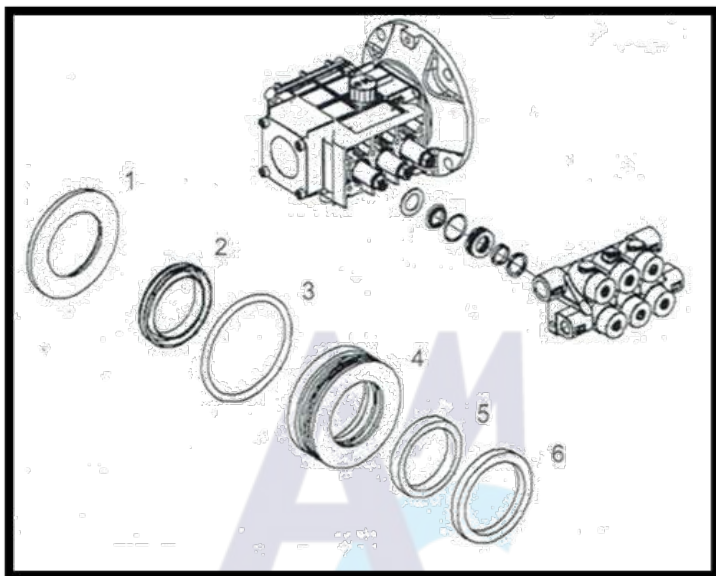


SRC HPP Seal Kit

B653090001



CONTENTS

ITEM	PART NUMBER	DESCRIPTION	QTY
1	12180510CO-30	Seal Retainer	3
2	12180510CO-31	Low Pressure Seal	3
3	12180510CO-32	O-ring Seal Case	3
4	12180510CO-33	Seal Case	3
5	12180510CO-34	Square Ring, High Pressure Seal	3
6	12180510CO-35	Glide Ring, High Pressure Seal	3
		Seal Installation Tool	1
		Tool Guide	1
7	12180510CO-26	O-ring Plunger	3
8	12180510CO-25	Anti-Extrusion Ring	3
		R.O. Seal Installation Tool	1

REPLACING PACKINGS USING SRC HPP Seal Kit

1) Remove head bolts using 5mm hex wrench and slide manifold away from crankcases. (It is normal for some packing assemblies to remain on the plungers).

Note: it may be necessary to rotate crankshaft and/or use pry bars to separate manifold from crankcase.

2) Inspect plungers for cracks, scoring or build-up and replace/clean as needed.

3) Insert 18 mm extractor collet through seal retainer. Tighten collet and extract packing assembly from manifold. Clean and inspect cavity for unusual wear, cracks, etc.

4) **Note: do not grease any portion of the packing assembly during this process.** Set high pressure seal insertion collar in manifold cylinder. Assemble Glide rings (position 5 & 6) and gently place inside cylinder tool so they are resting evenly. Insert pusher tool and firmly press down to set packing in manifold.

5) Set insertion collar over seal casing (position 4) and ensure recess for seal is facing upwards. Gently place low pressure seal (position 2) into collar ensuring the spring side of the seal is facing downward and resting evenly. Insert pusher tool into collar and firmly press down to set seal in casing.

6) Install o-ring (position 3) so it's properly seated in the casing groove that doesn't have through holes. Installation in the wrong groove will impede the flow of cooling water resulting in premature seal failure.

7) Place seal case into manifold cylinder with low pressure seal facing upwards. Firmly press into cylinder until properly seated and repeat for each cylinder.

8) Slide seal retainer ring over the plunger until seated in crankcase. Ensure ring is positioned so crankcase opening will receive aligned portion.

Note: a small amount of silicone grease on the back side of the retainer ring will help secure it in place.

9) Apply a light coating of silicone grease to each plunger, then rotate crankshaft so center plunger is furthest forward.

10) Slide manifold assembly on to center plunger first, then align to outer plungers while pushing towards crankcase. **Note: a pair of make shift 6mm alignment pins will minimize chance of seal damage at this point.**

11) Once manifold is properly seated, install head bolts and begin torque sequence. Tighten to 10.8 Nm or 8.0 Ft-lbs.