



# Installation Arrangements

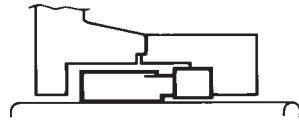
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## Arrangement

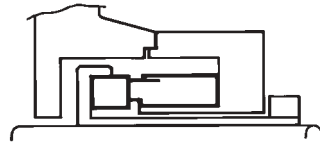
Wherever possible the recommended sealing solution is a single seal, but if a fluid concentration and temperature band present a significant hazard, the recommended solution will be for a single seal with a containment device, or, in extreme cases, a dual seal arrangement, with either a pressurised barrier fluid or unpressurised buffer fluid. Dual seal arrangements may also be recommended in cases where there are no suitable materials for a single seal solution.

### S - Single Seal

A single seal mounted internally

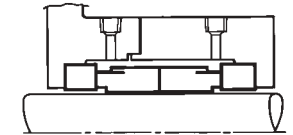


A single seal mounted in a stationary position with the seat/mating ring rotating

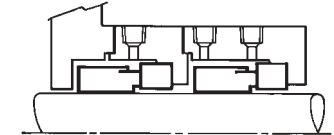


### D - Dual Seal

A dual seal installation where the seals are mounted in a back-to-back configuration



A dual seal installation where the seals are mounted in a tandem configuration



# Key to Selection Pages

## Flush and Neck Arrangements

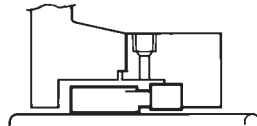
### Flush

A flush is usually clean pumped fluid which is injected into the seal chamber. If necessary, the fluid may pass through a cyclone separator or strainer to ensure that it is clean and free from debris or abrasive matter. Certain applications may require a clean compatible fluid injection from an external source. There are five different seal flush configurations or piping plans, and the recommended flush is stated for each fluid concentration and operating temperature band. API Plan numbers are quoted for each flush configuration in the following examples, and more details of API plans are provided on page 44.

#### F1 – No Flush

No seal flush to be installed, i.e. dead ended seal chamber with vent.

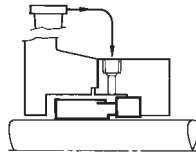
API Plan 02



#### F2 – Product Recirculation

Recirculation of the pumped product either from the pump discharge to the seat/face area of the seal, or from the seat/face areas of the seal to the pump suction.

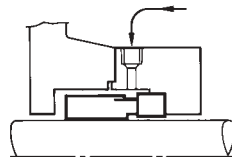
API Plans 01, 11, 13 and 21



#### F3 – Clean Flush

A flow of clean fluid to the seat/face area of the seal. The fluid can be either pumped fluid recirculated through a strainer or cyclone separator, or a clean compatible fluid from an external source.

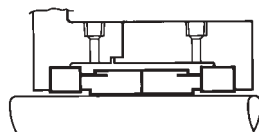
API Plans 12, 22, 31, 32 and 41



#### F4 – Dual Seal, Pressurised Barrier

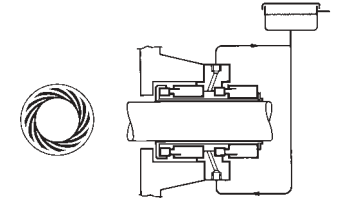
A pressurised and circulated barrier fluid or gas from an external reservoir for use with a dual seal pressurised arrangement. The barrier fluid must be clean and compatible with the fluid being pumped.

API Plans 53A, 53B, 53C, 54, 74



### F5 – Upstream Pumping

A non-pressurised buffer fluid from an external source for use with an Upstream Pumping seal installation. The buffer fluid must be clean and compatible with the fluid being pumped.



### Neck

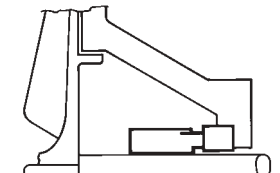
In certain circumstances a particular neck arrangement at the inboard end of the seal chamber may be recommended to control the fluid flow in or out of the seal chamber. Existing equipment may require modification to achieve the best seal performance.

#### N1

No special neck requirements

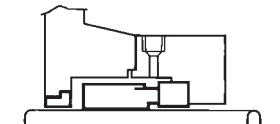
#### N2

An open large bore or open tapered seal housing is recommended



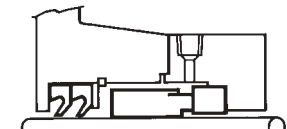
#### N3

A moderate neck restriction is required in the form of a close clearance neck bush



#### N4

A severe neck restriction is required in the form of a lip seal or similar device



# Secondary Containment

**Note:** Liquid quenches Q4 and Q5 must be piped in at bottom dead centre of the quench gland and out at top dead centre.  
Steam quenches Q4 and Q5 must be piped in at top dead centre of the quench gland and out at bottom dead centre.

## Secondary Containment

An external seal quench arrangement may be recommended for reasons of either safety, in the form of secondary containment, or to achieve optimum seal performance by use of a liquid or steam quench.

The selection pages refer to seven different secondary containment arrangements, and explanations of these are given below.

### Q1

No external quench facility required

### Q2 – Leakage Containment

A quench gland which is designed to operate as a seal failure control device, diverting leakage to either a safe area drain or to a flare.

The minimum requirement for failure control is a fixed throttle bush, but its ability to contain liquid or vapour emissions is relatively poor. Depending upon the fluid to be sealed, it is common practice to up-grade the method of containment to a higher integrity device such as an FS Lip Seal, or a floating or segmented bush. These seals can be installed in conjunction with an alarm or other seal failure indicator.

For particularly hazardous fluids, it may be preferable to up-grade the recommended quench arrangement from Q2 to Q6, a dual unpressurised seal arrangement.

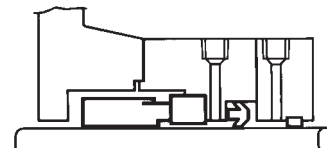
API Plan 61

### Q3 – Static Quench

A quench gland with provision for a static clean liquid quench such as an oil barrier.

