

<b>YORK INTERNATIONAL CORPORATION</b>	<b>ENGINEERED SYSTEMS (ES) ENGINEERING STANDARD</b>  <b>SEALS MOLDED ELASTOMER</b>	STANDARD NO.	R-807
		PAGE	1 OF 26
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		SUPERSEDES	10-21-04
		ECN	CS05-2129
		PREPARED BY	P Carrier
		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

This standard, defining the requirements of materials to be furnished or services to be performed, is not subject to interpretation.

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1. SCOPE

1.1 This standard covers molded elastomer seals, O-rings, made for commercial refrigeration application.

2. RELATED STANDARDS

2.1 The molded elastomer seals supplied under this standard shall be tested to the following appropriate ASTM Specification, or by the YORK Test Method as indicated.

- (a). ASTM D 395, Latest Rev.: Rubber Property - Compression Set
- (b). ASTM D 412, Latest Rev.: Vulcanized Rubber and Thermoplastic Rubbers and Thermoplastic Elastomers Tension
- (c). ASTM D 471, Latest Rev.: Rubber Property - Effect of Liquids
- (d). ASTM D 573, Latest Rev.: Rubber Deterioration In An Air Oven
- (e). ASTM D 2240, Latest Rev.: Rubber Property - Durometer Hardness
- (f). York R-1142: General Requirements for O-Ring Grooves and O-Ring Application.
- (g). SAE ARP 5316 Rev. B.: Storage of Elastomer Seals and Seal Assemblies.
- (h). Military Standard MIL-STD-413, Latest Rev.: Visual Inspection Guide for O-rings.
- (i). Aerospace Standard AS-568A Rev. 1974: Size Standard for O-rings.
- (j). Rubber Manufacturers Association sStandard RMA MO-1 Rev 1992: Rubber Handbook

3. MATERIAL CHARACTERISTICS

3.1 The mechanical and physical properties of the seal materials shall be as shown in Table 3.1(a) through 3.1(e).

3.1 (Continued)

- (a) Properties As Molded (At room Temperature).

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TABLE 3.1(a)

CHARACTERISTICS	ASTM TEST SPEC	NEOPREN E	NEOPRENE-1	BUNA N	Viton, Fluorel	HNBR
Hardness, Shore A Durometer	D 2240	60-75	65-75	60-70	70-80	60-75
Tensile Strength, psi min.	D 412	1500	1015	1500	1400	2000
Ultimate Elongation, % min.	D 412	225	150	250	125	250
Compression Set, % max.	D 395 Method B	25*	30	25*	Under .11" 20% Over .11" 15%	25*
Specific Gravity	----- -	***	***	***	***	***

\* - Percentage of original deflection after 22 hours at 212°F.  
\*\* - Percentage of original deflection after 70 hours at 75° ± 5°F max.  
\*\*\* - As determined for specific compound.

(b) Properties After Heat Aging shall be as shown in Table 3.1(b)

TABLE 3.1(b)

CHARACTERISTICS	ASTM TEST SPEC.	NEOPRENE	NEOPRENE-1	BUNA N	Viton, Fluorel	HNBR
Hardness, points change max.	D 573	+10	+10	+10	+10 / -5	+10
Tensile Strength, % change max.	D 573	-10	-10	-10	-35	-10
Elongation, % change max.	D 573	-45	-45	-45	-15	-10

(1) 70 hours at 212°F for Neoprene and Buna N.  
(2) 70 hours at 528°F for Viton and Fluorel.

(c) Properties After Oil Aging shall be as shown in Table 3.1(c).

TABLE 3.1(c)

Characteristics	ASTM Test Spec.	Neoprene	Neoprene-1	Buna N	Viton, Fluorel	HNBR
Hardness, points change max.	D 471	-15	-15	-10	0-15	-10
Volume, % change max.	D 471	+33	+33	+5	0-20	+20
Tensile Strength, % change max.	D 471	---	---	---	30	-10
Elongation, % change max.	D 471	---	---	---	-20	-10

(1) 70 hours at 212°F in YORK "C" Oil; Neoprene and Buna N.  
(2) 70 hours at 347° ± 5°F in Stauffer Blend 7700; Viton and Fluorel.

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(d) Resistance To Liquid Refrigerants With Oil shall be as shown in Table 3.1(d).

TABLE 3.1(d)

Characteristics	Neoprene	Neoprene-1	Buna N	Viton, Fluorel	HNBR
R-11 Thickness Increase, % max.	20	20	20	10	NA
R-12 Thickness Increase, % max.	5	NA	5	8	NA
R-22 Thickness Increase, % max.	6	8	NR	NR	36
R-123 Thickness Increase, % max.	NR	15	NR	NR	NR
R-134a Thickness Increase, % max.	7	7	NA	NA	20
R-11 Hardness points change, max.	-15	-10	-15	-20	NA
R-12 Hardness points change, max.	-10	NA	-10	-20	NA
R-22 Hardness points change, max.	-15	-5	NR	NR	-12
R-123 Hardness points change, max.	NR	-10	NR	NR	NR
R-236fa Hardness points Change, max.	-8~ +5	-8~ +5	NA	NA	-6
NA = NO DATA AVAILABLE					
NR = NOT RECOMMENDED					
(1) 93% refrigerant, 7% YORK "C" oil by weight.					
(2) One (1) week immersion at room temperature.					

(e) Chemical Stability shall be as shown in Table 3.1(e).

