Follow these steps to arrive at Finished Rod Gland Dimensions:

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

**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**
   - Add .001" to the maximum rod diameter, then add twice the maximum ring thickness, and add the machining tolerance.

3. **Calculate Throat Diameter**
   - Subtract twice the minimum ring thickness from the maximum Groove Diameter from Step 2. Add twice the minimum desired metal to metal clearance, and add the machining tolerance.

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

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