

Assembly Instructions for GEN III Rotor with Plunger Pin to Cartridge Sleeve

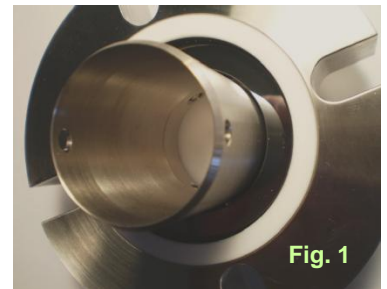
Important!

Before assembling rotor with plunger pins over sleeve, ensure that all pins work properly by pressing (compressing) on the center of the pin(s) evenly against inside of rotor by hand. Repeat 2-3 times.

Caution: Do not tilt or compress pin unevenly! If pins are difficult to compress or get stuck, consult with factory before proceeding to step #1.

Step 1. – Setup

Position seal vertically with the “gland end” resting on a flat surface and the rotor end facing upwards. The assembler should be able to clearly see 2 or 3 holes in cartridge sleeve (Fig.1).



Step 2. – Assembling Rotor w/plunger pins

Note: If at any time during this next step there is excessive resistance felt - Stop as the rotor may be mis-aligned with the sleeve. Start over.

Position rotor over the *chamfered* end of sleeve perpendicular with pins **offset** from holes in sleeve (**Fig.2A**). (Do not line up pins directly with holes.)



Pushing down **gently with fingers**, compress pins against inside of rotor, holding pins in as long as possible, begin to slide rotor slowly over cartridge sleeve until rotor is seated or resting firmly against end of sleeve. Turn rotor until pins engage (snap) into holes in cartridge sleeve (**Fig.2B**).



Ensure that all pins are fully and equally engaged into holes visually (**Fig.2C**). As a final check, try to pull rotor off from sleeve by hand. If rotor moves off from sleeve, pins were not fully locked in. **Visually** check pins, rotor and sleeve. If parts are ok, retry step 2. If unsure, please consult with factory.



Dis-Assembly Instructions for GEN III Rotor with Plunger Pin to Cartridge Sleeve

Important!

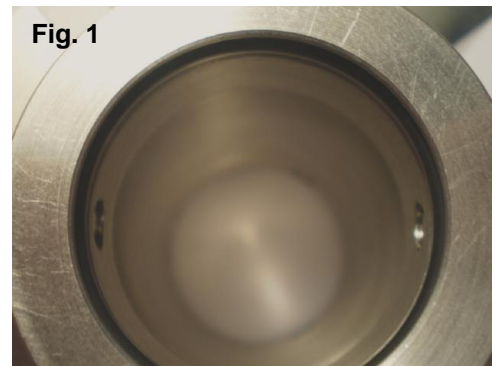
Before dis-assembling rotor with plunger pins from cartridge sleeve, visually inspect pin area for damage, corrosion, contamination etc. Press down on each pin evenly and towards the top as shown using a small tool such as a 1/8" allen wrench or a tool with a soft tip such as brass or hard plastic to ensure that pins move freely as dis-assembly from sleeve could be difficult. Do not over tilt pin or compress pin unevenly.



Step 1. – Setup

Note: Re-installing setting clips on Cartridge Seal Assembly first will provide additional spring force to assist indis-assembly.

Position seal vertically with the “gland end” resting on a flat surface and the rotor end facing upwards. The assembler should be able to see 2 or 3 holes in cartridge sleeve (**Fig.1**).



Step 2. – Dis-assembly- Release 1st pin.

Using same small **tool** previously noted (Allen wrench), press down **evenly** on the top end of one pin firmly so that it bottoms out, while holding this pin down at the same time pull back on rotor so that this pin **dis-engages** from sleeve hole (**Fig.2A**).

Note: Do not try to remove rotor from sleeve at this time as damage will result.

Visually check to see that pin has not sprung back into hole of sleeve. It is **important** to note that while pressing down on pin that you may need to press on side of pin **closest** to you.



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Step 3. – Dis-assembly- Release 2nd (or 3rd) pin.

Using same tool, press down on the top end of 2nd pin firmly and pull back on rotor. If two pin design, the Rotor will easily slide off from cartridge sleeve.

If 3 pin design, ensure that both pins 1 and 2 are still fully compressed and press down on the top end of pin 3. Rotor will slide off from sleeve easily.

If during **removal**, pins should spring back into holes, repeat steps 2 – 3.

If during **dis-assembly** the rotor cannot be removed from sleeve, please consult with factory.

