133				.065			.078	.320	.048	.038	2400	.138
HO-150	.180	±.007	.133	±.007	.066	±.007	.078		.340	.048	.038	2400	.141		
HO-156	.202		.157				.078			.078	.338	.064	.050	3900	.144
HO-156	.202		.157				.078			.078	.374	.064	.050	3900	.144
HO-162	.227	±.007	.164	±.007	.082	±.007	.078		.339	.064	.050	3900	.150		
HO-165	.230		.167				.083			.078	.348	.064	.050	3900	.153
HO-168	.230		.170				.085			.078	.357	.064	.050	3900	.156
HO-175	.230	±.007	.170	±.007	.083	±.007	.078		.372	.064	.050	3900	.162		
HO-181	.230		.170				.084			.093	.382	.064	.050	3900	.165

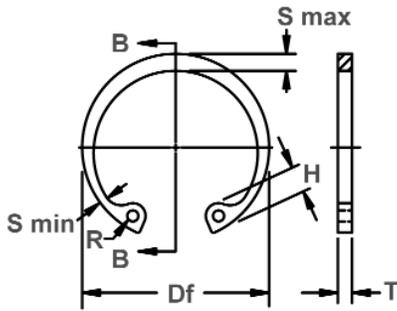
FOR HARDNESS SPECIFICATIONS, SEE END OF THIS SECTION



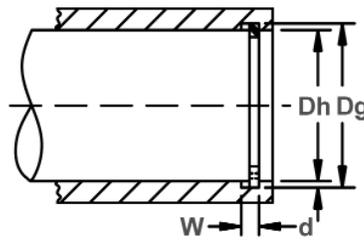
HO Housing Rings

Axially Assembled, Internal

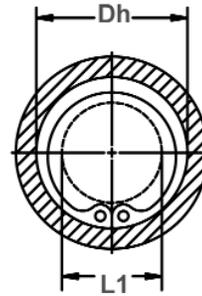
Once installed in the groove of a housing/bore, the portion of the ring protruding from the groove (also called a "shoulder") holds an assembly in place.



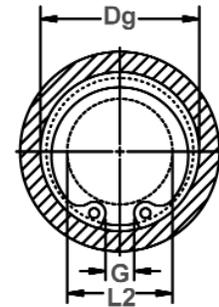
Free Diameter & Ring Measurements with Section B-B



Housing Diameter & Groove Dimensions



Clearance Diameter Compressed in Housing



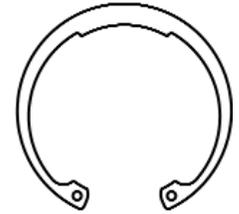
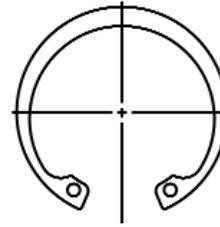
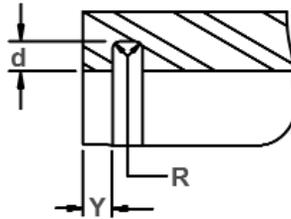
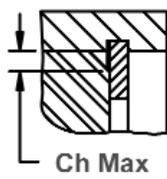
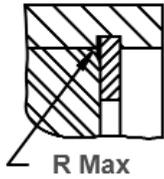
Clearance Diameter & Gap Width Released in Groove

