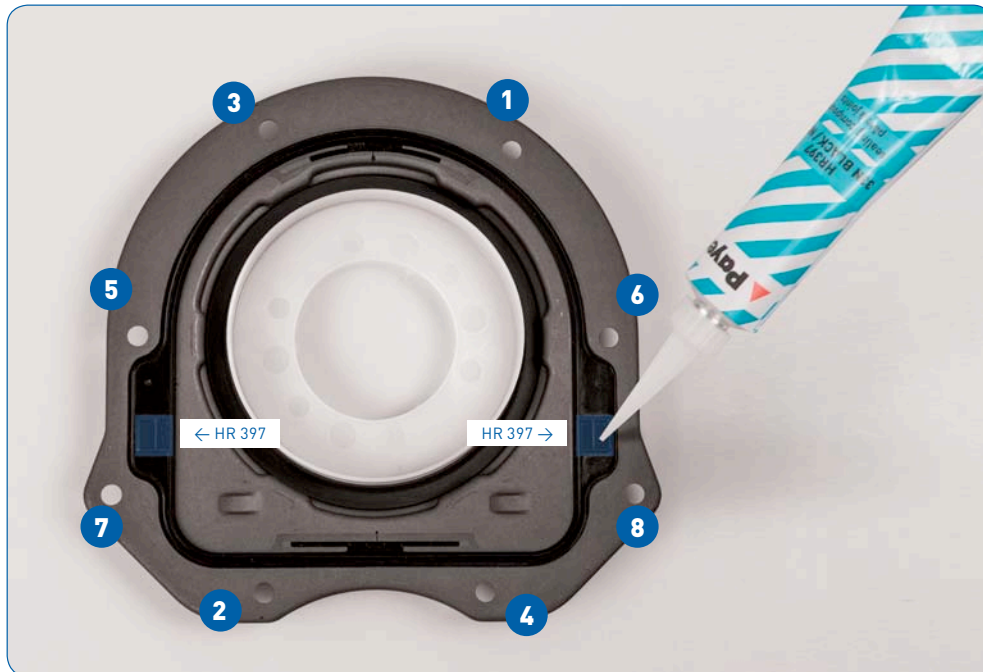


Assembly instructions for the integrated oil seal Ford/PSA – NA5030

IMPORTANT: It is imperative that this type of seal is installed 'dry' (i.e. without lubrication) to ensure that it beds in correctly upon initial start-up.



- Before starting, clean all the relevant areas of the engine.
- Fill the rectangular areas on the component to 75% with Payen sealing compound HR397, see picture. Use no more than the recommended amount of sealant, and never apply sealant to other areas. Once the sealant has been applied, the oil seal must be fitted within 5 minutes.
- Use the assembly aid to install the integrated oil seal.
- Use 10Nm of torque to tighten the bolts, following the sequence shown in the picture.
- Once the oil seal is properly seated, remove the assembly aid.
- The PTFE sealing lip needs to position itself evenly around the shaft, so do not run the engine for 4 hours after installation to be certain that the seal is secure.

Check **SB 2180** for more information about PTFE seals.

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