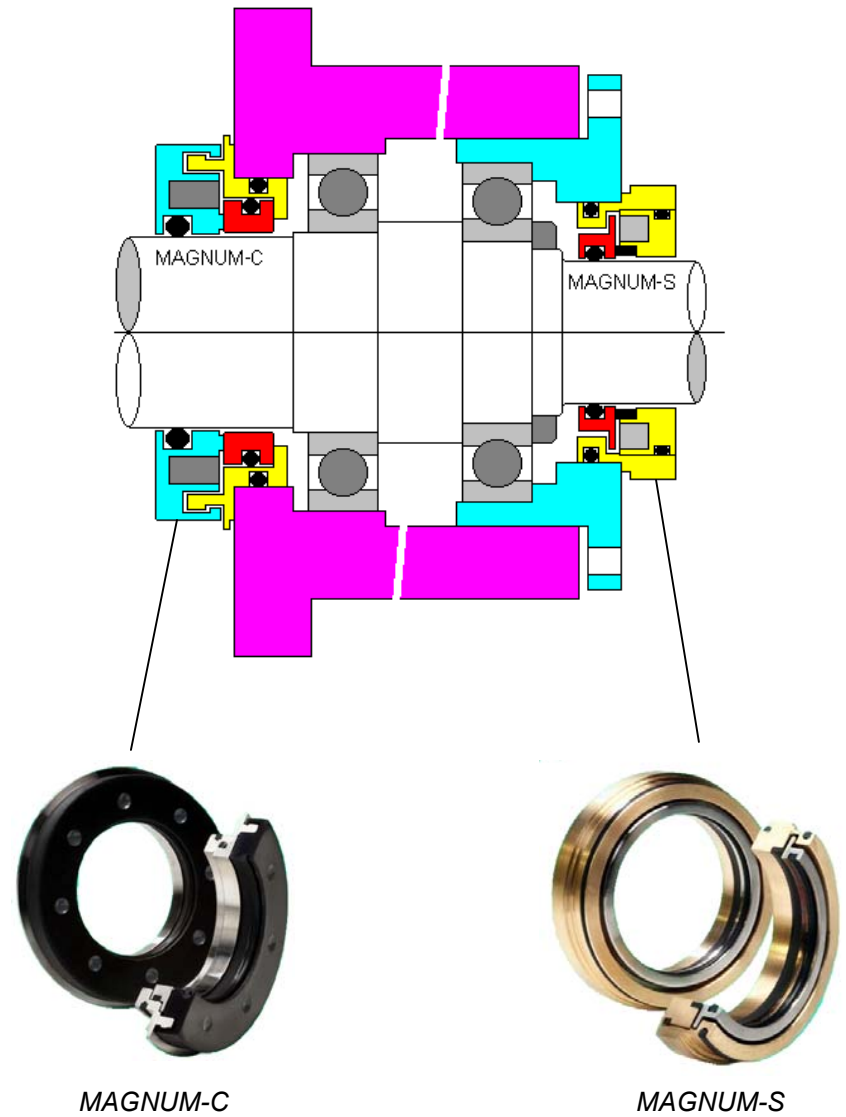
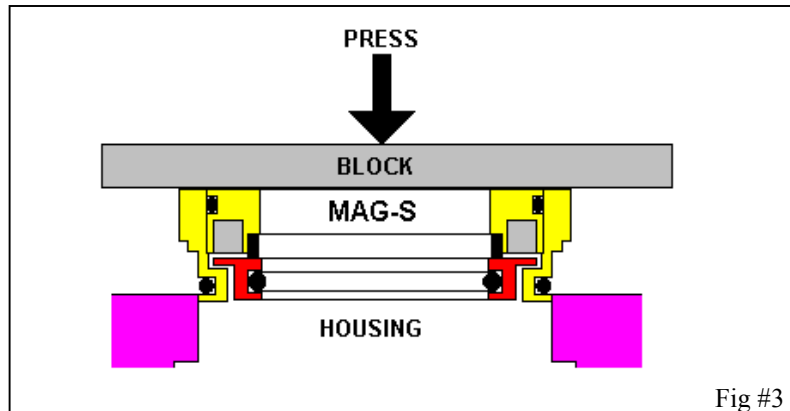
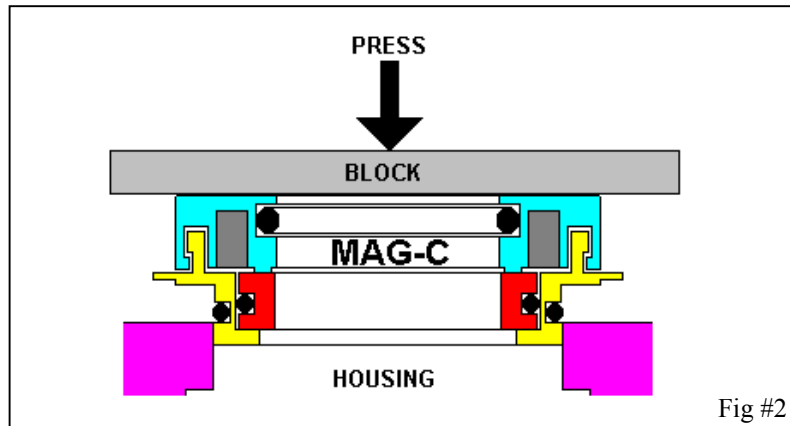
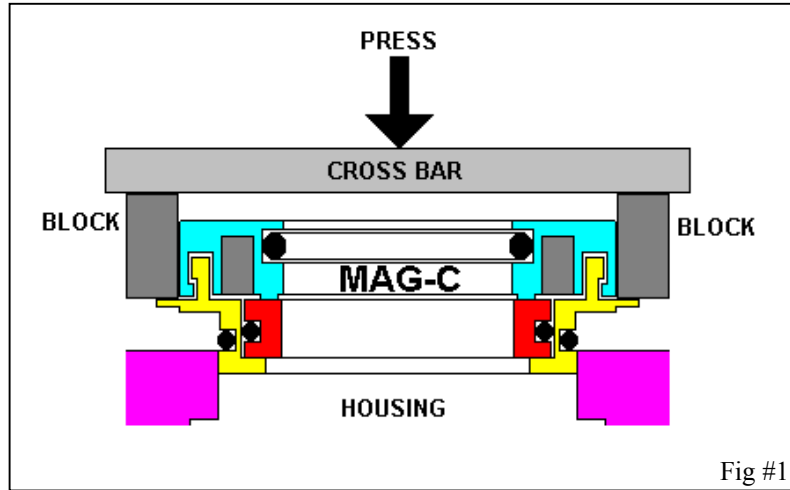