RING NO.	HOUSING DIAMETER			GROOVE SIZE			RING SIZE & WEIGHT				CLEARANCE DIA.			THRUST LD. (lbs.)			
				DIAMETER		WIDTH	DEPTH	Free Diameter		Thickness***		Wght. Per 1000 Pcs.	Compressed in housing	Re-leased in groove	Sqr. corner abutment		
	Dh DEC	Dh FRAC	Dh mm	Dg	Tol.	W	Tol.	d	Df	Tol.	T				Tol.	L1	L2
HO-185	1.850	-	47.0	1.962		.068		.056	2.054		.062		12.8	1.35	1.46	16443	8750
HO-187	1.875	1-7/8	47.6	1.989	±.005	.068	+.004	.057	2.072	+.035	.062		12.8	1.37	1.48	16697	9050
HO-193	1.938	1-15/16	49.2	2.056	.005*	.068	-.000	.059	2.141	-.025	.062		13.3	1.46	1.58	17255	9700
HO-200	2.000	2	50.8	2.122		.068		.061	2.210		.062		14.0	1.52	1.64	17763	10300
HO-206	2.047	-	52.0	2.171		.086		.062	2.280		.078		18.0	1.52	1.64	23091	10850
HO-206	2.062	2-1/16	52.4	2.186		.086		.062	2.280		.078		18.0	1.54	1.66	23091	10850
HO-212	2.125	2-1/8	54.0	2.251		.086		.063	2.350		.078		19.4	1.58	1.70	23751	11350
HO-218	2.165	-	55.0	2.295		.086		.065	2.415		.078		19.6	1.63	1.75	24461	12050
HO-218	2.188	2-3/16	55.6	2.318		.086		.065	2.415		.078		19.6	1.66	1.79	24461	12050
HO-225	2.250	2-1/4	57.1	2.382		.086		.066	2.490		.078		21.8	1.67	1.80	25223	12600
HO-231	2.312	2-5/16	58.7	2.450		.086		.069	2.560		.078		22.6	1.73	1.93	25832	13550
HO-237	2.375	2-3/8	60.3	2.517		.086		.071	2.630		.078		23.2	1.79	1.86	26542	14300
HO-244	2.440	2-7/16	62.0	2.584		.086		.072	2.702	+.040	.078		25.4	1.86	2.00	27304	14900
HO-250	2.500	2-1/2	63.5	2.648		.086		.074	2.775	-.030	.078		25.5	1.91	2.05	28014	15650
HO-250	2.531	2-17/32	64.3	2.681		.086		.075	2.775		.078		25.5	1.94	2.09	28014	15650
HO-256	2.562	2-9/16	65.1	2.714		.103		.076	2.844		.093		34.0	1.93	2.08	34206	16500
HO-262	2.625	2-5/8	66.7	2.781	±.006	.103	+.005	.078	2.910		.093	±.003	34.5	2.02	2.17	35068	17350
HO-268	2.677	-	68.0	2.837	.006*	.103	-.000	.080	2.980		.093		35.0	2.05	2.21	35931	18250
HO-268	2.688	2-11/16	68.3	2.848		.103		.080	2.980		.093		35.0	2.06	2.22	35931	18250
HO-275	2.750	2-3/4	69.8	2.914		.103		.082	3.050		.093		35.5	2.12	2.28	36642	19200
HO-281	2.812	2-13/16	71.4	2.980		.103		.084	3.121		.093		36.0	2.18	2.34	37504	20050
HO-281	2.835	-	72.0	3.006		.103		.085	3.121		.093		36.0	2.21	2.38	37504	20050
HO-287	2.875	2-7/8	73.0	3.051		.103		.088	3.191		.093		41.0	2.24	2.41	38367	21500
HO-300	2.953	-	75.0	3.135		.103		.091	3.325		.093		42.5	2.32	2.50	40093	23150
HO-300	3.000	3	76.2	3.182		.103		.091	3.325		.093		42.5	2.37	2.55	40093	23150
HO-306	3.062	3-1/16	77.8	3.248		.120		.093	3.418		.109		53.0	2.41	2.59	47807	24100
HO-312	3.125	3-1/8	79.4	3.315		.120		.095	3.488		.109		56.0	2.47	2.66	48822	25200
HO-315	3.149	-	80.0	3.341		.120		.096	3.523		.109		57.0	2.49	2.68	49329	25700
HO-315	3.156	3-5/32	80.2	3.348		.120		.096	3.523		.109		57.0	2.50	2.69	49329	25700
HO-325	3.250	3-1/4	82.5	3.446		.120		.098	3.623	±.055	.109		60.0	2.54	2.73	50750	27000
HO-334	3.346	3-11/32	85.0	3.546		.120		.100	3.734		.109		65.0	2.63	2.83	52374	28300
HO-347	3.469	3-15/32	88.1	3.675		.120		.103	3.857		.109		69.0	2.76	2.96	54201	30200
HO-350	3.500	3-1/2	88.9	3.710		.120		.105	3.890		.109		71.0	2.79	3.00	54709	31200
HO-354	3.543	-	90.0	3.755		.120		.106	3.936		.109		72.0	2.83	3.04	55419	31800
HO-354	3.562	3-9/16	90.5	3.776		.120		.107	3.936		.109		72.0	2.85	3.06	55419	31800
HO-362	3.625	3-5/8	92.1	3.841		.120		.108	4.024		.109		73.0	2.91	3.12	56739	33200
HO-375	3.740	-	95.0	3.964		.120		.112	4.157	±.065	.109		78.0	3.02	3.24	58566	35600
HO-375	3.750	3-3/4	95.2	3.974		.120		.112	4.157		.109		78.0	3.03	3.25	58566	35600

* F.I.M. (FULL INDICATOR MOVEMENT)- MAXIMUM ALLOWABLE DEVIATION OF CONCENTRICITY BETWEEN GROOVE & HOUSING.

