

- During assembly over threads, insert adequate protection between the sealing and the thread.
- Preassembled seals must never be subject to unilateral loads prior to assembly since this may cause deformation.
- Moderate heating of seals up to 60°C in hydraulic oils and application of mineral fat to seals and assembly components simplifies montage.

Guidelines for assembly of PTFE piston seals

To ensure a safe and proper assembly please adhere to the specified measurements, tolerances and surface areas strictly. Initially the O-ring is inserted in the groove. Piston seals of up to 100 mm nominal diameter and radial thickness of over 1.6 mm are stretched apart carefully using assembly tools and snap fit into the groove (see drawing).

Piston seals of over 100 mm nominal diameter can also be prised apart and fitted by hand taking care that the profile thickness is maintained as uniform as possible.

Lead in grooves that occur incidentally can be bridged by sheet metal or plastic strips or bands.

We recommend the use of a stretching housing to overcome assembly problems related to short lead-ins and large amount of stretching (see drawing).

Assembly tools are to be fabricated preferably from metals or polyamide.

