



Pressure Seals, Inc.

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Thousands of Seals, O-Rings, and U-Cups
World-Class Service since 1976!

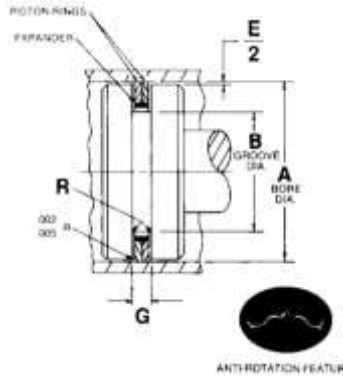


Notes:

1. This part is supplied in virgin TFE per MIL-R-8791. For other material callouts, refer to Technical Data section.
2. Each TF 054 assembly consists of two TF 052 piston rings and one TF 053 expander. Rings are to be rotated at installation so that step cuts are 180° apart.
3. Expander Material: Type 301 stainless steel per MIL-S-5059;
Alternate Material: 17-7PH CRES.

Ordering Instructions:

Example: TF 054-19-A
Basic Part Number _____
Size Dash No. _____
Alternate _____
17-7PH Expander Material



CODE IDENT. 07128 **TF 054**

**PISTON RING INSTALLATION
STANDARD FRACTIONAL BORE SIZE**

Dash No.	G Groove Width	R Groove Radius	E Diametral Clearance Max.
	+0.01 -0.01		
8-64	0.126	0.020	0.005
65-95	0.189	0.030	0.007

Dash No.	A Dia.	B Dia.	Dash No.	A Dia.	B Dia.	Dash No.	A Dia.	B Dia.
	+0.001	+0.004		+0.002	+0.004		+0.003	+0.004
	-0.001	-0.004		-0.000	-0.004		-0.000	-0.004
8	0.500	0.254	37	2.312	1.880	65	4.125	3.565
9	0.562	0.316	38	2.375	1.943	66	4.250	3.690
10	0.625	0.379	39	2.437	2.005	67	4.375	3.815
11	0.687	0.441	40	2.500	2.068	68	4.500	3.940
12	0.750	0.442	41	2.562	2.130	69	4.625	4.065
13	0.812	0.504	42	2.625	2.193	70	4.750	4.190
14	0.875	0.567	43	2.687	2.255	71	4.875	4.315
15	0.937	0.629	44	2.750	2.318	72	5.000	4.440
	+0.002	+0.004	45	2.812	2.380	73	5.125	4.565
	-0.000	-0.004	46	2.875	2.443	74	5.250	4.690
16	1.000	0.692	47	2.937	2.505	75	5.375	4.815
17	1.062	0.754	48	3.000	2.568	76	5.500	4.940
18	1.125	0.817	49	3.062	2.630	77	5.625	5.065
19	1.187	0.879	50	3.125	2.693	78	5.750	5.190
20	1.250	0.942	51	3.187	2.755	79	5.875	5.315
21	1.312	1.004	52	3.250	2.818	80	6.000	5.440
22	1.375	1.067	53	3.312	2.880	81	6.125	5.565
23	1.437	1.005		+0.003	+0.004	82	6.250	5.690
24	1.500	1.068		-0.000	-0.004	83	6.375	5.815
25	1.562	1.130	54	3.375	2.943	84	6.500	5.940
26	1.625	1.193	55	3.437	3.005	85	6.625	6.065
27	1.687	1.255	56	3.500	3.068	86	6.750	6.190
28	1.750	1.318	57	3.562	3.130	87	6.875	6.315
29	1.812	1.380	58	3.625	3.193	88	7.000	6.440
30	1.875	1.443	59	3.687	3.255	89	7.250	6.690
31	1.937	1.505	60	3.750	3.318	90	7.500	6.940
32	2.000	1.568	61	3.812	3.380	91	7.750	7.190
33	2.062	1.630	62	3.875	3.443	92	8.000	7.440
34	2.125	1.693	63	3.937	3.505	93	8.500	7.940
35	2.187	1.755	64	4.000	3.568	94	9.000	8.440
36	2.250	1.818				95	9.500	8.940

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