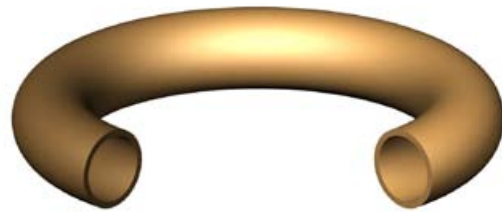


Sealing Concept

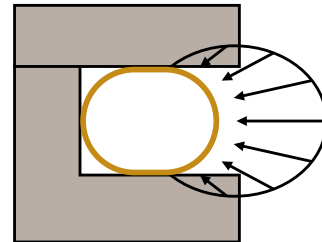
O-Flex™ Metal O-Rings are designed to provide a sealing option for high pressure/temperature applications that require minimal spring back. The O-Flex™ is made from high strength metal tubing that is coiled, cut and welded to size. It is available in standard cross section increments of 1/32". The O-Flex™ seating load can be adjusted to the application by varying the cross section and tubing wall thickness. Typical applications include Performance Engines, Plastic Extrusion/Molding, Military Specifications, Aerospace and Chemical Processing.



O-Flex™ Types

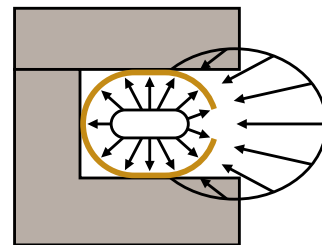
Basic

The basic O-Flex™ is designed for low to moderate pressure applications as high pressure may collapse the exposed tubing wall.



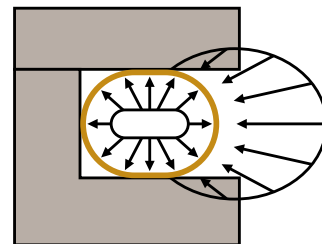
Self Energizing

The Self-Energizing O-Flex™ is designed for high pressure applications. Small holes are drilled in the tubing wall exposed to the system pressure. These holes create an energizing effect by allowing the pressure to enter the O-Flex™. As a result, the pressure inside the seal increases with the system pressure and minimizes the possibility of collapsing the exposed tubing wall.

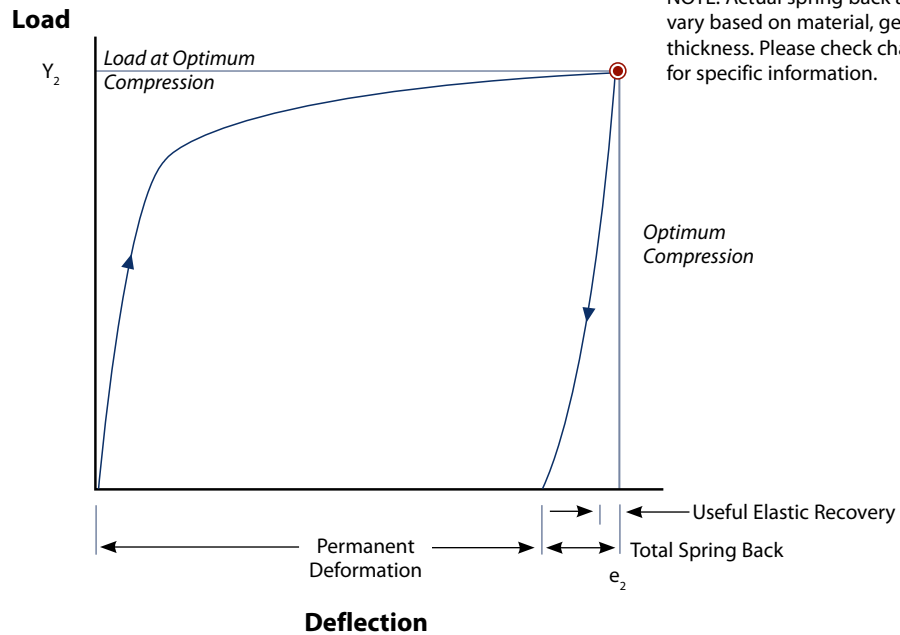


Pressure Filled

The Pressure Filled O-Flex™ is designed for Performance Engine applications that require sealing at elevated pressure and temperature in a high cycling environment. The O-Flex™ is filled with an inert gas that increases in pressure proportional to increases in system temperature. This results in an energizing effect that partially offsets the loss of material strength in service.