The quench gland should be sealed with a quench containment seal or lip seal, and the liquid level should be maintained at all times by a device such as a constant level oiler.

API Plan 51



Q2

### Q4 – Intermittent Quench

A quench gland with provision for an intermittent clean liquid or steam quench.

The quench gland should be sealed with a quench containment seal or a lip seal, and the liquid quench flow automatically regulated by a quench control device to minimise wastage of quench liquid. The outlet from the quench gland should be piped to a safe area drain.

API Plan 62

### Q5 – Continuous Quench

A quench gland which is fed with a continuous flow of liquid or steam.

The recommended quench gland sealing device for a continuous flow of liquid is either a quench containment seal or a lip seal. For a continuous flow of steam the recommended quench seal is a segmental carbon bush, a floating bush, or a fixed throttle bush. The outlet from the quench gland should be piped to a safe area drain.

API Plan 62

### Q6 – Unpressurised Dual Seal

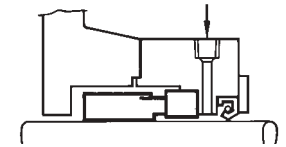
An arrangement where a non-pressurised buffer fluid from an external source is circulated between the inboard and outboard seals. Alternatively, a dry running mechanical containment seal could be used.

The outboard seal materials must be suitable for sealing the pumped fluid.

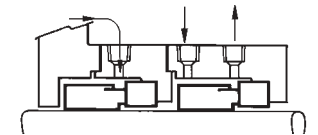
API Plans 51 and 52, 72, 75, 76

### Q7 – Splash Guard

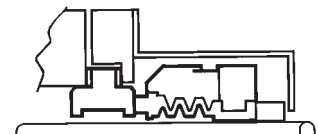
Externally mounted seals should be fitted with a splash guard incorporating a drain connection, in order to pipe any splash leakage to a safe area drain.



Q3, Q4 and Q5



Q6



Q7

# Selection Comments

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Where appropriate, comments have been added to the selection pages beside the materials suitability chart. The comments are numbered, and a key to them is included on the fold-out page 44i/ii. Most of the comments are self-explanatory, but the descriptions for the most commonly used ones are as follows.

## **1 Refer to John Crane Where No Selection Shown**

## **2 Confirm Selection at Very High Temperatures**

Certain fluids/applications may require special treatment at very high temperatures - please consult John Crane.

## **3 Abrasive**

The sealed fluid is likely to be of an abrasive nature. This has been taken into account by the preferred sealing solution.

## **4 Atmospheric Deposits**

The sealed fluid may leave deposits on the atmospheric side of the seal. It is recommended that a Q3, Q4 or Q5 quench be used with an appropriate quench medium to prevent accumulation of these deposits.

## **5 Crystallises**

Indicates that the fluid to be sealed is likely to crystallise on contact with atmosphere.

## **6 Clogging**

Certain fluids may be of a fibrous or abrasive nature, which may under normal circumstances result in clogging of the seal. This has been taken into account by the preferred sealing solution.

## **7 Heated Environment**

Indicates that the sealed fluid will solidify at normal temperatures, and therefore the pump/seal must be kept hot during operation and should be pre-heated before equipment start-up.

## **8 Avoid Springs in Product**

Certain fluids may be of a fibrous or abrasive nature, which may under normal circumstances result in clogging of the seal. A seal design where the springs are not immersed in the fluid is preferred.

## **9 Stationary-Mounted Seal**

A stationary-mounted seal with a rotating seat/mating ring is the preferred installation arrangement.

## **10 Vortex Breaker**

The pump design should include a vortex breaker in the area of the seal.

## **11 Q5 – Steam Quench**

A steam quench should be used. If the quench medium is not specified, water at ambient temperature is recommended.

## **12 Q5 – Hot Water Quench**

A hot water quench should be used. If the quench medium is not specified, water at ambient temperature is recommended.

## **13 FDA Materials Available**

For food-related or hygienic applications, Food and Drug Administration (FDA) approved materials are available and John Crane should be consulted if these are required.

## **14 Refer to Refinery Section**

Refer to John Crane hydrocarbon processing brochure.

## **15 Refer to Pulp & Paper Section**

Refer to John Crane pulp and paper processing brochure.

# Selection Comments

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**16 Refer to Positive Displacement Pump Section**

For positive displacement equipment solutions please refer to John Crane.

**17 Consider Dry Gas Seal**

Dry Gas seals may be a more economic solution on this application.

**18 Check Refrigeration Oil Materials**

Refrigeration oils present material compatibility problems. Please check compatibility with the materials selected for this application.

**19 Check Refrigeration Fluid Materials**

Refrigeration fluids present material compatibility problems. Please check compatibility with the materials selected for this application.

**20 Refer to John Crane for Higher Temperatures and Exceptions****21 Alloy C-276 Acceptable for Springs**

Springs and adaptive hardware in Alloy C-276 can be used if indicated. Thin section components such as the edge welded metal bellows are not suitable and should not be used.

**22 Quench Fluid Contained by a Mech. Seal Above 80°C**

Refer to John Crane pulp and paper processing brochure.

**23 Dry = >98%**

Application is dry if concentration is 98% or higher.

**24 Less Than 40% Gypsum**

Gypsum content to be less than 40%. If above, consult John Crane.

**25 From Wet Process**

Refer to pure Phosphoric Acid production.

**26 From Thermal Process**

Refer to pure Phosphoric Acid production.

**27 Pressure Surges C4 Stage**

Refer to John Crane pulp and paper processing brochure.

**28 See Seal Data Sheets for Specialised Face/Primary Ring Materials**

Specialist materials may be appropriate. Consult relevant seal data sheet or brochure for available materials.

**29 Dry = No water in Fluid**

Water is not present in fluid.

**30 < 2000ppm H<sub>2</sub>S. Refer to John Crane for Higher Levels**

If application contains greater than 2000ppm H<sub>2</sub>S consult John Crane.

