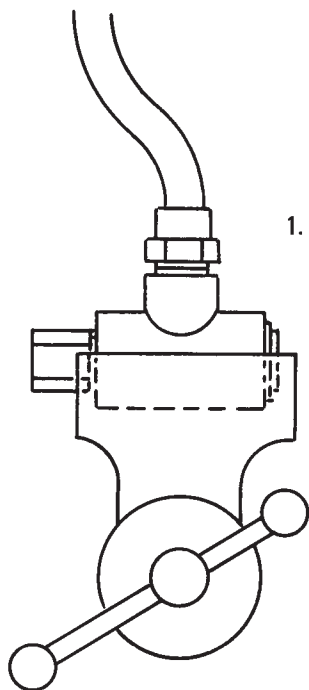


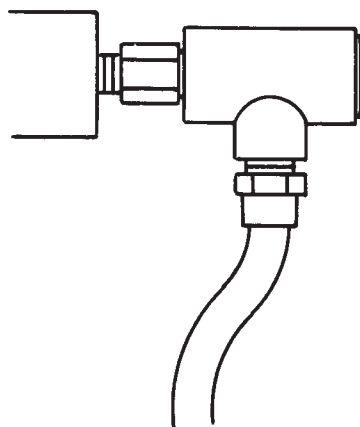
SINGLE AND TANDEM PASSAGE ROTATING UNIONS

Since Hytec's Rotating Unions incorporate a balanced seal design, it is not necessary to use exterior bracing to prevent the housing from rotating. Compensate for any eccentricities which may occur during installation by employing a flexible connection. Remember not to pipe solid. To make certain there is a slight curve in the hose, use a 45° elbow and pipe union on the riser. Hose cannot be installed taut.

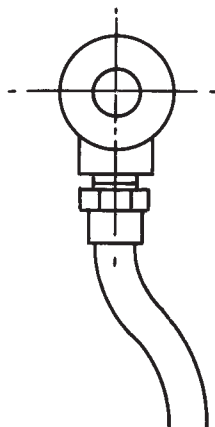
In order to avoid wrench torque damage to bearing when installing, the following procedure is recommended.



1. Grasp the housing in a bench vise and install Flexible Hose.
CAUTION: Grip housing lightly to avoid distortion.



2. Install rotating union to machine shaft, index table or fitting.



3. Attach flexible hose to the supply line.
Use a 45° elbow and pipe union on the riser.
Do not install hose taut.