O-Flex™ Characteristic Curve



NOTE: Actual spring back and load will vary based on material, geometry, and wall thickness. Please check characteristic chart for specific information.

Material Selection

Material	Status	Temperature	Heat Treatment
SS 321	Standard	T < 700°F	NA
Alloy 600	Standard	T < 1,000°F	NA
Alloy X750	Standard	T < 1,100°F	NA
Alloy 718	Optional	T < 1,200°F	NA
Other	Contact Applications Engineering		

Plating/Coating Selection

Plating/Coating	Status	Standard Thickness	Temperature	Groove Finish*
PTFE	Optional	.001/.003	T < 500°F	16 - 32 RMS
Silver	Standard	.001/.002	T < 800°F	16 - 63 RMS
Silver w/ Gold strike	Optional	.001/.002	T < 1,200°F	16 - 63 RMS
Nickel	Standard	.001/.002	T < 1,600°F	16 - 32 RMS
None	-	-	-	< 16 RMS
Other	Contact Applications Engineering			

Dimensions in inches

* Groove finish must follow seal circumference (lathe turned finish).
Contact Applications Engineering for non-standard thicknesses.

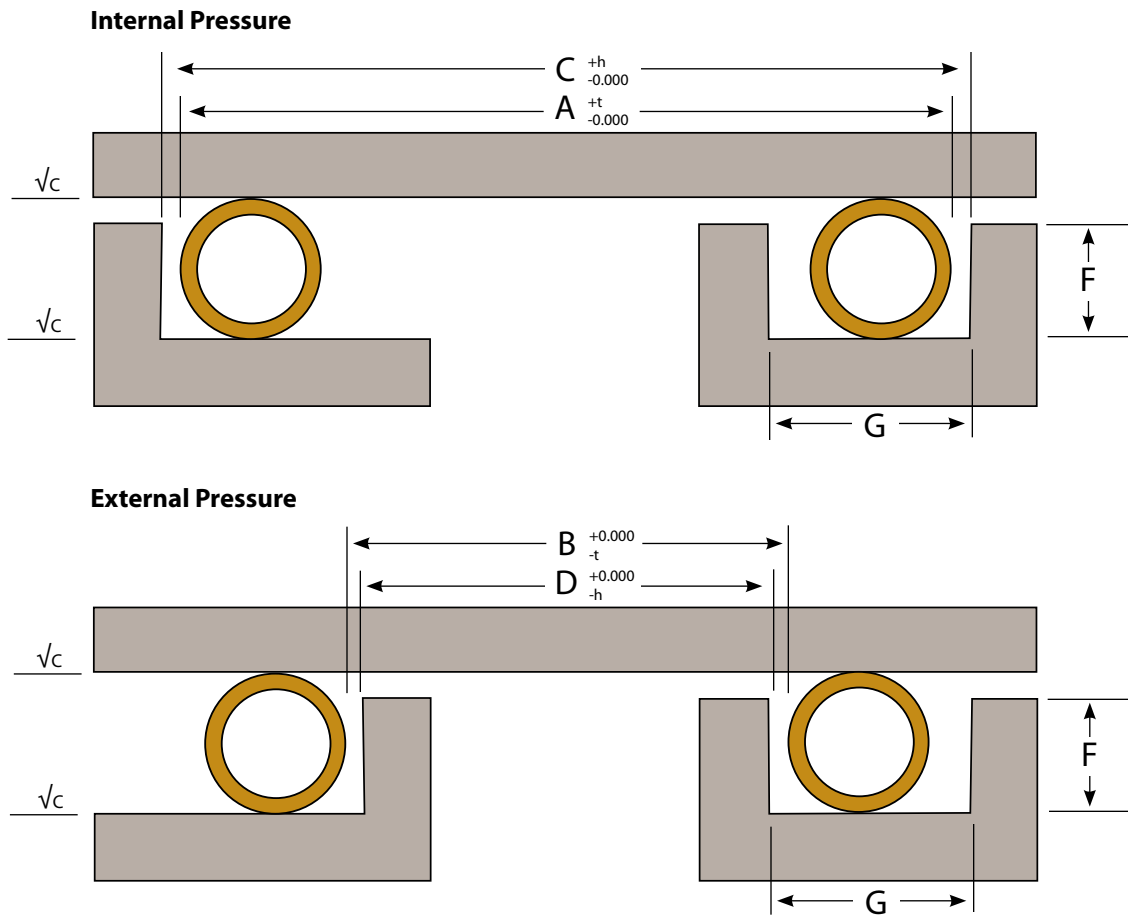
O-Flex™ Characteristic Values

Free Height	Compression e_2	Seal Diameter Range	Material Thickness	Thin (T) Medium (M) Heavy (H)	CHARACTERISTIC VALUES AT 70°F		
					SS 321 Seating Load (PCI) Y_2	Alloy 600 Seating Load (PCI) Y_2	Alloy X-750 Seating Load (PCI) Y_2
0.032	0.006	0.500 to 4.000	0.006	T	457	503	594
			0.010	M	1028	1131	1336
			-	H	-	-	-
0.063	0.012	0.500 to 10.000	0.010	T	571	628	742
			0.012	M	799	879	1039
			0.014	H	1256	1382	1633
0.094	0.020	1.000 to 20.000	0.010	T	343	377	446
			0.012	M	514	565	668
			0.018	H	1313	1444	1707
0.125	0.026	2.000 to 40.000	0.010	T	343	377	446
			0.020	M	1142	1256	1485
			0.025	H	2056	2262	2673
0.156	0.031	3.000 to 50.000 +	-	T	-	-	-
			0.020	M	857	943	1114
			0.025	H	1428	1571	1856
0.188	0.039	4.000 to 50.000 +	-	T	-	-	-
			0.020	M	657	723	854
			0.032	H	2113	2324	2747
0.250	0.051	5.000 to 50.000 +	0.025	T	799	879	1039
			0.032	M	1370	1507	1781
			0.049	H	3026	3329	3934

Dimensions in inches

