Follow these steps to arrive at Finished Piston Gland Dimensions

Standard Wear Ring Thickness(es)
W6 = .057/.060"
WT = .075/.080
WH = .122/.125
WR = .120/.125
WB = .184/.187

Direct Force 2.500" Piston Wear Strip

**STEPS**

All Dimensions are in inches.

1. List All "Knowns"
   
   List this data before you begin any calculations. Select A and B from this brochure and C, D and E from your materials and machining capabilities.

2. Calculate Groove Diameter
   
   Subtract .001" from the minimum bore, then subtract twice the maximum ring thickness, and subtract the machining tolerance.

3. Calculate Piston O.D.
   
   Add twice the minimum ring thickness to minimum Groove Diameter from Step 2. Subtract twice the minimum desired metal to metal clearance, and subtract the machining tolerance.

4. Determine Groove Length
   
   Add a +.010/.020" tolerance to the maximum ring width (axial length).
   a) Note: Above applies for A.L. up 1.499"
   b) For 1.500 to 3.999" A.L. add +.020/.030"
   c) For 4.000 to 6.999" A.L. add +.030/.040"
   d) For A.L. above 7" consult Tech Center

**Note:** Properly applied Hydra-Lon™ rings always provide clearance between the piston and bore. Check and be certain that the piston seal selected will not extruded into this clearance.