The chemical stability test is an evaluation of the elastomer materials that simulates the hardening, flattening, cracking and loss of strength which occurs with exposure to refrigerant, and shall be performed as described in ASTM D471.

**NOTE:** Appropriate steps are to be taken to insure the test equipment is suitable to contain the refrigerant pressures at the specified test conditions.

TABLE 3.1(e)

Characteristics	Neoprene	Neoprene-1	Buna N	Viton, Fluorel	HNBR
Tensile Strength, Decrease max.	55	55	55	65	55
Elongation, % change max.	-50	-50	-50	-25	-50
Shore Hardness	Points increase	0	0	0	0
	Points decrease	10	10	10	10

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(1) 21 days exposure (R-134a and air) at 200°F.

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4. DIMENSIONAL TOLERANCES

4.1 O-Rings shall be molded to the dimensions and shape (cross-section) as specified with tolerances per AS 568A Rev 1974.

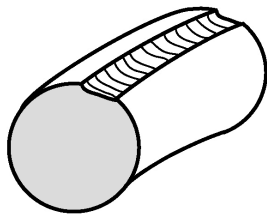
4.2 O-Rings shall be free of surface defects, indentations and cuts. NOTE: MIL-STD-413 is suggested as a visual guide for inspecting O-rings. Any major fault shall be rejected. Major faults are defined by Table 4.2.

TABLE 4.2

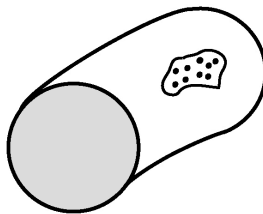
**Quantitative Classification of Imperfections, Maximum Acceptable Dimensions (INCHES)**

O-Ring Cross-Sectional Width "W"	Backrind		Parting Line Indentations		Foreign Material		Parting Line Projection and Excessive Flash Max. Hgt.	Non-Fill		Mold Deposit Indentations		Flow Marks		Off- Register and/or Mismatch Max.
	Depth	Width	Depth	Width	Depth	Width		Depth	Width	Depth	Width	Depth	Length	
Less than 0.100	0	0	0.003	0.010	0	0	0.003	0	0	0.003	0.010	0.002	0.060	0.003
0.100 to 0.134	0.003	0.005	0.003	0.015	0.003	0.005	0.003	0.002	0.010	0.003	0.015	0.002	0.060	0.004
0.135 to 0.204	0.004	0.006	0.004	0.020	0.004	0.007	0.004	0.003	0.015	0.004	0.020	0.002	0.180	0.005
0.205 to 0.268	0.004	0.006	0.005	0.025	0.005	0.010	0.005	0.003	0.025	0.004	0.025	0.002	0.180	0.006
0.269 and over	0.005	0.010	0.006	0.030	0.006	0.015	0.006	0.003	0.040	0.005	0.030	0.002	0.180	0.006

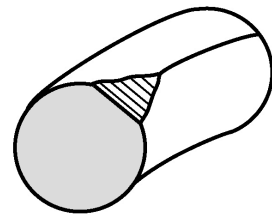
Supplementary Illustrations of Surface Imperfections



