AEROSPACE RECOMMENDED PRACTICE

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Superseding ARP1234C

Static Axial O-Ring Seal Applications Without Anti-Extrusion Devices for Engine and Engine Control Systems

RATIONALE

Standard is being revised to correct a typing error.

1. SCOPE

This document establishes standard gland design criteria and dimensions for static axial O-ring seal applications without anti-extrusion devices specifically for engines and engine control systems operating at a maximum pressure of 1500 psi (10345 kPa).

NOTE: The criteria herein are similar, but not identical, to those in AS4716 and the legacy standard MIL-G-5514.

2. APPLICABLE DOCUMENTS

The following publications form a part of this document to the extent specified herein. The latest issue of SAE publications shall apply. The applicable issue of other publications shall be the issue in effect on the date of the purchase order. In the event of conflict between the text of this document and references cited herein, the text of this document takes precedence. Nothing in this document, however, supersedes applicable laws and regulations unless a specific exemption has been obtained.

2.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or +1 724-776-4970 (outside USA), www.sae.org.

ARP1231 Gland Design, Elastomeric O-Ring Seals, General Considerations

AS568 Aerospace Size Standard for O-Rings

AS4716 Gland Design, O-Ring and Other Seals

TO PLACE A DOCUMENT ORDER: **Tel: 877-606-7323 (inside USA and Canada)**
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For more information on this standard, visit
https://www.sae.org/standards/content/ARP1234D/

2.2 U.S. Government Publications

Copies of these documents are available online at https://quicksearch.dla.mil.

MIL-G-5514 Gland Design, Packings, Hydraulic, General Requirements for (Cancelled)

3. GENERAL REQUIREMENTS

3.1 Gland Configurations

3.1.1 General

A static axial O-ring seal is one which compresses the surfaces normal to the ID and OD of the O-ring. The most common axial gland configurations are depicted in Figures 1, 2, and 3. The preferred configuration is one that provides a complete groove in one part, as in Figure 1. This configuration minimizes the number of gaps through which the seal can extrude and reduces the potential damage to the seal during assembly. The use of configurations with one gland wall missing, as in Figure 3, is not recommended because it may result in damage of the seal through pressure reversals.

