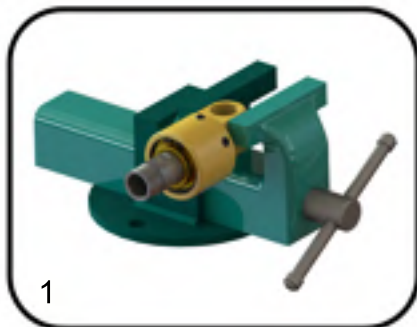
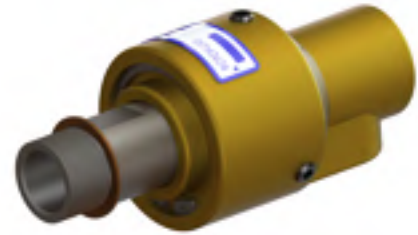
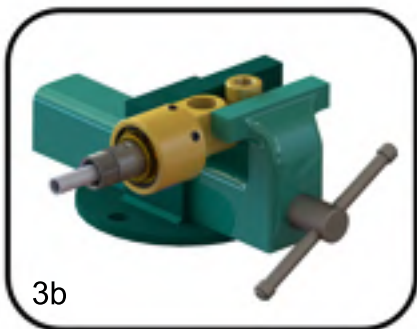


SIZE	MODEL
1/4"	402B
3/8"	403B
1/2"	405B
3/4"	407B
1"	410B
1 1/4"	412B
1 1/2"	415B
2"	420B



1. First hold the housing of the joint with a bench vise. Do not clamp too tightly, it will damage housing or bearings.

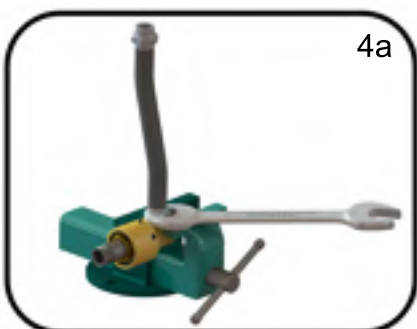
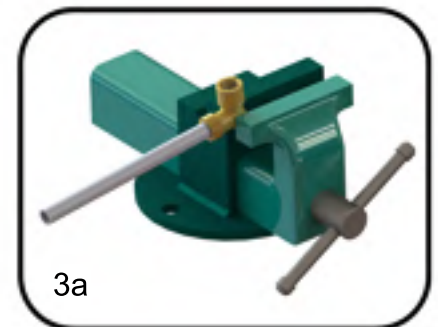


2. If the joint is used for single flow, apply adhesive or teflon tape to the threads of the pipe plug and fix it to the second port of the joint.

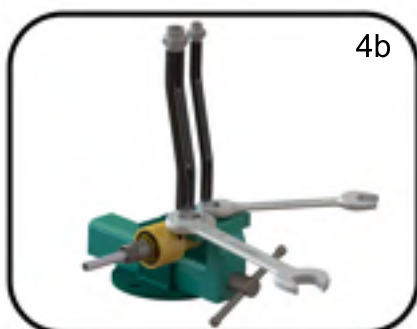
3. If the joint is used for dual flow,  
3.a) For S Types; apply adhesive or teflon tape to the threads of the siphon pipe and assemble it to the dual flow elbow.

3 b) For RSP Types; apply grease into the bronze bearing inside the elbow and assemble siphon pipe gently inside the bearing.

3.b) Apply adhesive or teflon tape to the thread of the dual flow elbow, be careful when assembling dual flow elbow with siphon pipe to the second port of the joint, internal siphon pipe may damage internal parts of the joint.



4. Apply sealant/adhesive or teflon tape to the threads of the hoses and assemble them to the housing.



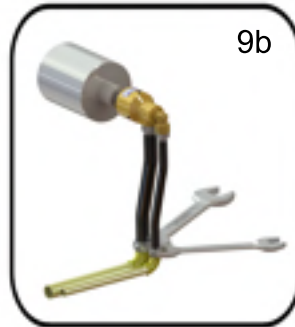
5. If housing connections are SAE Flange, place o-rings into the grooves and fix flanges of the hoses with appropriate bolts.

6. Clean machine bore surface before assembling.

7. Apply adhesive or teflon tape to the thread of the shaft and install the joint to the machine. When installing, pay attention not to install eccentrically.



8. If the joint shaft is quick release; put a new copper washer into the bore of the roll, assemble qr flange onto the shaft, place split rings onto the socket on the shaft correspondingly, place qr flange onto the split wedges and fix the flange to the bore of the roll with appropriate bolts.



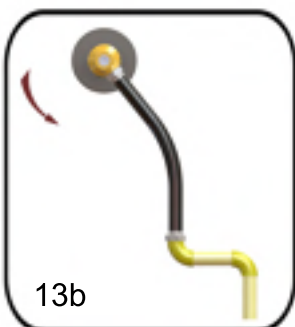
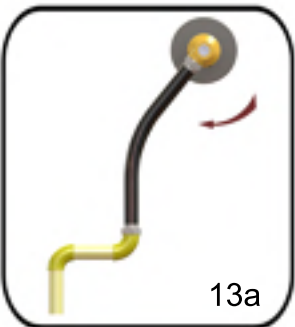
9. Connect hoses to the supply and return lines. Use flexible hoses and never install joint directly to the pipes.

10. Assemble hoses without sharp bends or without stress. Rotary joints are designed to float with the hoses.



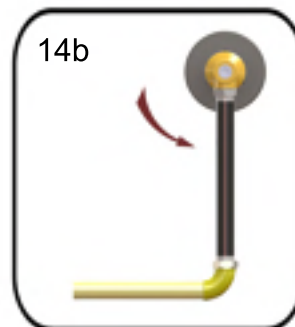
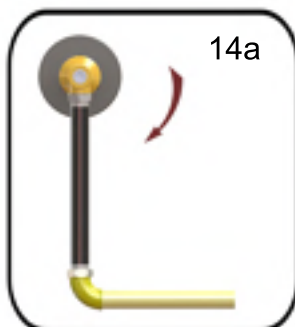
11. For air and hydraulic use rubber or steel flexible hoses. For water and steam, use stainless steel flexible hoses.

12. Install hoses with curves in direction of rotation.



13. Flexible hoses must not be twisted during operation. Twisted hoses lose flexibility. Use pipe fittings for proper installation.

14. If rotating joint and pipe axis are not on the same axis, hose must be installed with a smooth curve.



15. Flexible hoses must not be twisted during operation. Use proper pipe fittings.

16. After assembly; control rotation of joint. If any noise, wobble, vibration, knocking or noise show up or if any eccentricity seems; disassemble the joint from the machine and assemble it again.