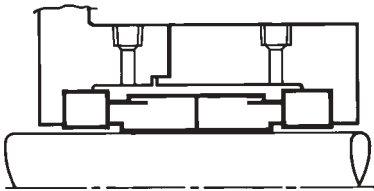
# Dual and Multiple Seals

## Introduction

### Selection of Dual Seals

Where a 'D' dual seal configuration is recommended, it is necessary to select the seal type and materials for the outboard seal in addition to the inboard seal.

### Pressurised Dual Seals – F4



Cross-Section of Pressurised Dual Seal

### Inboard Seal – Sealed Liquid Side

The recommended seal materials for the inboard seal will be specified in the selection pages. However, when selecting a seal type, it should be remembered that the operating pressure of the seal will be the difference between the barrier fluid pressure and the sealed fluid pressure. This barrier fluid pressure should be maintained at a minimum of 1 bar g or 10 per cent above the sealed fluid pressure, whichever is the greater – see Chart 1.

Due to this low differential pressure, in normal operating conditions it is unlikely that a balanced seal type will be required. If, however, the pump or equipment to be sealed is likely to run dry with a consequential loss of sealed fluid pressure, it is essential that the pressure capability of the selected inboard seal is greater than the maximum pressure of the seal barrier fluid.

For most applications it is necessary to ensure that the sealed fluid is contained and barrier fluid contamination minimised. To achieve this the inboard seal must have a reverse pressure

capability, for example the Type 8B1RP. If the barrier fluid pressure is lost, the inboard seal will not be forced open by the sealed fluid pressure. John Crane should be consulted before the selection and use of seals for these applications – see Figure 1.

Chart 1. Recommended Pressure

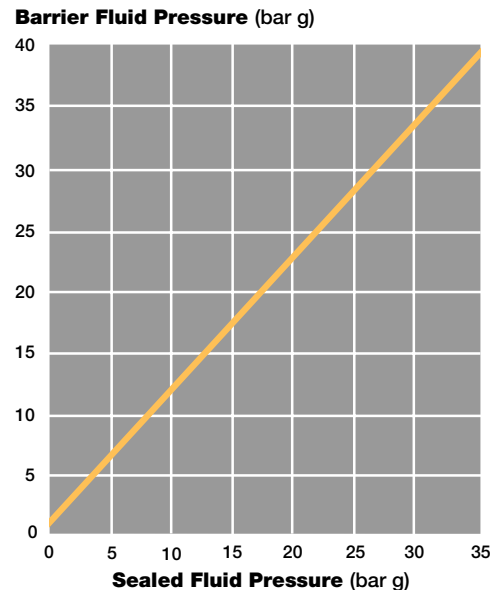
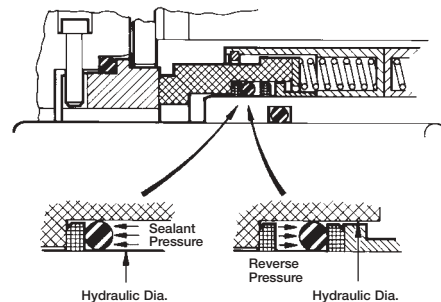


Figure 1



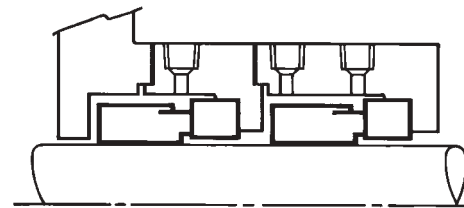
### Outboard Seal – Atmosphere Side

Generally, the seal family chosen and materials recommended for the inboard seal are also suitable for the outboard seal. However, the pressure of the barrier fluid must be considered and may affect the outboard seal selection.

If the sealed fluid is considered to be only moderately hazardous or corrosive it may be possible to select the outboard seal materials to suit the barrier fluid being used in preference to the sealed fluid. This option should only be considered where any migration of sealed fluid into the barrier fluid presents no hazard. If there is any doubt about this, John Crane should be consulted before the selection and use of alternative outboard seal materials.

### Unpressurised Dual Seals – Q6

In the case of non-pressurised dual seals, generally, both inboard and outboard seals used will be of the same family and material code.



Cross-Section of Non-Pressurised Dual Seal.

### Upstream Pumping

An Upstream Pumping seal, which is supplied as a cartridge, is a multiple seal combining the benefits of both a pressurised and a unpressurised dual seal.

The materials selected for the inboard seal and the outboard seal should be suitable for the pumped fluid and the buffer fluid used.

### Ancillary Fluid Control Equipment

Both pressurised and unpressurised dual seals require a fluid control system to manage the seal barrier/buffer fluid supply. The requirements of such a system are frequently tailored to suit the application and the operating plant requirements.

John Crane should be consulted before the selection and use of any fluid control equipment intended for use on hazardous applications.

### Barrier/Buffer Fluids

Selection of a barrier/buffer fluid is important to the safe and reliable operation of all dual seal arrangements.

As the fluid selected will be forming the barrier between the sealed fluid and atmosphere, the fluid must be non-hazardous. The fluid must be clean, i.e. not containing debris or abrasive deposits. It must also be compatible with and at a temperature appropriate for the selected seal materials.

