

Foreword

These instructions are provided to familiarise the user with the seal and its designated use. The instructions must be read and applied whenever work is done on the seal and must be kept available for future reference.

ATTENTION These instructions are for the installation and operation of a seal as used in rotating equipment and will help to avoid danger and increase reliability. The information required may change with other types of equipment or installation arrangements. These instructions must be read in conjunction with the instruction manuals for both the rotating equipment and any ancillary equipment.

If the seal is to be used for an application other than that originally intended or outside the recommended performance limits, John Crane must be contacted before its installation and use.

Any warranty may be affected by improper handling, installation or use of this seal. Contact John Crane for information as to exclusive product warranty and limitations of liability.

If questions or problems arise, contact your local John Crane Sales/Service Engineer or the original equipment manufacturer, as appropriate.

ATTENTION John Crane mechanical seals are precision products and must be handled appropriately. Take particular care to avoid damage to lapped sealing faces and flexible sealing rings. Do not excessively compress the seal before or during installation.

Safety instructions

1. The following designations are used in the installation instructions to highlight instructions of particular importance.

NOTE Refers to special information on how to install or operate the seal most efficiently.

ATTENTION Refers to special information or instructions directed towards the prevention of damage to the seal or its surroundings.



Refers to mandatory instructions designed to prevent personal injury or extensive damage to the seal or its surroundings.

2. Installation, removal and maintenance of the seal must be carried out only by qualified personnel who have read and understood these installation instructions.
3. The seal is designed exclusively for sealing rotating shafts. The manufacturer cannot be held liable for use of the seal for purposes other than this.
4. The seal must only be used in technically perfect condition and must be operated within the recommended performance limits in accordance with its designated use set out in these installation instructions.
5. If the pumped fluid is hazardous or toxic, appropriate precautions must be taken to ensure that any seal leakage is adequately contained. Further information on sealing hazardous or toxic fluids should be obtained from John Crane prior to seal installation.
6. Fluorocarbon components should never be burned or incinerated, as the fumes and residues are highly toxic. If fluorocarbons are

accidentally heated above 400° C (750° F), they can decompose. Therefore, protective gloves should be worn as hydrofluoric acid may be present.

7. PTFE components should never be burned or incinerated as the fumes are highly toxic.

Storage and transportation

1. Mechanical seal assemblies and component parts must be treated with extreme care to protect them from damage due to handling and deterioration. In all cases if established company procedures differ from the instructions provided in this document, the established procedures shall be followed.
2. Warehouse shelf storage:
 - a. John Crane mechanical seals and components are packaged to protect them from airborne dirt and grit, as well as from mishandling. If the packaging is removed for inspection, it should be replaced. Seals are generally packaged dry. Elastomer shelf-life can be a factor if the storage period is in excess of two years.
 - b. If storage is in excess of one year, it is recommended that the primary and mating rings be inspected for flatness prior to installing the seals into the pump.

Before starting the equipment

1. Check the machine at the coupling for proper alignment of the driver or motor.
2. Ensure that the gland plate nuts/bolts are evenly tightened according to the pump manual instructions, and all screws are securely fastened.
3. Complete the assembly of the equipment and ensure and turn the shaft (by hand if possible) to ensure free rotation.
4. Consult all available equipment operating instructions to check for the correctness of all piping and connections, particularly regarding seal recirculation/flush, heating or cooling requirements, and services external to the seal.

ATTENTION This mechanical seal is designed to operate in a liquid, so the heat energy it creates is adequately removed, and therefore the following check should be carried out not only after seal installation, but also following a period of shut-down.

5. Check that the seal chamber fluid lines are open and free of any obstruction and ensure that the seal chamber is fully vented.

ATTENTION Dry running is often indicated by a squealing noise from the seal area and will cause overheating, and scoring, or other damage to the sealing surfaces, resulting in excessive leakage or a much-shortened seal life.



