

Illustration 3

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2. Put rubber toric ring (2) on seal ring (1) . Make sure that the rubber toric ring is positioned at the bottom of seal ring ramp (7) . The rubber toric ring must rest against retaining lip (8) . The rubber toric ring must be straight in the seal ring. The rubber toric ring must not be twisted.

Note: Be careful when you are working on the rubber toric ring. Nicks, cuts or scratches may cause leaks.

3. Refer to Special Instruction, SEHS8484, "Tool and Specification Chart for Conventional Duo-Cone Seals" in order to select the proper installation tool.

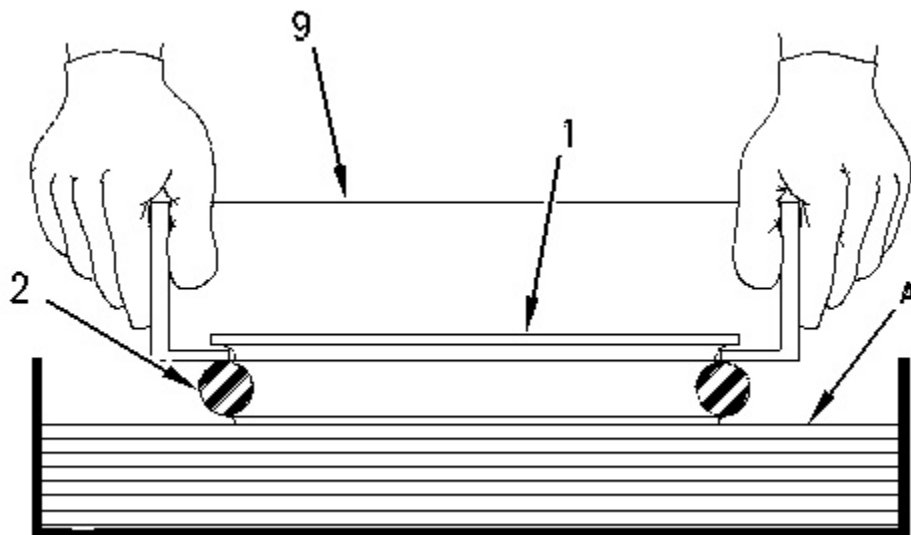


Illustration 4

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Use towels or a mat (A) that is made of foam to aid with installing the toric ring (2) .

4. Install rubber toric ring (2) on seal ring (1) with installation tool (9) . Lightly dampen the lower half of rubber toric ring (2) with an appropriate lubricant. Refer to the "Acceptable Lubricants for Assembly" section that is in this publication for additional information. Use the following techniques in order to dampen the rubber toric ring:
 - Wipe the seal with a lint free cloth.
 - Place towels or a mat that is made of foam at the bottom of a container. Soak the towels or the mat with the lubricant. Dip the rubber toric seal in the container.

Note: Periodically inspect the installation tool for damage. If necessary, replace the installation tool.

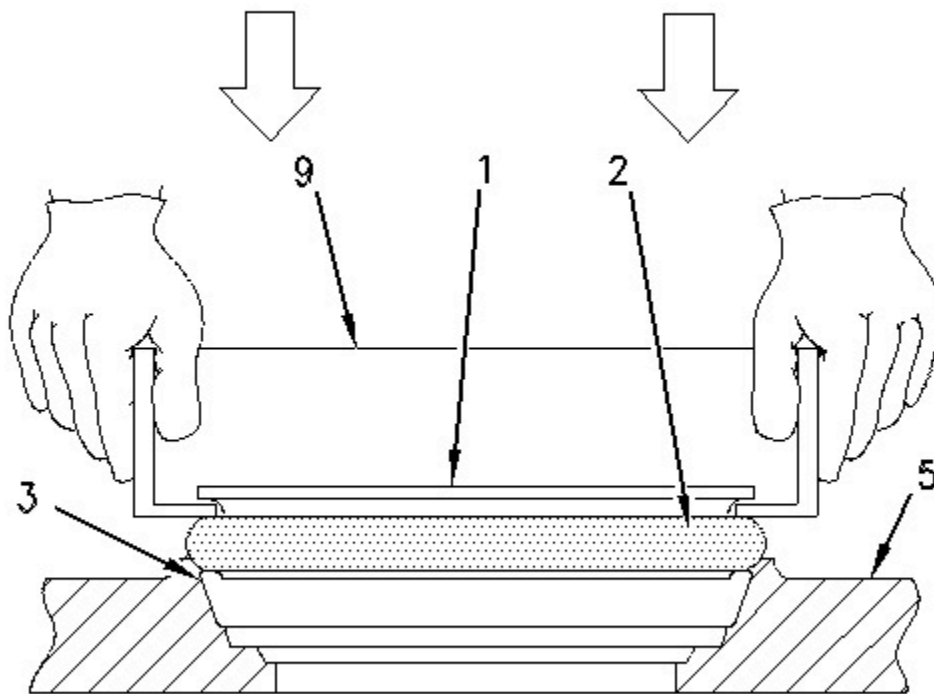


Illustration 5

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5. Make sure that the lower half of rubber toric ring (2) is still wet. Use installation tool (9) in order to position seal ring (1) and rubber toric ring (2) squarely against seal ring housing (5) . Make sure that you use sudden pressure and even pressure when you press a toric ring that has a small

diameter. Press rubber toric ring (2) under housing retaining lip (3) that is part of seal ring housing (5) . Use the following steps in order to install a rubber toric ring that has a large diameter:

- Push the rubber toric ring over the seal ring retaining lip on one side.
- Tap the installation tool with a rubber mallet on the opposite side of the rubber toric ring. Tap until the rubber toric ring is past the seal ring retaining lip of the housing.

