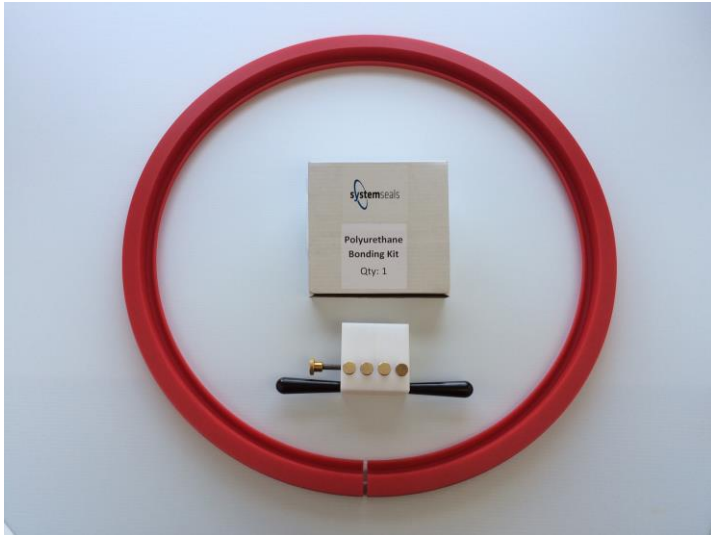


Bonding of a Large Diameter Polyurethane Shaft Seal

Date: 09/19/2016

Prepared By: Kurt Sassmannshausen

Your kit includes:



Inside the bonding kit:

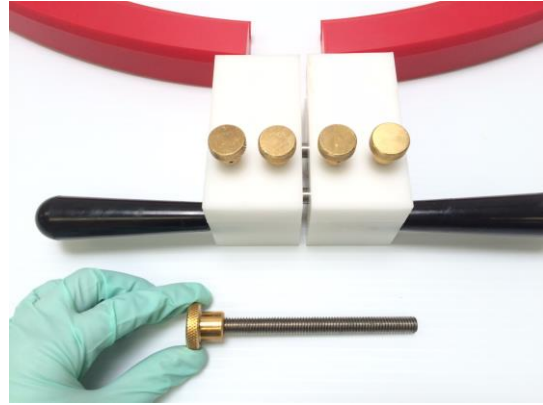
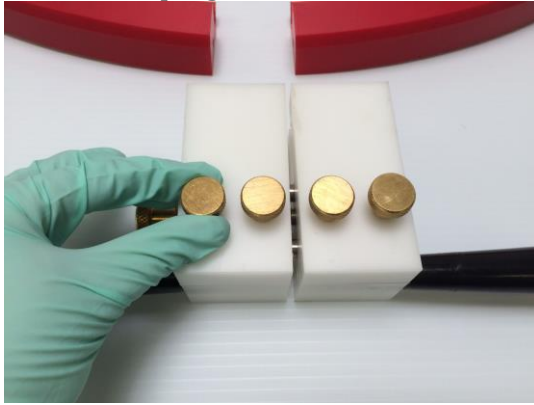


Bonding Instructions:

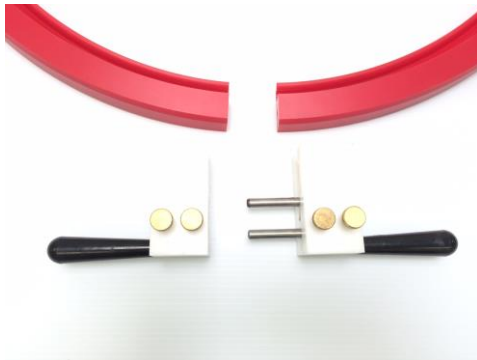
1. Remove dowel pins from seal.



2. Loosen the clamping bolts and remove center pin.



3. Pull the clamp apart and slide one half of seal into the clamp leaving a 1 mm extending from tool, tighten bolts.



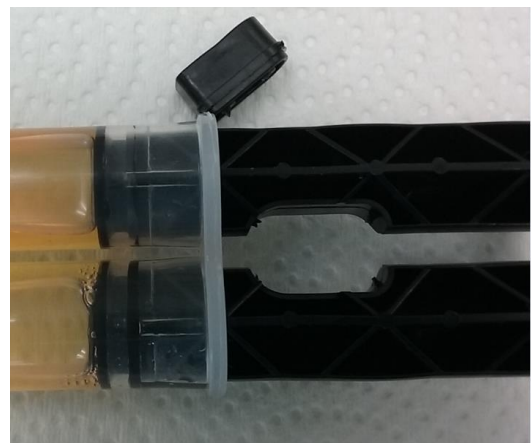
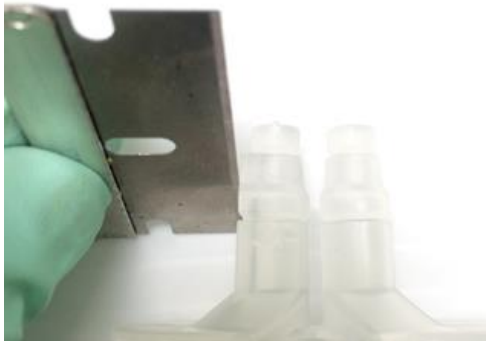
4. Repeat for other side.



