



Installation of bottom pan and absorber pan divider seals

Sealing the centre divider between the bottom pan and the absorber requires silicone rubber strips on each part that compress on each other when the parts are assembled and the cylinder assembly is latched closed.

The Bottom Pan seal

The bottom pan seal is siliconed (PN 3005012 RTV Silicone 108) down the center of the bottom pan over the 4 holes that were previously used to anchor the seal in place with the help of an alignment jig and two clamps. It is suggested that this be done early in any field service so the RTV will have time to set while other work is performed.



1. Wipe the surface of the bottom pan with a degreasing agent, here we have used alcohol.

2. Wipe the surface of seal PN 200A5413 with your degreaser.

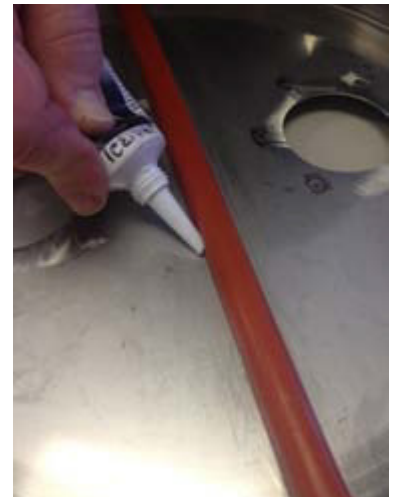
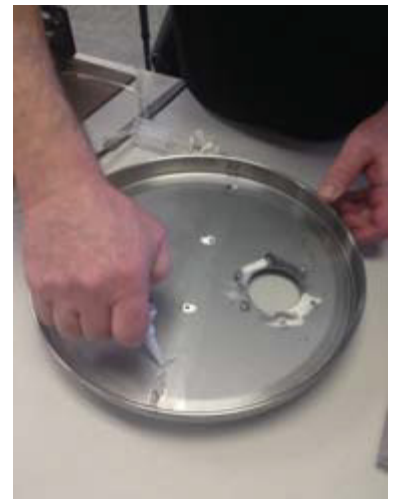
3. Place a thin bead of silicone down the centre of the bottom pan from edge to hole to hole eventually arriving at the opposite edge. Smooth the bead out with your finger and be sure there is silicone around each hole.



4. Place silicone in each end of the seal and smear it over the end surface. **This is important** to keep contaminants out of the seal interior where it cannot be effectively cleaned.

5. Place the seal with the flat side downwards over the silicone and press into place.

6. Set aside for 1 hour untouched while proceeding to the seal on the absorber pan and/or other service work.



7 Apply a small bead of silicone to both sides of the seal. Use your finger to smooth the bead and wipe off the excess silicone.

8 Be sure the ends are siliconed so no gas can leak around the ends.



The Absorber Pan seal and guards

1. Clean both the interior of the absorber pan seal channel and the bottom (flat part of the absorber pan divider seal (PN 200A5412 which is part of the Absorber Pan Divider Seal Kit PN 200A5414) with a degreaser.



2. Apply a thin bead of silicone down the centre of the Absorber Pan Seal Channel then smooth it wider and thinner with your finger.
3. Apply silicone in and over the end of the seal. Remember this is important to keep contaminants out of the seal interior where it cannot be effectively cleaned.



4. Place the seal in the seal channel. Be careful to press it in evenly along its entire length such that the flat bottom of the seal is flat against the seal channel.
5. Use a thin line of RTV sealant along the outer edge of the seal channel then press the neoprene edge trim (PN 200A5405 which is also part of the Absorber Pan Divider Seal Kit PN 200A5414) over the edge of the seal channel as pictured.



Press the trim on at every point to prevent a wavy installation.

6. Repeat on the opposite side.
7. After one hour put the absorber pan back in the machine and close the cylinder assembly to press all pieces together for the duration of the curing process.