

Thank you for choosing Durashield seals. This document illustrates the assembly or re-building of an SD series seal.

**REBUILD & INSTALLATION NOTES:** Before proceeding , if possible uninstall the seal from the machine. Having the seal free of the machine will make the rebuilding process a breeze! Be sure to thoroughly clean the housing removing all processed materials, silicone and other particulates. Assembling the seal on a clean surface is crucial for proper operation. Prior to reassembly verify the housing is free of contaminants which can cause premature seal failure. Denatured alcohol is recommended for degreasing the faceplates prior to reinstallation. Surfaces where RTV is to be applied must be degreased to obtain a proper bond. For re-installation apply a bead of Silicone RTV sealant to the seal and machine end. (Silicone RTV is used to create a surface bond between the machine end and seal) Certain applications may require a seal gasket, If so apply RTV to both sides of the gasket, place the gasket between the seal & machine end. Remove all excess RTV Sealant and verify that RTV does not make contact with the internal moving components of the seal. Use of thread locker or anti-seize is not recommended.

For additional assistance visit [www.durashieldseals.com](http://www.durashieldseals.com) or call 1.877.243.7325

### REQUIRED TOOLS:

- 3/16" SLOTTED HEAD SCREWDRIVER
- 1/8" ALLEN WRENCH / HEX DRIVER
- Denatured Alcohol Solvent or Simple Green
- Silicone RTV Sealant (for installation)
- Clean towel/paper towels
- Tools for seal housing removal (varies per installation)



### SD SERIES PARTS CHECKLIST:

- (1) SD Series Housing (HDPE High Density Polyethylene)
- (2) Stainless Steel faceplates
- (2) Stainless steel wear rings
- (4) Stainless steel compression sleeves
- (1) EPDM Elastomer Boot
- (1) Elastomer Clamp
- (2) Teflon Wear Plates
- 1/8" STAINLESS ALLEN HEAD SCREWS (qty varies per model)



### REBUILD KIT INCLUDES:

2 Stainless steel wear rings, 2 Teflon wear plates

1 EPDM Elastomer, 1 Elastomer clamp & new hardware.

The Seal housing ,Stainless faceplates & compression rings are

to be cleaned & re-used. If a new faceplate or housing is required please contact us & have your seal serial number to order additional parts.

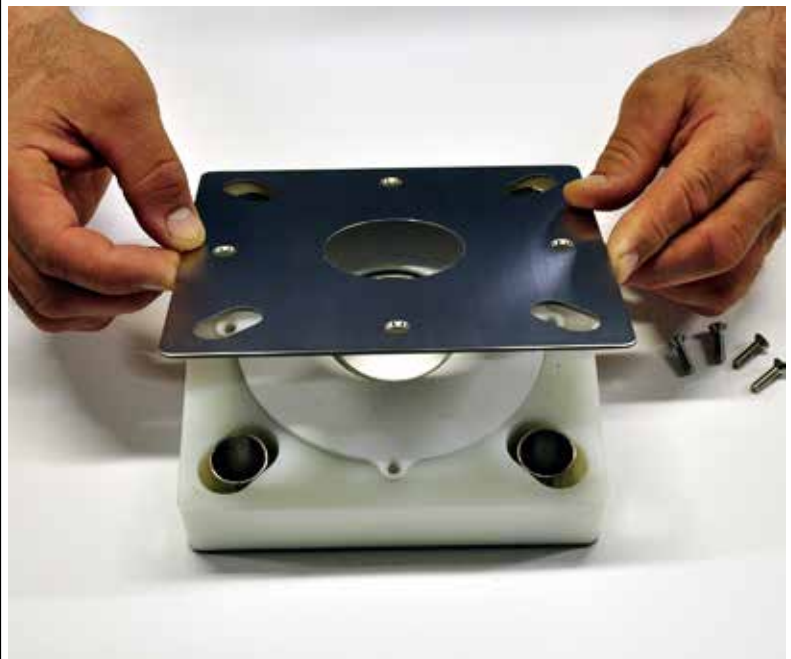
If you require additional assistance with assembly or rebuilding please contact us.