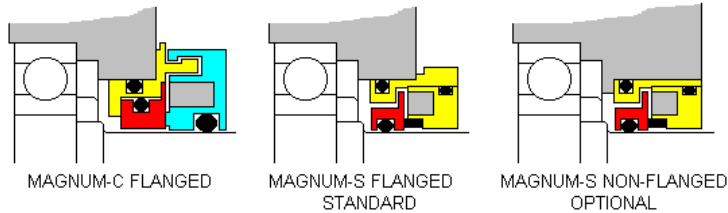


# MAGNUM SEAL GUIDE



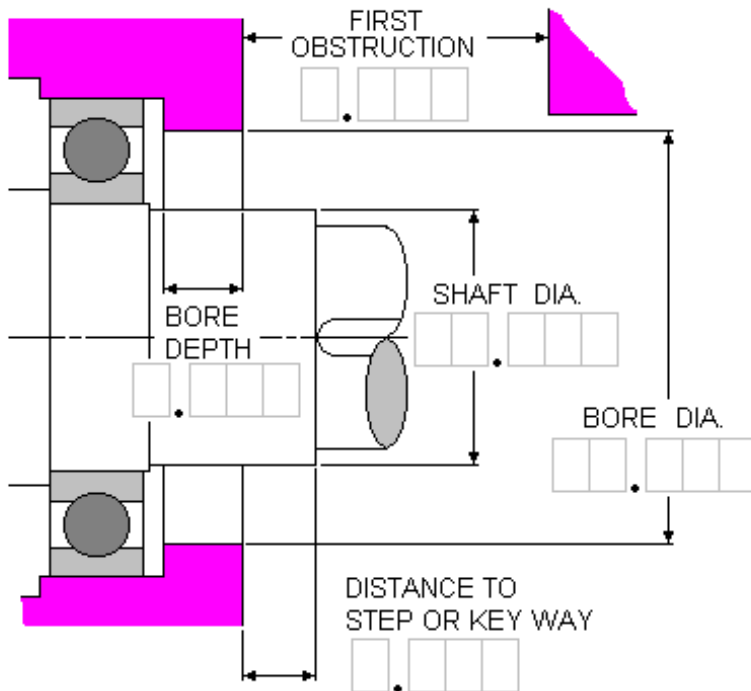


## MAGNUM CARTRIDGE SEALS



## HOW TO ORDER

1. Select seal type (Magnum-C or Magnum-S)
2. Select metal material (bronze or stainless steel)
3. Select o-ring material (viton standard.)
4. Measure equipment shaft and housing



PLEASE SUPPLY DIMENSIONS TO 3 DECIMAL PLACES

## Installation Instructions

### CHECK EQUIPMENT CONDITION

1. Shaft diameter, (+.002")
2. Shaft run out, (.0015" per inch of diameter not to exceed .020")
3. Shaft surface condition, (smooth, defect free, 32 RMS)
4. Housing bore diameter, (+.002", -.000")
5. Housing bore roundness, (.002")
6. Housing bore concentric with shaft, (.020" minus run out)
7. Housing square to shaft, (.001" per inch of diameter not to exceed .004")
8. Housing bore surface condition, (smooth and defect free)

### PREPARE EQUIPMENT

1. Clean shaft and housing bore
2. Break all sharp edges, key ways, shaft steps and bore edges to prevent cutting o-rings during assembly

### ROTOR O-RING LUBRICATION

Apply a thin coating of clean lightweight oil directly to the rotor o-ring. The lubricant being used in the host equipment is also applicable.

### DO NOT USE GREASE, ANTI-SEIZE or SILICONE

### ASSEMBLY

1. Press seal into housing (this may require a fair amount of force) a hydraulic or bench press may be helpful. **DO NOT HIT SEAL** Seal should fit snug into bore. If the fit is slightly loose, apply a small amount of RTV or sealant to the outside of seal then press into housing and allow to dry.
2. MAGNUM-C, it is best to push against the metal lip that extends around the outside of the seal using two metal blocks and a cross bar. (fig #1). If it is necessary to push against the composite rotor, place a block or spacer (fig #2) over the back of the seal rotor to push against. The block should be large enough to spread the pushing force over back of the seal. This will prevent damage to the seal.
3. MAGNUM-S, place a block or spacer over the back of the seal to push against (fig #3). The block should be large enough to spread the pushing force over back of the seal. This will prevent damage to the seal.

### MAGNUM SEALS ARE ONE PIECE CARTRIDGE DO NOT ATTEMPT TO DIS-ASSEMBLE

### DO NOT HIT SEAL

### DO NOT USE GREASE, ANTI-SEIZE or SILICONE