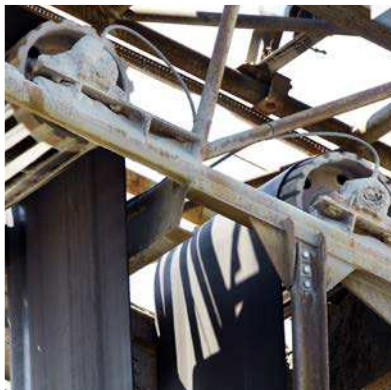


SKF Taconite Seals

One global design for split housings for extremely contaminated and wet applications



Superior protection and easier alignment

The SKF Taconite Seal consists of two rings (one stationary and one rotating) which form a very narrow labyrinth between the two rings. The rotating labyrinth ring carries a V-ring seal that seals against the stationary labyrinth ring. The V-ring seal blocks contaminants from entering the bearing housing and aids the purging of contamination and old grease when the seal is re-greased.

- **Multi-stage axial labyrinth cartridge seal** – includes two labyrinth rings, an internal low friction V-ring seal and provision for grease purging
- **Purging and re-greasing of labyrinths** – via a grease fitting on the stationary labyrinth ring
- **Flinger action** – the rotating labyrinth ring flings water away from the seal
- **In-groove or bolt-on seal designs** – for SKF split housings. Seals can be customized for use with competitor housings
- **Inch or metric sizes** – a wide product range to fit housings with different shaft sizes, from 50 mm ($1\frac{15}{16}$ in.) to 450 mm (18 in.) as standard. Contact SKF if larger sizes are needed.
- **V-ring seal and O-rings** – made of Acrylonitrile-butadiene rubber (NBR)
- **Easy alignment** – circumferential groove on the outer diameter surface of the stationary labyrinth ring aids assembly and alignment. Grub/set screws in the rotating labyrinth ring firmly secure it to the shaft.
- **Worldwide availability** – SKF can meet the needs of multinational producers and just-in-time delivery programmes

Heavy-duty industries

- Mining
- Mineral processing
- Cement
- Pulp and Paper
- Metals
- Marine

Typical applications

- Conveyor pulleys
- Grinding mill pinion housings
- Bucket elevators
- Hoists and winches
- Jack shafts
- Pulverizers
- Fans

Features

- Cartridge Taconite Seal of machined cast iron or steel
- Three and four axial labyrinth stages
- Internal V-ring seal to exclude contaminants and enable grease to purge
- Rotating labyrinth ring faces bearing housing to deflect and fling away water
- Short installed axial length
- The rotating labyrinth ring is sealed to the shaft by an O-ring in its bore
- 3 grub/set screws (at 120°) to center the seal on the shaft
- $\pm 0.5^\circ$ misalignment capability
- Circumferential groove to aid alignment and assembly
- Fits SKF metric SE, SNL, SNL 30, 31 and 32 series¹⁾
- Fits SKF inch SAF, SAF B, SAW, SAFD and SDAF housings¹⁾

Benefits

- Excellent exclusion of contaminants
- Improved water ingress prevention (including high pressure washing)
- Longer bearing and seal service life
- Reduced grease consumption
- Reduced environmental impact
- Compact design
- Easier installation and alignment
- Compatible with new and older housings¹⁾

¹⁾ Seals for shaft diameters, $d_1 \geq 340$ mm ($12\frac{15}{16}$ in.) are “bolt on” design.

The housings must have a machined face to accommodate the seal.



Grease filling and purging

The SKF Taconite Seal is supplied with a grease fitting for the re-greasing of the labyrinth. This purges the labyrinth of contamination and helps block the entrance of contaminants.

The seal can be greased three ways:

- Manually with a grease gun
- SKF SYSTEM 24
- SKF Automated Lubrication System (ALS)

To fill and purge SKF Taconite Seals, the grease used to lubricate the bearing, or one that is compatible with it, should normally be used. Where a sealed SKF spherical roller bearing is used, SKF recommends SKF LGEP 2 grease, which is the original factory fill grease in sealed spherical roller bearings with VT143 suffix. For lubrication with SKF SYSTEM24, use LGWA 2 grease.

