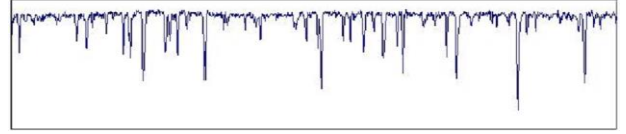


To maximize seal performance and durability, System Seals recommends the following finishing values for hydraulic seals.



Metric (DIN/ISO specification)

Surface Roughness	Ra	Rmax	Rz
Sliding Surface	0.20 - 0.80 μm	$\leq 6.3\mu\text{m}$	1.0 - 5.0 μm
Groove Root	$\leq 1.8\mu\text{m}$	$\leq 10.0\mu\text{m}$	6.3 - 16 μm
Groove Sides	$\leq 3.0\mu\text{m}$	$\leq 16.0\mu\text{m}$	N/A

Imperial

Surface Roughness	RMS
Sliding Surface	8 - 32
Groove Root	32
Groove Sides	125

Machining recommendations:

Rods: Plunge ground with non-oriented finish - no machine lead permitted

Hardness:

Heat treat to 45-60HRC to a minimum depth of 0.5mm.

