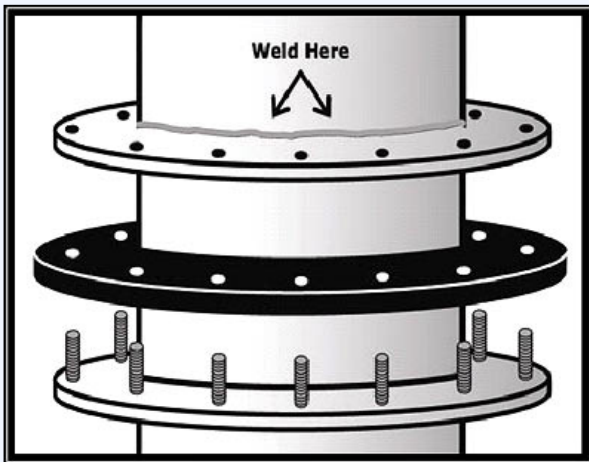




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INSTRUCTIONS FOR WELD-ON/SLIP-ON SEALS



The Lemco Seal® should be mounted as close to the screen as possible for maximum well production and corrosion resistance. For turbine pumps the seal can be mounted on the tailpipe assembly or anywhere on the column pipe.

When field welding, we suggest welding the cover plate to the drop pipe or column pipe. This way you can be welding down instead of overhead. Make sure that the nuts are on top or facing up when the seal is in place. It's best to tack-weld in several places along the cover plate, and then fill-in the weld.

In some cases, a tack-weld may be all that is necessary. We make the rubber packer fit close to the inside edge to help make a better seal where the weld is. Some of our customers don't weld the seal at all. If the weld-on is slipped up to a coupling, and the nuts tightened, the rubber will squeeze and secure itself to the drop pipe. This is the preferred method when mounting the seal on PVC drop pipe.

If the weld-on seal is going to be used with a submersible pump, it may be necessary to rotate the rubber so that the correct holes line up for the electrical wire. On turbine pumps, the rubber should be rotated so that none of the electrical holes show.

Tighten the nuts to sufficiently hold the wires and rubber packer firmly. The rubber should squeeze around the electrical wires. Do not over-tighten because distortion to the rubber packer may cause an air-leak. Under tightening may also cause an air-leak.

When venting is required, or when it's undesirable to place the well under vacuum, run ¼" plastic tubing through the seal to the top of the well. If you are trying to increase well production, this tubing must be sealed, otherwise leave it open.

If it's necessary to drill a new hole through the seal, do so with the seal assembled. This makes it much easier to drill through the rubber and to line up the holes.

The ¼" tubing can also be used to chlorinate the well. Make sure the tubing is open at the top of the well, and insert it into a jug of chlorine. When the pump runs, chlorine will siphon directly into the pump and screen area.