



CR Seals®

Metal face seals product listings

Understanding key table elements

Designed to be user-friendly, CR Seals and product listings convey a good deal of information on every line. As you familiarize yourself with the tables, keep these need-to-know basics in mind:

Seal and product sizes

All size listings for all CR Seals products are arranged by ascending shaft diameters, segregated as inch sizes (green bars) and metric sizes (blue bars). All bore and width sizes listed under the green bars are in inches, while all sizes listed under blue bars are in mm.

Bore / width

Once you have selected the right shaft size, you will need to identify the seals with a matching bore size. The recommended tolerance ranges for shaft and bore can be found on **pages 46-49**. While it is important to choose a seal with a close match to shaft and bore, it is less important to choose a seal with a predetermined width. As long as the seal is short enough not to protrude out of the bore, it will work just fine.

Preferred designs

Highlighted in bold in the “Part Number” and “Seal Type” columns, preferred seal design listings represent the highest performing or otherwise best suited sealing solution for a given shaft diameter.

Lip Material

- R = NBR** (nitrile rubber)
- RG = NBR** with advanced oil resistance and pumping ability
- D = XNBR** (carboxylated nitrile)
- H = HNBR** (hydrogenated nitrile)
- V = FKM** (fluorocarbon rubber)
- P = ACM** (polyacrylate elastomer)
- T = PTFE** (polytetrafluoroethylene)

Seal technologies

W = SKF Wave: Featuring the patented SKF Wave lip design, these are the most robust standard seals ever made.

E = SKF Edge: SKF Edge shaft seals HMS5 and HMSA10 combine an SKF-developed NBR compound with a rubber outside diameter according to ISO/DIN global design standards – primarily available in metric sizes.

F = SKF Flex: SKF Flex seals deliver heavy-duty performance in fully customizable sizes and features to fit and perform in the application.

S = Standard oil seal: SKF carries some older designs that do not have the modern advancements of the SKF Edge or SKF Wave lips, but may be adequate for some applications. Use these when SKF Edge or SKF Wave seals are not available in the size needed.

G = Grease seal: Oil seals can handle oil or grease applications, but grease seals do not have the garter spring needed for oil retention, so they are for grease only. Normally you point the lip away from grease if the main concern is water/dirt ingress, which also allows the grease to purge if needed.

Key features

- ▲ **WasteWatcher:** Indicates that the product is most likely to be in stock at our distributors and our own SKF warehouses. The CR Seals Waste-Watcher program helps distributors optimize seal inventories.
- **Bore-Tite:** Indicates the seal uses SKF Bore-Tite, a green, water-based acrylic sealant used as a coating on the outside diameter of the seal.
- ▣ **SS Case:** Indicates the seal has a stainless steel seal case.
- ◎ **SS Spring:** Indicates the seal has a stainless steel seal lip spring.
- ◆ **Pressure seal up to 50 psi:** Suitable for higher-pressure sealing applications; typical industrial shaft seals can handle only up to 5 or 10 psi.
- ◇ **Cover plate required:** Proper seal installation and operation requires a cover plate, which clamps down axially on an all-rubber seal to hold it in place in many large diameter seal applications.

skf.com/crseals

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Metal face seals

HDDF metal face seals from SKF (→ **fig. 1**) are designed for severe operating conditions at relatively low circumferential speeds. They offer reliable protection against solid and liquid contaminants as well as leak-proof lubricant retention.

Typical applications

Originally developed for off-road and tracked vehicles, HDDF metal face seals (→ **fig. 2**) have proven equally suitable in applications that need protection against sand, soil, mud, water and more. These include:

- Mixers and conveyors
- Sand treatment equipment
- Mining equipment
- Construction equipment
- Agricultural machinery
- Washing equipment
- Grinding mills /pulverizing equipment

Figure 1

HDDF seal

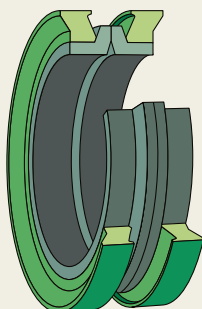
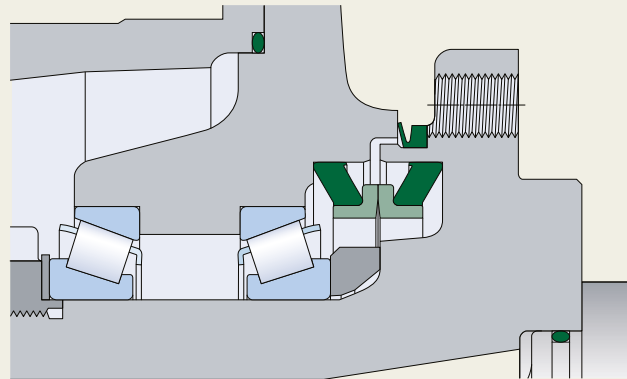


Figure 2

HDDF application



Design features

HDDF seals consist of two identical metal sealing rings and two similar Belleville washers (cup springs) made of nitrile or fluoro rubber compounds, specifically developed for these seals (→ **fig. 3**). The sealing rings are made of wear- and corrosion-resistant cast alloy and have finely finished sliding and sealing surfaces.

