



Installation procedures for SpeedySleeve

For part numbers: #034-15Z-S, #034-15Z-S-DSL, #067-26Z-A-S, #068-26Z-A-S, #068-26Z-B-S, #076-15Z-S & #090-31Z-S

Installation procedure

1. Clean the seal surface on the shaft. File down any burrs or rough spots and make sure that the sleeve will not be installed over keyways, cross holes, splines or similar.
2. Determine where the sleeve must be positioned to cover the worn area. Measure to the exact point, or mark directly on the surface. The sleeve must be placed over the worn area, not just bottomed or left flush with the end of the shaft.
3. Shallow wear grooves do not require filling. Optionally, a light layer of a non-hardening sealant can be applied to the inside surface of the sleeve. Clean away sealant that migrates to the shaft or sleeve outside surface.
4. If the shaft is deeply scored, fill the groove with a epoxy-type filler. Install the sleeve before the filler hardens, enabling the sleeve to wipe off any excess filler. Clean away any remaining filler from the sleeve outside surface.
5. DO NOT USE HEAT TO INSTALL THE SLEEVE.
6. If the flange needs to be removed after installation, cut it from the outside diameter into the radius in one location. The flange end of the sleeve goes on the shaft first. Then, place the installation tool over the sleeve (figure 1).
7. Gently tap the center of the installation tool until the sleeve covers the worn shaft surface (figure 2). If the installation tool is too short, a length of pipe or tubing with a squared-off, burr-free end can be used. Be sure that the inside diameter of the pipe is the same as that of the installation tool. Use care not to scratch the precision ground sleeve's outside surface.
8. *The SpeedySleeve* should always be installed so that the outside edge of the sleeve is seated on the full shaft. It must not rest in or outside the chamfer area since the sharp edge will likely cut the sealing lip during seal installation (figure 3).
9. If the flange was cut for removal, use a pair of long-nosed pliers to grasp the flange away from the sleeve and twist it into a coil, being careful not to lift the end of the sleeve off the shaft or it will leave a jagged edge. Flange removal must be done with care to avoid damage to the outside diameter of the sleeve.
10. After the sleeve is installed, check again for burrs that could damage the seal.
11. Lubricate the sleeve before installing the seal.
12. Proceed with seal installation.



Figure 1

Place SpeedySleeve on the shaft and then place the special installation tool over the sleeve.



Figure 2

Tap the installation tool with a mallet until the sleeve is seated on the shaft over the marked area. Remove the installation tool.



Figure 3

Properly installed with flange intact.