Our support team is available for telephone support Mon-Fri 9:00AM - 4:30PM est. Call toll free 1.877.243.7325 ]

Additional technical illustrations and documents are available at [www.durashieldseals.com](http://www.durashieldseals.com)



**STEP 1:** Remove the face plate screws using a 1/8" Allen / Hex head wrench. Depending on shaft diameter each seal utilizes a different amount of screws.



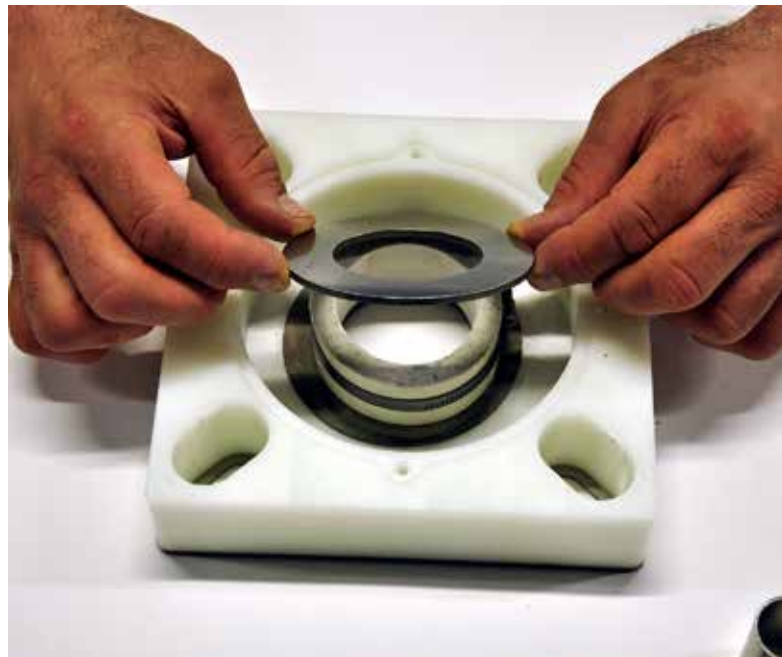
**STEP 2:** With the face plate screws removed you can now remove the outer faceplate. If rebuilding be sure to clean the inside/outside of this plate. Remove any RTV from prior installation. Both faceplates will be reused.



**STEP 3:** Remove the Teflon wear plate. A new plate is included with your Durashield rebuild kit. NOTE: Plates are sacrificial.



**STEP 4:** Inspect all four corners, check for expansion or cracks. Clean this area well (Simple green works well). Make sure the compression rings are clean and free of particulates.



**STEP 5:** With the Faceplate & Teflon wear plate removed the wear ring, elastomer & clamp assembly is accessible. Lift the components from the housing. Flip the housing and repeat steps 1-3. Rebuild kits include Rings, elastomer and clamp assembly. Take note of how these parts fit together.



**STEP 6:** After steps 1-3 have been repeated you should see a bare housing. Be sure to clean this well! Simple green is ideal. The flat surfaces which the wear plates rest in should be free of particulates for proper fitment of the new rebuild kit parts.



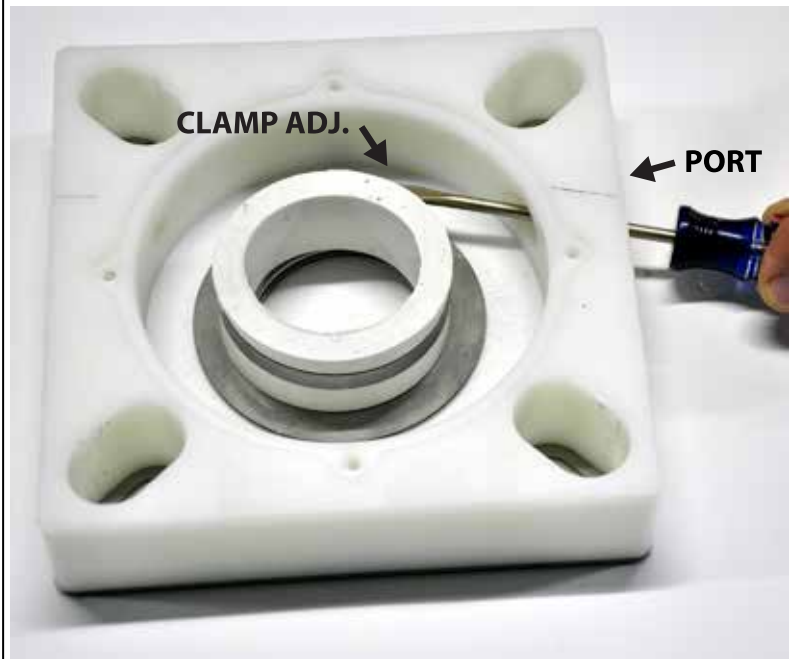
**STEP 7:** Install the new Teflon wear plate.