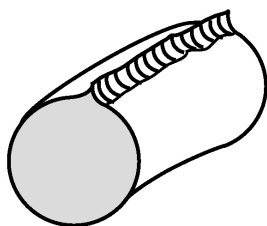
Backrind



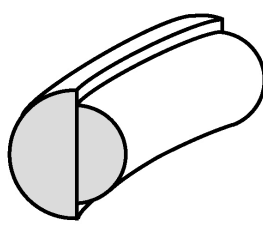
Foreign Material



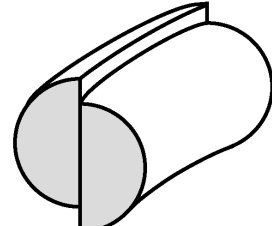
Excessive Trimming



Excessive Flash  
Remaining



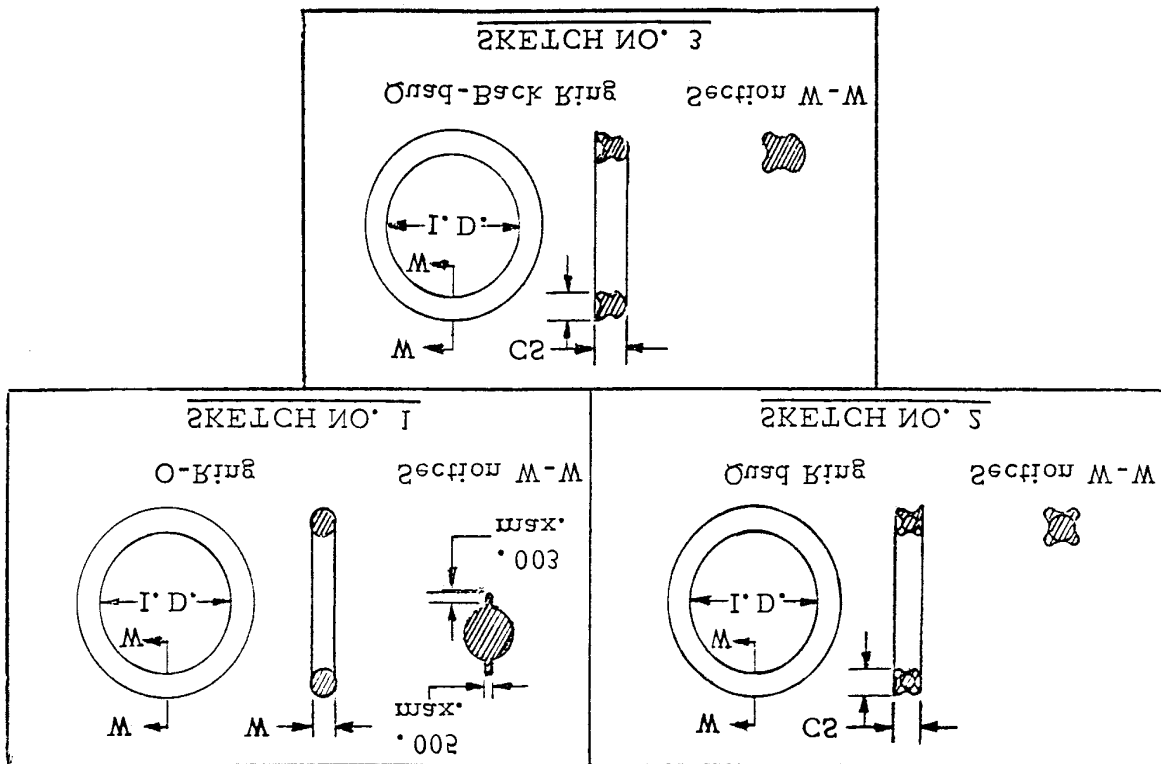
Mis-match



Off Register

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4.3 Mold alignment shall produce mold flashing which does not exceed the allowable maximum shown on Sketches No. 1, 2, and 3.



4.4 Standard size O-rings shall have the actual cross section diameters shown per AS 568A rev 1974.

TABLE 5.4

For General Reference Purposes ONLY

Nominal "W"	Actual "W"
1/16"	.070" +/- .003"
3/32"	.103" +/- .003"
1/8"	.139" +/- .004"
3/16"	.210" +/- .005"
1/4"	.275" +/- .006"

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- 4.5 Standard size O-ring dimensions shall be specified by the nominal I.D., O.D. and nominal "W" cross sectional diameter in fractional sizes, and appropriate AS-568 Code Number.
- 4.6 Non-standard size O-rings shall be supplied to the size specified by the order.

5. MARKING AND PACKAGING

- 5.1 Material identification marking of the rings shall be as follows unless otherwise specified on the particular part description.:
- (a) Rings molded of Neoprene shall be identified with Yellow marking
  - (b) Rings molded of Neoprene-1 shall be identified with an orange marking.
  - (c) Rings molded of Buna-N shall be identified with a Blue marking
  - (d) Rings molded of Viton shall be identified with a Green marking.
  - (e) Rings molded of Fluorel shall be identified with a Red marking.
  - (f) Rings molded of HNBR shall be identified with a Purple marking.
- 5.2 The supplier shall place his appropriate identifying marking adjacent to the material identification marking as follows:
- (a) Goshen Rubber; two (2) White marks
  - (b) Minnesota Rubber; one (1) White mark
  - (c) Parker Seal; one (1) Gold mark
  - (d) Parco: one (1) Gray mark
  - (e) Stillman; two (2) Pink marks
  - (f) Hercules; two (2) Gray marks
  - (g) Acushnet Rubber; two (2) Gold marks
  - (h) National O-Rings; one (1) Pink mark, marking is waived for Viton rings supplied for YORK Part Numbers 028-04408-000, 028-04519-000, 028-10047-000 and 028-10838-000.
- 5.3 Material used for marking shall not affect the proper use of the ring. The marking material shall be of type applied after molding of ring.
- 5.4 The material and vendor identification marking on rings smaller than 5/16" I.D. is waived provided the rings are individually packed and full identification is on the package.

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5.5 Each package shall contain rings of only one (1) manufacturing batch and each package shall be marked with the following data:

- (a) AS-568 Number
- (b) Cure date
- (c) Batch Number
- (d) Manufacturer's compound number
- (e) YORK Part Number
- (f) Material and Vendor identifying marking spelled out, i.e. Blue - one Pink. (Required only for individually packed rings per Paragraph 5.4).

6. INSPECTION

6.1 At its option, YORK may inspect incoming shipments, using the specific gravity as the indication of compliance with this standard. However, the supplier is responsible for full conformance with this standard without dependence on YORK inspection.

7. APPROVED SOURCES OF SUPPLY AND SUPPLIER'S COMPOUND (see footnotes at bottom of table)

<u>7.1</u>	<u>(a)</u>	<u>Compound</u>	<u>Specific Gravity</u>
	Goshen Rubber Company, Inc.		
	(1) Neoprene	1242	1.49
	(2) Buna-N		
	(3) Viton		
	(b) Minnesota Rubber		
	(1) Neoprene	486 BV	1.42
	(2) Buna-N	366Y	1.30
	''	417FM	1.22
	''	417GM	1.26
	(3) Viton	MRC514AD	1.89
	(c) Parker Seal Group		
	(1) Neoprene	C873-70	1.47
	(2) Buna-N	N674-7	1.23
	(3) Viton	V747-75	1.86
	(4) HNBR	N1173-70	1.43
	(d) Parco Inc.		
	(1) Neoprene	3229-70***	1.37
	''	3110-70	1.45
	(2) Neoprene-1	3231-70	1.44
	(3) Buna-N	4200-70	1.30
	(4) Viton	9000-75	1.83
	(5) Fluorel (Parco Fluor)	994-75*	1.87
	(6) HNBR	2269-70	1.28
	(e) Seals Eastern, Inc.		
	(1) Neoprene		
	(2) Buna-N	5403	1.24
	(3) Viton	5763-70	1.92
	(f) Stillman Seal Division		
	(1) Neoprene	5040B-70	1.46
	(2) Buna-N	SR310-70	1.23
	(3) Viton	SR277-70	1.93

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	''	SR2702-75	1.84
(g)	Hercules Products (1) Viton	8262	1.84
(h)	Acushnet Rubber Company, Inc. (1) Buna-N	H14327	1.29
(i)	National O-rings (1) Neoprene-1 (2) Buna-N (3) Viton (4) Viton (5) HNBR	N-2-70 B-46 V-14 (Black) V-35 (Brown)** D-58	1.43 1.29 1.83 2.04 1.19

\* Fluorel and Viton are both classified as Fluoro-elastomers but they shall not be interchanged unless so specified on the purchase order.