The Belleville washers of nitrile or fluoro rubber provide the necessary uniform face loading and effective sealing at the bore and outside diameters. Adequate tolerances between the seal assembly and the bore are critical for proper sealing performance.

Lubricant requirements

A lubricant should be applied on the dynamic sealing surfaces of a metal face seal to prevent scoring and cover at least 30% of the sealing surface to properly lubricate and cool the sealing rings. The lubricant can be either a detergent like SAE 10W-40, or a mineral-based oil ranging from 10 WT to 90 WT, depending on the ambient temperature. Some oils contain additives that make them incompatible with elastomers, which can cause degradation of the Belleville washers, especially when exposed to elevated temperatures.

Although mineral oils are always the recommended lubricant, a grease lubricant can also be used in some slowly rotating or oscillating applications, where the seal face surface speed does not exceed 100 ft/min (0.5 m/s). At higher speeds, an oil lubricant is required, not only to provide lubrication to the sealing faces, but also to cool the sealing rings.





Permissible operating conditions

Depending on their design, metal face seals can withstand different amounts of internal pressure. It should, however, generally be maintained below 35 psi (0.25 MPa). Other recommendations regarding operating conditions for the metal face seals, like temperature and speed, are provided in **Table 1**.

Contaminants

Due to their use in heavily contaminated environments, HDDF metal face seals are subject to a build-up of mud packing in the cavity between the housing and sealing rings and Belleville washer. Eventually, the packing mud will push the Belleville washers out of position, resulting in improper face loads or mud being pumped past the Belleville washers. Contaminants can also cause abrasion to the Belleville washers, which in turn causes deterioration of the elastomer.

Installing HDDF seals

Careful handling and installation of a metal face seal is critical to avoid cutting or tearing of the elastomeric Belleville washers or breaking the metal sealing rings, both of which can cause premature seal failure and immediate leakage. It is also vital to keep the sealing faces free from contaminants like dirt or lint.

All housing components contacting the Belleville washers must be free from contaminants (oil, grease, dust, lint particles, etc.). SKF recommends using a non-petroleum-based solvent and a clean, lint-free wipe to clean these components prior to installation. Once these preparations are complete, proceed with HDDF seal installation:

- 1 Install the Belleville washers seated against the inside shoulder of the metal sealing rings (→ **fig. 4a**).
- 2 Carefully push each seal half (Belleville washer and metal sealing ring) into the housing until it is fully seated. Check that the seal is not cocked and that the washers are seated evenly at the bottom of the housing bore. Improper seal installation can result in uneven face loads around the circumference of the seal faces, causing scoring or the sealing rings to separate and allow oil to leak.
- 3 Clean both metal sealing ring faces with a lint-free wipe and apply a thin film of oil. Ensure that no oil is applied to any surface but the sealing ring faces (→ **fig. 4b**).
- 4 Check that both housings are concentric and in correct alignment. The Belleville washers must not unseat from the bottom of the housing.

- 5 Carefully bring the two housings together, avoiding high impact that can scratch or break the seal components.
- 6 Finally, hold one half of the assembly stationary while rotating the other half at least ten complete revolutions.

NOTE: This procedure enables the installer to check that the housing and the Belleville washers are aligned. If the seal assembly wobbles, it is necessary to disassemble it and make sure that the Belleville washers are properly seated in the housing.

