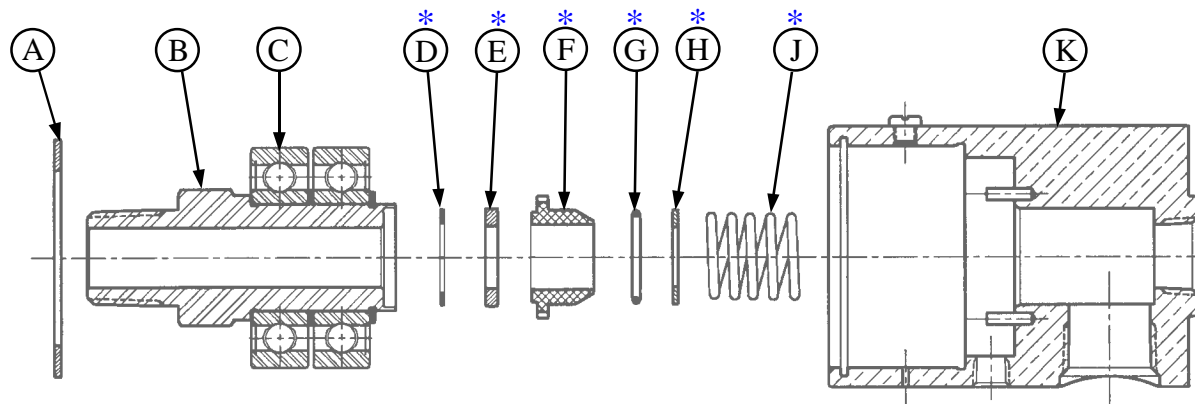




# Type E-75 RS

## Rotary Union Repair Kits & Repair Procedure

Issued 03/06



### E-75 RS COMPONENTS

Retaining Ring	A	Carbon Seal	* F
Sleeve	B	O-ring	* G
Bearings	C	Washer	* H
Sleeve Gasket	* D	Spring	* J
Seal Seat	* E	Casing	K

\* Items in repair kits.

## Repair Procedure

### Disassembly

1. Remove casing snap ring. (A).
2. Clamp sleeve hex (B) in vice. Insert a rod through the sleeve bore. Tap the rod to remove the casing (K).
3. Discard seal (F), o-ring (G), washer and spring (H & J).
4. Remove seal seat and sleeve gasket (D & E) from the sleeve counter bore and discard. The seal seat can be pried loose with a small screw driver.
5. Clean and inspect the small casing bore and the sleeve counter bore. Rust and scale deposits can be removed with crocus cloth or fine emery paper. **Attention : the sleeve (B) surfaces must be clean and free of scratches.**
6. Check the bearing for smooth operation and replace if questionable. To replace bearings, remove sleeve snap ring and pressing on the bearings remove bearings and bearing separator. Press the new bearings and separator on the sleeve by pressing on the inner race. Repack the space between the bearings with Mobilgrease XHP 222.

*Cleanliness is very important for successful repair of rotary unions. All parts must be clean and free of any contamination. Seal and seal seat should be cleaned with solvent and wiped clean with lint free toweling.*

### Assembly

1. Place spring (J) in the small casing bore **and then place washer (H) on the spring (J). Lubricate o-ring (G) with a thin coat of silicon grease and place it on the washer (H). Attention : Before placing carbon seal (F) it must be cleaned with a non-residue solvent (alcohol, etc.) and wiped clean with a lint free towel. Then lubricate seal surfaces with an acid-free oil. Place carbon seal (F) on o-ring (G).** Compress the spring (J) and set washer (H), o-ring (G) and carbon seal (F) in place, making sure that the slots in the carbon seal engages the roll pins in the casing.
2. Lubricate both sides of the sleeve gasket (D) with grease and place in the sleeve counter bore. **Attention : Before placing seal seat (E) in place, it must be cleaned with a non-residue solvent (alcohol, etc.) and wiped clean with a lint free towel. Then lubricate seal surfaces with an acid-free oil.** Press the seat (E) in place, aligning the seat flats with the flats on the sleeve.
3. **Control position of the components (F), (G), (J) and (H) in the casing before reassembling.**
4. Insert the sleeve assembly into the casing until the assembly bottoms. Install the casing snap ring.
5. The rotary union may be tested with low pressure air by sealing all parts and placing a drop of soap solution over one of the weep holes and watch for bubbles.

## Repair Kits

Union Size	Part Number	Union Size	Part Number
3/8"	10-67175-XX	1-1/4"	10-67625-XX
1/2"	10-67176-XX	1-1/2"	10-67293-XX
3/4"	10-67177-XX	2"	10-67294-XX
1"	10-67178-XX		

-XX Elastomer Suffix Specify:

-08 = HNBR (Standard)

-04 = EPR (Special)

-06 = Viton (Special)