\*\* V-35 shall be supplied only when specified by the Purchase Order.

\*\*\* O-ring suppliers must review the Purchase Order Requirements carefully to determine if Parco Compound 3229-70 is acceptable. Some York Part Number Descriptions specifically exclude the use of Parco Compound 3229-70.

- 1) For vendors supplying both Neoprene and Neoprene-1 compounds, this specification permits the substitution of any Neoprene-1 compound for a Neoprene compound.

## 8. PURCHASING

8.1 YORK Purchase Order shall specify:

- (a) Quantity
- (b) Size
- (c) AS Number
- (d) Type (O-Ring, Quad-Ring, or Quad-Bak Ring)
- (e) Material and Compound Number
- (f) YORK Part Number
- (g) YORK Standard R-807

## 9. PART DESCRIPTION

9.1 Part description must specify the following:

- (a) Seal, O-Ring
- (b) Size
- (c) AS Number
- (d) Material:
  - (1) Part description for reciprocating compressor shaft seal applications must specify in addition to the material, the compound and supplier.
  - (2) Part description for Buna-N rings must specify "Lube Treated" when special Molybdenum Disulfide processing for low friction is required.

## 10. CERTIFICATION

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10.1 The following data shall be included with all certifications sent with the material.

- (a) Purchase Order Number
- (b) Item Number
- (c) Quantity
- (d) Part description, as indicated, on Purchase Order and/or Industry Standards specified on drawings.
- (e) Part Number
- (f) Handwritten signature
- (g) Typed name of individual
- (h) Date
- (i) A statement of conformance that material conforms to the part description. This statement of conformance shall include:
  - [1] Cure date
  - [2] Expiration Date
  - [3] Date of Shipment
  - [4] Material Compound No.
  - [5] Batch No.
  - [6] Manufacturer of material supplied

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11. STORAGE INFORMATION

11.1 The age limitation of O-ring rubber compounds shall be as specified in SAE ARP 5316, latest issue revision shall apply.

11.2 Storage:

- (a) Stock shall be handled on a FIFO "first in, first out" basis.
- (b) Seals shall be stored in their shipping packaging until installed in equipment.
- (c) Storage conditions shall be as specified in SAE ARP 5316 Rev B.

11.3 Table 11.2 lists O-ring sizes which have been assigned an YORK Number.

- (a) Some O-ring part numbers listed in Table 11.2 may be inactive. Check data base to determine if part number is active or must be loaded to the data base.

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Table 11.2

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
001 CROSS SECTION DIAMETER 0.040							
1/32	0.029	001					
002 CROSS SECTION DIAMETER 0.050							
3/64	0.042	002					
003 CROSS SECTION DIAMETER 0.060							
1/16	0.056	003					
004-050 CROSS SECTION DIAMETER 0.070							
5/64	0.070	004					
3/32	0.101	005					
1/8	0.114	006	028-10058-000	028-06895-000			
5/32	0.145	007		028-09347-000			
3/16	0.176	008	028-10156-000	028-11134-000	028-11997-000	028-11746-000	
7/32	0.208	009					
1/4	0.239	010	028-13772-000N	028-08959-000			
5/16	0.301	011	028-09378-000N		028-12513-000	028-09373-000N	
3/8	0.364	012	028-08811-000	028-08116-000	028-11998-000		
7/16	0.426	013	028-09383-000	028-12551-000	028-13060-000N	028-09374-000	
1/2	0.489	014		028-07809-000			
9/16	0.551	015	028-08149-000		028-13061-000N	028-09375-000N	
5/8	0.614	016					
11/16	0.676	017	028-09471-000		028-13065-000N 028-13896-000	028-09376-000N	
3/4	0.739	018					
13/16	0.801	019	028-13436-000N		028-13062-000N	028-09377-000N	
7/8	0.864	020		028-04845-000	028-11188-000N	028-06932-000	
15/16	0.926	021					
1	0.989	022		028-06764-000	028-13063-000N		

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NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***					
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR	
004-050 CROSS SECTION DIAMETER 0.070 (Cont'd.)								
1	1/16	1.051	023					
1	1/8	1.114	024					
1	3/16	1.176	025		028-07872-000			
1	1/4	1.239	026					
1	5/16	1.301	027					
1	3/8	1.364	028					
1	1/2	1.489	029			028-13520-000N	028-08270-000N	
1	5/8	1.614	030					
1	3/4	1.739	031			028-14557-000N	028-08269-000	
1	7/8	1.864	032					
2		1.989	033					
2	1/8	2.114	034					
2	1/4	2.239	035		028-07936-000	028-14443-000N		
2	3/8	2.364	036					
2	1/2	2.489	037					
2	5/8	2.614	038					
2	3/4	2.739	039					
2	7/8	2.864	040			028-14468-000		
3		2.989	041		028-08394-000	028-11186-000N	028-09561-000N	
3	1/4	3.239	042	028-08729-000				
3	1/2	3.489	043					
3	3/4	3.739	044					
4		3.989	045			028-13898-000		
4	1/4	4.239	046			028-14457-000N		
4	1/2	4.489	047					
4	3/4	4.739	048			028-14447-000N		
5		4.989	049					
5	1/4	5.239	050					