Before start-up, ensure that all personnel and assembly equipment have been moved to a safe distance so there is no contact with rotating parts on the equipment, seal, coupling, or motor.



TYPE 8B1 IOM

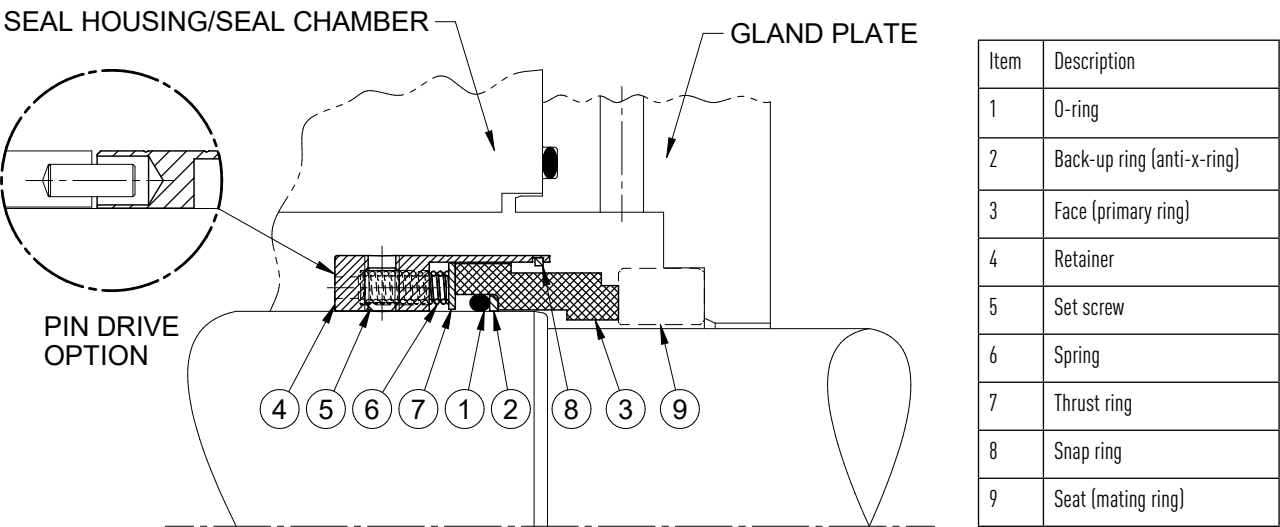
MECHANICAL SEAL

Installation, Operation & Maintenance Instructions

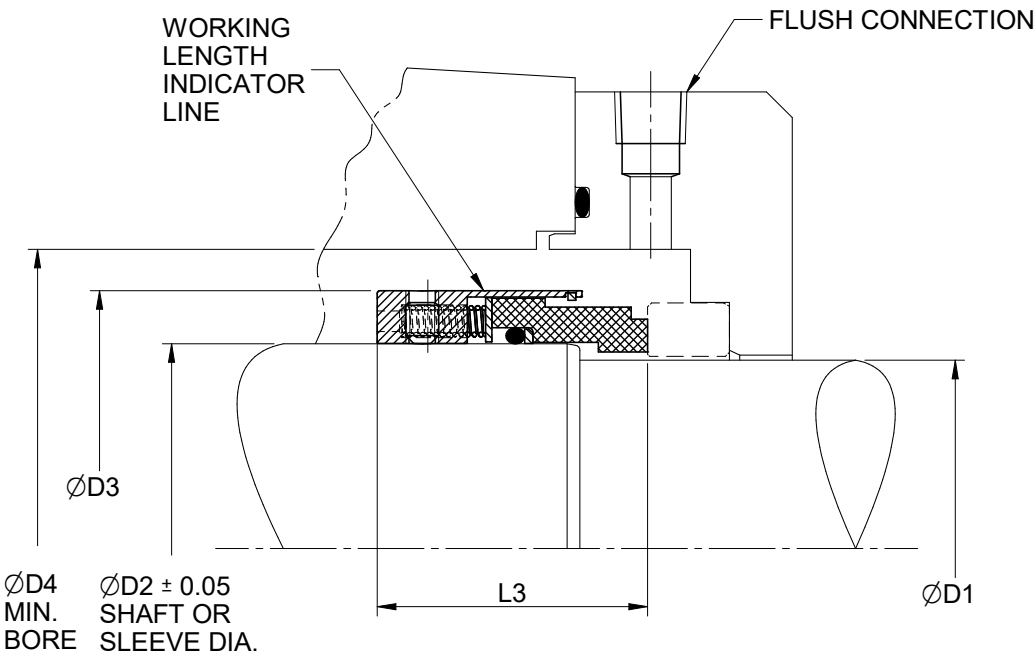
WARNING Seal installation should be handled only by qualified personnel. If questions arise, contact the local John Crane representative. Improper use and/or installation of this product could result in injury to the person and/ or harmful emissions to the environment and may affect any warranty on the product. Please contact the company for information as to the exclusive product warranty and limitations of liability.