In the case of a pressurised dual and Upstream Pumping seals, the fluid must also be fully compatible with the sealed fluid because migration of the barrier/buffer fluid will occur.

































































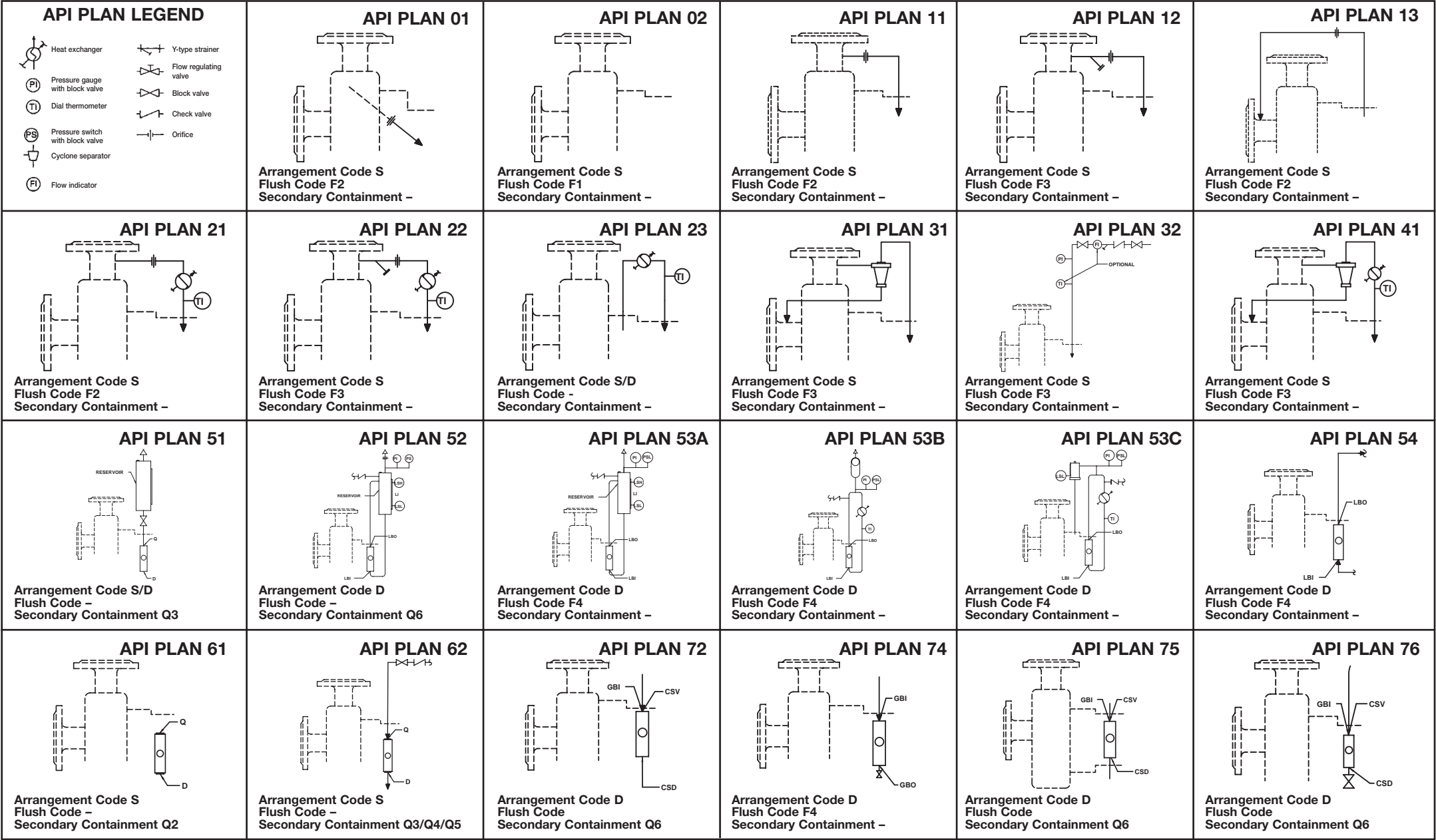






# Reference Data for Selection Pages

## API Plans



E & OE

**Hazard Code**  
 T = Toxicity  
 C = Corrosive to Tissue  
 F = Flammable  
 W = Water Reactive  
 O = Oxidising  
 E = Explosive  
 S = Spontaneously Combustible  
 See page 6

**Arrangement Code**  
 S = Single Seal  
 D = Dual Seal  
 See page 7

**Flush Code**  
 F1 = None = API Plan 02  
 F2 = Product Recirculation = API Plans 01, 11, 13 and 21  
 F3 = Clean Flush = API Plans 12, 22, 31, 32 and 42  
 F4 = Double Seal Pressurised Barrier = API Plans 53 and 54  
 F5 = Upstream Pumping  
 F6 = API Plan 74,75,76  
 See page 8

**Neck Code**  
 N1 = No Special Requirements  
 N2 = Large Bore or Tapered Housing  
 N3 = Moderate Restriction  
 N4 = Severe Restriction  
 See page 8

Recommended Material Description	Comp. Mat'l Code	Mat'l Descr. Code	DIN Mat'l Code
<b>Flexible Member</b>			
Nitrile	130	B	P
Chloroprene	132	N	N
Fluorocarbon	134	A	V
Ethylene Propylene	135	G	E
Nitrile (HNBR)	461	D	P1
Perfluoroelastomer	394	X	K
Perfluoroelastomer	230	X	K
Pure PTFE	138	Q	T
Glass Filled PTFE	198	W	Y1
Exfoliated Graphite	212	X	G2
Inconel Alloy 718	334	P	T
Alloy C-276	033	H	M2
AM350 Stainless Steel	208	X	T8
Inconel 718 (NACE heat treatment)	611	X	T
<b>Face/Primary Ring</b>			
Resin Impregnated Carbon Graphite	171	R	B
Antimony Impregnated Carbon Graphite	218	U	A2
Resin Impregnated Carbon Graphite	369	X	B
Antimony Impregnated Carbon Graphite	348	X	B
Nickel/Chrome Impregnated Carbon Graphite	605	X	A
Sintered Silicon Carbide	277	S	Q1
Silicon Carbide Coated Graphite	121	J	Q4
Nickel Bonded Tungsten Carbide	005	5	U2
<b>Metal Parts</b>			
316 Stainless Steel	001	1	G
Alloy C-276	033	H	M2
Alloy 400 (Monel)	011	M	M1
FV520B Stainless Steel	207	X	G2
Duplex Stainless Steel	015	X	G1
316L Stainless Steel	224	X	G
17-4 PH Stainless Steel	013	X	T5
Iron/Nickel Low Expansion Alloy	244	X	T7
20Cb-3 Stainless Steel	038	X	M3
Titanium	032	X	T1
<b>Seat/Mating Ring</b>			
Sintered Silicon Carbide	277	S	Q1
99.5% Aluminium Oxide Ceramic	059	C	V
Austenitic Cast Iron	007	7	R
Cobalt Bonded Tungsten Carbide	025	K	U1
Silicon Carbide (Banded)	469	X	Q1
<b>Springs</b>			
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- 1 = Refer to John Crane where no selection shown
- 2 = Confirm Selection at Very High Temperatures
- 3 = Abrasive
- 4 = Atmospheric Deposits
- 5 = Crystallises
- 6 = Clogging
- 7 = Heated Environment
- 8 = Avoid Springs in Product
- 9 = Stationary-Mounted Seal
- 10 = Vortex Breaker
- 11 = Q5 - Steam Quench
- 12 = Q5 - Hot Water Quench
- 13 = FDA Materials Available
- 14 = Refer to Refinery Section
- 15 = Refer to Pulp & Paper Section
- 16 = Refer to Positive Displacement Pump Section
- 17 = Consider Dry Gas Seal
- 18 = Check Refrigeration Oil Materials
- 19 = Check Refrigeration Fluid Materials
- 20 = Refer to John Crane for Higher Temps and Exceptions
- 21 = 033 Acceptable for Springs
- 22 = Quench fluid contained by a Mech. Seal above 80°C
- 23 = Dry = >98%
- 24 = Less than 40% Gypsum
- 25 = From Wet Process
- 26 = From Thermal Process
- 27 = Pressure Surges C4 Stage
- 28 = See family sections for specialised face materials
- 29 = Dry = No water in fluid
- 30 = < 2000ppm H<sub>2</sub>S. Refer to John Crane for higher levels