**STEP 8:** Place the Stainless steel faceplate onto the housing. Reinstall the faceplates screws. NOTE: Make sure counter sinks are in the proper orientation for assembly. (Beveled side out) After this step is complete flip the housing.



**STEP 9:** Place the polished face of the wear ring onto the Teflon wear plate. Using the unpolished side will result in premature seal failure and sealing issues. New wear rings are included with the rebuild kit.



**STEP 10:** Place the New elastomer boot & clamp onto the wear ring. Center the elastomer over the Stainless steel ring as shown. **NOTE:** ALIGN THE ADJUSTING SCREW OF THE ELASTOMER CLAMP WITH THE ACCESS PORT ON THE HOUSING. MAKE SURE THE CLAMP IS CENTERED ON THE ELASTOMER AS SHOWN.



**STEP 11:** Re-install the 4 compression sleeves. If you pitch the sleeve on an angle they pop into the housing with ease. Place the second Stainless wear ring polished side up onto the elastomer as shown.



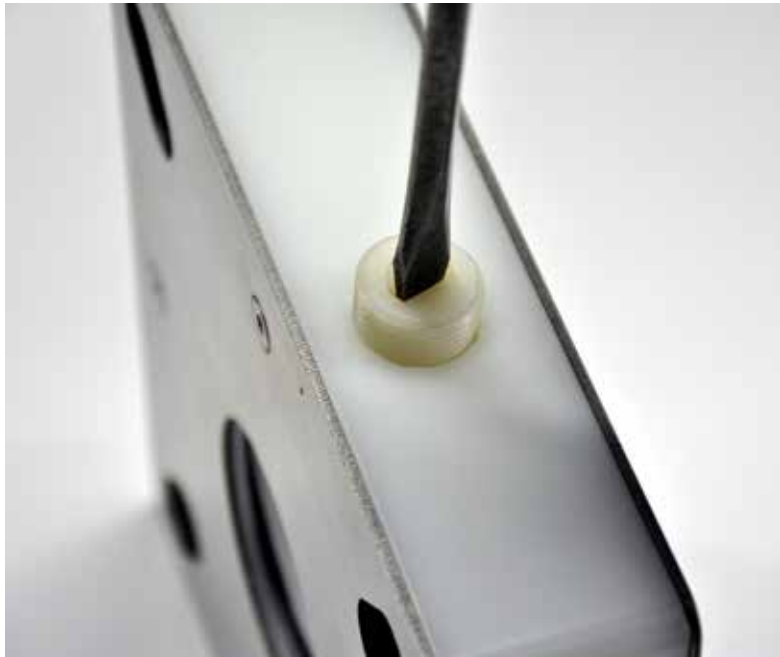
**STEP 12:** Install the new Teflon wear plate.

**STEP 13:** Place the Stainless steel faceplate onto the housing. Reinstall the faceplates screws.

**NOTE:** Make sure counter sinks are in the proper orientation for assembly. (Beveled side out)

**DO NOT OVERTIGHTEN**





**STEP 13:** Reinstall the adjustment port plug.  
Rebuild kits include a new threaded plug.



The SD series seal is now complete and ready for installation. For additional information please visit [www.durashieldseals.com](http://www.durashieldseals.com) or call 1.877.243.7325