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  SEALS MOLDED ELASTOMER	STANDARD NO.	R-807
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		PREPARED BY	P Carrier
		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I. D.	ACT. I. D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
102-178 CROSS SECTION DIAMETER 0.103							
1/16	0.049	102					
3/32	0.081	103					
1/8	0.112	104					
5/32	0.143	105					
3/16	0.174	106					
7/32	0.206	107					
1/4	0.237	108					
5/16	0.299	109	028-13770-000N				
3/8	0.362	110					
7/16	0.424	111		028-06729-000	028-14548-000N		
1/2	0.487	112					
9/16	0.549	113		028-03292-000		028-03657-000N	
5/8	0.612	114	028-04665-000	028-04662-000	028-11999-000		
11/16	0.674	115				028-05404-000	
3/4	0.737	116		028-14435-000	028-14549-000N		
13/16	0.799	117					
7/8	0.862	118					
15/16	0.924	119	028-06831-000			028-05403-000N	
1	0.987	120					
1 1/16	1.049	121	028-06832-000	028-04754-000	028-13717-000N		
1 1/8	1.112	122		028-06937-000			
1 3/16	1.174	123	028-06933-000		028-13426-000N		
1 1/4	1.237	124					
1 5/16	1.299	125	028-06834-000	028-06791-000	028-13701-000	028-10026-000	
1 3/8	1.362	126		028-06838-000			
1 7/16	1.424	127	028-06835-000	028-10964-000	028-13064-000N		
1 1/2	1.487	128		028-08131-000	028-11192-000N	028-04479-000	

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  SEALS MOLDED ELASTOMER	STANDARD NO.	R-807
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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***					
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR	
102-178 CROSS SECTION DIAMETER 0.103 (Cont'd)								
1	9/16	1.549	129					
1	5/8	1.612	130					
1	11/16	1.674	131					
1	3/4	1.737	132			028-06839-000		
1	13/16	1.799	133	028-07998-000	028-08294-000	028-12997-000N	028-07407-000N	
1	7/8	1.862	134					
1	15/16	1.925	135					
	2	1.987	136			028-14419-000		
2	1/16	2.050	137		028-07938-000N			
2	1/8	2.112	138					
2	3/16	2.175	139					
2	1/4	2.237	140					
2	5/16	2.300	141					
2	3/8	2.362	142					
2	7/16	2.425	143	028-09292-000			028-10023-000	
2	1/2	2.487	144					
2	9/16	2.550	145		028-11976-000			
2	5/8	2.612	146					
2	11/16	2.675	147	028-09966-000			028-10046-000	
2	3/4	2.737	148				028-09293-000	
2	13/16	2.800	149					
2	7/8	2.862	150			028-12943-000N		
	3	2.987	151					
3	1/4	3.237	152			028-14420-000		
3	1/2	3.487	153			028-15082-000		
3	3/4	3.737	154		028-15074-000			
	4	3.987	155					

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  <b>SEALS</b> <b>MOLDED ELASTOMER</b>	STANDARD NO.	R-807
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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***					
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR	
102-178 CROSS SECTION DIAMETER 0.103 (Cont'd.)								
4	1/4	4.237	156					
4	1/2	4.487	157					
4	3/4	4.737	158					
5		4.987	159					
5	1/4	5.237	160			028-14403-000		
5	1/2	5.487	161			028-14446-000N		
5	3/4	5.737	162		028-13870-000			
6		5.987	163					
6	1/4	6.237	164					
6	1/2	6.487	165					
6	3/4	6.737	166					
7		6.987	167			028-14445-000N		
7	1/4	7.237	168			028-13528-000N		
7	1/2	7.487	169					
7	3/4	7.737	170					
8		7.987	171					
8	1/4	8.237	172					
8	1/2	8.487	173					
8	3/4	8.737	174					
9		8.987	175					
9	1/4	9.237	176					
9	1/2	9.487	177					
9	3/4	9.737	178					

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  <b>SEALS</b> <b>MOLDED ELASTOMER</b>	STANDARD NO.	R-807
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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
201-284 CROSS SECTION DIAMETER 0.139							
3/16	0.171	201					
1/4	0.234	202					
5/16	0.296	203					
3/8	0.359	204					
7/16	0.421	205					
1/2	0.484	206					
9/16	0.546	207					
5/8	0.609	208					
11/16	0.671	209					
3/4	0.734	210	028-04666-000	028-03282-000			
13/16	0.796	211					
7/8	0.859	212	028-04930-000			028-07761-000	
15/16	0.921	213	028-04668-000	028-04664-000	028-13975-000		
1	0.984	214	028-09309-000	028-03516-000	028-12201-000	028-04522-000	
1 1/16	1.046	215					
1 1/8	1.109	216	028-07002-000	028-03838-000	028-12200-000	028-04353-000N	
1 3/16	1.171	217	028-11430-000N				
1 1/4	1.234	218	028-05189-000	028-05181-000	028-12922-000N		
1 5/16	1.296	219		028-12552-000	028-12920-000N		
1 3/8	1.359	220	028-08633-000*	028-03027-000	028-11190-000N	028-04408-000N**	
1 7/16	1.421	221	028-08831-000N				
1 1/2	1.484	222	028-05164-000	028-05410-000N	028-13071-000N		
1 5/8	1.609	223		028-10576-000	028-11187-000N	028-04861-000	
1 3/4	1.734	224	028-08640-000* 028-05196-000	028-05188-000	028-12998-000N	028-04348-000N	
1 7/8	1.859	225		028-11923-000			
2	1.984	226	028-08970-000	028-03236-000			028-15292-000
2 1/8	2.109	227	028-08622-000*	028-08681-000	028-13512-000N	028-04478-000	
2 1/4	2.234	228		028-03803-000			