See page 10

**Secondary Containment Code**

- Q1 = None
- Q2 = Leakage Containment = API Plan 61
- Q3 = Static Quench = API Plan 51
- Q4 = Intermittent Quench = API Plan 61
- Q5 = Continuous Quench = API Plan 62
- Q6 = Tandem Seal = API Plans 51, 52, 72, 75 and 76
- Q7 = Splash Guard

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 Q7 = Splash Guard  
 See page 9

44ii  
 |  
 44iii

**Group Material Codes**

For material combinations not shown refer to John Crane.

Seal Material Description Code	Group Material Code	Component Material Codes					
		Flexible Member		Face/Primary Ring	Metal Parts	Seat/Mating Ring	Springs
		Sec. Seal	Static Seal				
AR171	354A	134	-	171	001	007	001
AR1C1	352A	134	-	171	001	059	001
AR1S1	546C	134	-	171	001	277	001
AR1SH	402D	134	-	171	001	277	033
ARHSH	749D	134	-	171	033	277	033
ARMCM	357A	134	-	171	011	059	011
ARMSM	448D	134	-	171	011	277	011
AS1S1	397D	134	-	277	001	277	001
ASHSH	742D	134	-	277	033	277	033
BR171	387A	130	-	171	001	007	001
BR1C1	384A	130	-	171	001	059	001
BR1S1	753C	130	-	171	001	277	001
BRMCM	379A	130	-	171	011	059	011
BS1S1	419D	130	-	277	001	277	001
BSMSM	368D	130	-	277	011	277	011
GR171	468A	135	-	171	001	007	001
GR1C1	466A	135	-	171	001	059	001
GR1S1	530C	135	-	171	001	277	001
GRHCH	530B	135	-	171	033	059	033
GRMCM	531A	135	-	171	011	059	011
GS1S1	540C	135	-	277	001	277	001
GSHSH	374C	135	-	277	033	277	033
GSMSM	508D	135	-	277	011	277	011
GSMMSM	529C	135	-	277	011	277	011
GU1C1	476C	135	-	218	001	059	001
GU1S1	477C	135	-	218	001	277	001
GUMSM	257F	135	-	218	011	277	011
HASHS-	819E	033	134	277	033	277	-
HAXHS- X=369	853E	033	134	369	033	277	-
HBXHS-	286F	033	130	277	033	277	-
HXSXS-	623E	033	130	369	033	277	-
HXSXS-	622E	033	230	277	033	277	-
NR1C1	431A	132	-	171	001	059	001
PARXC-	809C	334	134	171	207	059	-
PARXS-	644C	334	134	171	207	277	-
PARXS-	808C	334	134	171	207	277	-
PBRX7-	800C	334	130	171	207	007	-
PBRXC-	801C	334	130	171	207	059	-
PBRXS-	931D	334	130	171	207	277	-
PGRXS-	640C	334	135	171	207	277	-
PXJXS-	648D	334	230	121	207	277	-
QR171	244A	138	-	171	001	007	001
QR1C1	234D	138	-	171	001	059	001
QR1S1	602C	138	-	171	001	277	001
QRHCH	308A	138	-	171	033	059	033
QRHSH	555D	138	-	171	033	277	033
QRMSM	309B	138	-	171	011	277	011
QS1S1	753A	138	-	277	001	277	001
QX1CX X=195 X=093	656A	138	198	198	001	059	093

**Group Material Codes (continued)**

Seal Material Description Code	Group Material Code	Component Material Codes					
		Flexible Member		Face/Primary Ring	Metal Parts	Seat/Mating Ring	Springs
		Sec. Seal	Static Seal				
QXS1SX X=195 X=093	606D	138	198	277	001	277	093
WR171	262A	198	-	171	001	007	001
WR1S1	214D	198	-	171	001	277	001
WR1S1	255C	198	-	171	001	277	001
WS1S1	201D	198	-	277	001	277	001
XR171 X=230	391C	230	-	171	001	007	001
XR1C1 X=230	390C	230	-	171	001	059	001
XR1S1 X=230	780C	230	-	171	001	277	001
XR1SH X=230	285F	230	-	171	001	227	033
XS1S1 X=230	379E	230	-	277	001	277	001
XS1S1 X=212	583C	212	-	277	001	277	001
XX51S- X=454 X=212	842E	334	212	005	001	277	-
XX51S- X=462 X=212	910E	208	212	005	001	277	-
XXX1S- X=276 X=212 X=369	855E	208	212	369	001	277	-
XXX1S- X=462 X=212 X=369	849E	208	212	369	001	277	-