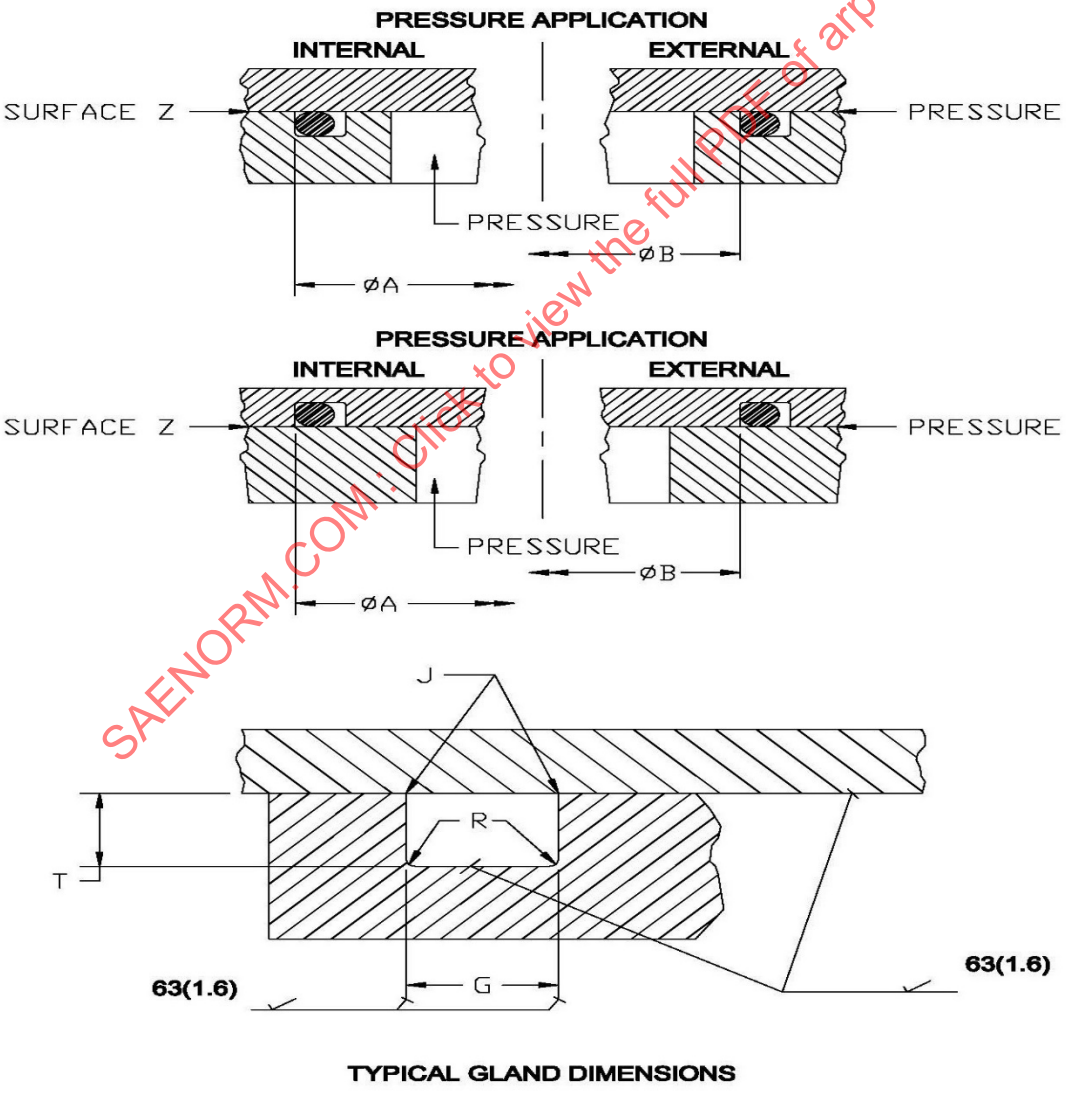

Figure 1 - O-ring seal axial gland preferred designs

NOTE: Values for J and R are listed in Table 1.

Table 1 - Gland edge breaks and radii

AS568 Dash No.	Nominal O-ring Cross-Section		Edge Break J		Radius R	
	Inch	mm	Inch	mm	Inch	mm
-004 thru -050	0.070	1.78	0.005-0.015	0.13-0.38	0.010-0.020	0.25-0.51
-102 thru -178	0.103	2.62	0.010-0.020	0.25-0.51	0.020-0.030	0.51-0.76
-201 thru -284	0.139	3.53	0.010-0.020	0.25-0.51	0.020-0.030	0.51-0.76
-309 thru -395	0.210	5.33	0.010-0.020	0.25-0.51	0.020-0.030	0.51-0.76
-425 thru -475	0.275	6.98	0.010-0.020	0.25-0.51	0.020-0.030	0.51-0.76

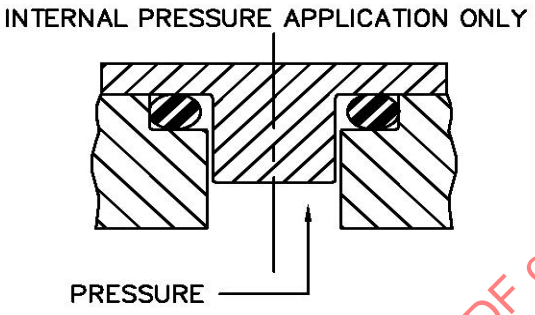

Figure 2 - O-ring seal axial glands alternate design

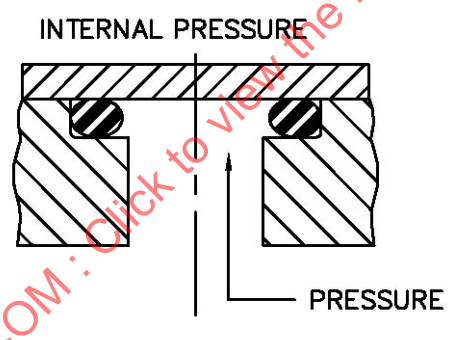

Figure 3 - O-ring seal axial glands

NOTE: This configuration is not recommended.

3.1.2 Non-Circular Glands

Although axial seals are usually circular, alternate configurations like that in Figure 4 are sometimes used. Sharp corners are not recommended and corners should be 0.005 x 45 degrees (0.13 x 45 degrees) minimum.