- GENERAL INSTRUCTIONS**
1. Study the engineering layout drawing to confirm the proper seal arrangement for the equipment being used. The following instructions describe the standard configurations.
 2. To ensure satisfactory operation, handle the seal with care. Take particular caution to see that the lapped sealing faces are not scratched or marred.

Typical arrangement Type 8B1



Typical installation of Type 8B1





TYPE 8B1 IOM

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Type 8B1 dimensional data (mm)

Seal size (inches)	Seal size code	D1	D2	D3	D4	L3
0.625	0158	12.70	15.87	30.8	34	27
0.750	0190	15.87	19.05	34.0	37	30
0.875	0222	19.05	22.22	37.2	40	32
1.000	0254	22.22	25.40	40.3	43	33
1.125	0285	25.40	28.58	43.4	46	35
1.250	0317	28.57	31.75	48.3	51	35
1.375	0349	28.57	34.93	51.3	54	37
1.500	0381	31.75	38.10	54.5	58	37
1.625	0412	34.92	41.28	60.8	64	45
1.750	0444	38.10	44.45	64.0	67	45
1.875	0476	41.27	47.63	67.2	70	45
2.000	0508	44.45	50.80	70.4	73	45
2.125	0539	47.62	53.98	76.7	80	52
2.250	0571	50.80	57.15	79.9	83	52
2.375	0603	53.97	60.33	83.1	86	52
2.500	0635	57.15	63.50	86.2	89	52
2.625	0666	60.32	66.68	89.4	92	52
2.750	0698	63.50	69.85	92.6	96	52
2.875	0730	66.67	73.03	95.8	99	52
3.000	0762	69.85	76.20	97.3	100	52
3.125	0793	73.02	79.38	100.5	104	52
3.250	0825	76.20	82.55	105.3	108	52
3.375	0857	79.37	85.73	108.5	111	52
3.500	0889	82.55	88.90	111.6	115	52
3.625	0920	85.72	92.08	114.8	118	52
3.750	0952	88.90	95.25	118.0	121	52
3.875	0984	92.07	98.43	121.2	124	52
4.000	1016	95.25	101.60	124.3	127	52
4.125	1047	98.42	104.78	130.2	134	52.4
4.250	1079	101.60	107.95	133.4	137	52.4
4.375	1111	104.77	111.13	136.5	140	52.4
4.500	1143	107.95	114.30	140.0	143	52.4
4.625	1174	111.12	117.48	142.9	146	52.4
4.750	1206	114.30	120.65	146.1	149	52.4
4.875	1238	117.47	123.83	149.2	153	52.4
5.000	1270	120.65	127.00	152.4	156	52.4
5.125	1301	123.82	130.18	155.6	159	52.4
5.250	1333	127.00	133.35	165.1	168	60.3
5.375	1365	130.17	136.53	168.8	172	60.3
5.500	1397	133.35	139.70	171.5	175	60.3
5.625	1428	136.52	142.87	174.6	178	60.3
5.750	1460	139.70	146.05	177.8	181	60.3
5.875	1492	142.87	149.23	181.0	184	60.3
6.000	1524	146.05	152.40	184.2	188	60.3