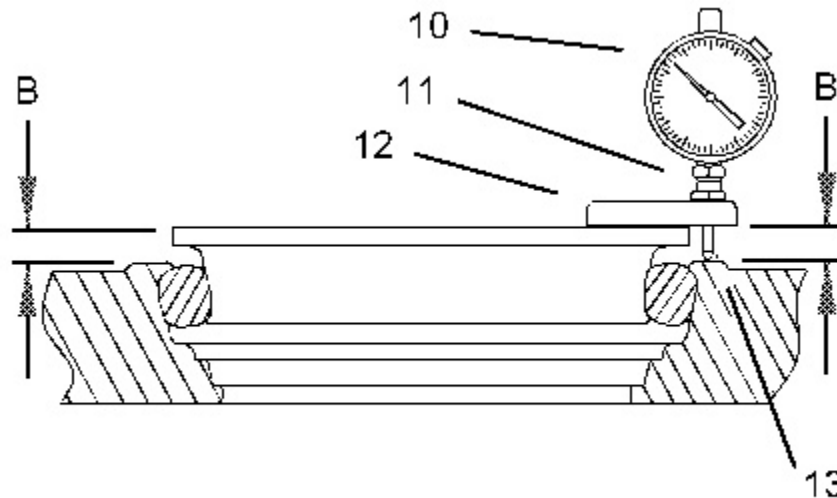


Illustration 6

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Tooling (A)

(B) Assembled height

(10) Dial indicator

(11) Collet assembly

(12) Dial indicator base (plastic)

(13) Contact point

6. Use Tooling (A) to check the assembled height (B) at four locations that are 90 degrees from each other. The difference in height must not exceed 1.0 mm (0.04 inch). Refer to Illustration 6.

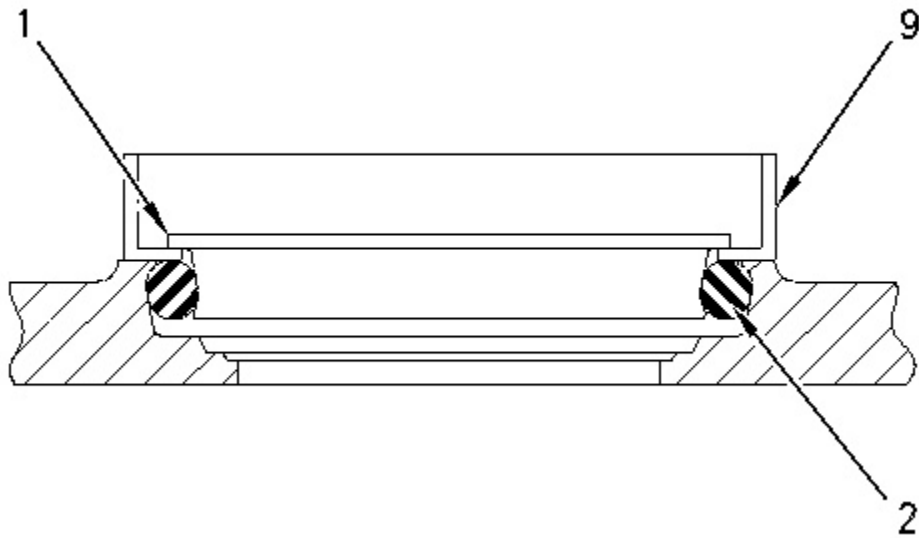


Illustration 7

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7. Do not adjust the seal ring (1) by pushing on the seal ring or by pulling on the seal ring. Use installation tool (9) in order to push down on the seal.

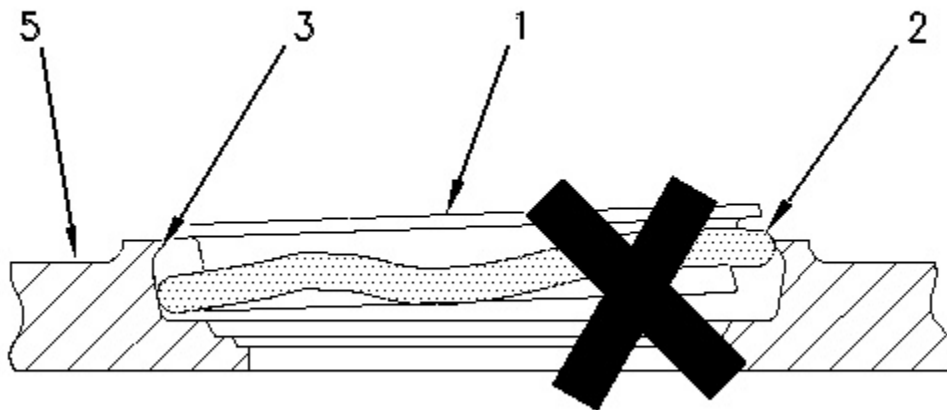


Illustration 8

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