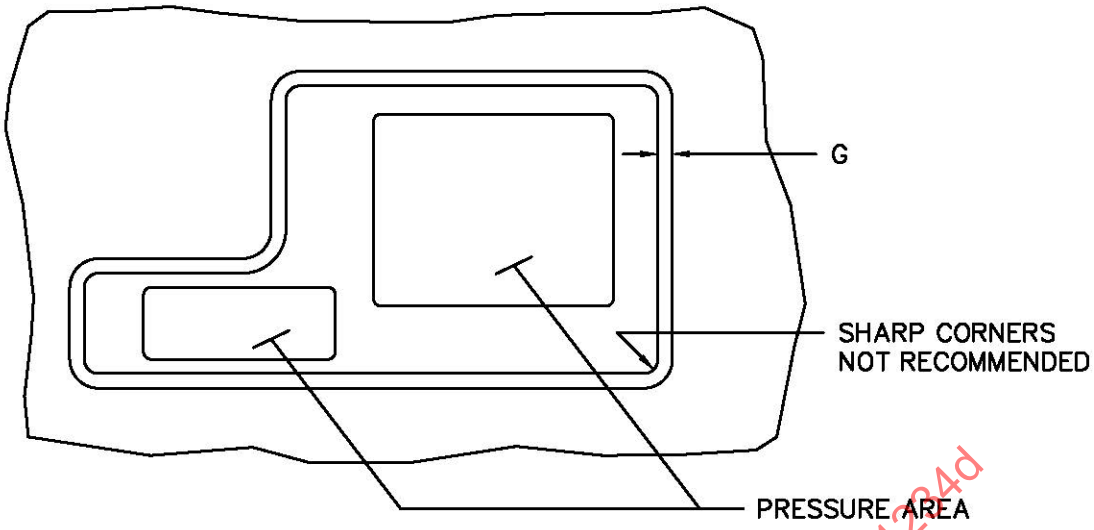

Figure 4 - Example of non-circular groove configuration (top view)

3.1.3 Placement of the Seal within the Groove

The placement of the seal within the groove depends on the direction of the pressure. Axial seals may be pressurized from a pressure source located within the seal's inner diameter (internal pressure application) or from a source located outside the outer diameter of the seal (external pressure application). The gland should be designed such that, prior to applying pressure, the seal will be in contact with the gland wall away from the pressure side of the seal.

3.1.4 Standard Glands

Standard gland diameters for axial seal glands are tabulated in Table 2. These dimensions are for use with seals conforming to AS568 tolerances. They are computed in accordance with the criteria defined in Section 4 and in ARP1231.

Table 2 - Standard gland diameters

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
004	---	---		0.070	1.78
	---	---		0.075	1.90
005	---	---		0.101	2.57
	---	---		0.106	2.69
006	---	---		0.114	2.90
	---	---		0.119	3.02
007	---	---		0.145	3.68
	---	---		0.150	3.81
008	---	---		0.176	4.47
	---	---		0.181	4.60
009	---	---		0.208	5.28
	---	---		0.213	5.41
010	---	---		0.239	6.07
	---	---		0.244	6.20
011	0.436	11.07		0.301	7.65
	0.441	11.20		0.306	7.77
012	0.499	12.67		0.364	9.25
	0.504	12.80		0.369	9.37
013	0.561	14.25		0.426	10.82
	0.566	14.38		0.431	10.95
014	0.624	15.85		0.489	12.42
	0.629	15.98		0.494	12.55
015	0.686	17.42		0.551	14.00
	0.691	17.55		0.556	14.12
016	0.749	19.02		0.614	15.60
	0.754	19.15		0.619	15.72
017	0.811	20.60		0.676	17.17
	0.816	20.73		0.681	17.30
018	0.874	22.20		0.739	18.77
	0.879	22.33		0.744	18.90
019	0.936	23.77		0.801	20.35
	0.941	23.90		0.806	20.47

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
020	0.999	25.37		0.864	21.95
	1.004	25.50		0.869	22.07
021	1.061	26.95		0.926	23.52
	1.066	27.08		0.931	23.65
022	1.124	29.55		0.989	25.12
	1.129	29.68		0.994	25.25
023	1.186	30.12		1.051	26.70
	1.191	30.25		1.056	26.82
024	1.249	31.72		1.114	28.30
	1.254	31.85		1.119	28.42
025	1.311	33.30		1.176	29.87
	1.316	33.43		1.181	30.00
026	1.374	34.90		1.239	31.47
	1.379	35.03		1.244	31.60
027	1.436	36.47		1.301	33.05
	1.441	36.60		1.306	33.17
028	1.499	38.07		1.364	34.65
	1.504	38.20		1.369	34.77
029	1.624	41.25		1.489	37.82
	1.629	41.38		1.494	37.95
030	1.749	44.42		1.614	41.00
	1.754	44.55		1.619	41.12
031	1.874	47.60		1.739	44.17
	1.879	47.73		1.744	44.30
032	1.999	50.77		1.864	47.35
	2.004	50.90		1.869	47.47
033	2.124	53.95		1.989	50.52
	2.129	54.08		1.994	50.65
034	2.249	57.12		2.114	53.70
	2.254	57.25		2.119	53.82
035	2.374	60.30		2.239	56.87
	2.379	60.43		2.244	57.00
036	2.499	63.47		2.364	60.05
	2.504	63.60		2.369	60.17
037	2.624	66.65		2.489	63.22
	2.629	66.78		2.494	63.35
038	2.749	69.82		2.614	66.40
	2.754	69.95		2.619	66.52
039	2.874	73.00		2.739	69.57
	2.879	73.13		2.744	69.70
040	2.999	76.17		2.864	72.75
	3.004	76.30		2.869	72.87