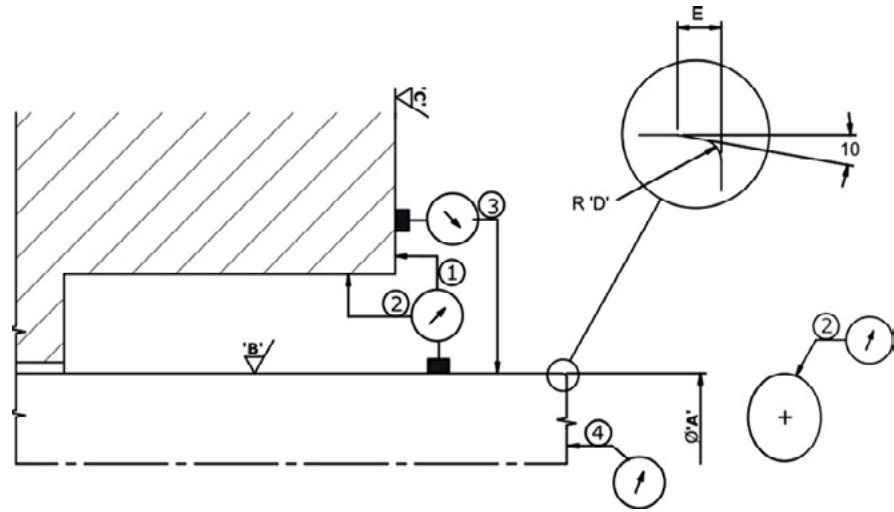
TYPE 8B1 IOM

MECHANICAL SEAL

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Checking the equipment

- A. Seal size
- B. 0.3-0.6 μm Ra
12-24 μinch Ra
- C. 1.6-3.2 μm Ra
63-125 μinch Ra
- D. 1.0 mm/0.040 inch
- E. 2.5 mm/0.098 inch
Shaft tolerance - h6



1	2	3	4
Squareness of shaft to seal chamber face	Concentricity seal chamber bore to shaft	Shaft runout	Shaft end play
$<0.08 \text{ mm FIM, speed} \leq 1,800 \text{ RPM}$ $<0.05 \text{ mm FIM, speed} > 1,800 \text{ RPM}$ $<0.003\text{-inch FIM, speed} \leq 1,800 \text{ RPM}$ $<0.002 \text{ inch FIM, speed} > 1,800 \text{ RPM}$	$<0.15 \text{ mm FIM}$ $<0.006 \text{ inch/FIM}$	$<0.08 \text{ mm FIM, speed} \leq 1,800 \text{ RPM}$ $<0.05 \text{ mm FIM, speed} > 1,800 \text{ RPM}$ $<0.003\text{-inch FIM, speed} \leq 1,800 \text{ RPM}$ $<0.002 \text{ inch FIM, speed} > 1,800 \text{ RPM}$	$<0.08 \text{ mm FIM}$ $<0.003 \text{ inch/FIM}$

NOTE If the measured dimensions exceed these values given, correct the equipment to meet the specifications prior to seal installation.

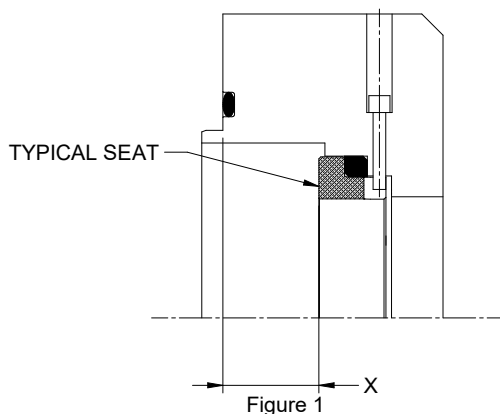
Setting the seal

The seal must be installed to its correct working length L3. Setting procedure is described with respect to a fitted sleeve.