Figure 3

Design features

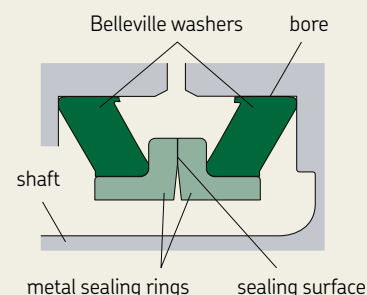


Figure 4

Installation procedure

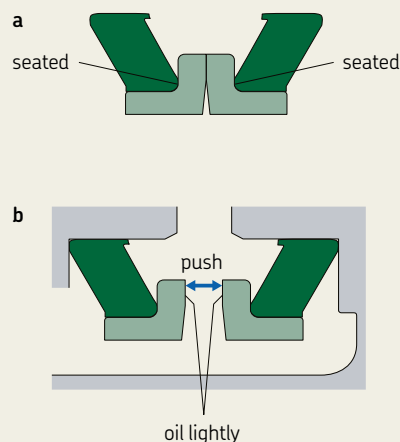
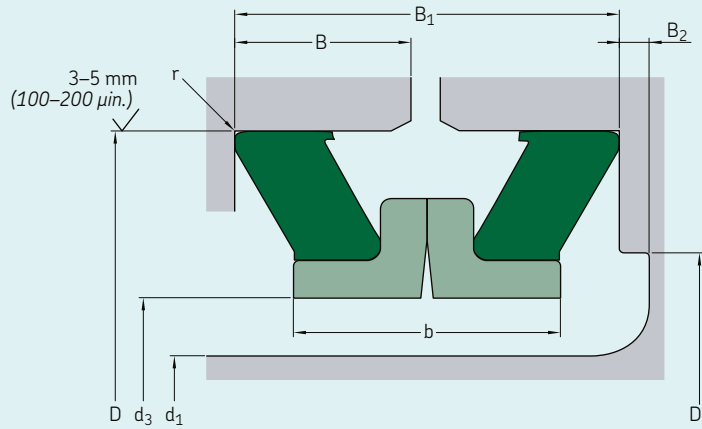


Table 1

Permissible operating conditions

Operating condition	Recommended value	
Temperature, max		
Continuous operation		
Nitrile rubber (NBR)	-15 to +210 °F	-25 to +100 °C
Fluoro rubber (FKM)	+15 to 375 °F	-10 to +190 °C
Circumferential speed, max		
Continuous operation	350 ft/min	1.8 m/s
Brief periods	750 ft/min	3.8 m/s
Pressure, max		
Continuous operation	35 psi	0.25 MPa
Brief periods	50 psi	0.35 MPa