**Alternative Materials**

Material Description	Component Material Code	Material Description Code	DIN Material Code
Hard-Faced Stainless Steel	009	9	K
Hard-Faced Alloy 400	010	L	T(4)
Hastelloy B-2	012	X	M
Chrome Oxide on 316 Stainless Steel	031	X	W
Titanium	032	X	T(1)
Carpenter 20 Cb-3 Stainless Steel	038	X	G(3)
PVDF Coated 316 Stainless Steel	093	X	T(2)
Compressed Fibre	140	V	Y
PTFE Coated Stainless Steel	146	X	T(2)
Gasket Grade PTFE	157	Q(W)	T
Carbon Filled PTFE	180	X	Y2
Composite Filled/Pure/Filled PTFE	195	X	-
Glass Filled PTFE	198	X	Y1
304 Stainless Steel	200	X	F
Low Carbon 316 Stainless Steel	224	X	G
Nitrile (FDA)	234	X	P(1)
Ethylene Propylene (FDA)	235	X	E(2)
Iron-Nickel Low Expansion Alloy	244	X	T(7)
Inconel X-750	246	X	T(9)
FEP Jacketed Fluorocarbon	282	X	M(4)
SS Reinforced Exfoliated Graphite	323	X	G(1)
904L Stainless Steel	429	X	G(5)
Resin Impregnated Carbon Graphite	444	R	B
Antimony Impregnated Carbon Graphite	448	U	A(2)
Ethylene Propylene (EDF)	449	G	E
SiC/Silicon/Graphite Compound	477	X	Q3
320 Stainless Steel	475	X	G
Reaction Bonded Silicon Carbide	509	S	Q2
Resin Impregnated Carbon Graphite	539	X	B

Note: DIN code numbers shown in brackets indicate John Crane DIN code additions.



# Temperature Conversion Table

Find the temperature you want to convert (°C or °F) in the centre column (heavy type).  
The converted temperature in °C will be in the left hand column, or in °F in the right hand column.

°C		°F
-62.2	<b>-80</b>	-112.0
-56.7	<b>-70</b>	-94.0
-51.1	<b>-60</b>	-76.0
-45.6	<b>-50</b>	-58.0
-40.0	<b>-40</b>	-40.0
-34.4	<b>-30</b>	-22.0
-28.9	<b>-20</b>	-4.0
-23.3	<b>-10</b>	14.0
-17.8	<b>0</b>	32.0
-17.2	<b>1</b>	33.8
-16.7	<b>2</b>	35.6
-16.1	<b>3</b>	37.4
-15.6	<b>4</b>	39.2
-15.0	<b>5</b>	41.0
-14.4	<b>6</b>	42.8
-13.9	<b>7</b>	44.6
-13.3	<b>8</b>	46.4
-12.8	<b>9</b>	48.2
-12.2	<b>10</b>	50.0
-11.7	<b>11</b>	51.8
-11.1	<b>12</b>	53.6
-10.6	<b>13</b>	55.4
-10.0	<b>14</b>	57.2
-9.4	<b>15</b>	59.0
-8.9	<b>16</b>	60.8
-8.3	<b>17</b>	62.6
-7.8	<b>18</b>	64.4
-7.2	<b>19</b>	66.2
-6.7	<b>20</b>	68.0
-6.1	<b>21</b>	69.8
-5.6	<b>22</b>	71.6
-5.0	<b>23</b>	73.4
-4.4	<b>24</b>	75.2
-3.9	<b>25</b>	77.0
-3.3	<b>26</b>	78.8
-2.8	<b>27</b>	80.6
-2.2	<b>28</b>	82.4
-1.7	<b>29</b>	84.2
-1.1	<b>30</b>	86.0
-0.6	<b>31</b>	87.8
<b>0</b>	<b>32</b>	89.6
0.6	<b>33</b>	91.4
1.1	<b>34</b>	93.2
1.7	<b>35</b>	95.0
2.2	<b>36</b>	96.8
2.8	<b>37</b>	98.6

°C		°F
3.3	<b>38</b>	100.4
3.9	<b>39</b>	102.2
4.4	<b>40</b>	104.0
5.0	<b>41</b>	105.8
5.6	<b>42</b>	107.6
6.1	<b>43</b>	109.4
6.7	<b>44</b>	111.2
7.2	<b>45</b>	113.0
7.8	<b>46</b>	114.8
8.3	<b>47</b>	116.6
8.9	<b>48</b>	118.4
9.4	<b>49</b>	120.2
10.0	<b>50</b>	122.0
10.6	<b>51</b>	123.8
11.1	<b>52</b>	125.6
11.7	<b>53</b>	127.4
12.2	<b>54</b>	129.2
12.8	<b>55</b>	131.0
13.3	<b>56</b>	132.8
13.9	<b>57</b>	134.6
14.4	<b>58</b>	136.4
15.0	<b>59</b>	138.2
15.6	<b>60</b>	140.0
16.1	<b>61</b>	141.8
16.7	<b>62</b>	143.6
17.2	<b>63</b>	145.4
17.8	<b>64</b>	147.2
18.3	<b>65</b>	149.0
18.9	<b>66</b>	150.8
19.4	<b>67</b>	152.6
20.0	<b>68</b>	154.4
20.6	<b>69</b>	156.2
21.1	<b>70</b>	158.0
21.7	<b>71</b>	159.8
22.2	<b>72</b>	161.6
22.8	<b>73</b>	163.4
23.3	<b>74</b>	165.2
23.9	<b>75</b>	167.0
24.4	<b>76</b>	168.8
25.0	<b>77</b>	170.6
25.6	<b>78</b>	172.4
26.1	<b>79</b>	174.2
26.7	<b>80</b>	176.0
27.2	<b>81</b>	177.8
27.8	<b>82</b>	179.6
28.3	<b>83</b>	181.4