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  SEALS MOLDED ELASTOMER	STANDARD NO.	R-807
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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
201-284 CROSS SECTION DIAMETER 0.139 (Cont'd.)							
2	3/8	2.359	229				
2	1/2	2.484	230		028-03029-000		
2	5/8	2.609	231		028-12965-000	028-14495-000 028-13144-000N	
2	3/4	2.734	232		028-05166-000	028-13578-000 028-13713-000N	
2	7/8	2.859	233	028-08971-000	028-11193-000N		
3		2.984	234			028-13519-000N 028-07198-000	028-04606-000N
3	1/8	3.109	235			028-13923-000 028-12938-000N	
3	1/4	3.234	236		028-11903-000	028-11189-000N	028-04409-000N
3	3/8	3.359	237				
3	1/2	3.484	238		028-05173-000	028-14404-000	
3	5/8	3.609	239			028-12996-000N	028-09562-000N
3	3/4	3.734	240			028-12925-000N	028-07901-000N
3	7/8	3.859	241	028-13068-000	028-08299-000	028-12208-000	028-04352-000N
4		3.984	242	028-13067-000	028-03878-000	028-12210-000	028-04349-000N
4	1/8	4.109	243	028-11940-000		028-12205-000	
4	1/4	4.234	244		028-12259-000	028-13125-000N	
4	3/8	4.359	245		028-06788-000	028-13111-000N	028-04639-000N
4	1/2	4.484	246	028-09294-000			028-10024-000N
4	5/8	4.609	247	028-10158-000		028-12202-000	
4	3/4	4.734	248			028-13536-000N	028-09577-000
4	7/8	4.859	249	028-11939-000	028-12225-000	028-12207-000	028-08848-000N
5		4.984	250	028-10571-000		028-12211-000N	028-04517-000
5	1/8	5.109	251			028-13169-000N	028-13026-000N
5	1/4	5.234	252			028-14449-000N	
5	3/8	5.359	253	028-10837-000	028-11975-000	028-12203-000	
5	1/2	5.484	254		028-11978-000		
5	5/8	5.609	255		028-12258-000		
5	3/4	5.734	256			028-14555-000N	

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  <b>SEALS</b> <b>MOLDED ELASTOMER</b>	STANDARD NO.	R-807
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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
201-284 CROSS SECTION DIAMETER 0.139 (Cont'd.)							
5 7/8	5.859	257	028-10836-000		028-12204-000		
6	5.984	258			028-14405-000		
6 1/4	6.234	259					
6 1/2	6.484	260		028-12224-000	028-12939-000N		
6 3/4	6.734	261					
7	6.984	262		028-12550-000	028-12923-000N		
7 1/4	7.234	263			028-13130-000N		
7 1/2	7.484	264		028-12713-000			
7 3/4	7.734	265	028-11941-000	028-12256-000	028-12206-000	028-04679-000	
8	7.984	266	028-11409-000	028-12255-000	028-13123-000N		
8 1/4	8.234	267	028-03234-000	028-05409-000	028-12993-000N		
					028-15078-000		
					028-13165-000N		
8 1/2	8.484	268	028-03587-000	028-12902-000			
8 3/4	8.734	269			028-12945-000N		
9	8.984	270			028-14508-000		
9 1/4	9.234	271		028-04696-000			
9 1/2	9.484	272			028-12946-000N		
9 3/4	9.734	273		028-07931-000			
10	9.984	274		028-12247-000	028-12994-000N		
10 1/2	10.484	275		028-12226-000			
11	10.984	276			028-13514-000N		
11 1/2	11.484	277		028-12567-000	028-13977-000		
12	11.984	278	028-13773-000N	028-12568-000	028-14411-000		
13	12.984	279			028-14412-000		
14	13.984	280			028-14454-000N		
15	14.984	281					028-15063-000
16	15.955	282			028-13525-000N	028-10371-000N	
17	16.955	283			028-12928-000N		
18	17.955	284		028-12257-000			

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  SEALS MOLDED ELASTOMER	STANDARD NO.	R-807
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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
309-395 CROSS SECTION DIAMETER 0.210							
7/16	0.412	309					
1/2	0.475	310					
9/16	0.537	311					
5/8	0.600	312					
11/16	0.662	313					
3/4	0.725	314					
13/16	0.787	315					
7/8	0.850	316					
15/16	0.912	317					
1	0.975	318					
1 1/16	1.037	319					
1 1/8	1.100	320					
1 3/16	1.162	321					
1 1/4	1.225	322					
1 5/16	1.287	323					
1 3/8	1.350	324			028-13046-000N		
1 1/2	1.475	325					
1 5/8	1.600	326	028-05195-000	028-05183-000			
1 3/4	1.725	327		028-10997-000		028-09306-000	
1 7/8	1.850	328			028-12926-000N		
2	1.975	329	028-05190-000	028-05182-000			
2 1/8	2.100	330	028-03788-000	028-03517-000	028-13513-000N	028-04519-000**	
2 1/4	2.225	331	028-05193-000	028-08125-000			
2 3/8	2.350	332					
2 1/2	2.475	333			028-13099-000N		
2 5/8	2.600	334	028-08638-000* 028-05194-000	028-05184-000	028-14469-000	028-10047-000**	
2 3/4	2.775	335		028-03241-000	028-12941-000N		
2 7/8	2.850	336		028-07420-000			