Inch

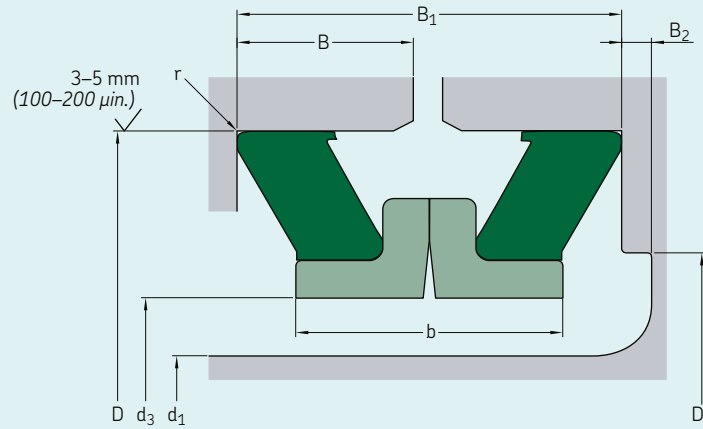
SKF part number

Lip mat'l

Inch dimensions

SKF part number	Lip mat'l	Shaft diameter	Bore diameter	Operating width	Seal inside diameter	Bore depth	Recommended shoulder diameter		Undercut	Sealing ring width	Radius
		D_1 max	D	B_1	d_3 min	B	D_1 max	min ²⁾	B_2 min	b max	r max
in.											
16904	R	1.688	2.760 ±0.002	0.974 ±0.038	1.760	0.453	2.282	-	-	0.846	0.037
18259	R	1.812	3.003 ±0.002	0.892 ±0.031	1.910	0.416	2.475	-	-	0.790	0.042
21306	R	2.125	3.250 ±0.002	0.900 ±0.033	2.215	0.418	2.759	-	-	0.812	0.045
25096	R	2.500	3.762 ±0.002	0.907 ±0.033	2.580	0.422	3.188	-	-	0.840	0.042
27536	R	2.750	4.030 ±0.002	0.918 ±0.035	2.830	0.426	3.480	-	-	0.810	0.042
30651	R	3.063	4.500 ±0.002	1.016 ±0.035	3.170	0.475	3.833	-	-	0.912	0.042
35076	R	3.500	4.953 ±0.002	1.096 ±0.043	3.620	0.511	4.296	-	-	0.962	0.035
38740	R	3.875	5.312 ±0.003	1.102 ±0.024	4.040	0.524	4.750	-	-	1.002	0.042
38751	R	3.875	5.562 ±0.003	1.267 ±0.050	4.040	0.594	4.791	-	-	1.110	0.051
43135	R	4.312	5.823 ±0.003	1.102 ±0.024	4.420	0.524	5.125	-	-	1.002	0.042
43150	R	4.312	6.000 ±0.003	1.320 ±0.040	4.420	0.625	5.173	-	-	1.090	0.051
46975	R	4.688	6.400 ±0.003	1.525 ±0.050	4.795	0.722	5.583	-	-	1.254	0.047
50655	R	5.062	6.750 ±0.003	1.280 ±0.040	5.170	0.605	5.975	-	-	1.150	0.057
54000	R	5.400	6.990 ±0.003	1.310 ±0.030	5.625	0.625	6.625	-	-	1.182	0.057
56170	R	5.625	7.250 ±0.003	1.366 ±0.031	5.825	0.650	6.486	6.174	0.032	1.300	0.057
58775	R	5.875	7.641 ±0.003	1.510 ±0.031	6.000	0.724	6.868	6.548	0.056	1.490	0.073
63796	R	6.375	8.120 ±0.003	1.265 ±0.040	6.570	0.598	7.555	7.505	0.125	1.350	0.042
67560	R	6.750	8.620 ±0.004	1.375 ±0.030	6.920	0.656	7.750	-	-	1.260	0.042
74310	R	7.438	9.400 ±0.004	1.656 ±0.040	7.540	0.793	8.431	-	-	1.344	0.073
78020	R	7.800	10.000 ±0.004	1.750 ±0.050	7.940	0.835	8.910	-	-	1.500	0.058
82540	R	8.250	10.062 ±0.004	1.560 ±0.040	8.358	0.745	9.280	9.220	0.071	1.562	0.058
86850	R	8.688	10.911 ±0.005	1.924 ±0.030	8.790	0.932	9.754	-	-	1.642	0.058
93115	R	9.312	11.000 ±0.005	1.437 ±0.032	9.410	0.687	10.360	10.260	0.090	1.510	0.050
93125	R	9.312	11.625 ±0.005	1.754 ±0.050	9.410	0.837	10.750	-	-	1.510	0.089
95620	R	9.562	11.859 ±0.005	1.949 ±0.069	9.660	0.925	10.703	-	-	1.700	0.074
108710	R	10.875	12.969 ±0.005	1.540 ±0.050	11.060	0.730	12.100	12.000	0.143	1.670	0.043
116500	R	11.625	13.250 ±0.005	1.290 ±0.030	11.780	0.615	12.780	-	-	1.210	0.450
124020	R	12.400	14.375 ±0.005	1.656 ±0.050	12.500	0.788	13.530	13.470	0.060	1.610	0.057
137570	R	13.750	15.817 ±0.005	1.875 ±0.032	13.910	0.906	14.985	-	-	1.670	0.089
806715	R	14.750	16.695 ±0.005	1.875 ±0.032	14.950	0.906	15.863	-	-	1.670	0.620
807115	V	14.750	16.695 ±0.005	1.875 ±0.032	14.950	0.906	15.863	-	-	1.670	0.062
171025	R	17.125	19.240 ±0.006	1.531 ±0.053	17.280	0.724	18.400	18.300	0.140	1.659	0.043
191022	R	19.125	21.500 ±0.006	1.640 ±0.042	19.250	0.784	20.950	20.850	0.175	1.832	0.057
238020	R	23.875	26.875 ±0.006	2.125 ±0.040	24.280	1.018	25.550	-	-	1.851	0.089
807199	V	23.875	26.875 ±0.006	2.125 ±0.040	24.280	1.018	25.550	-	-	1.851	0.089
807149	V	29.000	32.000 ±0.006	2.125 ±0.040	29.512	1.028	30.672	-	-	1.851	0.089





Metric (mm)

