



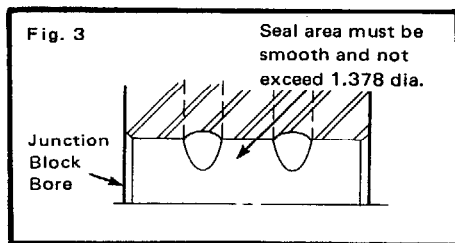
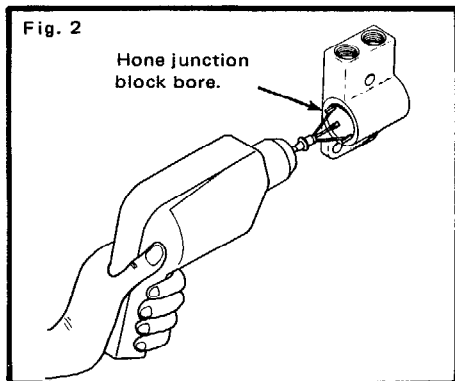
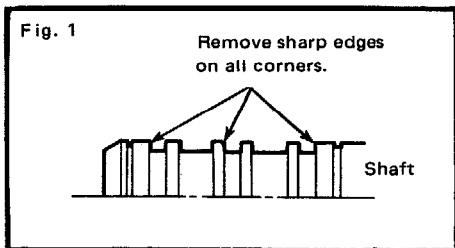
Installation Instructions

**Service Kit 646340
For Junction Blocks
646054, 646055, 646056
646057, 646058, 646059**

These instructions describe the procedures to install shaft seals and rings provided in Service Kit 646340. The kit includes 3 O-rings, 2 back-up rings and 1 ring loader.

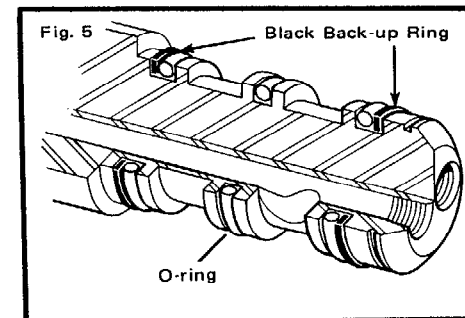
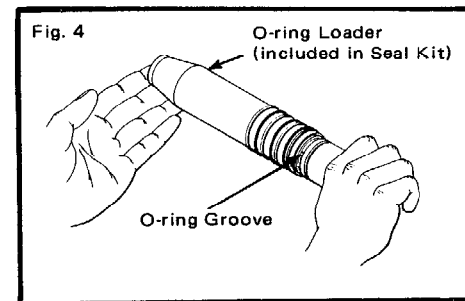
For best results and extended service life of your parts, follow these instructions closely.

1. Remove the worn seals and snap ring from the shaft.
2. Inspect the seal grooves on the shaft. If sharp edges, nicks or projections are found, use emery cloth (320 grit) to dress and smooth up. If imperfections cannot be removed from the critical sealing surfaces (metal surfaces O-rings seat against) shaft replacement may be necessary.
3. Inspect the junction block bore. Use a brake hone (1 1/2" recommended stone length) or butterfly hone (320 grit) and a light lubricant to clean the bore of ALL wear marks and sharp edges in the critical O-ring sealing areas.
IMPORTANT: Do not drag the hone across the sealing surfaces in the bore.
4. After honing, measure the inside diameter of the bore. The I.D. must not exceed 1.378 inches. If the diameter exceeds this dimension, premature seal leakage will occur and replacement is strongly recommended.
5. Rinse the shaft and junction block in a noncorrosive solvent to remove all traces of grit. Blow dry with compressed air.
6. Heavily lube the shaft with petroleum jelly or equivalent.



7. The black back-up rings are placed into the outer shaft grooves. See Figure 5. Apply lubricant to the seal loader. Install one back-up ring onto the loader and deposit into its' respective groove.
NOTE: IT IS IMPORTANT TO LOAD AND DEPOSIT THE BLACK BACK-UP RINGS INDIVIDUALLY AND AS QUICKLY AS POSSIBLE. See Figures 4 and 5.

8. Allow the back-up rings to set in the shaft grooves for about 5 minutes.
9. Next, install the O-rings into their respective grooves. (The O-rings may be installed onto the loader and deposited into their grooves together rather than individually). See Figures 4 and 5.
10. Slide the seal loader back over the shaft to compress the seals. Lightly tap (do not rotate) the loader down the shaft. Leave on the shaft 10 minutes to thoroughly compress the rings, if necessary.
11. Heavily lube the shaft with petroleum jelly or equivalent.
12. Install the shaft into the junction block by gently pushing down and rotating.
13. Install the snap ring.



**Do you have questions
you need answered
right now?**

Dial Directline
800-227-2233
(toll free)