† BASED ON HOUSINGS/SHAFTS MADE OF COLD ROLLED STEEL. FOR AN EXPLANATION OF FORMULAS USED TO DERIVE THRUST LOAD AND OTHER PERFORMANCE DATA CONTACT THE ROTOR CLIP ENGINEERING DEPARTMENT.

***FOR PLATED RINGS ADD .002" TO THE LISTED MAXIMUM THICKNESS. MAXIMUM THICKNESS WILL BE A MINIMUM OF .0002" LESS THAN THE LISTED GROOVE WIDTH (W) MINIMUM.



Allowable Corner Radius and Chamfer

Exploded Groove Profile & Edge Margin (Y)
Maximum bottom radii (R), .005 for ring sizes
-25 thru -100; .010 for ring sizes 102 thru 1000

Alternate Lug Design
For Larger Sizes
(Manufacturer's Option)

Alternate Design
(Manufacturer's Option)

RING NO.	LUG HEIGHT		MAXIMUM SECTION		MINIMUM SECTION		HOLE DIAMETER		GAP WIDTH Ring in Groove		ALLOWABLE CORNER RADII & CHAMFERS			MAX. LOAD w/ R max or Ch max (lbs.)		EDGE MARGIN	
	H	Tol.	S max	Tol.	S min	Tol.	R	Tol.	G Min	R max	Ch max	Pr	Y				
HO-185	.234		.170		.085		.093		.360	.064	.050	3900	.168				
HO-187	.234		.170		.085		.093		.430	.064	.050	3900	.171				
HO-193	.230		.170		.085		.093		.438	.064	.050	3900	.177				
HO-200	.230		.170		.085		.093		.453	.064	.050	3900	.183				
HO-206	.250		.186		.091		.093		.428	.078	.061	6200	.186				
HO-206	.250		.186		.091		.093		.468	.078	.062	6200	.186				
HO-212	.250		.195		.096		.093		.460	.078	.062	6200	.189				
HO-218	.250		.199		.098		.093		.439	.078	.062	6200	.195				
HO-218	.250		.199		.098		.093		.489	.078	.062	6200	.195				
HO-225	.280		.203		.099		.093		.478	.078	.062	6200	.198				
HO-231	.280	±.005	.206	±.007	.100	±.007	.093		.486	.078	.062	6200	.207				
HO-237	.280		.207		.102		.093		.504	.078	.062	6200	.213				
HO-244	.280		.209		.103		.110		.518	.078	.062	6200	.216				
HO-250	.280		.210		.103		.110		.532	.078	.062	6200	.222				
HO-250	.280		.210		.103		.110	+ .015	.597	.078	.062	6200	.225				
HO-256	.300		.222		.109		.110	- .002	.540	.088	.070	9000	.228				
HO-262	.290		.226		.111		.110		.558	.088	.070	9000	.234				
HO-268	.300		.230		.113		.110		.539	.090	.072	9000	.240				
HO-268	.300		.230		.113		.110		.568	.090	.072	9000	.240				
HO-275	.300		.234		.115		.110		.590	.092	.074	9000	.246				
HO-281	.300		.230		.115		.110		.615	.088	.070	9000	.252				
HO-281	.300		.230		.115		.110		.676	.088	.070	9000	.255				
HO-287	.300		.240		.120		.110		.626	.092	.074	9000	.264				
HO-300	.300		.250		.122		.110		.619	.092	.074	9000	.273				
HO-300	.300		.250		.122		.110		.738	.092	.074	9000	.273				
HO-306	.310		.254		.126		.125		.651	.097	.078	12000	.279				
HO-312	.310		.259		.129		.125		.655	.099	.079	12000	.285				
HO-315	.310		.262		.129		.125		.650	.100	.080	12000	.288				
HO-315	.310		.262		.129		.125		.669	.100	.080	12000	.288				
HO-325	.342		.269		.135		.125		.698	.104	.083	12000	.294				
HO-334	.342	±.008	.276	±.008	.140	±.008	.125		.705	.108	.086	12000	.300				
HO-347	.342		.286		.144		.125		.763	.108	.086	12000	.309				
HO-350	.342		.289		.142		.125		.774	.110	.088	12000	.315				
HO-354	.342		.292		.142		.125		.788	.110	.088	12000	.318				
HO-354	.342		.292		.142		.125		.842	.110	.088	12000	.321				
HO-362	.342		.299		.150		.125		.833	.116	.093	12000	.324				
HO-375	.342		.309		.155		.125		.844	.120	.096	12000	.336				
HO-375	.342		.309		.155		.125		.871	.120	.096	12000	.336				

