

# CAT® SEALS

## Heavy Duty Dual Face Seals Installation

### Cat Heavy Duty Dual Face Seal

#### Assembly Contents:

1. (2) Metal Seal Rings
2. (2) Rubber Belleville Washers

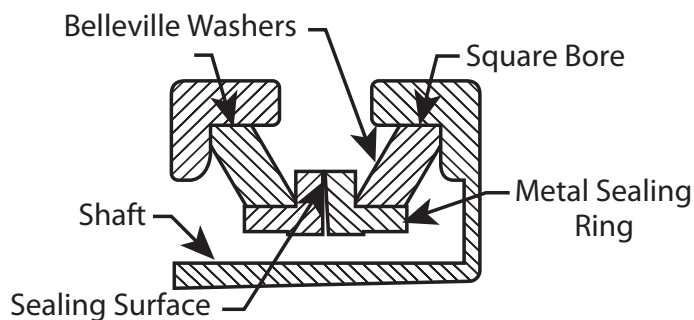
#### Service Kit Contents:

1. (1) Seal Group
2. Installation Instruction

#### Field Kit Contents:

1. (2) Rubber Belleville Washers
2. Installation Instructions

### Terminology



### Handling the Seals

The idea is to protect the seal face. The more precautions

taken, the more likely the seals will last in the field.

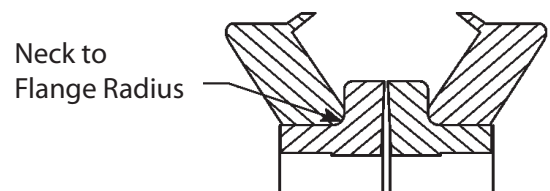
### Housing Preparation

The housing components that contact the Belleville Washers must be free from foreign material (oil, grease, dirt, metal chips, dust or lint particles, etc.) before installing the seal. The housings should be cleaned using a lint-free wipe and a non-petroleum base solvent. Dry with a clean wipe.

Seal rings must be handled with care. Machined seal faces must not be damaged or scratched. All parts are to be free of grease, oil, dirt and scale.

### Seal Preparation

The Belleville washer should be installed with the inside diameter radius in contact with the neck to flange radius of the seal ring.

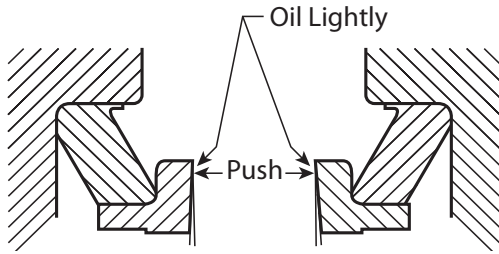


### Installation Process

Install each half seal (Belleville Washer and sealing ring) into the housing by carefully pushing on the seal half until it is fully seated. Using a non petroleum based solvent (isopropyl alcohol is recommended) on the Belleville Washer can help ensure the seal slides all the way into the bore. Check to be sure that the seal is not cocked and that the washer is seated evenly at the bottom of the bore. If the seal is a single barb design, the barbed half goes in the suspended housing to ensure no movement of the seal half during the assembly process.

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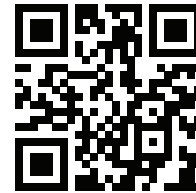


After installing the seal halves into the unit, wipe both metal sealing faces clean with a lint-free wipe. Apply a thin film of oil to the sealing faces with a lint free applicator. Oil must not contact surfaces other than the sealing faces.

## Final Assembly

While completing the final assembly of the unit, make sure that both housings are in correct alignment and are concentric. Observe carefully that the rubber rings do not unseat from the bottom of the housing. Slowly bring the two housings together. (High impact can scratch or break the seal components)

To set the seals, hold one-half of the assembly stationary while rotating the other member a minimum of ten complete revolutions. This is very important!



**For more information on Cat Seals**

**[www.cat.com/cat-seals](http://www.cat.com/cat-seals)**