NOTES:

1. PCI = Pounds force per circumferential inch
2. Seating Load (Y_2) is an approximation and may vary based on groove clearance, seal diameter, tolerance and plating thickness. It does not allow for system pressure requirements and should be verified for each application and seal size.
3. The customer must verify that system bolts and flanges can generate the required seating load without warping or distorting.
4. The customer must test and verify that the seal design meets customer designated performance requirements.



Seal and Groove Sizing Calculations

The equations below can be used for basic groove calculations. Applications that have significant thermal expansion may require additional clearance. Please contact Applications Engineering for design assistance.

Determining Seal Diameter:

Internal
 $A = C - X - 2P_{max}$

External
 $B = D + X + 2P_{max}$

Determining Groove Diameter:

Internal
 $C = A + X + 2P_{max}$

External
 $D = B - X - 2P_{max}$

Tolerancing: See chart

Where: A = Seal Outer Diameter
B = Seal Inner Diameter
C = Groove Outer Diameter
D = Groove Inner Diameter
P_{max} = Maximum Plating or Coating Thickness
X = Diametrical Clearance

Groove Finish \sqrt{c} : See Plating/Coating Section

Seal and Groove Dimensions

SEAL			GROOVE			
Free Height	Seal Diameter Range	Seal Tolerance t	Diametrical Clearance x	Groove Tolerance h	Groove Depth F	Groove Width (Min.) G
0.032	0.500 to 4.000	0.005	0.006	0.004	0.026 ±0.001	0.055
0.063	0.500 to 10.000	0.005	0.006	0.004	0.051 ±0.001	0.090
0.094	1.000 to 20.000	0.005	0.008	0.004	0.073 ±0.002	0.125
0.125	2.000 to 40.000	0.005	0.008	0.004	0.099 ±0.002	0.160
0.156	3.000 to 50.000 +	0.005	0.014	0.006	0.125 ±0.002	0.200
0.188	4.000 to 50.000 +	0.005	0.014	0.006	0.149 ±0.002	0.250
0.250	5.000 to 50.000 +	0.008	0.019	0.008	0.199 ±0.002	0.350

Dimensions in inches

NOTE: Contact Applications Engineering for additional sizes.



