

## **D3075523 Main Shaft Seal Installation Recommendations**

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The D3075523 main shaft seal can be difficult to install due to the dimensional tolerances of the D3075523 seal outside diameter and the front cover seal bore inside diameter. The key to a trouble free installation is to follow the Cummins instructions that require heating the front cover prior to installing the seal. Please see the instructions below.

### **Installation Instructions:**

1. Do not remove the cardboard support tube from the seal until you are ready to insert the drive shaft assembly.
2. If a chamfer is not present on the entry of the seal bore in the housing, use sandpaper to create a small chamfer. Afterwards, clean the housing.
3. Cummins specifies heating the front cover in an oven at 275 degrees Fahrenheit for 30 minutes. **Note:** Experience shows in most cases it is not necessary to reach the full 275 degree temperature before installing the seal.
4. Lubricate the rubber outside diameter of the seal with a thin film of calibration fluid. Do not allow any fluid to get on the Teflon lip of the seal.
5. Without removing the support tube, use a 3824225 seal driver and an arbor press, to slowly press the seal into the bore. If the seal is pressed in too quickly the rubber outside diameter may tear.
6. Remove the cardboard tube from the seal only when ready to insert the main shaft. Do not leave the seal lip unsupported for more than five minutes as permanent damage can result. Using the plastic seal installation sleeve that comes with the seal, care fully install the main shaft assembly. Maintain proper alignment during the drive shaft installation to prevent damage to the Teflon lip.

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