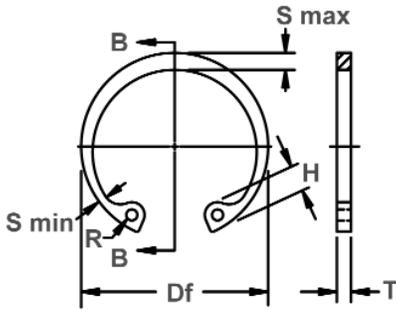
FOR HARDNESS SPECIFICATIONS, SEE END OF THIS SECTION



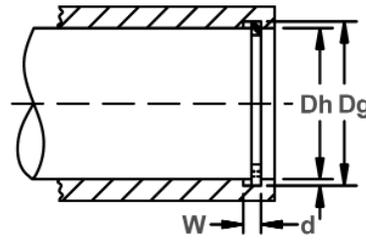
HO Housing Rings

Axially Assembled, Internal

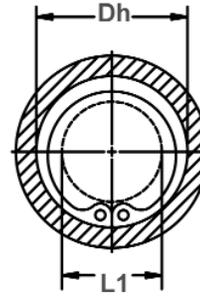
Once installed in the groove of a housing/bore, the portion of the ring protruding from the groove (also called a "shoulder") holds an assembly in place.



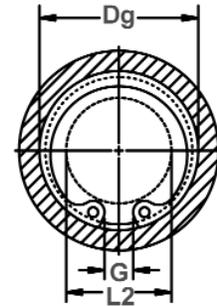
Free Diameter & Ring Measurements with Section B-B



