



# Assembly Instructions

## 'D' Series Reciprocating Crosshead Seals 24648A Kit

### REPLACING 7534B1 ASSEMBLY WITH 24648A KIT

This kit is a replacement for the 7534B1 oil seal assembly and can be retrofitted to all D Series Pumps. Initial field installation of these kits will require removal of the fluid end to replace the existing retainer and seals. On some fluid ends it may be necessary to hand grind I.D. of fluid end to fit new kit. It is advisable to check the kit with the fluid end to see if grinding needs to be done. The same spring and gasket is used to hold and seal the retainer. Thereafter only the housings and seals will need to be removed as explained in the next paragraph.

### REPLACING CROSSHEAD ROD OIL SEALS

The rod seal assembly contains two seals, two oil seals with lips facing power end. The oil seal can be replaced without taking the fluid end off by removing the piston and the cylinder liner to allow access for oil seal housing. Unscrew two Allen screws and place into the other two tapped holes. Gradually screw them in to push oil seal housing off the retainer. After assembling new seals in oil seal housing, an assembly thimble should be used on end of crosshead rod for sliding oil seal housing back into retainer. Check gasket and replace if damaged. Fig. 2 shows a recommended thimble for installation. The thimble should be machined from high carbon steel and polished on the exterior to reduce possibility of seal lip damage. Place two Allen screws into clearance holes and tighten snug.

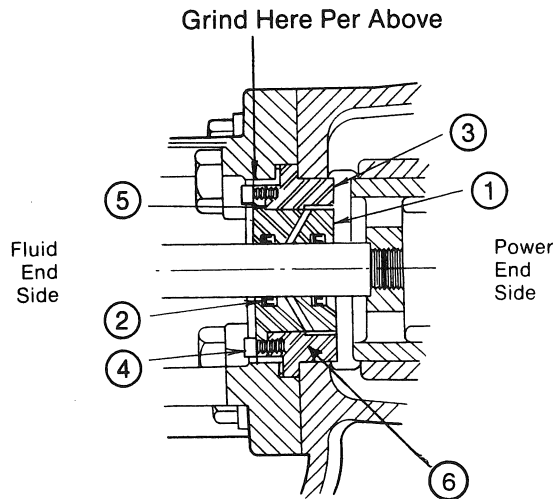


Fig. 1 Oil Seal Housing Assembly

REF. NO.	DESCRIPTION	QTY	PART NO.
1	Housing, oil seal	3	24959A1
2	Oil Seal	6	22835A4
3	Retainer, oil seal housing	3	24958A
4	Screw, Allen	6	6106A34
5	Gasket, seal housing	3	5059A434
6	Gasket	3	5059A58

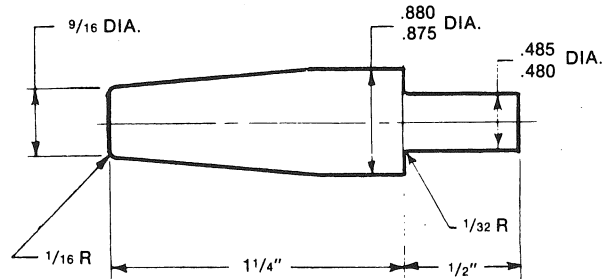


Fig. 2

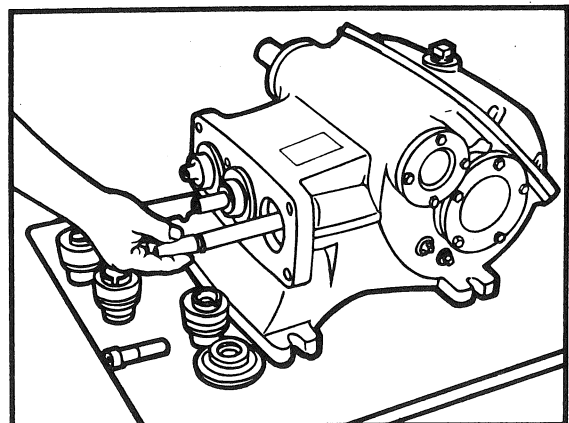


Fig. 3



Pentair Pump Group

F. E. Myers, 1101 Myers Parkway, Ashland, Ohio 44805-1969  
 419/289-1144, FAX: 419/289-6658, www.femyers.com  
 Myers (Canada), 269 Trillium Drive, Kitchener, Ontario N2G 4W5  
 519/748-5470, FAX: 519/748-2553