

Work Instruction

## APPLY GLUE ON MECHANICAL SEAL FOR OIL TYPE END UNIT

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**\* APPLY GLUE ON OIL TYPE END UNIT ONLY.**

### APPLY GLUE

- EVENLY APPLY GLUE "PERMATEX 26B" ON THE METAL SURFACE OF MECHANICAL SEAL.

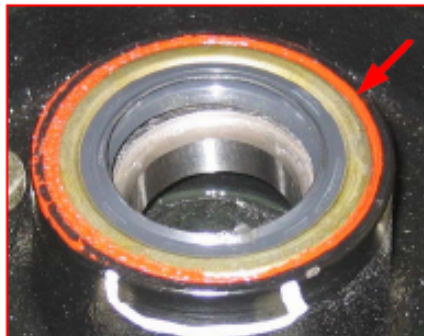


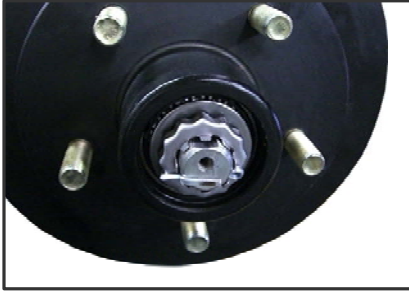
### PRESS IN

- PRESS MECHANICAL SEAL INTO HUB **WITHIN 5 MINUTES BEFORE THE GLUE DRY.**

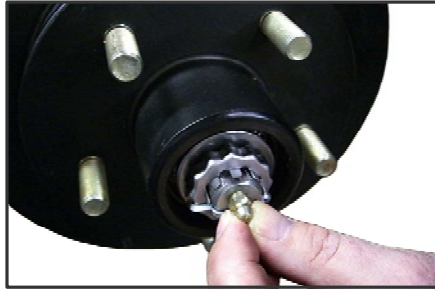
### CHECK, CLEAN & WAIT 1 HR.

- VISUAL CHECK THAT RED GLUE SHOULD HAVE NO VOID ON CIRCLE. **IF VOID THE SEAL MUST BE REMOVED.**
- CLEAN EXCESS GLUE ON HUB.
- **WAIT ONE HOUR FOR GLUE CURING BEFORE ADD OIL.**





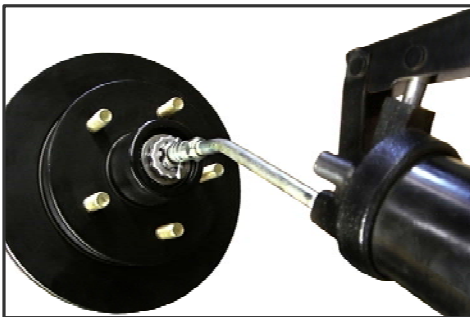
Install hub nose O-ring & adjust bearings per UFP Assembly Instructions.\*



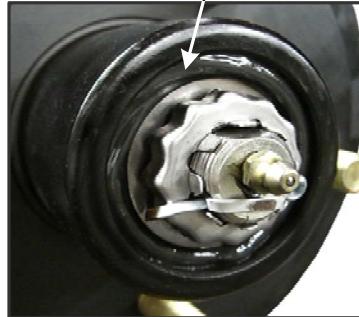
Screw a 1/8" NPT (Auto parts store) grease fitting into the threaded hole in the end of the spindle.



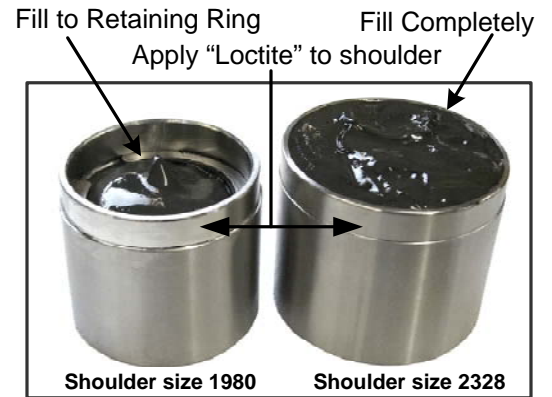
ONLY use UFP's proprietary HYBRID-OIL lubricant in a grease gun. \*If no spindle hole, hand pack bearings during assembly.



Fill hub cavity with the HYBRID-OIL lubricant. Rotate hub during filling to disperse air.



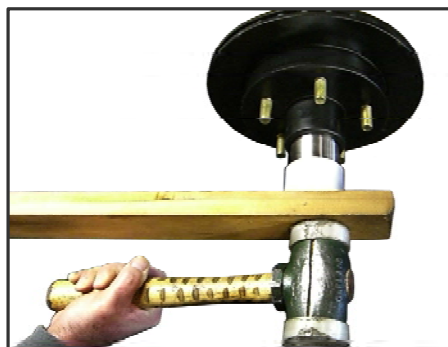
Hub cavity is full when the HYBRID-OIL lubricant first appears around edge of spindle washer. Remove grease fitting.



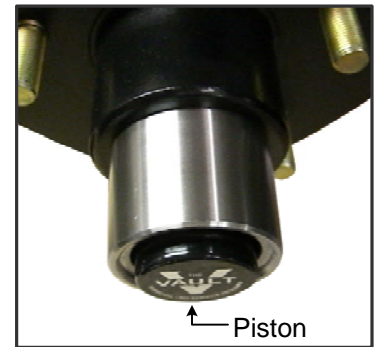
Fill THE VAULT protector cap with HYBRID-OIL lubricant. As shown in the photo above. Apply "Loctite" retaining compound to shoulder of protector.



Place PVC collar over protector (2"x1-1/2" slip collar for 1980 size) (2" female adapter for 2328 size) in order to prevent damage to the protector during installation.



Place a piece of wood over the collar and hit with a mallet to drive the protector STRAIGHT into the hub. You can expect excess HYBRID-OIL to escape from the sides of the protector.



When properly installed, THE VAULT piston will extend out of the end of the protector approx. 1/16" to 3/16".