Housing Diameter & Groove Dimensions



Clearance Diameter Compressed in Housing



Clearance Diameter & Gap Width Released in Groove

RING NO.	HOUSING DIAMETER			GROOVE SIZE			RING SIZE & WEIGHT				CLEAR. DIA.			† THRUST LD. (lbs.)			
				DIAMETER		WIDTH	DEPTH	Free Diameter		Thickness***		Weight. Per 1000 Pcs.	Compressed in housing	Released in groove	Sqr. corner abutment	Ring Safety Factor of 4	Groove Safety Factor of 2
	Dh DEC	Dh FRAC	Dh mm	Dg	Tol.	W	Tol.	d	Df	Tol.	T						
HO-387	3.875	3-7/8	98.4	4.107		.120		.116	4.291		.109		87.0	3.11	3.34	60494	38000
HO-393	3.938	3-15/16	100.0	4.174		.120		.118	4.358		.109		88.0	3.17	3.40	61611	39300
HO-400	4.000	4	101.6	4.240		.120		.120	4.424		.109		93.0	3.23	3.47	62626	40700
HO-412	4.125	4-1/8	104.8	4.365		.120		.120	4.558		.109		97.0	3.36	3.60	64554	42000
HO-425	4.250	4-1/4	108.0	4.490	±.006	.120	+ .005	.120	4.691		.109	±.003	101.0	3.48	3.72	66483	43200
HO-433	4.331	-	110.0	4.571	.006*	.120	-.000	.120	4.756		.109		105.0	3.50	3.74	67599	44500
HO-450	4.500	4-1/2	114.3	4.740		.120		.120	4.940		.109		111.0	3.66	3.90	70340	45800
HO-462	4.625	4-5/8	117.5	4.865		.120		.120	5.076	±.065	.109		117.0	3.79	4.03	72370	47000
HO-475	4.724	-	120.0	4.969		.120		.122	5.213		.109		124.0	3.88	4.12	74298	49000
HO-475	4.750	4-3/4	120.6	4.995		.120		.122	5.213		.109		124.0	3.90	4.14	74298	49000
HO-500	5.000	5	127.0	5.260		.120		.130	5.485		.109		136.0	4.08	4.34	78155	55000
HO-525	5.250	5-1/4	133.3	5.520		.139		.135	5.770		.125		174.0	4.35	4.62	94091	60000
HO-537	5.375	5-3/8	136.5	5.650	±.007	.139	+ .006	.135	5.910		.125	±.004	179.0	4.45	4.72	96324	61500
HO-550	5.500	5-1/2	139.7	5.770	.006*	.139	-.000	.135	6.066		.125		183.0	4.57	4.84	98658	63300
HO-575	5.750	5-3/4	146.0	6.020		.139		.135	6.336		.125		192.0	4.82	5.09	103124	65900
HO-600	6.000	6	152.4	6.270		.139		.135	6.620		.125		202.1	5.07	5.34	107489	68600
HO-625	6.250	6-1/4	158.7	6.530		.174		.140	6.895		.156		266.0	5.24	5.52	139766	74100
HO-650	6.500	6-1/2	165.1	6.790		.174		.145	7.170		.156		281.0	5.49	5.78	145450	79900
HO-662	6.625	6-5/8	168.3	6.925		.174		.150	7.308	±.080	.156		305.0	5.60	5.90	148190	84200
HO-675	6.750	6-3/4	171.4	7.055		.174		.152	7.445		.156		325.0	5.68	5.98	151032	87000
HO-700	7.000	7	177.8	7.315		.174		.157	7.720		.156		344.0	5.91	6.22	156615	93100
HO-725	7.250	7-1/4	184.1	7.575		.209		.162	7.995		.187		428.0	6.11	6.43	194373	99600
HO-750	7.500	7-1/2	190.5	7.840	±.008	.209	+ .008	.170	8.270		.187	±.005	485.0	6.36	6.70	201173	108100
HO-775	7.750	7-3/4	196.8	8.100	.006*	.209	-.000	.175	8.545		.187		520.0	6.58	6.93	207872	115000
HO-800	8.000	8	203.2	8.360		.209		.180	8.820		.187		555.0	6.83	7.19	214571	122000
HO-825	8.250	8-1/4	209.5	8.620		.209		.185	9.095		.187		603.0	7.04	7.41	221270	129300
HO-850	8.500	8-1/2	215.9	8.880		.209		.190	9.285	±.090	.187		634.0	7.29	7.67	227969	136900
HO-875	8.750	8-3/4	222.2	9.145		.209		.197	9.558		.187		653.0	7.38	7.77	233856	145500
HO-900	9.000	9	228.6	9.405		.209		.202	9.830		.187		732.0	7.63	8.03	241367	154100
HO-925	9.250	9-1/4	235.0	9.668		.209		.209	10.102		.187		767.0	7.88	8.30	248066	163600
HO-950	9.500	9-1/2	241.3	9.930		.209		.215	10.375		.187		803.0	7.98	8.41	254765	173100
HO-975	9.750	9-3/4	247.7	10.190		.209		.220	10.648		.187		833.0	8.23	8.67	261464	181900
HO-1000	10.000	10	254.0	10.450		.209		.225	10.920		.187		863.0	8.48	8.93	268163	190700

* F.I.M. (FULL INDICATOR MOVEMENT)- MAXIMUM ALLOWABLE DEVIATION OF CONCENTRICITY BETWEEN GROOVE & HOUSING.

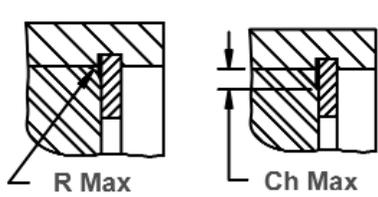
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***FOR PLATED RINGS ADD .002" TO THE LISTED MAXIMUM THICKNESS. MAXIMUM THICKNESS WILL BE A MINIMUM OF .0002" LESS THAN THE LISTED GROOVE WIDTH (W) MINIMUM.

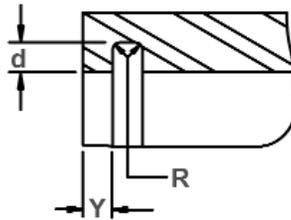
HARDNESS RANGES: STAINLESS STEEL RINGS (PH 15-7MO)

RING TYPE	SIZE RANGE	SCALE	ROCKWELL HARDNESS
HO	25&31	15N	82.5-86
	37-102	30N	63-69.5
	106+	C	44-51

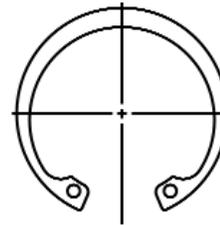




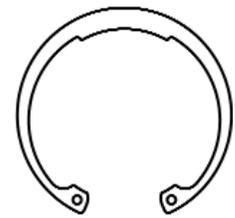
Allowable Corner Radius and Chamfer



Exploded Groove Profile & Edge Margin (Y)
Maximum bottom radii (R), .005 for ring sizes
-25 thru -100; .010 for ring sizes 102 thru 1000