Metric dimensions										Lip mat'l	SKF part number
Shaft diameter	Bore diameter	Operating width	Seal inside diameter	Bore depth	Recommended shoulder diameter	Under-cut	Sealing ring width	Radius			
D ₁ max	D	B ₁	d ₃ min	B	D ₁ max min ²⁾	B ₂ min	b max	r max			
in.											
42.88	70.10 ±0.06	24.74 ±0.97	44.70	11.51	57.96	-	-	21.49	0.94	R	16904
46.03	76.28 ±0.06	22.66 ±0.79	48.51	10.57	62.87	-	-	20.07	1.07	R	18259
53.98	82.55 ±0.06	22.86 ±0.84	56.26	10.62	70.08	-	-	20.62	1.14	R	21306
63.50	95.54 ±0.06	23.04 ±0.84	65.53	10.72	80.98	-	-	21.34	1.07	R	25096
69.85	102.36 ±0.06	23.32 ±0.89	71.88	10.82	88.39	-	-	20.57	1.07	R	27536
77.80	114.30 ±0.06	25.81 ±0.89	80.52	12.07	97.36	-	-	23.16	1.07	R	30651
88.90	125.81 ±0.06	27.84 ±1.09	91.95	12.98	109.12	-	-	24.43	0.89	R	35076
98.43	134.92 ±0.08	27.99 ±0.61	102.62	13.31	120.65	-	-	25.45	1.07	R	38740
98.43	141.27 ±0.08	32.18 ±1.27	102.62	15.09	121.69	-	-	28.19	1.30	R	38751
109.52	147.90 ±0.08	27.99 ±0.61	112.27	13.31	130.18	-	-	25.45	1.07	R	43135
109.52	152.40 ±0.08	33.53 ±1.02	112.27	15.88	131.39	-	-	27.69	1.30	R	43150
119.08	162.56 ±0.08	38.74 ±1.27	121.79	18.34	141.81	-	-	31.85	1.19	R	46975
128.57	171.45 ±0.08	32.51 ±1.02	131.32	15.37	151.77	-	-	29.21	1.45	R	50655
137.16	177.55 ±0.08	33.27 ±0.76	142.88	15.88	168.28	-	-	30.02	1.45	R	54000
142.88	184.15 ±0.08	34.70 ±0.79	147.96	16.51	164.74	156.82	0.81	33.02	1.45	R	56170
149.23	194.08 ±0.08	38.35 ±0.79	152.40	18.39	174.45	166.32	1.42	37.85	1.85	R	58775
161.93	206.25 ±0.08	32.13 ±1.02	166.88	15.19	191.90	190.63	3.18	34.29	1.07	R	63796
171.45	218.95 ±0.10	34.93 ±0.76	175.77	16.66	196.85	-	-	32.00	1.07	R	67560
188.93	238.76 ±0.10	42.06 ±1.02	191.52	20.14	214.15	-	-	34.14	1.85	R	74310
198.12	254.00 ±0.10	44.45 ±1.27	201.68	21.21	226.31	-	-	38.10	1.47	R	78020
209.55	255.57 ±0.10	39.62 ±1.02	212.29	18.92	235.71	234.19	1.80	39.67	1.47	R	82540
220.68	277.14 ±0.13	48.87 ±0.76	223.27	23.67	247.75	-	-	41.71	1.47	R	86850
236.52	279.40 ±0.13	36.50 ±0.81	239.01	17.45	263.14	260.60	2.29	38.35	1.27	R	93115
236.52	295.28 ±0.13	44.55 ±1.27	239.01	21.26	273.05	-	-	38.35	2.26	R	93125
242.87	301.22 ±0.13	49.50 ±1.75	245.36	23.50	271.86	-	-	43.18	1.88	R	95620
276.23	329.41 ±0.13	39.12 ±1.27	280.92	18.54	307.34	304.80	3.63	42.42	1.09	R	108710
295.28	336.55 ±0.13	32.77 ±0.76	299.21	15.62	324.61	-	-	30.73	11.43	R	116500
314.96	365.13 ±0.13	42.06 ±1.27	317.50	20.02	343.66	342.14	1.52	40.89	1.45	R	124020
349.25	401.75 ±0.13	47.63 ±0.81	353.31	23.01	380.62	-	-	42.42	2.26	R	137570
374.65	424.05 ±0.13	47.63 ±0.81	379.73	23.01	402.92	-	-	42.42	15.75	R	806715
374.65	424.05 ±0.13	47.63 ±0.81	379.73	23.01	402.92	-	-	42.42	1.57	V	807115
434.98	488.70 ±0.15	38.89 ±1.35	438.91	18.39	467.36	464.82	3.56	42.14	1.09	R	171025
485.78	546.10 ±0.15	41.66 ±1.07	488.95	19.91	532.13	529.59	4.45	46.53	1.45	R	191022
606.43	682.63 ±0.15	53.98 ±1.02	616.71	25.86	648.97	-	-	47.02	2.26	R	238020
606.43	682.63 ±0.15	53.98 ±1.02	616.71	25.86	648.97	-	-	47.02	2.26	V	807199
736.60	812.80 ±0.15	53.98 ±1.02	749.60	26.11	779.07	-	-	47.02	2.26	V	807149