Aerospace Industry



Racing Industry

Tube Coatings	Tube Diameter	S.steel 321			Alloy 600			Alloy X750		
		T	M	H	T	M	H	T	M	H
Non Plated	Wall Thickness									
	0.032"	■	■	●	■	■	●	■	●	●
	0.063"	■	■	■	■	■	●	■	■	●
	0.094"	■	■	■	■	■	●	■	■	●
	0.125"	■	■	●	■	■	●	■	■	●
	0.156"	■	■	●	■	■	●	■	■	●
	0.188"	■	■	●	■	■	●	■	■	●
0.250"	■	●	●	■	●	●	■	●	●	
PTFE	Wall Thickness									
	0.032"	●	▲	▲		▲	▲	●	▲	▲
	0.063"	●	▲	▲		▲	▲	●	▲	▲
	0.094"	●	●	▲		●	▲	●	●	▲
	0.125"	●	▲	▲		▲	▲	●	▲	▲
	0.156"	■	▲	▲	■	▲	▲	■	▲	▲
	0.188"	■	●	▲	■	●	▲	■	●	▲
0.250"	▲	▲	▲	▲	▲	▲	▲	▲	▲	
Silver	Wall Thickness									
	0.032"	●	●	▲	●	●	▲	●	●	▲
	0.063"	●	●	▲	●	●	▲	●	●	▲
	0.094"	■	●	▲	■	●	▲	●	●	▲
	0.125"	■	●	▲	■	●	▲	●	●	▲
	0.156"	■	●	▲	■	●	▲	■	●	▲
	0.188"	■	●	▲	■	●	▲	■	●	▲
0.250"	●	●	▲	●	●	▲	●	●	▲	
Nickel	Wall Thickness									
	0.032"	■	●	●	■	●	●	■	●	●
	0.063"	■	■	●	■	●	●	■	●	●
	0.094"	■	■	●	■	■	●	■	■	●
	0.125"	■	●	●	■	●	●	■	●	●
	0.156"	■	●	●	■	●	●	■	●	●
	0.188"	■	■	●	■	■	●	■	●	●
0.250"	■	●	●	●	●	●	●	●	▲	

Legend

- : $Q > 1.32 \times 10^{-5}$ std.cc/sec He
 - : $1.32 \times 10^{-9} < Q < 1.32 \times 10^{-5}$ std.cc/sec He
 - ▲ : $Q < 1.32 \times 10^{-9}$ std.cc/sec He
- Q : Approximate leak rate per meter of circumference

- T: Thin
- M: Medium
- H: Heavy



O-Flex™ Seals for Military Standards



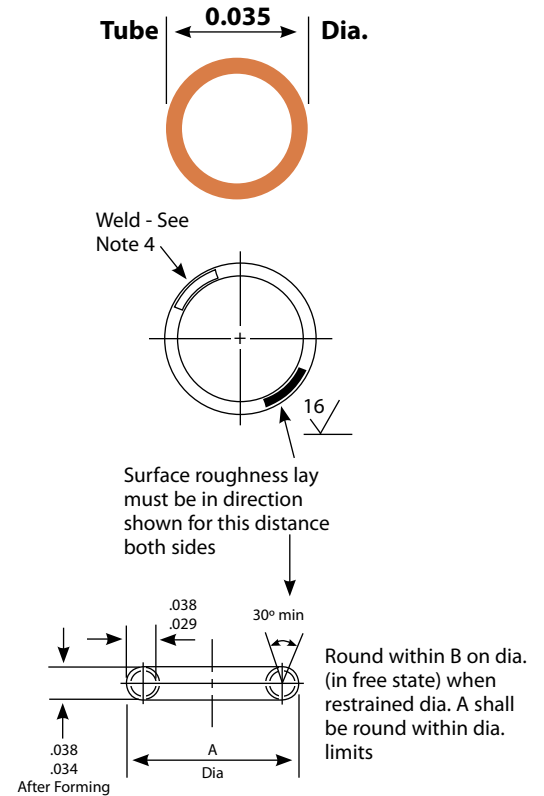
Tube 0.035 Diameter

Military Standard

MS 9141 Gasket, metal O-ring, .035 tube x .006 wall, cres

MS 9371 Gasket, metal O-ring, .035 tube x .006 wall, cres, silver plated

1. Ring shall be flat within B.
2. *Preferred sizes.
3. Material: Corrosion and heat resistant steel tubing AMS 5570 or AMS 5576.
4. Finish weld flush with tube OD. Smooth blend within .125 of Weld. Dimensions at blend shall not be more than .003 below adjacent surfaces.
5. Finish: Silver plate AMS 2410 .0010-.0015 thick. Dimensions to be met before plating. Contact points permissible on ID of ring: (MS 9371 only)
6. Surface roughness: AS 291/ANSI B46.1
7. Manufacturing specification: AMS 7325
8. Identification: Mark MS part number and manufacturer's identification on container.
9. Dimensions in inches.
10. Do not use unassigned part numbers.
11. Contact Applications Engineering for design requirements.



Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B
-03	.250 †	.020	-15	.750*	.020
-04	.281 †	.020	-16	.812	.020
-05	.312 †	.020	-17	.875*	.020
-06	.344 †	.020	-18	.938	.020
-07	.375 †	.020	-19	1.000*	.020
-08	.406 †	.020	-20	1.125	.020
-09	.438 †	.020	-21	1.250	.020
-10	.469 †	.020	-22	1.375	.020
-11	.500	.020	-23	1.500*	.020
-12	.562	.020	-24	1.625	.020
-13	.625*	.020	-25	1.750*	.020
-14	.688	.020	-26	1.875	.020
			-27	2.000*	0.20

Dimensions in inches

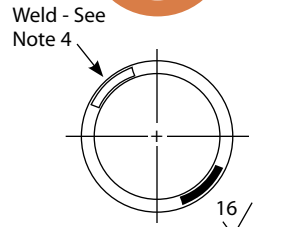
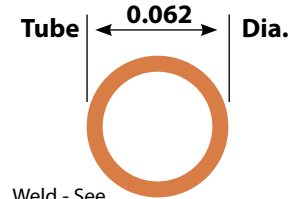
† Contact Applications Engineering for these sizes.

Tube 0.062 Diameter

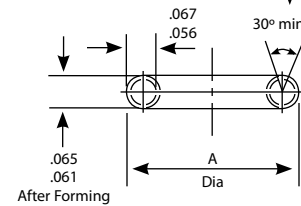
Military Standard

- MS 9142** Gasket, metal O-ring, .062 tube x .006 wall, cres
- MS 9202** Gasket, metal O-ring, .062 tube x .010 wall, cres
- MS 9372** Gasket, metal O-ring, .062 tube x .006 wall, cres, silver plated
- MS 9373** Gasket, metal O-ring, .062 tube x .010 wall, cres, silver plated

1. Ring shall be flat within B.
2. *Preferred sizes.
3. Material: Corrosion and heat resistant steel tubing AMS 5570 or AMS 5576.
4. Finish weld flush with tube OD. Smooth blend within .125 of Weld. Dimensions at blend shall not be more than .004 below adjacent surfaces.
5. Finish: Silver plate AMS 2410 .0010-.0015 thick. Dimensions to be met before plating. Contact points permissible on ID of ring: (MS 9372, MS 9373 only)
6. Surface roughness: AS 291/ANSI B46.1
7. Manufacturing specification: AMS 7325
8. Identification: Mark MS part number and manufacturer's identification on container.
9. Dimensions in inches.
10. Do not use unassigned part numbers.
11. Contact Applications Engineering for design requirements.



Surface roughness lay must be in direction shown for this distance both sides



Round within B on dia. (in free state) when restrained dia. A shall be round within dia. limits

NOTE: MS 9142 and MS 9372 available only from dash 013 through dash 099.

Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B
-013	.438*	.030	-037	1.188	.030	-061	2.625	.060	-103	5.250	.090
-014	.469	.030	-038	1.219	.030	-062	2.688	.060	-105	5.375	.090
-015	.500*	.030	-039	1.250*	.030	-063	2.750*	.060	-107	5.500	.090
-016	.531	.030	-040	1.312	.030	-064	2.812	.060	-109	5.625	.090
-017	.562*	.030	-041	1.375*	.030	-065	2.875	.060	-111	5.750	.090
-018	.594	.030	-042	1.438	.030	-066	2.938	.060	-113	5.875	.090
-019	.625*	.030	-043	1.500*	.030	-067	3.000*	.060	-115	6.000*	.090
-020	.656	.030	-044	1.562	.030	-069	3.125	.060	-117	6.125	.090
-021	.688*	.030	-045	1.625*	.030	-071	3.250	.060	-119	6.250	.090
-022	.719	.030	-046	1.688	.030	-073	3.375	.060	-121	6.375	.090
-023	.750*	.030	-047	1.750*	.030	-075	3.500*	.060	-123	6.500	.090
-024	.781	.030	-048	1.812	.030	-077	3.625	.060	-125	6.625	.090
-025	.812	.030	-049	1.875	.030	-079	3.750	.060	-127	6.750	.090
-026	.844	.030	-050	1.938	.030	-081	3.875	.060	-129	6.875	.090
-027	.875*	.030	-051	2.000*	.030	-083	4.000*	.060	-131	7.000*	.090
-028	.906	.030	-052	2.062	.030	-085	4.125	.060	-133	7.125	.090
-029	.938	.030	-053	2.125	.030	-087	4.250	.060	-135	7.250	.090
-030	.969	.030	-054	2.188	.030	-089	4.375	.060	-137	7.375	.090
-031	1.000*	.030	-055	2.250*	.030	-091	4.500*	.060	-139	7.500	.090
-032	1.031	.030	-056	2.312	.030	-093	4.625	.060	-141	7.625	.090
-033	1.062	.030	-057	2.375	.030	-095	4.750	.060	-143	7.750	.090
-034	1.094	.030	-058	2.438	.030	-097	4.875	.060	-145	7.875	.090
-035	1.125*	.030	-059	2.500*	.030	-099	5.000*	.060	-147	8.000*	.090
-036	1.156	.030	-060	2.562	.060	-101	5.125	.090			

