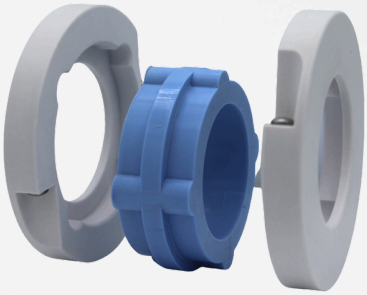
THE INSTALLATION INSTRUCTION

for CinchSeal Rotary Shaft Seals

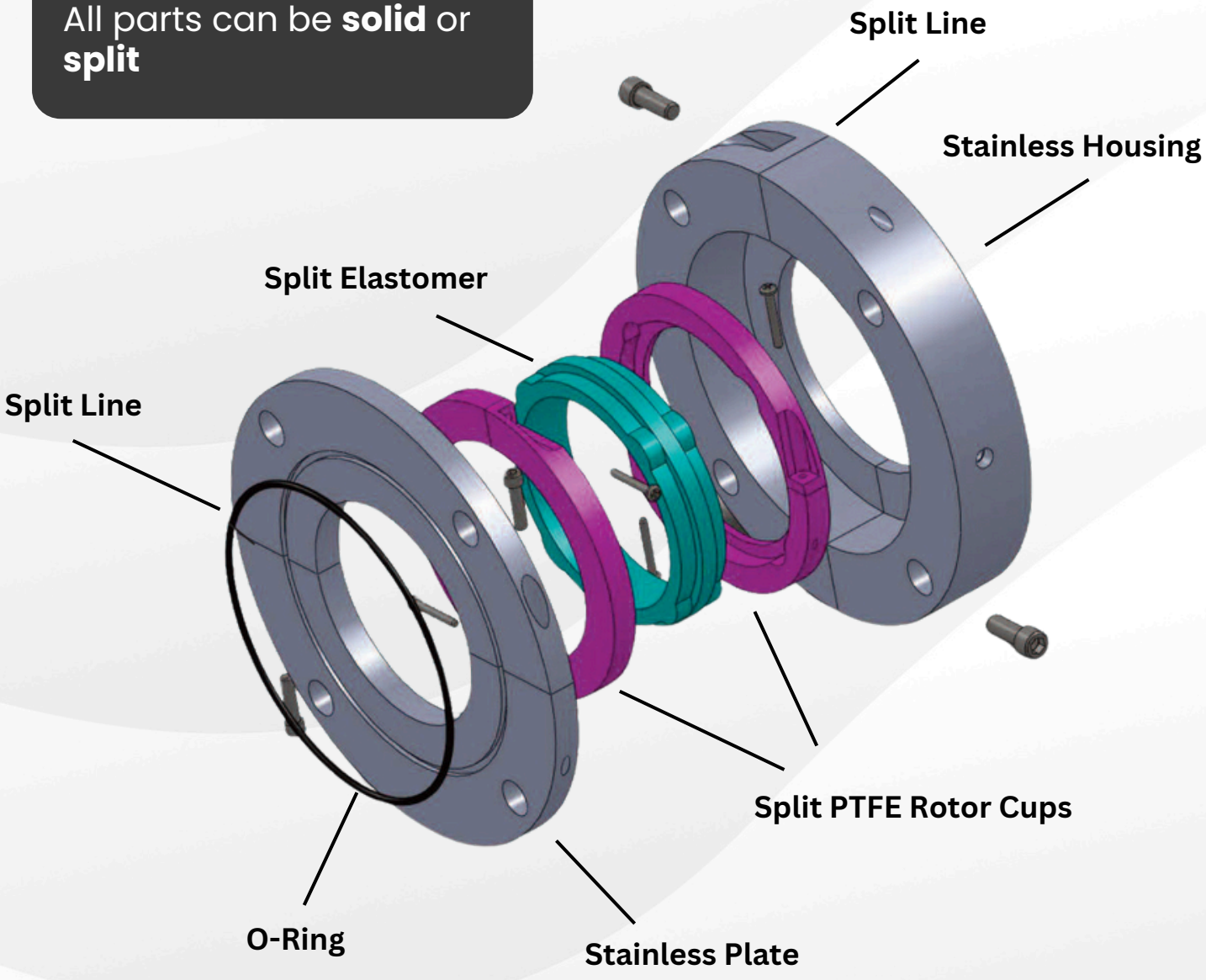
INDIVIDUAL PARTS



2 white **Rotor Cups,** PTFE compound

1 blue **Rubber 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 rubber boot should not be touched with bare hands to prevent grease deposits on the inside diameter.

ASSEMBLY STEPS

4. **Mount both rotor cups onto the shaft,** making sure that the smooth sides face away from each other and the sides with the notches face toward each other. **Place the rubber 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.

6. **Then press the rubber boot into the notches** of the first rotor cup.

7. **Press the second rotor cup into the notches as well,** paying attention to the offset of the dividing lines.

ASSEMBLY STEPS

8. **Then mount the housing and screw it to the end plate.** Now you have to wait 1 to 2 hours for the rubber boot to vulcanize.

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!