Depending on their compatibility with the grease used to lubricate the bearing, other SKF greases can also be used – according to operating requirements:

- SKF LGHB 2 – higher ambient temperature applications
- SKF LGWM 1 – cold climates
- SKF LGGB 2 – biodegradable grease



SKF Taconite Seal designation system and selection guide

All SKF Taconite Seals have the designation prefix TK. The seals can be ordered in metric or inch dimensions. An SKF Taconite Seal can be ordered as an individual item for metric or inch dimensions or as part of a kit with the SAF, SAF B, SAW, SAFD and SDAF inch housings (**table 1**).

Designation for metric sizes consist of the prefix TK and the housing size. Designation for inch sizes consists of prefix TK and the number from **table 1**. For non-standard sizes, contact SKF application engineering service.

Examples for ordering SKF Taconite Seals only:

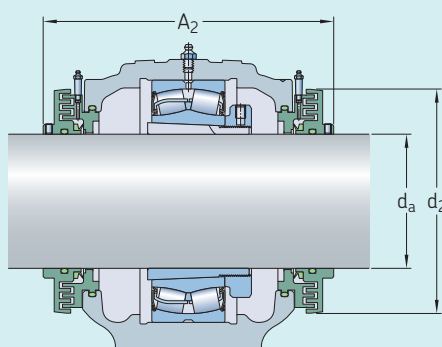
Metric housing, adapter sleeve:	TK..	eg. TK 524
Inch housing, adapter sleeve:	TK..	eg. TK-115V

Safety warning

All rotating machinery requires adequate fixed safety guards, including the exposed rotating labyrinth ring of SKF Taconite Seals. If manual purging of the labyrinths is used, provisions must be made for the safe, purge/re-greasing of the labyrinths by extending the grease supply fittings to the outside of the safety guards.

Table 1

SKF Taconite Seal general data

**Metric sizes**Principal dimensions Designation Recommended
relubrication rated_a d₂ A₂

mm grams/hr

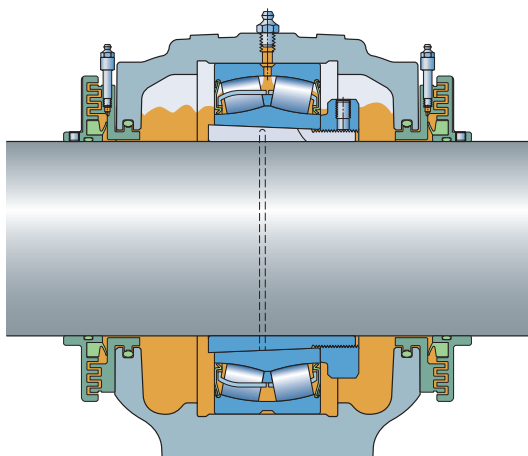
50	125	165 ¹⁾	TK 511	0.03
55	130	175 ¹⁾	TK 512	0.03
60	135	180 ¹⁾	TK 513	0.03
65	140	176 ¹⁾	TK 515	0.03
70	150	205 ¹⁾	TK 516	0.04
75	155	210 ¹⁾	TK 517	0.04
80	165	225 ¹⁾	TK 518	0.04
85	170	220 ¹⁾	TK 519	0.04
90	175	232 ¹⁾	TK 520	0.05
100	185	250 ¹⁾	TK 522	0.05
110	205	260 ¹⁾	TK 524	0.05
115	215	265 ¹⁾	TK 526	0.06
125	225	285 ¹⁾	TK 528	0.06
135	235	295 ¹⁾	TK 530	0.07
140	240	315 ¹⁾	TK 532	0.07
150	280	324 ²⁾ , 302 ³⁾	TK 34, TK 34N	0.09
160	290	334 ²⁾ , 312 ³⁾	TK 36, TK 36N	0.11
170	300	352 ²⁾ , 330 ³⁾	TK 38, TK 38N	0.11
180	310	374 ²⁾ , 350 ³⁾	TK 40, TK 40N	0.15
200	330	390 ²⁾ , 367 ³⁾	TK 44, TK 44N	0.16
220	350	410 ²⁾ , 383 ³⁾	TK 48, TK 48N	0.17
240	378	424 ²⁾ , 401 ³⁾	TK 52, TK 52N	0.18
260	398	424 ²⁾ , 401 ³⁾	TK 56, TK 56N	0.19
280	418	455 ²⁾ , 431 ³⁾	TK 60, TK 60N	0.21
300	438	475 ²⁾ , 451 ³⁾	TK 64, TK 64N	0.21
320	456	523 ²⁾ , 515 ⁴⁾	TK 68, TK 68B	0.33
340	480	523 ²⁾ , 515 ⁴⁾	TK 72, TK 72B	0.34
360	500	525 ²⁾ , 550 ⁴⁾	TK 76, TK 76B	0.36
380	520	555 ²⁾ , 550 ⁴⁾	TK 80, TK 80B	0.37
400	547	585 ²⁾ , 585 ⁴⁾	TK 84, TK 84B	0.37
410	557	585 ²⁾ , 585 ⁴⁾	TK 88, TK 88B	0.39
430	575	599 ²⁾ , 629 ⁴⁾	TK 92, TK 92B	0.39
450	601	599 ²⁾ , 629 ⁴⁾	TK 96, TK 96B	0.39