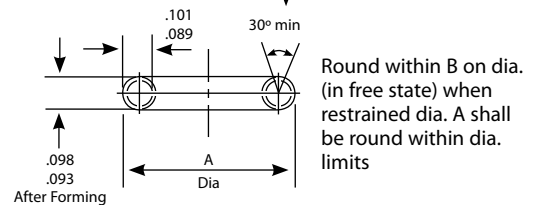
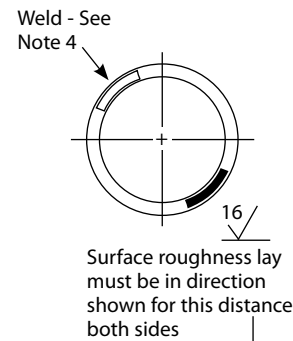
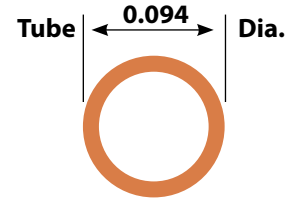
Dimensions in inches

Tube 0.094 Diameter

Military Standard

- MS 9203** Gasket, metal O-ring, .094 tube x .006 wall, cres
- MS 9204** Gasket, metal O-ring, .094 tube x .010 wall, cres
- MS 9374** Gasket, metal O-ring, .094 tube x .006 wall, cres, silver plated
- MS 9375** Gasket, metal O-ring, .094 tube x .010 wall, cres, silver plated

1. Ring shall be flat within B.
2. *Preferred sizes.
3. Material: Corrosion and heat resistant steel tubing AMS 5570 or AMS 5576.
4. Finish weld flush with tube OD. Smooth blend within .125 of Weld. Dimensions at blend shall not be more than .004 below adjacent surfaces.
5. Finish: Silver plate AMS 2410 .0010-.0015 thick. Dimensions to be met before plating. Contact points permissible on ID of ring: (MS 9374, MS 9375 only)
6. Surface roughness: AS 291/ANSI B46.1
7. Manufacturing specification: AMS 7325
8. Identification: Mark MS part number and manufacturer's identification on container.
9. Dimensions in inches.
10. Do not use unassigned part numbers.
11. Contact Applications Engineering for design requirements.



