





## Fitting Guide for Lionsele® U3 — hydraulic seal for pistons


**i** This seal operates with slight axial float. It must not be axially compressed.

**1**  For Health & Safety reasons, shut down the hydraulic system before installing your new seal. **Shut off power**

**2**  Check the seal and housing. Ensure that seal is the correct size and housing is suitable for the seal. **Check sizes of seal & housing**

**3**  Remove old seal, then thoroughly clean the housing. **Remove old seal. Clean the housing**

**4**  Lightly lubricate the seal and the housing with the hydraulic fluid prior to assembly. **Lightly lubricate seal & housing**

**5a Split-type pistons**  Fit the seal well home in exposed housing recess, with grooved side facing positive pressure. Ensure sealing faces are not damaged. **Stretch seal into housing**

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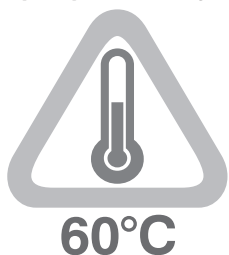
5<sub>b</sub>



Reassemble housing and insert piston carefully into cylinder.

**Reassemble housing & insert piston in cylinder**

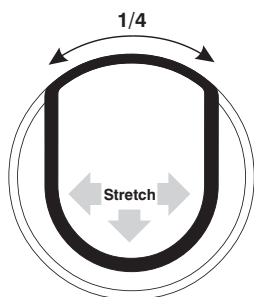
5<sub>a</sub> Semi-open pistons only



Heat seal to 60°C in oil bath or dry oven — take care not to over-heat the seal.

**Heat seal to 60°C maximum**

5<sub>b</sub>



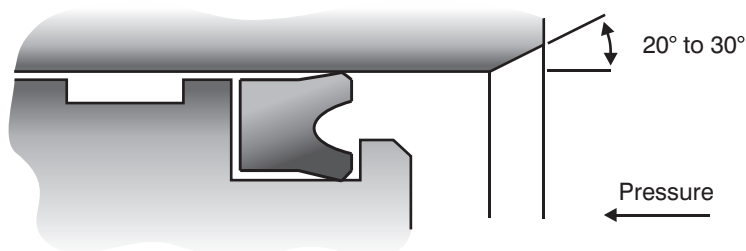
Insert one-quarter of seal circumference firmly into semi-open housing recess with grooved side facing positive pressure.

**Insert 1/4 of seal into recess**

5<sub>c</sub>

Stretch remainder of seal into position and ensure it is firmly seated in housing recess for full circumference. Lower piston carefully into cylinder.

**Insert 3/4 of seal into recess. Insert piston in cylinder**



**Material Safety Data Sheets are available on request**

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