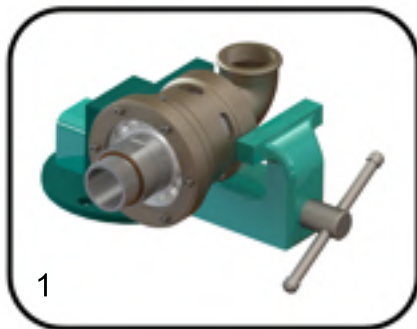
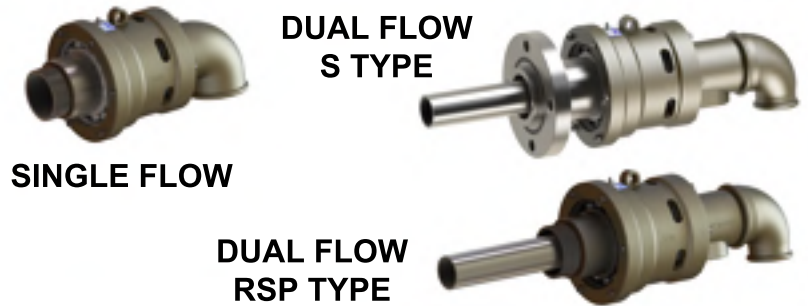
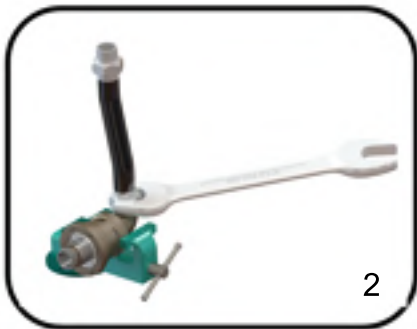


SIZE	MODEL
2"	520
2 1/2"	525
3"	530
4"	540



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 inlet hose and assemble it to the housing.

3. If the joint is used for s type;

3.a) apply sealant or teflon tape to the threads of the siphon pipe and assemble it to the siphon thread inside the end cap. Be careful not to touch internal parts with the siphon pipe.

3.b) Apply sealant to the threads of the inlet and outlet hoses and assemble them to the housing and dual flow elbow.

4. If the joint is used for rsp type;

4.a) apply grease to the o-rings in the siphon bearing in the end cap

4.b) push siphon pipe inside the bronze bearing, be careful not to damage o-rings and internal parts

4.c) Apply sealant to the threads of the inlet and outlet hoses and assemble them to the housing and dual flow elbow.



5. If housing connections are with flanges, place a new gasket onto the flange and fix flanges of the hoses with appropriate bolts.

6. Clean machine bore surface before assembling.

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



8. If the joint shaft is flanged,

8.a) Clean rotating joint flange surface

8.b) Place a new flange sealing o-ring into the flange groove

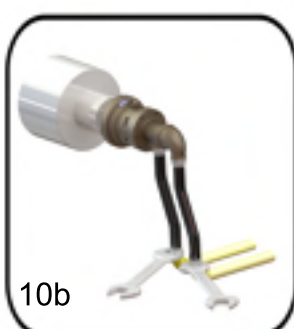
8.c) Align rotating joint flange and machine bore flange.

8.d) Fix flange to the bore of the roll with appropriate bolts.

Make sure the sealing o-ring on the shaft flange is in position.



9. 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.



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

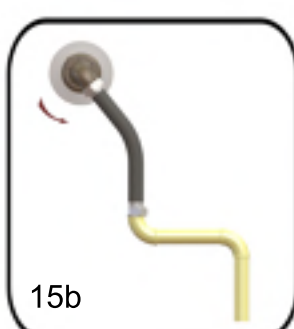
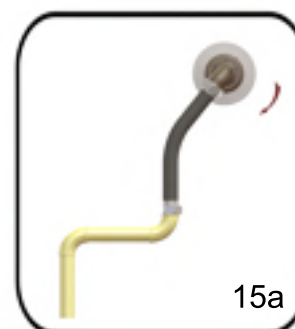
11. Assemble hoses without sharp bends or without stress. Rotary joints are designed to float with the hoses.



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

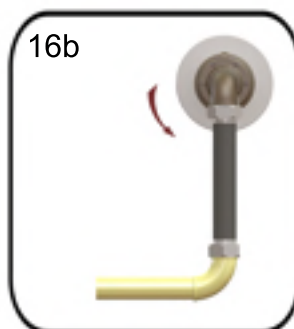
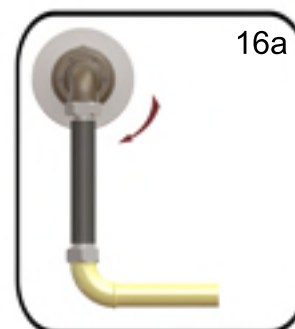
13. Install hoses with curves in direction of rotation.

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



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

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



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