NOTE: MS 9374 and MS 9375 available only through dash 195

Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B
-010	1.000*	.030	-038	2.188	.030	-065	3.875	.060	-143	8.750	.090
-012	1.031	.030	-039	2.250*	.030	-066	3.938	.060	-147	9.000*	.090
-013	1.062	.030	-040	2.312	.030	-067	4.000*	.060	-151	9.250	.090
-014	1.094	.030	-041	2.375	.030	-069	4.125	.060	-155	9.500	.090
-015	1.125*	.030	-042	2.438	.030	-071	4.250	.060	-159	9.750	.090
-016	1.156	.030	-043	2.500*	.030	-073	4.375	.060	-163	10.000*	.090
-017	1.188	.030	-044	2.562	.060	-075	4.500*	.060	-167	10.250	.125
-018	1.219	.030	-045	2.625	.060	-077	4.625	.060	-171	10.500	.125
-019	1.250*	.030	-046	2.688	.060	-079	4.750	.060	-175	10.750	.125
-020	1.281	.030	-047	2.750*	.060	-081	4.875	.060	-179	11.000*	.125
-021	1.312	.030	-048	2.812	.060	-083	5.000*	.060	-183	11.250	.125
-022	1.344	.030	-049	2.875	.060	-085	5.125	.090	-187	11.500	.125
-023	1.375*	.030	-050	2.938	.060	-087	5.250	.090	-191	11.750	.125
-024	1.406	.030	-051	3.000	.060	-089	5.375	.090	-195	12.000*	.125
-025	1.438	.030	-052	3.062	.060	-091	5.500*	.090	-203	12.500	.150
-026	1.469	.030	-053	3.125	.060	-095	5.750	.090	-211	13.000	.150
-027	1.500*	.030	-054	3.188	.060	-099	6.000*	.090	-219	13.500	.150
-028	1.562	.030	-055	3.250	.060	-103	6.250	.090	-227	14.000	.150
-029	1.625	.030	-056	3.312	.060	-107	6.500	.090			
-030	1.688	.030	-057	3.375	.060	-111	6.750	.090			
-031	1.750*	.030	-058	3.438	.060	-115	7.000*	.090			
-032	1.812	.030	-059	3.500*	.060	-119	7.250	.090			
-033	1.875	.030	-060	3.562	.060	-123	7.500	.090			
-034	1.938	.030	-061	3.625	.060	-127	7.750	.090			
-035	2.000*	.030	-062	3.688	.060	-131	8.000*	.090			
-036	2.062	.030	-063	3.750	.060	-135	8.250	.090			
-037	2.125	.030	-064	3.812	.060	-139	8.500	.090			

Dimensions in inches

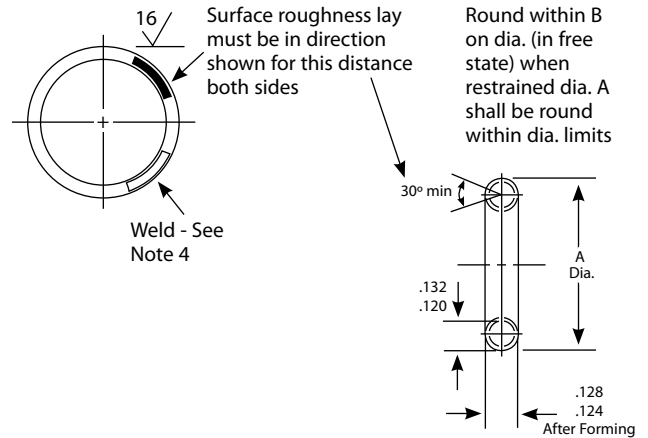
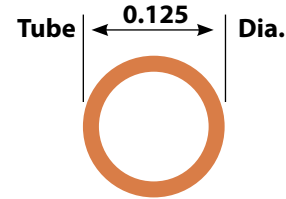
Tube 0.125 Diameter

Military Standard

MS 9205 Gasket, metal O-ring, .125 tube x .010 wall, cres

MS 9376 Gasket, metal O-ring, .125 tube x .010 wall, cres, silver plated

1. Ring shall be flat within B.
2. *Preferred sizes.
3. Material: Corrosion and heat resistant steel tubing
AMS 5570 or AMS 5576. Tube size .124-.127 dia.,
wall thick. .009-.011.
4. Finish weld flush with tube OD. Smooth blend within
.125 of weld. Dimensions at blend shall not be more
than .004 below adjacent surfaces.
5. Finish: Silver plate AMS 2410 .0010-.0015 thick.
Dimensions to be met before plating. Contact points
permissible on ID of ring: (MS 9376 only)
6. Surface roughness: AS 291/ANSI B46.1
7. Manufacturing specification: AMS 7325
8. Identification: Mark MS part number and
manufacturer's identification on container.
9. Dimensions in inches.
10. Do not use unassigned part numbers.
11. Contact Applications Engineering for design requirements.