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
041	3.124	79.35		2.989	75.92
	3.129	79.48		2.994	76.05
042	3.374	85.70		3.239	82.27
	3.379	85.83		3.244	82.40
043	3.624	92.05		3.489	88.62
	3.629	92.18		3.494	88.75
044	3.874	98.40		3.739	94.97
	3.879	98.53		3.744	95.10
045	4.124	104.75		3.989	101.32
	4.129	104.88		3.994	101.45
046	4.374	111.10		4.239	107.67
	4.379	111.23		4.244	107.80
047	4.624	117.45		4.489	114.02
	4.629	117.58		4.494	114.15
048	4.874	123.80		4.739	120.37
	4.879	123.93		4.744	120.50
049	5.124	130.15		4.989	126.72
	5.129	130.28		4.994	126.85
050	5.374	136.50		5.239	133.07
	5.379	136.63		5.244	133.20
102	---	---		0.049	1.24
	---	---		0.054	1.37
103	---	---		0.081	2.06
	---	---		0.086	2.18
104	---	---		0.112	2.84
	---	---		0.117	2.97
105	---	---		0.143	3.63
	---	---		0.148	3.76
106	---	---		0.174	4.42
	---	---		0.179	4.55
107	---	---		0.206	5.23
	---	---		0.211	5.36
108	---	---		0.237	6.02
	---	---		0.242	6.15
109	---	---		0.299	7.59
	---	---		0.304	7.72
110	0.563	14.30		0.362	9.19
	0.568	14.43		0.367	9.32

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
111	0.625	15.88		0.424	10.77
	0.630	16.00		0.429	10.90
112	0.688	17.48		0.487	12.37
	0.693	17.60		0.492	12.50
113	0.750	19.05		0.549	13.94
	0.755	19.18		0.554	14.07
114	0.813	20.65		0.612	15.54
	0.818	20.78		0.617	15.67
115	0.875	22.22		0.674	17.12
	0.880	22.35		0.679	17.25
116	0.938	23.83		0.737	18.72
	0.943	23.95		0.742	18.85
117	1.000	25.40		0.799	20.29
	1.005	25.53		0.804	20.42
118	1.063	27.00		0.862	21.89
	1.068	27.13		0.867	22.02
119	1.125	28.58		0.924	23.47
	1.130	28.70		0.929	23.60
120	1.188	30.18		0.987	25.07
	1.193	30.30		0.992	25.20
121	1.250	31.75		1.049	26.64
	1.255	31.88		1.054	26.77
122	1.313	33.35		1.112	28.24
	1.318	33.48		1.117	28.37
123	1.375	34.92		1.174	29.82
	1.380	35.05		1.179	29.95
124	1.438	36.53		1.237	31.42
	1.443	36.65		1.242	31.55
125	1.500	38.10		1.299	32.99
	1.505	38.23		1.304	33.12
126	1.563	39.70		1.362	34.59
	1.568	39.83		1.367	34.72
127	1.625	41.28		1.424	36.17
	1.630	41.40		1.429	36.30
128	1.688	42.88		1.487	37.77
	1.693	43.00		1.492	37.90
129	1.750	44.45		1.549	39.34
	1.755	44.58		1.554	39.47
130	1.813	46.05		1.612	40.94
	1.818	46.18		1.617	41.07

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
131	1.875	47.62		1.674	42.52
	1.880	47.75		1.679	42.65
132	1.938	49.23		1.737	44.12
	1.943	49.35		1.742	44.25
133	2.000	50.80		1.799	45.69
	2.005	50.93		1.804	45.82
134	2.063	52.40		1.862	47.29
	2.068	52.53		1.867	47.42
135	2.126	54.00		1.925	48.90
	2.131	54.13		1.930	49.02
136	2.188	55.58		1.987	50.47
	2.193	55.70		1.992	50.60
137	2.251	57.18		2.050	52.07
	2.256	57.30		2.055	52.20
138	2.313	58.75		2.112	53.64
	2.318	58.88		2.117	53.77
139	2.376	60.35		2.175	55.24
	2.381	60.48		2.180	55.37
140	2.438	61.93		2.237	56.82
	2.443	62.05		2.242	56.95
141	2.501	63.53		2.300	58.42
	2.506	63.65		2.305	58.55
142	2.563	65.10		2.362	59.99
	2.568	65.23		2.367	60.12
143	2.626	66.70		2.425	61.60
	2.631	66.83		2.430	61.72
144	2.688	68.28		2.487	63.17
	2.693	68.40		2.492	63.30
145	2.751	69.88		2.550	64.77
	2.756	70.00		2.555	64.90
146	2.813	71.58		2.612	66.34
	2.818	71.58		2.617	66.47
147	2.876	73.05		2.675	67.94
	2.881	73.18		2.680	68.07
148	2.938	74.63		2.737	69.52
	2.943	74.75		2.742	69.65
149	3.001	76.23		2.800	71.12
	3.006	76.35		2.805	71.25
150	3.063	77.80		2.862	72.69
	3.068	77.93		2.867	72.82