Inch sizesPrincipal dimensions Designation Recommended
relubrication rated_a d₂ A₂

in. grams/hr

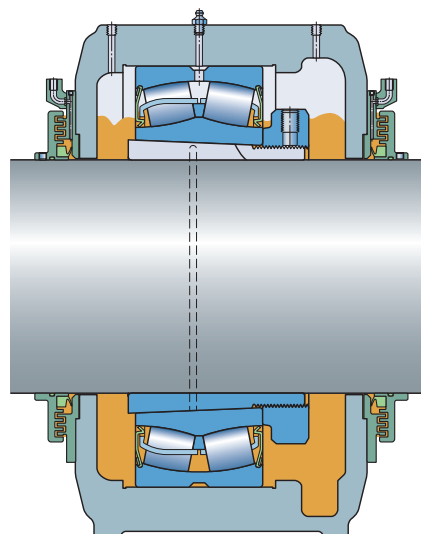
1 15/16	4.84	6.65 ⁵⁾	TK 24 V	0.03
2 3/16	5.04	7.36 ⁵⁾	TK-29 V	0.03
2 7/16	5.24	7.52 ⁵⁾	TK-37 V	0.03
2 11/16	5.87	8.46 ⁵⁾	TK-44 V	0.04
2 15/16	6.10	8.50 ⁵⁾	TK-53 V	0.04
3 3/16	6.34	9.33 ⁵⁾	TK-188 V	0.04
3 7/16	6.77	8.78 ⁵⁾	TK-102 V	0.05
3 15/16	7.17	9.84 ⁵⁾	TK-109 V	0.05
4 3/16	7.91	10.71 ⁵⁾	TK-113 V	0.05
4 7/16	7.91	10.83 ⁵⁾	TK-117 V	0.06
4 15/16	8.82	10.98 ⁵⁾	TK-122 V	0.06
5 3/16	8.78	11.93 ⁵⁾	TK-125 V	0.07
5 7/16	9.41	12.17 ⁵⁾	TK-130 V	0.07
5 15/16	11.02	13.00 ⁵⁾	TK-140 V	0.09
6 7/16	11.42	13.33 ⁵⁾	TK-148 V	0.11
6 15/16	12.20	14.35 ⁵⁾	TK-155 V	0.11
7 3/16	12.20	15.10 ⁵⁾	TK-159 V	0.15
7 15/16	12.99	15.85 ⁵⁾	TK-167 V	0.16
8 15/16	13.78	15.10 ⁵⁾	TK-552 V	0.17
9 7/16	14.88	15.85 ⁵⁾	TK-553 V	0.18
9 15/16	15.67	16.34 ⁵⁾	TK-607 V	0.19
10 7/16	15.67	16.34 ⁵⁾	TK-606 V	0.19
10 15/16	16.54	20.40 ⁶⁾	TK-858 V	0.21
11 7/16	16.54	20.40 ⁶⁾	TK-861 V	0.21
11 15/16	17.24	20.40 ⁶⁾	TK-859 V	0.21
12 7/16	17.24	20.65 ⁶⁾	TK 865 V	0.33
12 15/16	18.90	21.15 ⁶⁾	TK-869 V	0.34
13 7/16	19.29	21.15 ⁶⁾	TK-872 V	0.34
13 15/16	19.29	21.15 ⁶⁾	TK-875 V	0.36
15	20.47	22.28 ⁶⁾	TK-847 V	0.37
15 3/4	21.54	22.50 ⁶⁾	TK-969 V	0.37
16 1/2	22.32	23.87 ⁶⁾	TK-958 V	0.39
17	22.64	23.58 ⁶⁾	TK-838 V	0.39
18	23.66	26.57 ⁶⁾	TK-888 V	0.39

