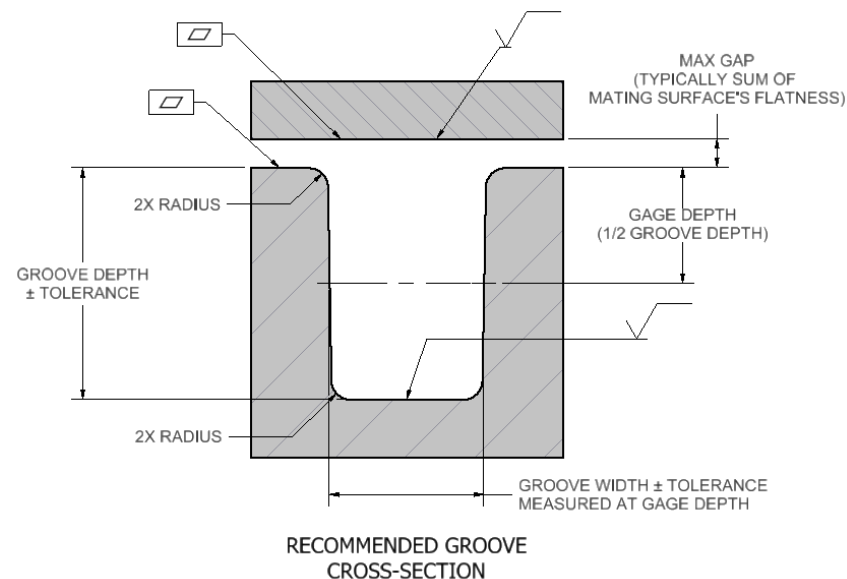


Standard PIP Groove Sizes

Millimeters						Max Draft per side
Width	Height	Groove Tolerance		Max Gap	Radius	
1.52	2.29	±	0.08	0.05	0.25	1°
2.00	3.00	±	0.10	0.10	0.25	1°
2.40	3.50	±	0.10	0.20	0.25	1°
2.75	4.00	±	0.15	0.20	0.35	1°
3.00	4.50	±	0.15	0.30	0.35	1°
3.50	5.00	±	0.15	0.40	0.50	2°
4.00	6.00	±	0.20	0.50	0.50	2°
4.50	7.00	±	0.20	0.70	0.75	2°
5.00	8.00	±	0.25	0.80	0.75	2°

Inches						Max Draft per side
Width	Height	Groove Tolerance		Max Gap	Radius	
.060	.090	±	.003	.002	.010	1°
.079	.118	±	.004	.004	.010	1°
.094	.138	±	.004	.008	.010	1°
.108	.157	±	.006	.008	.014	1°
.118	.177	±	.006	.012	.014	1°
.138	.197	±	.006	.016	.020	2°
.157	.236	±	.008	.020	.020	2°
.177	.276	±	.008	.028	.030	2°
.197	.315	±	.010	.031	.030	2°



- Select size based on tolerance & space available. Highlighted sizes are the most common.
- When space permits, Parker OES recommends using 2.75 x 4.00 or larger grooves for improved seal contact width.
- Max gap should include both mating surface's flatness, any standoffs, component deflections, and / or creep.
- Surface finish RMS
 - Liquid : 0.8 μm (32 μin) recommended
1.6 μm (63 μin) max
 - Gas : 0.4 μm (16 μin)