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
151	3.188	80.98		2.987	75.87
	3.193	81.10		2.992	76.00
152	3.438	87.33		3.237	82.22
	3.443	87.45		3.242	82.35
153	3.688	93.68		3.492	88.57
	3.693	93.80		3.498	88.70
154	3.938	100.03		3.737	94.92
	3.943	100.15		3.742	95.05
155	4.188	106.38		3.987	101.27
	4.193	106.50		3.992	101.40
156	4.438	112.73		4.237	107.62
	4.443	112.85		4.242	107.75
157	4.688	119.08		4.487	113.97
	4.693	119.20		4.492	114.10
158	4.938	125.43		4.737	120.32
	4.943	125.55		4.742	120.45
159	5.188	131.78		4.987	126.67
	5.193	131.90		4.992	126.80
160	5.438	138.13		5.237	133.02
	5.443	138.25		5.242	133.15
161	5.688	144.48		5.487	139.37
	5.693	144.60		5.492	139.50
162	5.938	150.83		5.737	145.72
	5.943	150.95		5.742	145.85
163	6.188	157.18		5.987	152.07
	6.193	157.30		5.992	152.20
164	6.438	163.53		6.237	158.42
	6.443	163.65		6.242	158.55
165	6.688	169.88		6.487	164.77
	6.693	170.00		6.492	164.90
166	6.938	176.23		6.737	171.12
	6.943	176.35		6.742	171.25
167	7.188	182.58		6.987	177.47
	7.193	182.70		6.992	177.60
168	7.438	188.93		7.237	183.82
	7.443	189.05		7.242	183.95
169	7.688	195.28		7.487	190.17
	7.693	195.40		7.492	190.30
170	7.938	201.63		7.737	196.52
	7.943	201.75		7.742	196.65

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
171	8.188	207.98		7.987	202.87
	8.193	208.10		7.992	203.00
172	8.438	214.33		8.237	209.22
	8.443	214.45		8.242	209.35
173	8.688	220.68		8.487	215.57
	8.693	220.80		8.492	215.70
174	8.938	227.03		8.737	221.92
	8.943	227.15		8.742	222.05
175	9.180	233.38		8.987	228.27
	9.193	233.50		8.992	228.40
176	9.438	239.73		9.237	234.62
	9.443	239.85		9.242	234.75
177	9.688	246.08		9.487	240.97
	9.693	246.20		9.492	241.10
178	9.938	252.43		9.737	247.32
	9.943	252.55		9.742	247.45
201	---	---		0.171	4.34
	---	---		0.176	4.47
202	---	---		0.234	5.94
	---	---		0.239	6.07
203	---	---		0.296	7.52
	---	---		0.301	7.65
204	---	---		0.359	9.12
	---	---		0.364	9.25
205	0.694	17.63		0.421	10.69
	0.699	17.75		0.426	10.82
206	0.757	19.23		0.484	12.29
	0.762	19.35		0.489	12.42
207	0.819	20.80		0.546	13.87
	0.824	20.93		0.551	14.00
208	0.882	22.40		0.609	15.47
	0.887	22.53		0.614	15.60
209	0.944	23.98		0.671	17.04
	0.949	24.10		0.676	17.17
210	1.007	25.58		0.734	18.64
	1.012	25.70		0.739	18.77
211	1.069	27.15		0.796	20.22
	1.074	27.28		0.801	20.35

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
215	1.319	33.50		1.046	26.57
	1.324	33.63		1.051	26.70
216	1.382	35.10		1.109	28.17
	1.387	35.23		1.114	28.30
217	1.444	36.68		1.171	29.74
	1.449	36.80		1.176	29.87
218	1.507	38.28		1.234	31.34
	1.512	38.40		1.239	31.47
219	1.569	39.85		1.296	32.92
	1.574	39.98		1.301	33.05
220	1.632	41.45		1.359	34.52
	1.637	41.58		1.364	34.65
221	1.694	43.03		1.421	36.09
	1.699	43.15		1.426	36.22
222	1.757	44.63		1.484	37.69
	1.762	44.75		1.489	37.82
223	1.882	47.80		1.609	40.87
	1.887	47.93		1.614	41.00
224	2.007	50.98		1.734	44.04
	2.012	51.10		1.739	44.17
225	2.132	54.15		1.859	47.22
	2.137	54.28		1.864	47.35
226	2.257	57.33		1.984	50.39
	2.262	57.45		1.989	50.52
227	2.382	60.50		2.109	53.57
	2.387	60.63		2.114	53.70
228	2.507	63.68		2.234	56.74
	2.512	63.80		2.239	56.87
229	2.632	66.85		2.359	59.92
	2.637	66.98		2.364	60.05
230	2.757	70.03		2.484	63.09
	2.762	70.15		2.489	63.22
231	2.882	73.20		2.609	66.27
	2.887	73.33		2.614	66.40
232	3.007	76.38		2.734	69.44
	3.012	76.50		2.739	69.57
233	3.132	79.55		2.859	72.62
	3.137	79.68		2.864	72.75
234	3.257	82.73		2.984	75.79
	3.262	82.85		2.989	75.92

