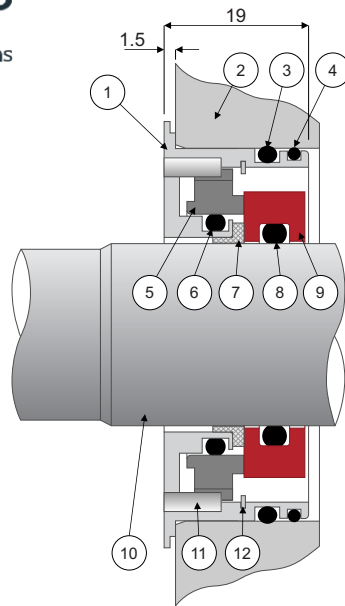
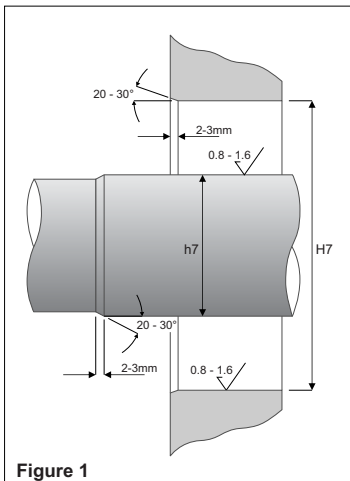
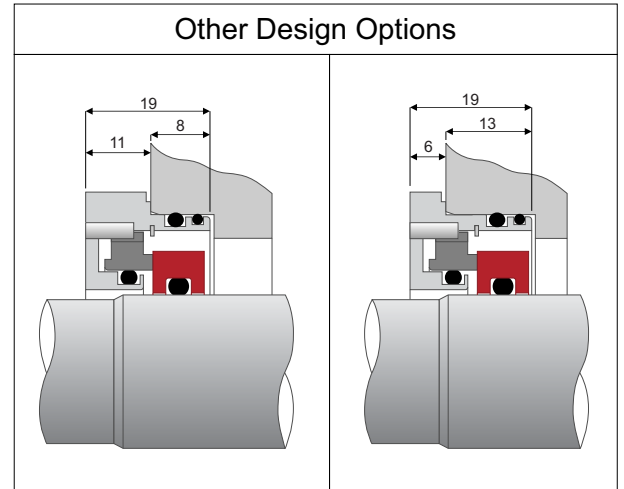


### Items:

1. Stationary Housing
2. Bearing Housing
3. Static Stationary O-ring
4. Static Stationary O-ring
5. Stationary Face
6. Dynamic Stationary O-ring
7. Setting Ring (Only used in installation)
8. Rotary O-ring
9. Rotary Face
10. Shaft
11. Stationary Anti-rotation Pins
12. Circlip



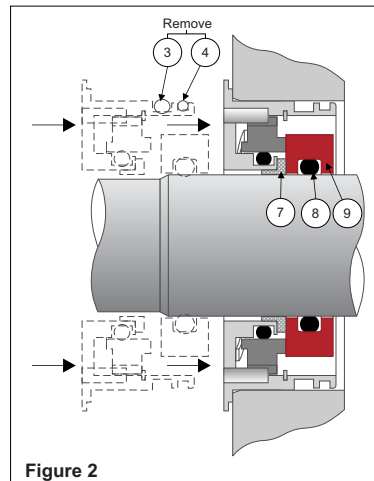
### Other Design Options



### Step 1: Pre-installation checks

- Check surface finish is suitable for O-ring sealing.
- Shaft run out < 0.1mm T.I.R.
- Make sure that there is a sufficient lead-on for the rotary and the stationary.
- Make sure that the Shaft and Housing diameters are within tolerance.
- Make sure that the shaft and bearing housing have been cleaned.
- There are no sharp edges over which the seal O-Rings (3,4 & 8) must pass.

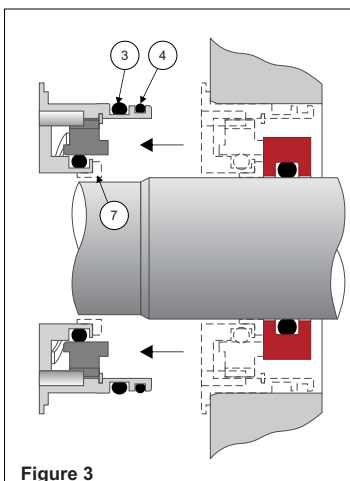
Figure 1



### Step 2: Set rotary position

- Slide rotary face with o-ring (Items 8 & 9) onto the shaft. Do not use lubrication grease.
- Ensure that the rotary face and stationary face have been wiped clean.
- With the setting ring (item 7) installed into the stationary unit and the static stationary o-rings (items 3 & 4) removed, assemble the stationary unit onto the shaft allowing the rotary and stationary faces to make contact. Do this slowly and carefully to avoid damaging the faces.
- Carefully and as evenly as possible, push the stationary assembly into the bearing housing until there is no gap between the bearing housing and the landing of the stationary housing.

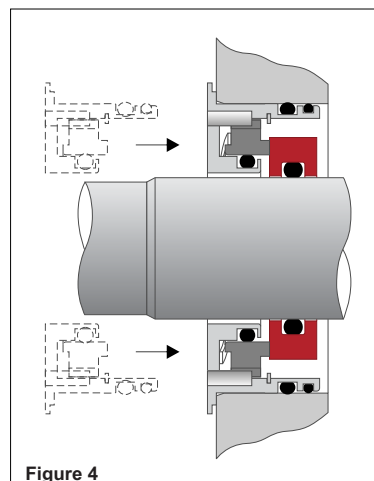
Figure 2



### Step 3: Prepare stationary for installation

- Remove the stationary assembly from the bearing housing, this can be achieved by using two screwdrivers or flat edges to wedge between the stationary housing and the bearing housing.
- Remove the setting ring (Item 7).
- Place the two static stationary o-rings (Items 3 & 4) into their o-ring grooves.

Figure 3



### Step 4: Stationary Installation

- With the static stationary o-rings installed and the setting ring removed, the stationary assembly can be pushed into the bearing housing until there is no gap between the bearing housing and the landing of the stationary housing. It is advisable to not use lubrication of any kind on the stationary housing o-rings or on the bearing housing.
- Once in place, turn the shaft by hand, listen and feel for any shaft binding, etc.

Figure 4