ATTENTION If L3 is overlength, the seal will be under-compressed and will leak; if L3 is under length, the seal will be over-compressed, and this will cause dry running and high wear of the seal faces.

Find the true seal position as follows:

1. Refer to the appropriate seat (mating ring) instruction manual to obtain dimensions "X" from the face of the gland plate to the seat mating surface (Figure 1).



2. With the sleeve in its working position, mark the surface at "Y" in line with the seal housing end face, mark the sleeve again at "Z" the obtained distance away from the face position (Figure 2). This second mark is a datum for the seal working length L3.

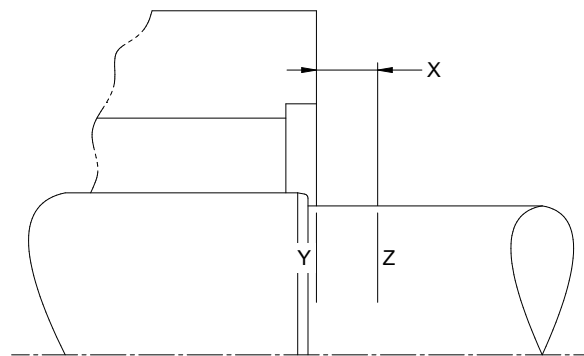


Figure 2

Installation, Operation & Maintenance Instructions

- From the dimension tables find dimension L3 for the size of seal being fitted and measure the distance back from position "Z" (Figure 3). The new marked position is the point on the sleeve where the back of the seal is to be located. After marking, the sleeve must be removed for seal installation.

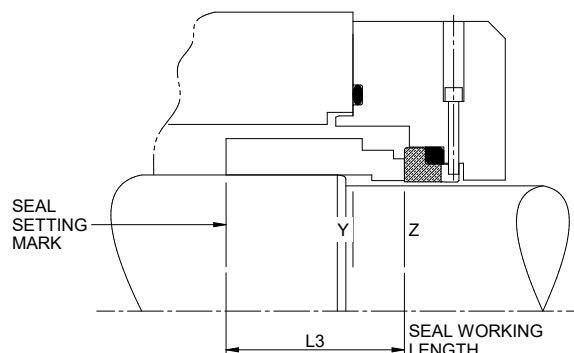


Figure 3

Installing the seal

- Before installing the mechanical seal read the instructions carefully. Keep for future use. Seal installation must only be carried out by a suitably qualified person.
- Check that the machine is clean and meets the fitting tolerances shown in the figure above.
- Remove the protective packaging from the seal, inspect for damage, wipe clean.
- Fit the seal into the gland plate as described in the seal instruction manual. Check that the gland plate O-ring or gasket is in position and will not be displaced during fitting and then position gland plate on the shaft.

NOTE Use a suitable lubricant when fitting the seal. The recommended lubricants for an elastomer O-ring are soft hand soap and water, glycerine, or silicone grease; do not use washing-up liquid, liquid soaps, or hand cleaning gels. Light mineral oil may be used with most elastomers.

ATTENTION Do not use hydrocarbon-based liquids on ethylene propylene elastomers.

- Clean and sparingly lubricate the shaft and sleeve.

ATTENTION Particular care should be taken when passing the seal over the sleeve shoulder to avoid impact and consequent damage to the stepped bore of the seal face.

NOTE The seal is designed for two alternative methods of drive set screwed onto the sleeve, or pin-driven via a collar or sleeve ring abutment.

- Set screw driven seals:** Adjust the set screws until clear of the retainer bore. Fit the seal until onto the sleeve, making sure that the back of the retainer is in line with the seal setting mark. Lightly tighten the set screws to hold the seal in the setting position, then continue to tighten the screws evenly and progressively to the torque recommended in the torque table.

