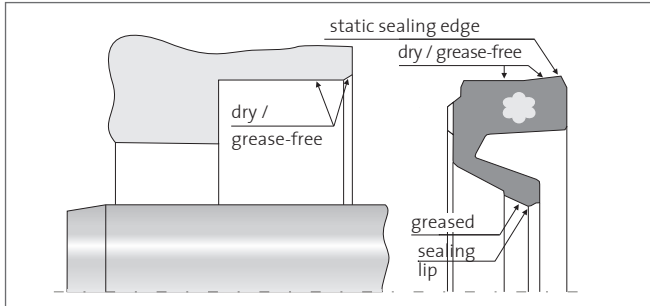


# MERKEL RADIAMATIC RPM 41



## Preparing assembly

Check the bore in the radial shaft seal housing for possible sharp edges, paint residues and impurities – especially on the inserting bevel. The radial shaft seal housing must be free of any grease or oil residues, so as to ensure the retaining function of the seal. Clean the housing, if necessary, using a dry lint-free cloth. Check the Merkel Radiamatic RPM 41 before assembly for any damage possibly sustained in transit. The static sealing edge as well as the sealing lip must be free of damage all over the circumference.

We recommend that the point of junction be placed to the housing's "noon position". If the seal has been stored below the freezing point, it will have to be warmed up to temperatures of over 0 °C before assembly.

## Assembly

The seal is mounted into the fixing bore in dry condition, i. e. no fitting grease or similar agents should be used! Place the radial shaft seal with 2 to 4 loops into the housing diameter, depending on the diameters involved.

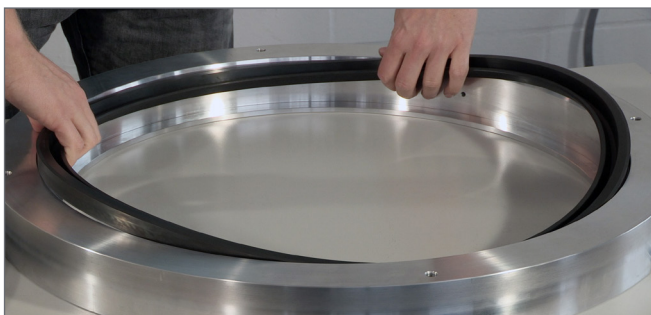


Fig. 1

## Recommendation:

Shaft diameter up to 300 mm: 2 loops  
Shaft diameter up to 600 mm: 3 loops (see Fig. 1)  
Shaft diameter >600 mm: 4 loops

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Now, insert the protruding loops evenly and carefully, using a plastic tip hammer (Fig. 2). Caution! The static sealing edge should not be damaged during such inserting operations!

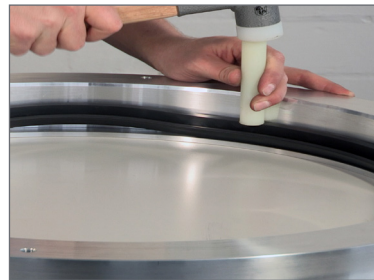


Fig. 2



Fig. 3

Insert the loops evenly all over the circumference with several persons, if necessary. Now, press the radial shaft seal evenly and step by step over the circumference, using an appropriate plastic mandrel (Fig. 3). Only then will it be ensured that the radial shaft seal is seated evenly and concentrically inside the housing.

Any further radial shaft seals should be mounted in the same way.

As a rule, the mounting operations are first performed inside the housing bore, as specified above. Only then will the shaft and/or cylinder liner be mounted.

The cylinder liner is to be provided with a mounting bevel, as described in the brochure. This mounting bevel must be checked and coated with grease before mounting the cylinder liner.

Be careful that the sealing lip is inserted evenly, and that it is not jammed and/or folded back during assembly.

The Merkel Radiamatic RPM 41 may also be mounted directly on the cylinder liner into the housing fixture, as represented on the enclosed figures. However, axial access must be ensured for this purpose. Be careful, here again, that the fixing bore remains free of grease and oil. Only coat the sealing lip with grease before assembly.