°C		°F
28.9	<b>84</b>	183.2
29.4	<b>85</b>	185.0
30.0	<b>86</b>	186.8
30.6	<b>87</b>	188.6
31.1	<b>88</b>	190.4
31.7	<b>89</b>	192.2
32.2	<b>90</b>	194.0
32.8	<b>91</b>	195.8
33.3	<b>92</b>	197.6
33.9	<b>93</b>	199.4
34.4	<b>94</b>	201.2
35.0	<b>95</b>	203.0
35.6	<b>96</b>	204.8
36.1	<b>97</b>	206.6
36.7	<b>98</b>	208.4
37.2	<b>99</b>	210.2
<b>37.8</b>	<b>100</b>	212.0
38.3	<b>101</b>	213.8
38.9	<b>102</b>	215.6
39.4	<b>103</b>	217.4
40.0	<b>104</b>	219.2
40.6	<b>105</b>	221.0
41.1	<b>106</b>	222.8
41.7	<b>107</b>	224.6
42.2	<b>108</b>	226.4
42.8	<b>109</b>	228.2
43.3	<b>110</b>	230.0
43.9	<b>111</b>	231.8
44.4	<b>112</b>	233.6
45.0	<b>113</b>	235.4
45.6	<b>114</b>	237.2
46.1	<b>115</b>	239.0
46.7	<b>116</b>	240.8
47.2	<b>117</b>	242.6
47.8	<b>118</b>	244.4
48.3	<b>119</b>	246.2
48.9	<b>120</b>	248.0
49.4	<b>121</b>	249.8
50.0	<b>122</b>	251.6
50.6	<b>123</b>	253.4
51.1	<b>124</b>	255.2
51.7	<b>125</b>	257.0
52.2	<b>126</b>	258.8
52.8	<b>127</b>	260.6
53.3	<b>128</b>	262.4
53.9	<b>129</b>	264.2

°C		°F
54.4	<b>130</b>	266.0
55.0	<b>131</b>	267.8
55.6	<b>132</b>	269.6
56.1	<b>133</b>	271.4
56.7	<b>134</b>	273.2
57.2	<b>135</b>	275.0
57.8	<b>136</b>	276.8
58.3	<b>137</b>	278.6
58.9	<b>138</b>	280.4
59.4	<b>139</b>	282.2
60.0	<b>140</b>	284.0
60.6	<b>141</b>	285.8
61.1	<b>142</b>	287.6
61.7	<b>143</b>	289.4
62.2	<b>144</b>	291.2
62.8	<b>145</b>	293.0
63.3	<b>146</b>	294.8
63.9	<b>147</b>	296.6
64.4	<b>148</b>	298.4
65.0	<b>149</b>	300.2
65.6	<b>150</b>	302.0
66.1	<b>151</b>	303.8
66.7	<b>152</b>	305.6
67.2	<b>153</b>	307.4
67.8	<b>154</b>	309.2
68.3	<b>155</b>	311.0
68.9	<b>156</b>	312.8
69.4	<b>157</b>	314.6
70.0	<b>158</b>	316.4
70.6	<b>159</b>	318.2
71.1	<b>160</b>	320.0
71.7	<b>161</b>	321.8
72.2	<b>162</b>	323.6
72.8	<b>163</b>	325.4
73.3	<b>164</b>	327.2
73.9	<b>165</b>	329.0
74.4	<b>166</b>	330.8
75.0	<b>167</b>	332.6
75.6	<b>168</b>	334.4
76.1	<b>169</b>	336.2
76.7	<b>170</b>	338.0
77.2	<b>171</b>	339.8
77.8	<b>172</b>	341.6
78.3	<b>173</b>	343.4
78.9	<b>174</b>	345.2
79.4	<b>175</b>	347.0

°C		°F
80.0	<b>176</b>	348.8
80.6	<b>177</b>	350.6
81.1	<b>178</b>	352.4
81.7	<b>179</b>	354.2
82.2	<b>180</b>	356.0
82.8	<b>181</b>	357.8
83.3	<b>182</b>	359.6
83.9	<b>183</b>	361.4
84.4	<b>184</b>	363.2
85.0	<b>185</b>	365.0
85.6	<b>186</b>	366.8
86.1	<b>187</b>	368.6
86.7	<b>188</b>	370.4
87.2	<b>189</b>	372.2
87.8	<b>190</b>	374.0
88.3	<b>191</b>	375.8
88.9	<b>192</b>	377.6
89.4	<b>193</b>	379.4
90.0	<b>194</b>	381.2
90.6	<b>195</b>	383.0
91.1	<b>196</b>	384.8
91.7	<b>197</b>	386.6
92.2	<b>198</b>	388.4
92.8	<b>199</b>	390.2
<b>93.3</b>	<b>200</b>	392.0
96.1	<b>205</b>	401.0
98.9	<b>210</b>	410.0
101.7	<b>215</b>	419.0
104.4	<b>220</b>	428.0
107.2	<b>225</b>	437.0
110.0	<b>230</b>	446.0
112.8	<b>235</b>	455.0
115.6	<b>240</b>	464.0
118.3	<b>245</b>	473.0
121.1	<b>250</b>	482.0
123.9	<b>255</b>	491.0
126.7	<b>260</b>	500.0
129.4	<b>265</b>	509.0
132.2	<b>270</b>	518.0
135.0	<b>275</b>	527.0
137.8	<b>280</b>	536.0
140.6	<b>285</b>	545.0
143.3	<b>290</b>	554.0
146.1	<b>295</b>	563.0
148.9	<b>300</b>	572.0
151.7	<b>305</b>	581.0