ATTENTION Accurate torque settings will avoid set screw damage and eliminate seal movement in operation.

Pin-driven seals: Remove and discard all the set screw from the retainer. With the pin-drive in position, fit the seal unit onto the sleeve and against the abutment, positively engaging the drive pin.

- Wipe the lapped surface of the seal perfectly clean, then fit the sleeve and seal assembly to the shaft, taking care to lift the gland plate and avoid contact while passing the sleeve through the bore.
- Install the seal housing; then locate the gland plate squarely on the fixing studs and pull on the plate to compress the seal as necessary to fit the retaining nuts.
- Apply the correct torque to the nuts as advised by the pump instruction manual.

NOTE If the seal is visible after installation, a setting length check can be made. The setting is correct if the rear surface of the thrust ring as seen through the seal retainer holes is lined up with the external line cut in the retainer wall.

Recommended torques for set screws

Set screw size (imperial)	Set screw size (metric)	Torque	
		Nm	lbf ft
#10-24 or #10-32	M5	3	2.2
1/4-20 or 1/4-28	M6	4	3.0
5/16-18 or 5/16-24	M8	11	8.0
3/8-16 or 3/8-24	M10	16	12

The torque values given above are for 316 stainless steel cup point set screws.



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Maintenance

During operation, periodic inspection of the seal should be carried out. A measure of seal condition is the level of leakage, and as no maintenance is possible while installed, the seal should be replaced when leakage becomes unacceptable. It is recommended that a spare seal unit and seat are held in stock to allow immediate replacement of a removed seal.

It is recommended that used seals are returned to a John Crane Seal Rebuilding Centre, as rebuilding to as-new specifications must be carried out by qualified personnel.



It is the responsibility of the equipment user to ensure that any parts being sent to a third party have appropriate safe handling instructions externally attached to the package.

This seal has been assembled in accordance with John Crane Quality Assurance Standards, and with proper maintenance and use will give safe and reliable operation to the maximum recommended performance as shown in any relevant approved John Crane publication.

Instructions for the handling, packaging, storage and transport of seal units given in the John Crane Instruction Sheet ref. **I-Storage**, available on request.

Decommissioning the equipment

1. Ensure that the pump is electrically isolated.



If the equipment has been used on toxic or hazardous fluids, ensure that the equipment is correctly decontaminated and made safe prior to commencing work. Remember, that fluid is often trapped during draining and may be present inside the seal chamber. The pump instruction manual should be consulted to check for any special precautions.

2. Ensure that the pump is isolated by the appropriate valves. Check that the fluid is drained and pressure fully released.

Removing the seal

1. Referring to the pump instruction manual, dismantle the equipment sufficiently to expose the gland plate and seal housing.
2. Evenly slacken and remove the gland plate nuts and carefully slide the plate off the studs.
3. Remove the seal housing and then complete the removal of the seal and the gland plate assembly, in the reverse order of installation.

NOTE

Although the original seal position may be marked on the shaft or sleeve as a reference point before seal removal, the location must be checked even if the same seal and seat specification is intended as a replacement.

A seal unit should always be serviced after removal from duty.

Quality assurance

This seal has been assembled in accordance with John Crane Quality Assurance Standards and with proper machine maintenance and use will give safe and reliable operation to the maximum recommended performance as shown in any relevant approved John Crane publication.

Please visit www.johncrane.com for material options and operating limits.



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Singapore
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If the products featured will be used in a potentially dangerous and/or hazardous process, your John Crane representative should be consulted prior to their selection and use. In the interest of continuous development, John Crane Companies reserve the right to alter designs and specifications without prior notice. It is dangerous to smoke while handling products made from PTFE. Old and new PTFE products must not be incinerated. ISO 9001 and ISO14001 Certified, details available on request.