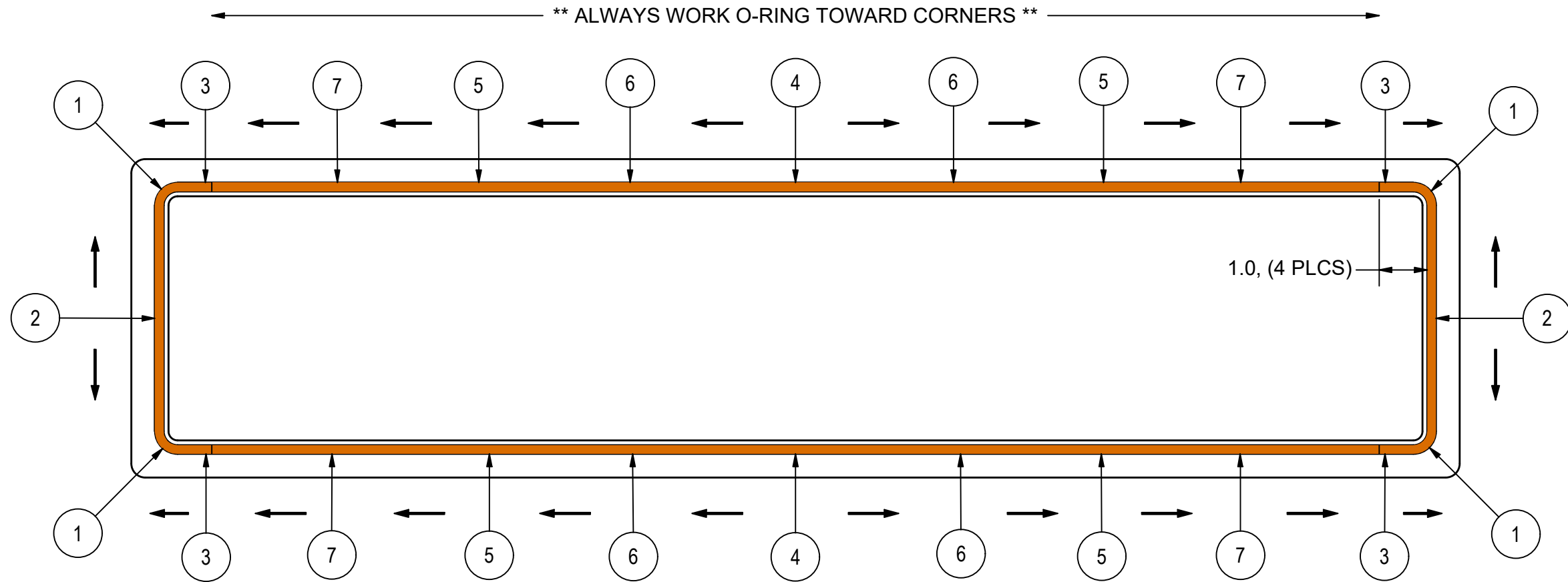


INSTALLATION PROCEDURE:

1. LUBE O-RING WITH A SMALL AMOUNT OF VACUUM COMPATIBLE GREASE.
2. LAY O-RING EVENLY ALONG THE TOP OF THE O-RING GROOVE.
3. PUSH THE O-RING INTO THE GROOVE AT THE CORNERS, AT POINT #1, (4 PLCS) THEN POINT #2, (2 PLCS).
4. PUSH THE O-RING INTO THE GROOVE AT POINT #3, APPROXIMATELY 1.0" FROM THE END (4 PLCS).
5. WORK SEGMENT 3-1 INTO GROOVE, BY STARTING AT POINT #3 AND WORKING IT TOWARD THE CORNER #1.
6. WORK SEGMENT 2-1 INTO GROOVE, BY STARTING AT POINT #2 AND WORKING IT TOWARD THE CORNER #1.
7. REPEAT STEPS #5 & #6 FOR THE REMAINING 3 CORNERS.

INSTALLATION PROCEDURE, CONT'D:

8. DIVIDE EACH STRAIGHT SECTION IN HALF, PRESSING THE O-RING INTO THE GROOVE AT POINT #4, (MIDDLE, 2 PLCS).
9. HALF EACH SECTION AGAIN, PRESSING THE O-RING INTO THE GROOVE AT POINT #5, (4 PLCS).
10. HALF EACH SECTION AGAIN, PRESSING THE O-RING INTO THE GROOVE AT POINTS #6 AND #7, (4 PLCS, EACH).
11. STARTING WITH ONE OF THE 3-4 SEGMENTS, FOLLOW THE STEPS BELOW:
12. WORK SEGMENT 7-3 INTO GROOVE, BY STARTING AT POINT #7 AND WORKING IT TOWARD THE CORNER #3.
13. WORK SEGMENT 5-7 INTO GROOVE, BY STARTING AT POINT #5 AND WORKING IT TOWARD THE CORNER #7.
14. WORK SEGMENT 6-5 INTO GROOVE, BY STARTING AT POINT #6 AND WORKING IT TOWARD THE CORNER #5.
15. WORK SEGMENT 4-6 INTO GROOVE, BY STARTING AT POINT #4 AND WORKING IT TOWARD THE CORNER #6.
16. REPEAT STEPS #12 THRU 15 FOR THE REMAINING 3-4 SEGMENTS, (3 PLCS)



LINEAR O-RING INSTALLATION GUIDE

NO.	DATE	REVISION	BY

TOLERANCES (UNLESS OTHERWISE SPECIFIED)	
LINEAR (IN.) FRACTIONAL = ± 1/64	LINEAR (MM) NO DECIMAL = ±0.5
2 PLACE DECIMAL = ±0.01	1 PLACE DECIMAL = ±0.1
3 PLACE DECIMAL = ±0.005	2 PLACE DECIMAL = ±0.01
4 PLACE DECIMAL = ±0.0005	
ANGULAR	
DEGREES = ±1°	
DEGS, MINS = ±00°,30'	
DEGS, MINS, SECS = ±00°,00',30"	

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DRAWN BY: JWhalen	DATE: 10/4/2022
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APVL. BY:	DATE:
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PART NO.:	

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