¹⁾ Applicable for TK 511–532 with SNL 5 housing only²⁾ Applicable for TK 34–96 with SNL 31 housing only³⁾ Applicable for TK N with SNLD/VZ2N7 housing only⁴⁾ Applicable for TK B with SDJD/VZ2N9 housing only⁵⁾ Applicable for TKV with SAF housing only⁶⁾ Applicable for TKV with SDAF 30 housing only



Housing with SKF Taconite Seal – “in-groove”

Fits into the seal groove of SKF split housings. The SKF housings do not require modification to accommodate the new “in-groove” SKF Taconite Seal. “In-groove” seals have three or four stage labyrinths, depending on size.



Housing with SKF Taconite Seal – “bolt-on” – optional for larger sizes

The optional SKF Taconite Seal for larger sizes (from size 68) is flanged for bolting to the housing. The SKF housing can be delivered from the factory with the necessary machining or, with existing housings, can be modified by a local SKF Solution Factory to accommodate the new SKF Taconite Seal in the larger sizes.



The ultimate SKF Three-Barrier Solution

For optimum performance in extremely dirty and wet applications, especially where high-pressure washdowns of the machinery are common, SKF recommends the ultimate three-barrier solution:

- **SKF housing with SKF Taconite Seals** – primary barrier: prevents ingress of solid and liquid contaminants, even during high-pressure washdowns
- **Grease barrier** – secondary barrier: grease fill in bearing housing cavity
- **Upgraded sealed SKF Explorer spherical roller bearings** – final barrier: excludes contaminants during initial installation and in operation

Case Study 1 – Conveyor pulley



Conveyor pulley bearings mounted in competitor split plummer block housings with taconite seals in an iron ore ship loading facility were suffering regular premature failures with an MTBF* of only

12 months. Investigation showed the cause to be gross iron contamination of the bearing grease inside the housings with samples showing a content of 5 000 to 140 000 ppm. The existing seals were replaced with SKF Taconite Seals and the levels of contamination of the bearing grease inside the housings dropped dramatically. Samples taken at 6 months showed only 10 – 60 ppm of iron and bearing MTBF was extended beyond that of the pulley lagging.

Case Study 3 – Grinding mill pinion



The non-drive end spherical roller bearing on an ultra-fine grinding mill at a gold mine suffered failure every 15 months. Analysis showed the cause of failure to always be the same: water ingress into

the housing. When the non-drive end bearing failed, both it and the drive side bearing were replaced as a precautionary measure, increasing maintenance costs. The SKF ultimate three-barrier solution (SKF housings, SKF Taconite Seals and upgraded sealed SKF Explorer spherical roller bearings) was installed in May of 2012. The bearings are still in service with very satisfactory performance.

Case Study 2 – Conveyor pulley



Open spherical roller bearings mounted in split plummer block housings fitted with competitor taconite seals supporting conveyor pulleys were suffering premature failures with an MTBF of approximately

18 months. Analysis showed the cause of failure to be extremely contaminated bearing grease. The ultimate SKF Three-Barrier Solution (SKF housings, SKF Taconite Seals and upgraded sealed SKF Explorer spherical roller bearings) was installed to address the problem. MTBF is now expected to be in excess of 5 years.

Case Study 4 – Conveyor pulley



Open spherical roller bearings mounted in competitor split plummer block housings with taconite seals supporting conveyor pulleys were suffering premature failures with an MTBF between 3 and

12 months. Analysis showed the cause of failure to be contamination of the bearing grease. Since the ultimate SKF Three-Barrier Solution (SKF housings, SKF Taconite Seals and upgraded sealed SKF Explorer spherical roller bearings) was installed, there have been no further failures.

*MTBF – Mean Time Between Failure

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