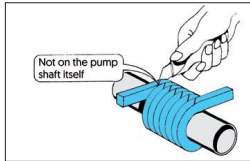


1. Disassembly

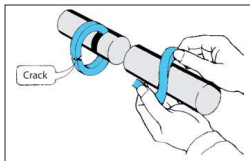
Remove the old packing and clean the packing chamber and shaft/spindle. Make sure the shaft is clean and undamaged and has the recommended roughness (pump shaft $R_t \leq 2 \mu\text{m}$ / stuffing box $R_t \leq 16 \mu\text{m}$).



2. Preparation

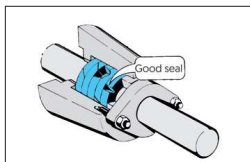
Choose the correct type and size of gasket and cut the rings to the correct length.

- With gasket cutter:** adjust to desired shaft diameter and gasket size. Pull the gasket from the spool into the gasket cutter. Press the clamp in. Cut off the front end of the gasket and reinsert the gasket. The gasket cutter is now set for cutting the correct lengths. Check the first ring in the stuffing box. If necessary, adjust the cutter slightly by a small amount, so that the packing ends are in contact. (oversize up to $\varnothing 50\text{mm}$ = approx. 2mm; above $\varnothing 50\text{mm}$: approx. 3mm)
- Without gasket cutter:** Wrap the gasket around a shaft or pipe of the correct diameter. The rings can then be cut diagonally. If the gasket starts to fray, use ptfе tape to protect the ends.



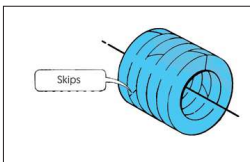
3. Mounting

Mount ring by ring, each ring first with the connecting seam in the packing box. Every next ring must be turned at least 60° compared to the previous ring. Press the rings together with a packing gland and tighten the packing to form a good seal. Loosen packing gland nuts and tighten by hand only, before start-up.



4. In operation

In the beginning, a high leakage is necessary. The recommended leakage pressure is 1.05 to 2 times the pressure of the medium. The minimum pressure required is $0.5 - 1.5 \text{ N/mm}^2$. When the packing gets too hot, the pump should be stopped and the nuts loosened. After a while a regular dripping should be observed and the pump can be restarted. This procedure may need to be repeated a few times before regular leakage occurs. A leakage of 10 - 20 drops per minute is recommended.



For valves, a leakproof seal is desirable. The stuffing box must be tightened before applying pressure to the system. For liquids and gases, the operating pressure should be 2 times or 5 times the pressure of the medium. A minimum pressure of 5 N/mm^2 is required.

Warning!

The gland packing may only be used for pump and valve applications according to the packing specification indicated on the label. Use of the gasket must be in accordance with the instructions only. Do not apply the maximum values simultaneously.