Alternate Lug Design
For Larger Sizes
(Manufacturer's Option)



Alternate Design
(Manufacturer's Option)

RING NO.	LUG HEIGHT		MAXIMUM SECTION		MINIMUM SECTION		HOLE DIAMETER		GAP WIDTH Ring in Groove	EDGE MARGIN	ALLOWABLE CORNER RADII & CHAMFERS		MAX. LOAD w/R max or Ch max. (lbs.)
	H	Tol.	S max	Tol.	S min	Tol.	R	Tol.			G Min	Y	
HO-387	.370		.319		.160		.125		.891	.348	.123	.098	12000
HO-393	.370		.324	±.008	.161	±.008	.125	+.015	.905	.354	.124	.099	12000
HO-400	.370		.330		.166		.125	-.002	.918	.360	.128	.102	12000
HO-412	.370		.330		.171		.125		.940	.360	.130	.104	12000
HO-425	.370		.335		.180		.125		.960	.360	.138	.110	12000
HO-433	.405	±.008	.343		.180		.156		1.000	.360	.142	.114	12000
HO-450	.405		.351		.181		.156		.980	.360	.146	.117	12000
HO-462	.405		.405		.183		.156		1.000	.360	.151	.121	12000
HO-475	.405		.370		.183		.156		.960	.366	.154	.123	12000
HO-475	.405		.370	±.009	.183	±.009	.156		1.030	.366	.154	.123	12000
HO-500	.435		.390		.186		.156		.970	.390	.158	.126	12000
HO-525	.435		.435		.198		.156		1.10	.405	.168	.134	15000
HO-537	.455		.408		.198		.156		1.12	.405	.168	.134	15000
HO-550	.435		.435		.198		.156		1.09	.405	.168	.134	15000
HO-575	.435		.435		.198		.156		1.11	.405	.168	.134	15000
HO-600	.435		.435		.198		.156		1.13	.405	.168	.134	15000
HO-625	.485		.485		.211		.187		1.16	.420	.177	.142	23000
HO-650	.485		.438		.219		.187		1.25	.435	.181	.145	23000
HO-662	.485		.485		.221		.187	+.020	1.28	.450	.183	.146	23000
HO-675	.530		.456		.224		.187	-.005	1.21	.456	.188	.150	23000
HO-700	.515		.515		.232		.187		1.26	.471	.196	.157	23000
HO-725	.545	±.010	.545		.238		.187		1.32	.486	.202	.162	34000
HO-750	.560		.507		.247		.187		1.39	.510	.208	.166	34000
HO-775	.560		.523		.255		.187		1.44	.525	.214	.171	34000
HO-800	.560		.560		.262		.187		1.50	.540	.220	.176	34000
HO-825	.600		.558	±.010	.270	±.010	.187		1.53	.555	.229	.183	34000
HO-850	.600		.573		.277		.187		1.71	.570	.235	.188	34000
HO-875	.660		.591		.286		.187		1.77	.591	.241	.193	34000
HO-900	.660		.609		.294		.187		1.83	.606	.249	.199	34000
HO-925	.660		.625		.299		.187		1.87	.627	.253	.202	34000
HO-950	.735		.642		.304		.187		1.91	.645	.258	.206	34000
HO-975	.735		.658		.309		.187		2.00	.660	.263	.210	34000
HO-1000	.735		.675		.315		.187		2.01	.675	.270	.216	34000

LARGER SIZES MAY BE AVAILABLE UPON REQUEST.

HARDNESS RANGES: CARBON STEEL RINGS (SAE 1060-1090)

RING TYPE	SIZE RANGE	SCALE	ROCKWELL HARDNESS
HO	25&31	15N	86-88
	37-51	30N	69.5-73
	56-77	30N	67.5-72
	81-102	30N	66-71
	106-347	C	47-52
	350-700	C	44-51
	725-1000	C	40-47

HARDNESS RANGES: BERYLLIUM COPPER RINGS

RING TYPE	SIZE RANGE	SCALE	ROCKWELL HARDNESS
HO	25&31	15N	77-82
	37-102	30N	54-62
	106+	C	34-43