NOTE: MS 9376 available only through dash 170

Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B	Add to MS Number	A +.005 -.000	B
-010	2.000*	.030	-049	4.438	.060	-102	7.750	.090	-238	16.250	.200	-490	32.000*	.500
-011	2.062	.030	-050	4.500*	.060	-104	7.875	.090	-242	16.500	.200	-498	32.500	.500
-012	2.125	.030	-051	4.562	.060	-106	8.000*	.090	-246	16.750	.200	-506	33.000	.500
-013	2.188	.030	-052	4.625	.060	-108	8.125	.090	-250	17.000	.200	-514	33.500	.500
-014	2.250*	.030	-053	4.688	.060	-110	8.250	.090	-254	17.250	.200	-522	34.000	.500
-015	2.312	.030	-054	4.750	.060	-112	8.375	.090	-258	17.500	.200	-530	34.500	.500
-016	2.375	.030	-055	4.812	.060	-114	8.500	.090	-262	17.750	.200	-538	35.000	.500
-017	2.438	.030	-056	4.875	.060	-116	8.625	.090	-266	18.000*	.200	-546	35.500	.500
-018	2.500*	.030	-057	4.938	.060	-118	8.750	.090	-270	18.250	.200	-554	36.000*	.500
-019	2.562	.060	-058	5.000*	.060	-120	8.875	.090	-274	18.500	.200	-562	36.500	.500
-020	2.625	.060	-059	5.062	.090	-122	9.000*	.090	-278	18.750	.200	-570	37.000	.500
-021	2.688	.060	-060	5.125	.090	-126	9.250	.090	-282	19.000	.200	-578	37.500	.500
-022	2.750*	.060	-061	5.188	.090	-130	9.500	.090	-286	19.250	.250	-586	38.000	.500
-023	2.812	.060	-062	5.250	.090	-134	9.750	.090	-290	19.500	.250	-594	38.500	.500
-024	2.875	.060	-063	5.312	.090	-138	10.000*	.090	-294	19.750	.250	-602	39.000	.500
-025	2.938	.060	-064	5.375	.090	-142	10.250	.125	-298	20.000*	.250	-610	39.500	.500
-026	3.000*	.060	-065	5.438	.090	-146	10.500	.125	-306	20.500	.250	-618	40.000*	1.000
-027	3.062	.060	-066	5.500*	.090	-150	10.750	.125	-314	21.000	.250	-634	41.000	1.000
-028	3.125	.060	-067	5.562	.090	-154	11.000*	.125	-322	21.500	.250	-650	42.000	1.000
-029	3.188	.060	-068	5.625	.090	-158	11.250	.125	-330	22.000*	.250	-666	43.000	1.000
-030	3.250	.060	-069	5.688	.090	-162	11.500	.125	-338	22.500	.500	-682	44.000	1.000
-031	3.312	.060	-070	5.750	.090	-166	11.750	.125	-346	23.000	.500	-698	45.000*	1.000
-032	3.375	.060	-071	5.812	.090	-170	12.000*	.125	-354	23.500	.500	-714	46.000	1.000
-033	3.438	.060	-072	5.875	.090	-174	12.250	.150	-362	24.000*	.500	-730	47.000	1.000
-034	3.500*	.060	-073	5.938	.090	-178	12.500	.150	-370	24.500	.500	-746	48.000	1.000
-035	3.562	.060	-074	6.000*	.090	-182	12.750	.150	-378	25.000	.500	-762	49.000	1.000
-036	3.625	.060	-076	6.125	.090	-186	13.000	.150	-386	25.500	.500	-778	50.000*	1.000
-037	3.688	.060	-078	6.250	.090	-190	13.250	.150	-394	26.000	.500			
-038	3.750	.060	-080	6.375	.090	-194	13.500	.150	-402	26.500	.500			
-039	3.812	.060	-082	6.500	.090	-198	13.750	.150	-410	27.000	.500			
-040	3.875	.060	-084	6.625	.090	-202	14.000*	.150	-418	27.500	.500			
-041	3.938	.060	-086	6.750	.090	-206	14.250	.175	-426	28.000*	.500			
-042	4.000*	.060	-088	6.875	.090	-210	14.500	.175	-434	28.500	.500			
-043	4.062	.060	-090	7.000*	.090	-214	14.750	.175	-442	29.000	.500			
-044	4.125	.060	-092	7.125	.090	-218	15.000	.175	-450	29.500	.500			
-045	4.188	.060	-094	7.250	.090	-222	15.250	.175	-458	30.000	.500			
-046	4.250	.060	-096	7.375	.090	-226	15.500	.175	-466	30.500	.500			
-047	4.312	.060	-098	7.500	.090	-230	15.750	.175	-474	31.000	.500			
-048	4.375	.060	-100	7.625	.090	-234	16.000*	.175	-482	31.500	.500			

Dimensions in inches

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