



111 Brookside Drive • P.O. Box 37  
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# TECH TIP *Installing Piston Seals*

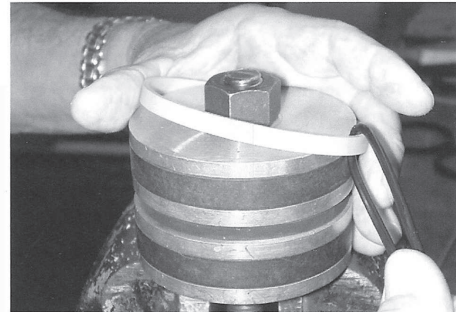
*At the request of many customers, here are some tips on how to install PTFE piston seals.*

## STEP 1



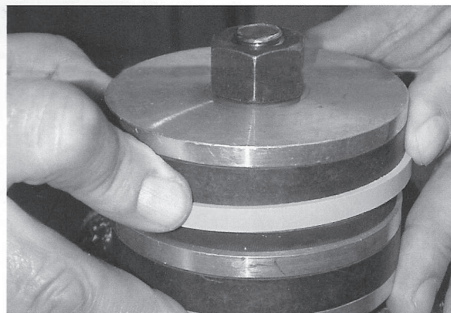
Lubricate and install the rubber expander ring into the groove as shown.

## STEP 2



With your hand over the edge of the piston and holding the seal with your palm, cut and loop an o-ring through the seal. With one motion, pull down and around until the seal is on the piston. Now, remove the o-ring.

## STEP 3



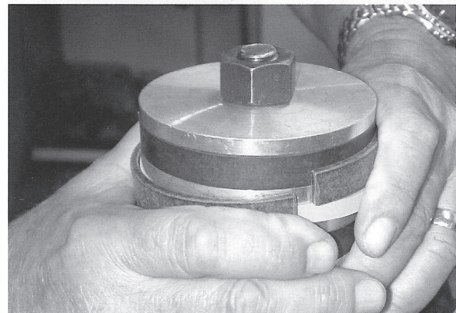
Next, push the seal over the groove.

## STEP 4



Place a nylon wear ring - 1/4\"/>

## STEP 5



Re-form the seal by squeezing the wear ring over the seal.

## HELPFUL HINTS

It may be necessary to heat the ring before installation. Warming the ring in water or oil at 130° F or 140° F for about 5 minutes will soften the material for easier installation. Always avoid inconsistent stretching or over stretching of the PTFE seal.

To prevent the PTFE ring from snapping into the wrong groove, cover wear ring grooves with plastic tape.

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