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Instructions for Installing 155mm SEPCO® TJS Seal On a Gyro

Note: Reference Sepco Assembly #AY11403A (Rev. 1) & Parts List #UCM0155TJS-AMCX-01 (Rev. 1) prior to installing the seal(s).

1. Thoroughly clean and inspect the housing and shaft where the seal will be installed.
2. Check the condition of the housing where the stationary o-ring (Item #10) will be sealing. Be sure to remove any burrs that could damage the o-ring during installation. Measure the counter bore diameter to insure the actual dimension falls between 185,87mm (7.318") and 186,13mm (7.328") as specified on the assembly drawing. If the actual dimension is not within the recommended tolerance, contact the SEPCO® Engineering Office before attempting to install the seal.
3. Inspect the end of the shaft/sleeve that the rotary unit will slide over. It should be free of burrs and sharp edges that might nick or damage the static o-ring (Item #8) when the rotary unit is slid onto the shaft/sleeve. A 1/32" minimum chamfer is recommended.
4. Measure the actual OD of the shaft/sleeve to insure it is within the tolerance specified on the assembly drawing. Do not attempt to install the seal if the shaft/sleeve is not within the recommended specifications.
5. Remove the plug from the housing to gain access to the seal cavity.
6. Lubricate the stationary o-ring (Item #10) with a silicon-based lubricant and slide the stationary seat (Item #3) into place as shown in the assembly drawing. Be sure the slot in the seat lines up with the anti-rotation pin installed in the housing.
7. Re-install the housing with the access hole at the 12 o'clock position.
8. Measure the distance from the stationary mating face to the end of the shaft/sleeve and record this dimension.

Note: The Gyro is double-ended with a seal mounted on each end of the equipment. Axial distances from the stationary face to the step will vary so it will be necessary to take and record this measurement for both stuffing boxes in order to accurately set the working length of the seal.

9. Measure back 1-13/16" from the stationary face and scribe a mark on the OD of the shaft through the access hole.
10. Lubricate the static o-ring (Item #8) with a silicon-based lubricant and slide the rotary unit over the end of the shaft. A slight twisting motion while pushing against the lock ring will help to compress the static o-ring and start it over the end of the shaft/sleeve.

Note: Insure the TJS rotating assembly is positioned on the shaft so the rotary seal ring (Item #1) will align to the stationary seat mating face.

11. Slide the TJS rotary assembly in place against the stationary seat and align the back of the lock ring (Item #4) up with the scribe mark that was made in step #9.

Note: It is best to slide the rotary in place with constant pressure instead of striking the lock collar with a foreign object. This practice could cause impact damage to the seal faces.

12. Evenly tighten the (6) 3/8" set screws (Item #5) to the shaft/sleeve with the Allen wrench provided.
13. Subtract the seal working length (1-13/16") from the dimension measured and recorded in step #8.
14. Measure the actual distance from the back of the lock ring to the step. It should equal the result in step #13.
15. Replace the thread tape or o-ring on the access hole plug and tighten sufficiently to prevent leakage.
16. Reassemble the equipment and static test the seal prior to installing it back on-line.

If you need further assistance, please call our Engineering Department at:

1-800-633-4770