HP Seal Kit

#11451

Installing the New HP Seals*

**Required parts:**
- Seal kit which includes: 4 - HP seals with o-rings, 4 - hoops, 1 - grease packet
- Seal backup.
- Seal replacement tools (right)

1. Remove cylinder from pump.

| **IMPORTANT** | Use a clean rag to wipe the interior of the LP basket so that there is no grease to make the LP poppet stick. |

2. Place the stepped end of the cylinder on the seal tool locating ring. Use a rubber mallet at the small end of the Push Tool to drive the bottom seal and hoop out of the HP cylinder. Flip the cylinder over and repeat the process. The seals, hoops, spacer tube, and low pressure poppet cap should now be free of the HP cylinder.

3. **Remove** the seal backup from the seal housing in the hydraulic end cap. It may be necessary to partially remove the seal housing.

4. **Clean** and **inspect** the cylinder bore.
   - During use the inner surfaces at the ends of the HP cylinder may become worn. To clean this area roll polish the ID (Inside Diameter) of the cylinder ends on a table. First use 180 grit or finer abrasive paper, then finish with a Scotch-Brite pad.
   - If the bronze back-up is going to be reused, verify that the weep hole and ID groove are clear.

5. **Apply grease** from the packet onto each new o-ring. Place each o-ring onto the HP seal while making sure that the o-ring does not twist.

6. Place the HP cylinder on the spacer puck then insert the spacer tube, basket, and LP poppet as shown.
7. **Place** the locating ring and seal guide on the end of the cylinder. The large ID end of the seal guide should be up. Coat the inner diameter of the seal guide with the packet grease.

8. Place the seal with o-ring inside the seal guide with the o-ring toward the cylinder. Push the seal into the bore using the non-stepped end of the seal insertion tool. Always hold the seal guide firmly against the HP cylinder to prevent the o-ring from cutting as it enters the bore.

9. Place the silver hoop in the seal guide with the sharp edge toward the cylinder.

10. Use the non-stepped end of the seal insertion tool and a soft blow hammer to pound the hoop into place.

11. The hoop is seated properly when the seal insertion tool bottoms out on the seal guide.

12. Apply a small amount of grease from the packet around the OD of the pilot on the check valve body. Put high pressure lubricant in the pilot bores on either end of the HP cylinder. Carefully insert the check valve body into the end of the high pressure cylinder until it is seated firmly against the cylinder body.

13. Flip the cylinder and balance it on the check valve body, then repeat steps 3-5.

**NOTE:** The seal back-up can only be reused once. Either install a new backup or reuse the old one. It may be necessary to pull the seal housing out slightly to access and remove the backup.

* This description is for installing in an AccuStream pump. For use with a JE pump consult your pump manual.