°C		°F
154.4	<b>310</b>	590.0
157.2	<b>315</b>	599.0
160.0	<b>320</b>	608.0
162.8	<b>325</b>	617.0
165.6	<b>330</b>	626.0
168.3	<b>335</b>	635.0
171.1	<b>340</b>	644.0
173.9	<b>345</b>	653.0
176.7	<b>350</b>	662.0
179.4	<b>355</b>	671.0
182.2	<b>360</b>	680.0
185.0	<b>365</b>	689.0
187.8	<b>370</b>	698.0
190.6	<b>375</b>	707.0
193.3	<b>380</b>	716.0
196.1	<b>385</b>	725.0
198.9	<b>390</b>	734.0
201.7	<b>395</b>	743.0
<b>204.4</b>	<b>400</b>	752.0
207.2	<b>405</b>	761.0
210.0	<b>410</b>	770.0
212.8	<b>415</b>	779.0
215.6	<b>420</b>	788.0
218.3	<b>425</b>	797.0
221.1	<b>430</b>	806.0
223.9	<b>435</b>	815.0
226.7	<b>440</b>	824.0
229.4	<b>445</b>	833.0
232.0	<b>450</b>	842.0
235.2	<b>455</b>	851.0
237.8	<b>460</b>	860.0
240.6	<b>465</b>	869.0
243.3	<b>470</b>	878.0
246.1	<b>475</b>	887.0
248.9	<b>480</b>	896.0
251.7	<b>485</b>	905.0
254.4	<b>490</b>	914.0
257.2	<b>495</b>	923.0
<b>260.0</b>	<b>500</b>	932.0
265.6	<b>510</b>	950.0
271.1	<b>520</b>	968.0
276.7	<b>530</b>	986.0
282.2	<b>540</b>	1004.0
287.8	<b>550</b>	1022.0
293.3	<b>560</b>	1040.0
298.9	<b>570</b>	1058.0

°C		°F
304.4	<b>580</b>	1076.0
310.0	<b>590</b>	1094.0
<b>315.6</b>	<b>600</b>	1112.0
321.1	<b>610</b>	1130.0
326.7	<b>620</b>	1148.0
332.2	<b>630</b>	1166.0
337.8	<b>640</b>	1184.0
343.3	<b>650</b>	1202.0
348.9	<b>660</b>	1220.0
354.4	<b>670</b>	1238.0
360.0	<b>680</b>	1256.0
365.6	<b>690</b>	1274.0
<b>371.1</b>	<b>700</b>	1292.0
376.7	<b>710</b>	1310.0
382.2	<b>720</b>	1328.0
387.8	<b>730</b>	1346.0
393.3	<b>740</b>	1364.0
398.9	<b>750</b>	1382.0
404.4	<b>760</b>	1400.0
410.0	<b>770</b>	1418.0
415.6	<b>780</b>	1436.0
421.1	<b>790</b>	1454.0
<b>426.7</b>	<b>800</b>	1472.0
432.2	<b>810</b>	1490.0
437.8	<b>820</b>	1508.0
443.3	<b>830</b>	1526.0
448.9	<b>840</b>	1544.0
454.4	<b>850</b>	1562.0
460.0	<b>860</b>	1580.0
465.6	<b>870</b>	1598.0
471.1	<b>880</b>	1616.0
476.7	<b>890</b>	1634.0
<b>482.2</b>	<b>900</b>	1652.0
487.8	<b>910</b>	1670.0
493.3	<b>920</b>	1688.0
498.9	<b>930</b>	1706.0
504.4	<b>940</b>	1724.0
510.0	<b>950</b>	1742.0
515.6	<b>960</b>	1760.0
521.1	<b>970</b>	1778.0
526.7	<b>980</b>	1796.0
532.2	<b>990</b>	1814.0
<b>537.8</b>	<b>1000</b>	1832.0

# Seal Size Codes

## Metric Seal Sizes

Seal Size (mm)	Seal Size Code
8	0080
10	0100
12	0120
13	0130
14	0140
15	0150
16	0160
17	0170
18	0180
19	0190
20	0200
22	0220
23	0230
24	0240
25	0250
28	0280
30	0300
32	0320
33	0330
35	0350
38	0380
40	0400
43	0430
45	0450
48	0480
50	0500
53	0530
55	0550
58	0580
60	0600

Seal Size (mm)	Size Size Code
63	0630
65	0650
68	0680
70	0700
73	0730
75	0750
78	0780
80	0800
83	0830
85	0850
88	0880
90	0900
93	0930
95	0950
98	0980
100	1000
105	1050
110	1100
115	1150
120	1200
125	1250
130	1300
135	1350
140	1400
145	1450
150	1500
155	1550
160	1600
165	1650
170	1700

## Inch Seal Sizes

Seal Size (Decimal Inches)	Seal Size Code	Seal Size (Fractional Inches)
0.375	0095	3/8
0.500	0127	1/2
0.625	0158	5/8
0.750	0190	3/4
0.813	0206	1 3/16
0.875	0222	7/8
1.000	0254	1
1.125	0285	1 1/8
1.250	0317	1 1/4
1.375	0349	1 3/8
1.500	0381	1 1/2
1.625	0412	1 5/8
1.750	0444	1 3/4
1.875	0476	1 7/8
2.000	0508	2
2.125	0539	2 1/8
2.250	0571	2 1/4
2.375	0603	2 3/8
2.500	0635	2 1/2
2.625	0666	2 5/8
2.750	0698	2 3/4
2.875	0730	2 7/8
3.000	0762	3
3.125	0793	3 1/8

Seal Size (Decimal Inches)	Seal Size Code	Seal Size (Fractional Inches)
3.250	0825	3 1/4
3.375	0857	3 3/8
3.500	0889	3 1/2
3.625	0920	3 5/8
3.750	0952	3 3/4
3.875	0984	3 7/8
4.000	1016	4
4.125	1047	4 1/8
4.250	1079	4 1/4
4.375	1111	4 3/8
4.500	1143	4 1/2
4.625	1174	4 5/8
4.750	1206	4 3/4
4.875	1238	4 7/8
5.000	1270	5
5.125	1301	5 1/8
5.250	1333	5 1/4
5.375	1365	5 3/8
5.500	1397	5 1/2
5.625	1428	5 5/8
5.750	1460	5 3/4
5.875	1492	5 7/8
6.000	1524	6