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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
<b>309-395 CROSS SECTION DIAMETER 0.210 (Cont'd.)</b>							
3	2.975	337	028-03167-000	028-03164-000	028-13096-000N		
3 1/8	3.100	338			028-12597-000		
3 1/4	3.225	339	028-05163-000	028-03840-000	028-13097-000N		
3 3/8	3.350	340	028-08626-000*	028-03739-000	028-13704-000	028-10838-000**	
3 1/2	3.475	341	028-05191-000	028-05187-000			
3 5/8	3.600	342	028-03166-000	028-03165-000			
3 3/4	3.725	343					
3 7/8	3.850	344					
4	3.975	345			028-12927-000N		
4 1/8	4.100	346	028-05192-000	028-05186-000			
4 1/4	4.225	347	028-08637-000*	028-04825-000	028-13035-000N	028-07685-000	
4 3/8	4.350	348					
4 1/2	4.475	349					
4 5/8	4.600	350					
4 3/4	4.725	351					
4 7/8	4.850	352					
5	4.975	353			028-13461-000N		
5 1/8	5.100	354					
5 1/4	5.225	355					
5 3/8	5.350	356					
5 1/2	5.475	357					
5 5/8	5.600	358		028-09305-000			
5 3/4	5.725	359					
5 7/8	5.850	360			028-15318-000		
6	5.975	361			028-14482-000		
6 1/4	6.225	362					
6 1/2	6.475	363			028-13042-000N		
6 3/4	6.725	364					

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  SEALS MOLDED ELASTOMER	STANDARD NO.	R-807
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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
309-395 CROSS SECTION DIAMETER 0.210 (Cont'd.)							
7	6.975	365			028-13051-000N		
7 1/4	7.225	366	028-13032-000				
7 1/2	7.475	367			028-15061-000		
7 3/4	7.725	368					
8	7.975	369					
8 1/4	8.225	370					
8 1/2	8.475	371					
8 3/4	8.725	372			028-13131-000N		
9	8.975	373			028-13458-000N		
9 1/4	9.225	374					
9 1/2	9.475	375			028-15319-000		
9 3/4	9.725	376					
10	9.975	377					
10 1/2	10.475	378					
11	10.975	379					
11 1/2	11.475	380			028-14464-000N		
12	11.975	381					
13	12.975	382					
14	13.975	383					
15	14.975	384					
16	15.995	385					
17	16.995	386					
18	17.995	387					
19	18.953	388			028-13135-000N		
20	19.953	389			028-14413-000		
21	20.953	390					
22	21.953	391			028-12991-000N		
23	22.940	392					

<b>YORK INTERNATIONAL CORPORATION</b>	<b>ENGINEERED SYSTEMS (ES) ENGINEERING STANDARD</b>  <b>SEALS MOLDED ELASTOMER</b>	STANDARD NO.	R-807
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		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
<b>309-395 CROSS SECTION DIAMETER 0.210 (Cont'd.)</b>							
24	23.940	393			028-13175-000N		
25	24.940	394			028-13041-000N		
26	25.940	395			028-13176-000N		
<b>425-475 CROSS SECTION DIAMETER 0.275</b>							
4 1/2	4.475	425					
4 5/8	4.600	426					
4 3/4	4.725	427					
4 7/8	4.850	428					
5	4.975	429	028-03796-000	028-04401-000			
5 1/8	5.100	430			028-12937-000N		
5 1/4	5.225	431					
5 3/8	5.350	432	028-08630-000*	028-07970-000	028-13706-000		
5 1/2	5.475	433					
5 5/8	5.600	434					
5 3/4	5.725	435					
5 7/8	5.850	436					
6	5.975	437					
6 1/4	5.225	438					
6 1/2	6.475	439			028-13484-000N		
6 3/4	6.725	440					
7	6.975	441					
7 1/4	7.225	442					
7 1/2	7.475	443					
7 3/4	7.725	444					
8	7.975	445					
8 1/2	8.475	446					
9	8.975	447					
9 1/2	9.475	448			028-13093-000N		

<b>YORK INTERNATIONAL CORPORATION</b>	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  <b>SEALS</b> <b>MOLDED ELASTOMER</b>	STANDARD NO.	R-807
		PAGE	25 OF 26
		DATE	03-01-05
		SUPERSEDES	10-21-04
		ECN	CS05-2129
		PREPARED BY	P Carrier
		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
<b>425-475 CROSS SECTION DIAMETER 0.275 (Cont'd.)</b>							
10	9.975	449	028-09295-000			028-10025-000	
10 1/2	10.475	450		028-03856-000	028-13168-000N		
11	10.975	451					
11 1/2	11.475	452			028-12942-000N		
12	11.975	453					
12 1/2	12.475	454					
13	12.975	455		028-03855-000			
13 1/2	13.475	456		028-11977-000			
14	13.975	457					
14 1/2	14.475	458			028-11191-000N		
15	14.975	459					
15 1/2	15.475	460			028-13094-000N	028-13754-000	
16	15.955	461					
16 1/2	16.455	462					
17	16.955	463					
17 1/2	17.455	464					
18	17.955	465					
18 1/2	18.455	466					
19	18.955	467			028-14414-000		
19 1/2	19.455	468	028-09432-000	028-08297-000		028-05401-000N	
20	19.955	469	028-10557-000				
21	20.955	470					
22	21.955	471			028-14406-000	028-11974-000N	
23	22.940	472					
24	23.940	473					
25	24.940	474					
26	25.940	475					

