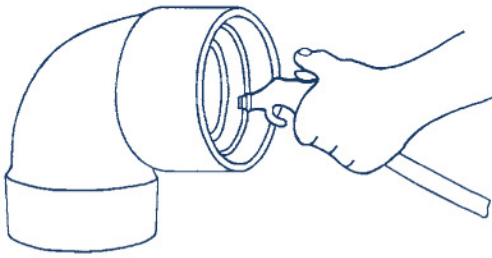


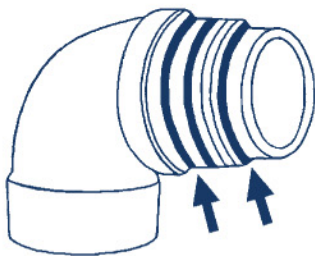
# O-ring Swivel Joints

## O-ring Swivel Seal Replacement Procedure

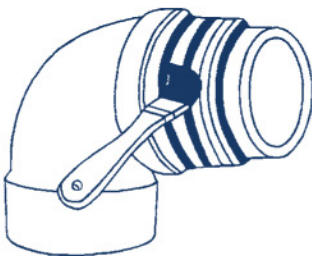
Note: Instructions not for assembly with spring-loaded Teflon® pressure seal. Consult the factory.



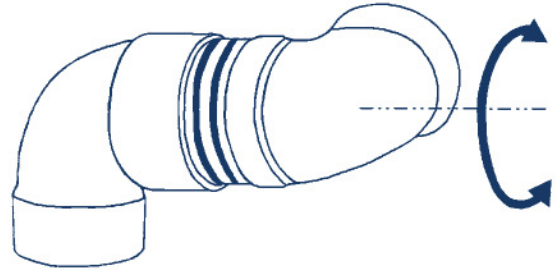
- 1** Remove the ball retainer screws. Add a sufficient amount of solvent into each raceway to flush out the lubricant. Rotate the sleeve, catching the balls as they fall out. When all the balls have been removed, the body and sleeve can be separated. Discard old seals. Thoroughly clean the body and sleeve.



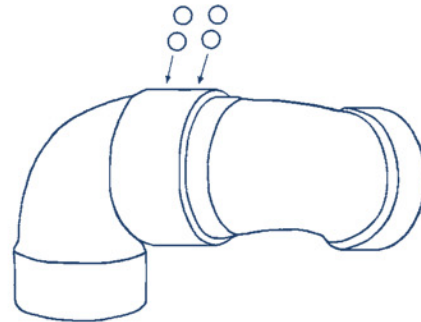
- 2** Install the new O rings on the sleeve, dust seal to the rear, product (pressure) seal up front.



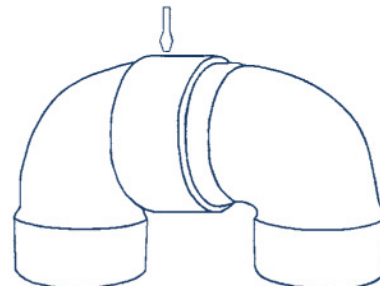
- 3** Lubricate the body and the sleeve with grease.



- 4** Insert the sleeve into the body, slowly rotate the sleeve while inserting into the body.



- 5** When the sleeve is fully inserted, feed the ball bearings into the raceways while rotating the sleeve. To make space for all the balls, insert a screw driver into the raceway, while continuing to rotate the sleeve in one direction (be careful not to damage the threads). This will cause the balls to jam up, making room for the remaining balls. Now reverse rotation of sleeve and insert the remaining balls.



- 6** Reinstall ball retainer screws until tight. If this interferes with the smooth rotation of the ball bearings, then back off 1/8 - 1/4 turn. A thread locking sealant is recommended to prevent screws from backing off. After pressure testing, the unit is ready for installation.

SAFETY  
ALERT

### Caution:

Body and sleeve are matched during manufacturing. Do not mix components with other units.