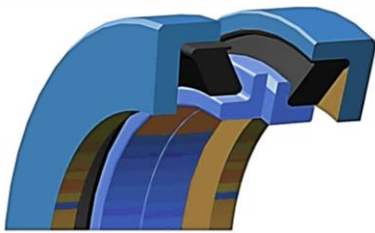




METAL FACE SEALS INSTALLATION GUIDELINES

Metal Face Seals – L Type



Heavy Duty Metal Face seals are fitted in the Flat collar of retaining housing , to form the sealing at the adjoining faces. Metal faces are precision Lapped. The flat edge of the metal Seal and Flat Housings tend to straighten the Trapezoidal shape of the Rubber ring to slide into and form a compressed profile

giving load on the seals and making it intact.

Handling of the Seals

The installation guidelines are aimed to protect the precision lapped and functional metal sealing faces. The more precautions taken, the more likely the seals will last in the field.



Metal Face Seals Installation Guidelines & Recommendations

Customized Seal Install Tools & Accessories

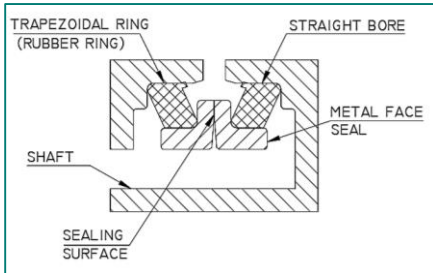
2020

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Heavy Duty Mechanical Flat Face Seal Assembly Arrangement:



1. Metal Seal Rings – 2 Nos.
2. Trapezoidal Rubber Loaders – 2 Nos.

Housing Preparation:



The housing components that contact the Trapezoidal Rubber Loaders (T-Rings), must be free from foreign material (oil, grease, dirt, metal chips, dust or lint particles, etc.) before

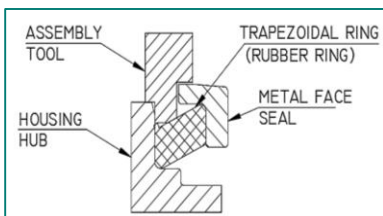
installing the seal. The housings should be cleaned using a lint-free Cloth, and a non-petroleum base solvent. SAP Parts™ **Seal-O-Fix** is an ideal recommendation for this purpose. Dry with a clean wipe. Seal rings must be handled with care. Machined seal faces must not be damaged or scratched. All parts are to be free of grease, oil, dirt and scale.

Seal Preparation:

The Trapezoidal Rubber Loaders (T-Rings) should be installed with the inside diameter radius in contact with the neck to flange radius of the seal ring.

Installation Process:

Use only SAP Parts™ Special Seal installation Tool designated for the respective seal Part number. Do not attempt to install seals manually without tool. Install each



half seal (Trapezoidal Rubber Loaders) into the housing by carefully pushing on the seal half until it is fully seated. Using a non-petroleum based solvent (SAP Parts™

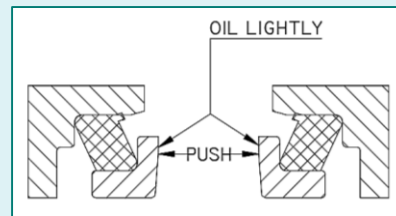
Seal-O-Fix is recommended) on the Trapezoidal Rubber Loaders (T-Rings) can help ensure the seal slides all the way into the bore. Check to be sure that the seal is not cocked and that the rubber Loader is seated evenly at the bottom of the bore. If the seal is a single barb# design, the barbed half goes in the suspended housing to ensure no movement of the seal half during the assembly process.



#Note – Barb is the extended projection on T-Ring Edge, facilitate rubber loader fix in the radius of flange and ensures right fitment.

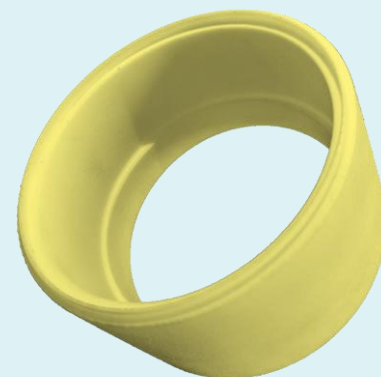
After installing the seal halves into the unit, wipe both metal sealing faces clean with a lint-free wipe. Apply a thin film of oil to the sealing faces with a lint-free applicator. Oil must not contact surfaces other than the sealing faces.

Final Assembly:



While completing the final assembly of the unit, make sure that both housings are in correct alignment and are concentric.

Observe very carefully that the rubber rings do not unseat from the bottom of the housing. Slowly bring the two housings together. (High impact can make scratch on the precision lapped sealing surface or break the seal components even) To set the seals, hold one-half of the assembly stationary while rotating the other member a minimum of 10 complete revolutions, clock wise and counter clockwise as well. This is very important for ensuring the perfect seal installation in the housing assembly.



Seal Installation Tool