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
235	3.382	85.90		3.109	78.97
	3.387	86.03		3.114	79.10
236	3.507	89.08		3.234	82.14
	3.512	89.20		3.239	82.27
237	3.632	92.25		3.359	85.32
	3.637	92.38		3.364	85.45
238	3.757	95.43		3.484	88.49
	3.762	95.55		3.489	88.62
239	3.882	98.60		3.609	91.67
	3.887	98.73		3.614	91.80
240	4.007	101.78		3.734	94.84
	4.012	101.90		3.739	94.97
241	4.132	104.95		3.859	98.02
	4.137	105.08		3.864	98.15
242	4.257	108.13		3.984	101.19
	4.262	108.25		3.989	101.32
243	4.382	111.30		4.109	104.37
	4.387	111.43		4.114	104.50
244	4.507	114.48		4.234	107.54
	4.512	114.60		4.239	107.67
245	4.632	117.65		4.359	110.72
	4.637	117.78		4.364	110.85
246	4.757	120.83		4.484	113.89
	4.762	120.95		4.489	114.02
247	4.882	124.00		4.609	117.07
	4.887	124.13		4.614	117.20
248	5.007	127.18		4.734	120.24
	5.012	127.30		4.739	120.37
249	5.132	130.35		4.859	123.42
	5.137	130.48		4.864	123.55
250	5.257	133.53		4.984	126.59
	5.262	133.65		4.989	126.72
251	5.382	136.70		5.109	129.77
	5.387	136.83		5.114	129.90
252	5.507	139.88		5.234	132.94
	5.512	140.00		5.239	133.07
253	5.632	143.05		5.359	136.12
	5.637	143.18		5.364	136.25
254	5.757	146.23		5.484	139.29
	5.762	146.35		5.489	139.42

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
255	5.882	149.40		5.609	142.47
	5.887	149.53		5.614	142.60
256	6.007	152.58		5.734	145.64
	6.012	152.70		5.739	145.77
257	6.132	155.75		5.859	148.82
	6.137	155.88		5.864	148.95
258	6.257	158.93		5.984	151.99
	6.262	159.05		5.989	152.12
259	6.507	165.28		6.234	158.34
	6.512	165.40		6.239	158.47
260	6.757	171.63		6.484	164.69
	6.762	171.75		6.489	164.82
261	7.007	177.98		6.734	171.04
	7.012	178.10		6.739	171.17
262	7.247	184.33		6.984	177.39
	7.262	184.45		6.989	177.52
263	7.507	190.68		7.234	183.74
	7.512	190.80		7.239	183.87
264	7.757	197.03		7.484	190.09
	7.762	197.15		7.489	190.22
265	8.007	203.38		7.734	196.44
	8.012	203.50		7.739	196.57
266	8.257	209.73		7.984	202.79
	8.262	209.85		7.989	202.92
267	8.507	216.08		8.234	209.14
	8.512	216.20		8.239	209.27
268	8.757	222.43		8.484	215.49
	8.762	222.55		8.489	215.62
269	9.007	228.78		8.734	221.84
	9.012	228.90		8.739	221.97
270	9.257	235.13		8.984	228.19
	9.262	235.25		8.989	228.32
271	9.507	241.48		9.234	234.54
	9.512	241.60		9.239	234.67
272	9.757	247.83		9.484	240.89
	9.762	247.95		9.489	241.02
273	10.007	254.18		9.734	247.24
	10.012	254.30		9.739	247.37
274	10.257	260.53		9.984	253.59
	10.262	260.65		9.989	253.72

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
275	10.757	273.23		10.484	266.29
	10.762	273.35		10.489	266.42
276	11.257	285.93		10.984	278.99
	11.262	286.05		10.989	279.12
277	11.757	298.63		11.484	291.69
	11.769	298.75		11.489	291.82
278	12.257	311.33		11.984	304.39
	12.262	311.45		11.989	304.52
279	13.257	336.73		12.984	329.79
	13.262	336.85		12.989	329.92
280	14.257	362.13		13.984	355.19
	14.262	362.25		13.989	355.32
281	15.257	387.53		14.984	380.59
	15.262	387.65		14.989	380.72
282	16.228	412.19		15.955	405.26
	16.233	412.32		15.960	405.38
283	17.228	437.59		16.955	430.66
	17.233	437.72		16.960	430.78
284	18.228	462.99		17.955	456.06
	18.233	463.12		17.960	456.18
309	---	---		0.412	10.46
	---	---		0.417	10.59
310	0.890	22.61		0.475	12.06
	0.895	22.73		0.480	12.19
311	0.952	24.18		0.537	13.64
	0.957	24.31		0.542	13.77
312	1.015	25.78		0.600	15.24
	1.020	25.91		0.605	15.37
313	1.077	27.36		0.662	16.81
	1.082	27.48		0.667	16.94
314	1.140	28.96		0.725	18.42
	1.145	29.08		0.730	18.54
315	1.202	30.53		0.787	19.99
	1.207	30.66		0.792	20.12
316	1.265	32.13		0.850	21.59
	1.270	32.26		0.855	21.72
317	1.327	33.71		0.912	23.16
	1.332	33.83		0.917	23.29
318	1.390	35.31		0.975	24.76
	1.395	35.43		0.980	24.89

