

SIZE	MODEL
2 x 1/4"	725
2 x 3/8"	737
2 x 1/2"	750
2 x 3/4"	775



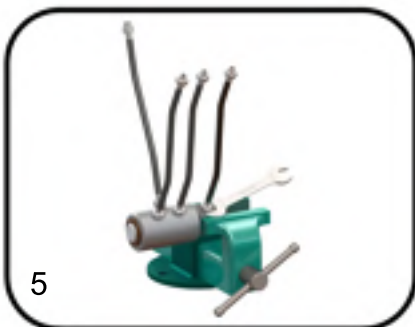
1. First hold the housing of the joint with a bench vise. Do not clamp too tightly, it will damage housing or bearings.



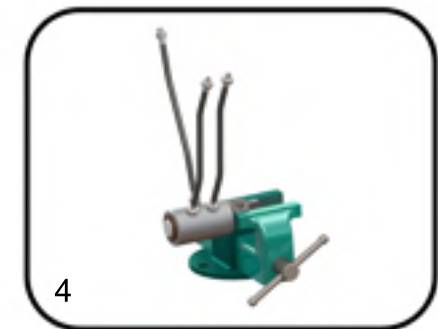
2. Place new copper gaskets onto the nipple threads of the hydraulic hoses and fix them to the ports of the housing.



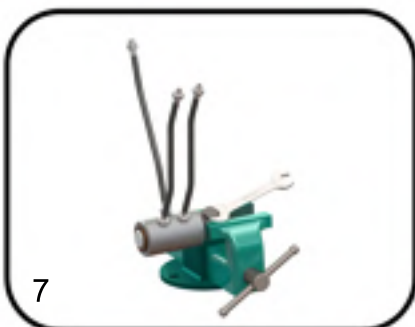
3. Place new copper gasket onto the nipple threads of the drain hose and assemble it to the drain port of the housing.



4. Hold the joint from the main shaft with bench vise.



5. Place a new copper washer onto the nipple thread of the hose and fix it to the side outlet port of the shaft.



6. Rotate the shaft 180° and hold the joint from the main shaft with a bench vise.

7. Place a new copper gasket onto pipe plug's thread and fix it to the second outlet port on the main shaft.



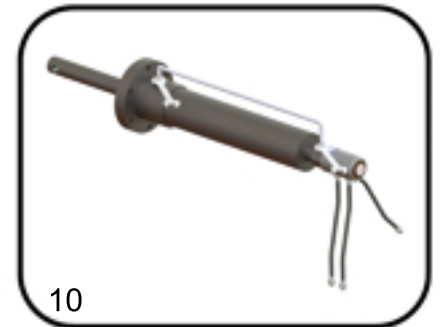
8. Clean machine bore surface before assembling.

9. Place a copper washer onto the main shaft thread and install the joint to the machine. When installing, pay attention not to install eccentricity.

10. Connect second outlet port hose to the second line on the machine.

11. Connect hoses on the housing to the supply lines.

12. There is no anti rotation socket on the housing. For this reason if the housing needs to be stopped from rotating; hold the fittings of the housing inlet and outlet hose with an anti rotation rod or bracket.



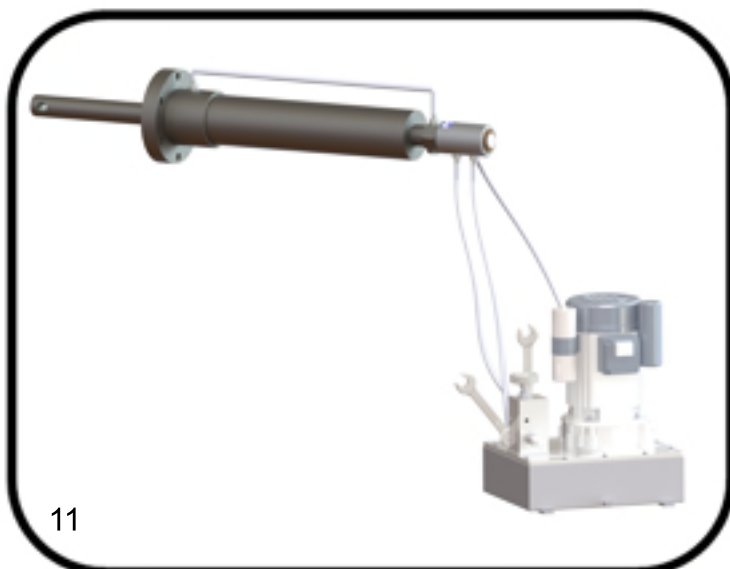
13. Rigid connection of the anti rotation rod will damage the joint.

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

15. Install hoses with curves in direction of rotation.

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

17. For air and hydraulic use rubber or steel flexible hoses.



18. After assembly, check rotating joint for leakage. A small amount of leakage may be seen in the starting period. Never use leaking joint.

19. 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.