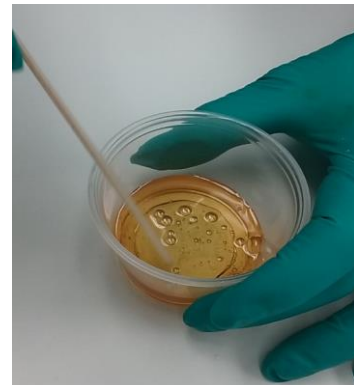
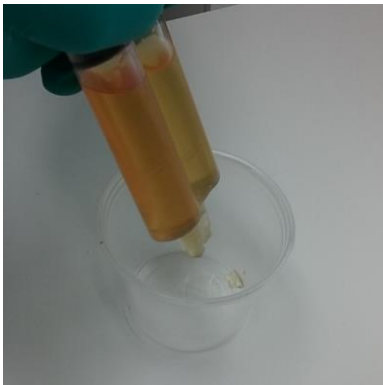
5. Clean all sealing surfaces with alcohol pads provide. This includes both sides of dowel pins.



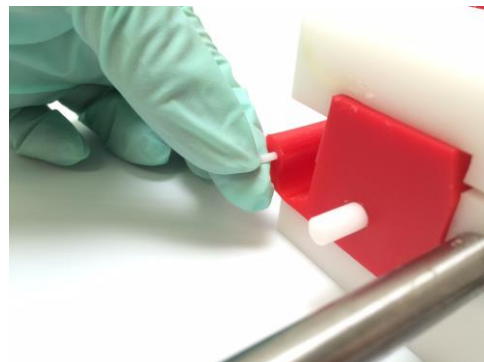
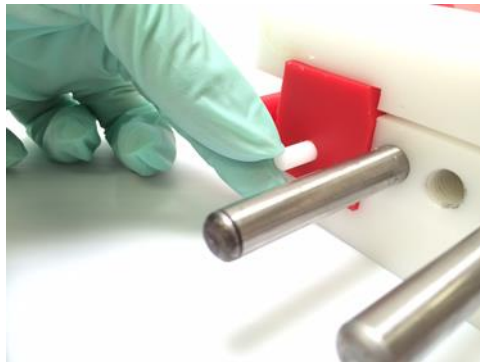
6. Cut off the tops of the adhesive syringe with a razor and break off plastic tab.



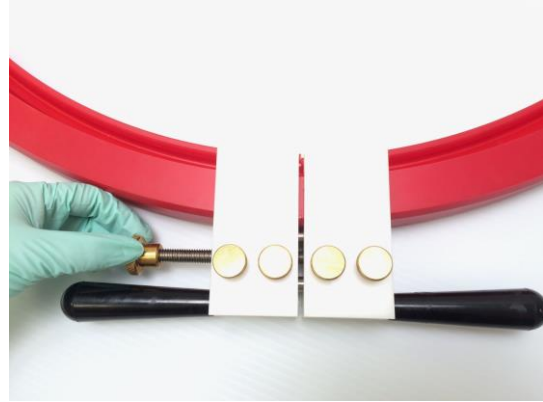
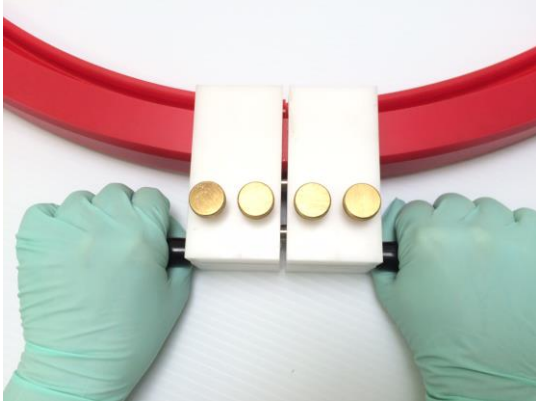
7. Push adhesive contents into mixing cup. Stir contents for 3 minutes with wooden mixer provided.



8. Apply adhesive with brush to seal and both sides of dowel pins. Insert dowel pins into either half of seal.



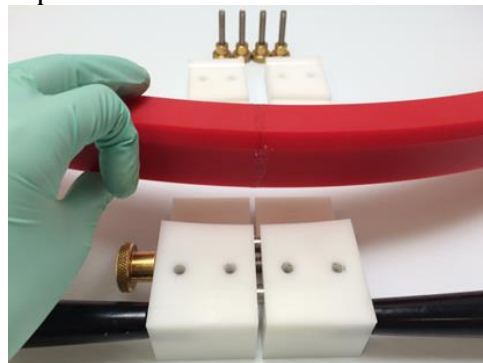
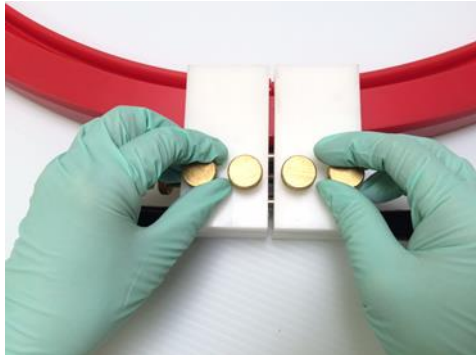
9. Draw the two ends of the clamp together and insert center pin and tighten. A very small gap $< 1\text{mm}$ is acceptable to ensure the adhesive is not pushed out.



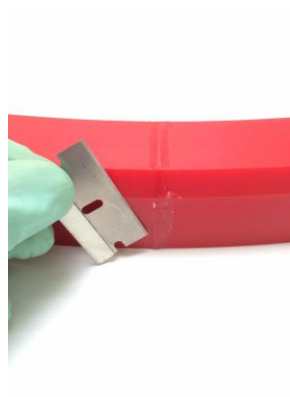
10. Wipe any excess adhesive off the sealing lip ID. **Let bond cure for minimum 2 hours.** Heat can be applied to increase integrity of bond. But 2 hours is still required for minimum bond time.



11. Loosen and remove red clamp screws and upper clamps. Remove seal from fixture.



12. Any excess adhesive can be removed with a sharp razor.



13. Lip maintains flexural integrity.