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Min Max	mm Min Max		Inch Min Max	mm Min Max
319	1.452	36.88		1.037	26.34
	1.457	37.01		1.042	26.47
320	1.515	38.48		1.100	27.94
	1.520	38.61		1.105	28.07
321	1.577	40.06		1.162	29.51
	1.582	40.18		1.167	29.64
322	1.640	41.66		1.225	31.12
	1.645	41.78		1.230	31.24
323	1.702	43.23		1.287	32.69
	1.707	43.36		1.292	32.82
324	1.765	44.83		1.350	34.29
	1.770	44.96		1.355	34.42
325	1.890	48.01		1.475	37.46
	1.895	48.13		1.480	37.59
326	2.015	51.18		1.600	40.64
	2.020	51.31		1.605	40.77
327	2.140	54.36		1.725	43.82
	2.145	54.48		1.730	43.94
328	2.265	57.53		1.850	46.99
	2.270	57.66		1.855	47.12
329	2.390	60.71		1.975	50.16
	2.395	60.83		1.980	50.29
330	2.515	63.88		2.100	53.34
	2.520	64.01		2.105	53.47
331	2.640	67.06		2.225	56.52
	2.645	67.18		2.230	56.64
332	2.765	70.23		2.350	59.69
	2.770	70.36		2.355	59.82
333	2.890	73.41		2.475	62.86
	2.895	73.53		2.480	62.99
334	3.015	76.58		2.600	66.04
	3.020	76.71		2.605	66.17
335	3.140	79.76		2.725	69.22
	3.145	79.88		2.730	69.34
336	3.265	82.93		2.850	72.39
	3.270	83.06		2.855	72.52
337	3.390	86.11		2.975	75.56
	3.395	86.23		2.980	75.69
338	3.515	89.28		3.100	78.74
	3.520	89.41		3.105	78.87

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch	mm		Inch	mm
	Min Max	Min Max		Max Min	Min Max
339	3.640	92.46		3.225	81.92
	3.645	92.58		3.230	82.04
340	3.765	95.63		3.350	85.09
	3.770	95.76		3.355	85.22
341	3.890	98.81		3.475	88.26
	3.895	98.93		3.480	88.39
342	4.015	101.98		3.600	91.44
	4.020	102.11		3.605	91.57
343	4.140	105.16		3.725	94.62
	4.145	105.28		3.730	94.74
344	4.265	108.33		3.850	97.79
	4.270	108.46		3.855	97.92
345	4.390	111.51		3.975	100.96
	4.395	111.63		3.980	101.09
346	4.515	114.68		4.100	104.14
	4.520	114.81		4.105	104.27
347	4.640	117.86		4.225	107.32
	4.645	117.98		4.230	107.44
348	4.765	121.03		4.350	110.49
	4.770	121.16		4.355	110.62
349	4.890	124.21		4.475	113.66
	4.895	124.33		4.480	113.79
350	5.015	127.38		4.600	116.84
	5.020	127.51		4.605	116.97
351	5.140	130.56		4.725	120.02
	5.145	130.68		4.730	120.14
352	5.265	133.73		4.850	123.19
	5.270	133.86		4.855	123.32
353	5.390	136.91		4.975	126.36
	5.395	137.03		4.980	126.49
354	5.515	140.08		5.100	129.54
	5.520	140.21		5.105	129.67
355	5.640	143.26		5.225	132.72
	5.645	143.38		5.230	132.84
356	5.765	146.43		5.350	135.89
	5.770	146.56		5.355	136.02
357	5.890	149.61		5.475	139.06
	5.895	149.73		5.480	139.19
358	6.015	152.78		5.600	142.24
	6.020	152.91		5.605	142.37

