60K HP Seal Kit Manual #11135

HP Seal kit **11135** contains the following parts:

11076 HP Seals with O-rings (4)	11077 HP Hoops (4)
11134 Backup Discs (2)	11447 Vacuum Grease Packet

60K Seal Kit #11135

HP Seal Tool Kit # 12387

Tools needed: HP Seal Tool Kit **12387,** Rubber Mallet.

Kit installation procedure:

1. Remove cylinder(s) from pump.
2. Place the cylinder on the Seal Guide tool.

3. Use the small (stepped) end of the installation tool to push the internal ***Backup Sleeve*** through the cylinder forcing the seals and hoops out the other end of the cylinder. Do not remove this sleeve. Turn the cylinder over and repeat this process.
4. Visually inspect the cylinder bore at **both** ends of the cylinder. If the inside bore finish is *blemished* remove the backup sleeve and go to Step 5. If the ID is good proceed to Step 6.

5. To refinish the ID cylinder bore, place the cylinder on a table and with a piece of *180* grit abrasive paper in *each* end and roll the cylinder back and forth to remove any blemishes. Repeat this process with *Scotch Brite* to polish the surface. Clean the cylinder thoroughly after polishing.
6. With clean hands, remove the o-rings and seals from their bags. Apply grease from the enclosed packet to the o-ring and install the o-ring on the seal without twisting the o-ring.
7. With the backup sleeve in place, **thread** the Seal Guide Tool onto one end of the cylinder. Install the Installation Sleeve into the Sleeve Guide with the larger ID (tapered) end up.

8. Lubricate the ID of the Sleeve with grease and load the seal with the o-ring side down into the sleeve. Keep the seal square while inserting it into the sleeve with your fingers.

9. Use the blunt (non-stepped) end of the installation tool to hand press the seal the rest of the way into the cylinder.

10. Place the Hoop with the sharp (tapered) end down into the installation sleeve.

11. Push the hoop down into the sleeve with the blunt end of the installation tool. Secure the Hoop in place by tapping the installation tool the rest of the way in with a rubber mallet.

12. Remove the tools from the finished end of the cylinder and repeat the seal installation process to the opposite end of the cylinder.

13. Remove the old Backup disc from the plunger and replace it with a new disc from the kit.

14. Apply *Accu-Goop* (11448) to the end of the plunger.

15. While supporting the end of the cylinder with your hand to keep the seal and hoop from popping out of the other end of the cylinder, push and rotate the cylinder onto the plunger.

16. Apply Blue-Goop (11111) to the threads on both ends of the cylinder. Thread the cylinder into the end bell.

NOTE: After time, the cylinder bore will open up making the hoops loose. This may require special care when the cylinder is installed. Eventually excessive use/wear in the cylinder wall may require the replacement of the cylinder.