YORK INTERNATIONAL CORPORATION	ENGINEERED SYSTEMS (ES) ENGINEERING STANDARD  SEALS MOLDED ELASTOMER	STANDARD NO.	R-807
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		SUPERSEDES	10-21-04
		ECN	CS05-2129
		PREPARED BY	P Carrier
		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NOM. I.D.	ACT. I.D.	AS568 DASH NUMBER	YORK PART NUMBER ***				
			BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR
<b>901 CROSS SECTION DIAMETER 0.056</b>							
3/32	0.185	901					
<b>902-903 CROSS SECTION DIAMETER 0.065</b>							
1/8	0.239	902					
3/16	0.301	903		028-11198-000	028-12209-000	028-07519-000N	
<b>904-905 CROSS SECTION DIAMETER 0.072</b>							
1/4	0.351	904	028-08012-000N		028-13056-000N 028-13832-000	028-07442-000	
5/16	0.414	905					
<b>906 CROSS SECTION DIAMETER 0.078</b>							
3/8	0.468	906	028-07759-000N	028-11462-000N	028-11195-000N	028-07422-000N	
<b>907 CROSS SECTION DIAMETER 0.082</b>							
7/16	0.530	907					
<b>908 CROSS SECTION DIAMETER 0.087</b>							
1/2	0.644	908	029-08035-000N	028-07937-000	028-13057-000N 028-12919-000N	028-07443-000N	
<b>909-910 CROSS SECTION DIAMETER 0.097</b>							
9/16	0.706	909					
5/8	0.755	910	028-08282-000N		028-13066-000N	028-07524-000N	
<b>911-918 CROSS SECTION DIAMETER 0.116</b>							
11/16	0.863	911					
3/4	0.924	912	028-07848-000N		028-11194-000N	028-07431-000N	
13/16	0.986	913					
7/8	1.047	914			028-13563-000	028-07497-000	
1	1.171	916	028-08259-000N		028-13058-000N 028-12918-000N	028-07828-000	
1 1/8	1.355	918					
<b>920-932 CROSS SECTION DIAMETER 0.118</b>							
1 1/4	1.475	920			028-13070-000N	028-07457-000	
1 1/2	1.720	924			028-13059-000N 028-13160-000N	028-07453-000N	
1 3/4	2.090	928					
2	2.337	932			028-13709-000N	028-08708-000N	

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  SEALS MOLDED ELASTOMER	STANDARD NO.	R-807
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		SUPERSEDES	10-21-04
		ECN	CS05-2129
		PREPARED BY	P Carrier
		APPROVED BY	M. Adams
		APPROVED BY	P. Snell

NON STANDARD SIZES							
NOM. I.D.	ACT. I.D.	YORK PART NUMBER					
		BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR	
<b>CROSS SECTION DIAMETER 0.070</b>							
	5.340		028-10157-000N		028-13777-000		
<b>CROSS SECTION DIAMETER 0.103</b>							
	4.819				028-13500-000N		
<b>CROSS SECTION DIAMETER 0.139</b>							
	6.792				028-12931-000N		
	14.759				028-13184-000N		
	17.722				028-12213-000		
	17.775				028-13934-000N		
	23.940				028-13981-000N		
	24.605				028-12930-000N		
<b>CROSS SECTION DIAMETER 0.210</b>							
	18.450				028-13526-000N		
	23.440				028-12951-000N		
	23.440				028-13142-000N		
	26.969				028-13515-000N		
	28.615				028-13541-000N		
	29.095				028-13129-000N		
	29.615				028-13527-000N		
<b>CROSS SECTION DIAMETER 0.275</b>							
8	3/4				028-04501-000		
	9.748				028-13138-000N		
	21.550				028-12929-000N		
	25.440				028-13134-000N		
	26.455				028-13935-000N		
	26.623				028-13846-000		
	26.840				028-12924-000N		
	31.440				028-12992-000N		
	31.906				028-13163-000N		

YORK INTERNATIONAL CORPORATION	<b>ENGINEERED SYSTEMS (ES)</b> <u>ENGINEERING STANDARD</u>  <b>SEALS</b> <b>MOLDED ELASTOMER</b>	STANDARD NO.	R-807
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NON STANDARD SIZES							
CROSS SECTION DIAMETER 0.275 (Cont'd.)							
NOM. I.D.	ACT. I.D.	YORK PART NUMBER					
		BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR	
	ACT.	YORK PART NUMBER					
	I.D.	BUNA-N	NEOPRENE	NEOPRENE-1	VITON	HNBR	
	35.3			028-13166-000N			
	35.94			028-13516-000N			
	37.050			028-15083-000			

\* "Lube Treated" Special processing for reduced friction.

\*\* When these Viton O-rings are supplied by National O-Rings they shall be compound V-35 (brown).

\*\*\* Some part numbers may be inactive. Check data base to determine if part number is active or must be loaded to the data base.

N - Marine, Military & Government Part.