

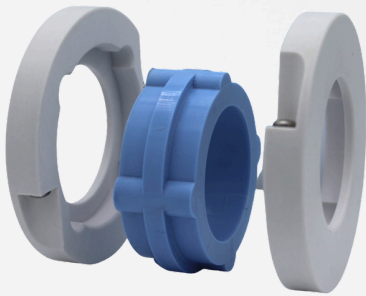


ASSEMBLY INSTRUCTIONS

for CinchSeal Rotary Shaft Seals



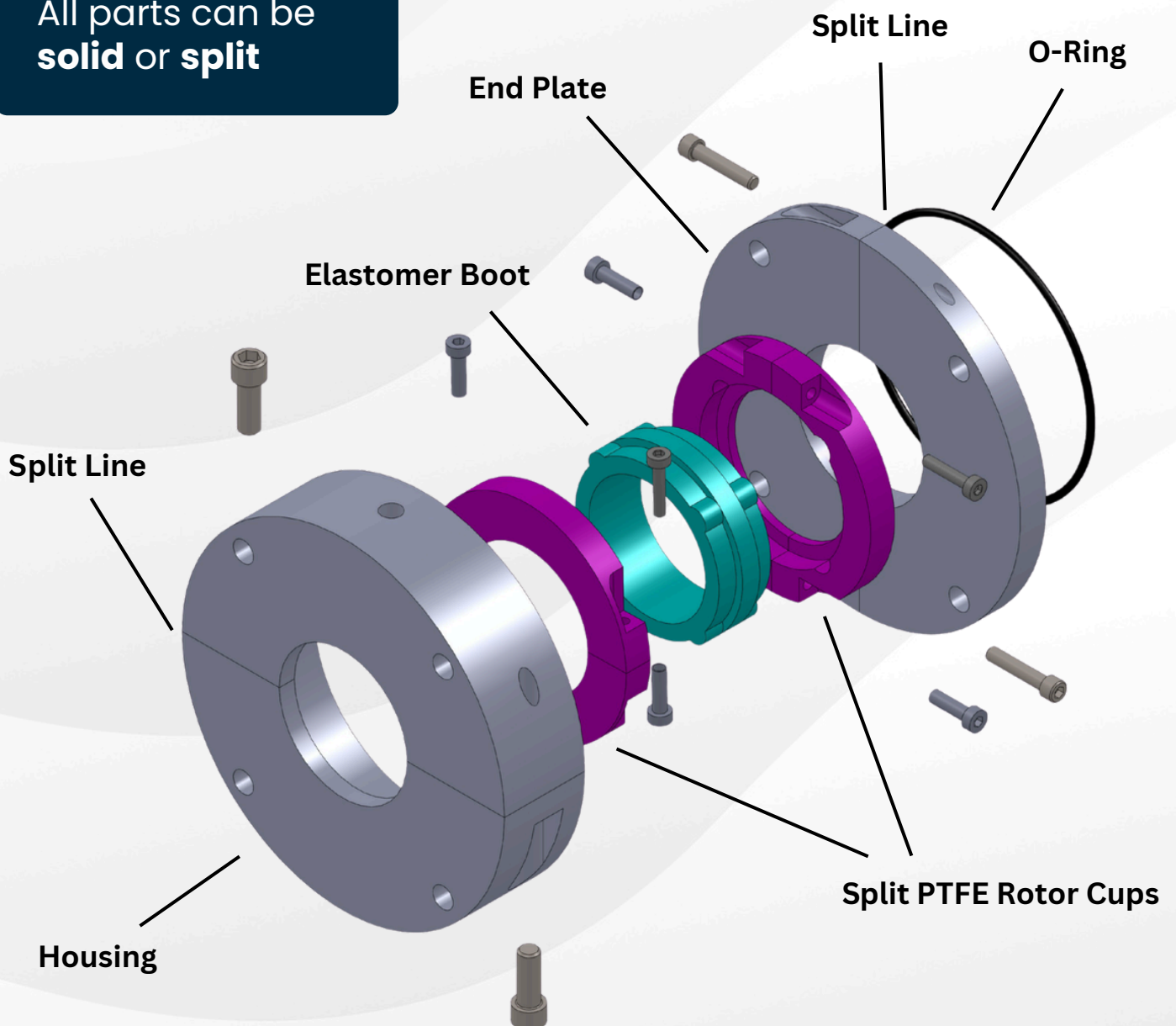
INDIVIDUAL PARTS



2 white **Rotor Cups**, PTFE compound

1 blue **Elastomer Boot**, silicon compound

All parts can be
solid or **split**





ASSEMBLY STEPS



1.

Fit the O-ring in the end plate, using a little grease in the groove at 3 points (12, 4 and 8 o'clock) in the groove so that the O-ring sticks in the groove during assembly.

2.

Fit the end plate with the O-ring to the machine wall on the machine wall. Ensure that there is an even

distance between the through hole in the end plate and the shaft. Tighten the screws in the end plate.

If there is an O-ring between the end plate and the housing, insert it into the groove as described above. **Remove all grease residue.**



3.

The shaft must now be thoroughly cleaned and all grease and oil residues removed. Silicone gloves should then be put on to avoid contaminating the surface of the shaft with hand perspiration. Likewise, the elastomer boot should not be touched with bare hands to prevent grease deposits on the inside diameter.





ASSEMBLY STEPS



4.

Fit both rotor cups onto the shaft (Tightening torque: 0.45 Nm), with the smooth sides facing away from each other and the sides with the notches facing each other. Place the elastomer boot around the shaft so that the puzzle cut is facing upwards. A small gap should be visible

5.

Coat both sides of the puzzle cut with the enclosed sealant. Ensure the full depth of the gap is filled.



6.

Then press the elastomer boot into the notches of the first rotor cup.

7.

Press the second rotor cup onto the notches as well, paying attention to offset the rotor cup split lines. Note the time this step was completed (for step 8).





ASSEMBLY STEPS



8.

Then mount the housing and screw it to the end plate. Now you shall wait 3.5 hours from the completion of step 7 for the sealant has cured.

9.

Attach the pressure regulator and the pressure gauge to the housing and set a pressure of at least 0.3 to 0.5 bar above the system pressure on the pressure gauge. Each housing requires its own pressure regulator and pressure gauge! **Connect the pressure regulator and pressure gauge as close as possible to the housing and avoid long supply lines.** Now allow the shaft to run in for at least 45 to 60 minutes without product, but with air pressure on the housing at medium speed.



Initially escaping air should be significantly reduced after this running-in process. Small white particles coming out of the housing indicate correct running-in inside and are not critical.

Production can now start!



Occasionally check that the pressure gauge is set correctly and never turn off the air! ❌