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Max Min	mm Min Max		Inch Max Min	mm Min Max
359	6.140	155.96		5.725	145.42
	6.145	156.08		5.730	145.54
360	6.265	159.13		5.850	148.59
	6.270	159.26		5.855	148.72
361	6.390	162.31		5.975	151.76
	6.395	162.43		5.980	151.89
362	6.640	168.66		6.225	158.12
	6.645	168.78		6.230	158.24
363	6.890	175.01		6.475	164.46
	6.895	175.13		6.480	164.59
364	7.140	181.36		6.725	170.82
	7.145	181.48		6.730	170.94
365	7.390	187.71		6.975	177.16
	7.395	187.83		6.980	177.29
366	7.640	194.06		7.225	183.52
	7.645	194.18		7.230	183.64
367	7.890	200.41		7.475	189.86
	7.895	200.53		7.480	189.99
368	8.140	206.76		7.725	196.22
	8.145	206.88		7.730	196.34
369	8.390	213.11		7.975	202.56
	8.395	213.23		7.980	202.69
370	8.640	219.46		8.225	208.92
	8.645	219.58		8.230	209.04
371	8.890	225.81		8.475	215.26
	8.895	225.93		8.480	215.39
372	9.140	232.16		8.725	221.62
	9.145	232.28		8.730	221.74
373	9.390	238.51		8.975	227.96
	9.395	238.63		8.980	228.09
374	9.640	244.86		9.225	234.32
	9.645	244.98		9.230	234.44
375	9.890	251.21		9.475	240.66
	9.895	251.33		9.480	240.79
376	10.140	257.56		9.725	247.02
	10.145	257.68		9.730	247.14
377	10.390	263.91		9.975	253.36
	10.395	264.03		9.980	253.49
378	10.890	276.61		10.475	266.06
	10.895	276.73		10.480	266.19

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch	mm		Inch	mm
	Max Min	Min Max		Max Min	Min Max
379	11.390	276.61		10.475	266.06
	11.395	276.73		10.480	266.19
380	11.890	302.01		11.475	291.46
	11.895	302.13		11.480	291.59
381	12.390	314.71		11.975	304.16
	12.395	314.83		11.980	304.29
382	13.390	340.11		12.975	329.56
	13.395	340.23		12.980	329.69
383	14.390	365.51		13.975	354.96
	14.395	365.63		13.980	355.09
384	15.390	390.91		14.975	380.36
	15.395	391.03		14.980	380.49
385	16.370	415.80		15.955	405.26
	16.375	415.92		15.960	405.38
386	17.370	441.20		16.955	430.66
	17.375	441.32		16.960	430.78
387	18.370	466.60		17.955	456.06
	18.375	466.72		17.960	456.18
388	19.370	492.00		18.955	481.46
	19.375	492.12		18.960	481.58
389	20.370	517.40		19.955	506.86
	20.375	517.52		19.960	506.98
390	21.370	542.80		20.955	532.26
	21.375	542.92		20.960	532.38
391	22.370	568.20		21.955	557.66
	22.375	568.32		21.960	557.78
392	23.355	593.22		22.940	582.68
	23.360	593.34		22.945	582.80
393	24.355	618.62		23.940	608.08
	24.360	618.74		23.945	608.20
394	25.355	644.02		24.940	633.48
	25.360	644.14		24.945	633.60
395	26.355	669.42		25.940	658.88
	26.360	669.54		25.945	659.00
425	5.020	127.51		4.475	113.66
	5.025	127.64		4.480	113.79
426	5.145	130.68		4.600	116.84
	5.150	130.81		4.605	116.97

Table 2 - Standard gland diameters (continued)

Gland and AS568 Dash No.	Internal Pressure Application - ØA			External Pressure Application - ØB	
	Inch Max Min	mm Min Max		Inch Max Min	mm Min Max
427	5.270	133.86		4.725	120.02
	5.275	133.98		4.730	120.14
428	5.395	137.03		4.850	123.19
	5.400	137.16		4.855	123.32
429	5.520	140.21		4.975	126.36
	5.525	140.34		4.980	126.49
430	5.645	143.38		5.100	129.54
	5.650	143.51		5.105	129.67
431	5.770	146.56		5.225	132.72
	5.775	146.68		5.230	132.84
432	5.895	149.73		5.350	135.89
	5.900	149.86		5.355	136.02
433	6.020	152.91		5.475	139.06
	6.025	153.04		5.480	139.19
434	6.145	156.08		5.600	142.24
	6.150	156.21		5.605	142.37
435	6.270	159.26		5.725	145.42
	6.275	159.38		5.730	145.54
436	6.395	162.43		5.850	148.59
	6.400	162.56		5.855	148.72
437	6.520	165.61		5.975	151.76
	6.525	165.74		5.980	151.89
438	6.770	171.96		6.225	158.12
	6.775	172.08		6.230	158.24
439	7.020	178.31		6.475	164.46
	7.025	178.44		6.480	164.59
440	7.270	184.66		6.725	170.82
	7.275	184.78		6.730	170.94
441	7.520	191.01		6.975	177.16
	7.525	191.14		6.980	177.29
442	7.770	197.36		7.225	183.52
	7.775	197.48		7.230	183.64
443	8.020	203.71		7.475	189.86
	8.025	203.84		7.480	189.99
444	8.270	210.06		7.725	196.22
	8.275	210.18		7.730	196.34
445	8.520	216.41		7.975	202.56
	8.525	216.54		7.980	202.69
446	9.020	229.11		8.475	215.26
	9.025	229.24		8.480	215.39