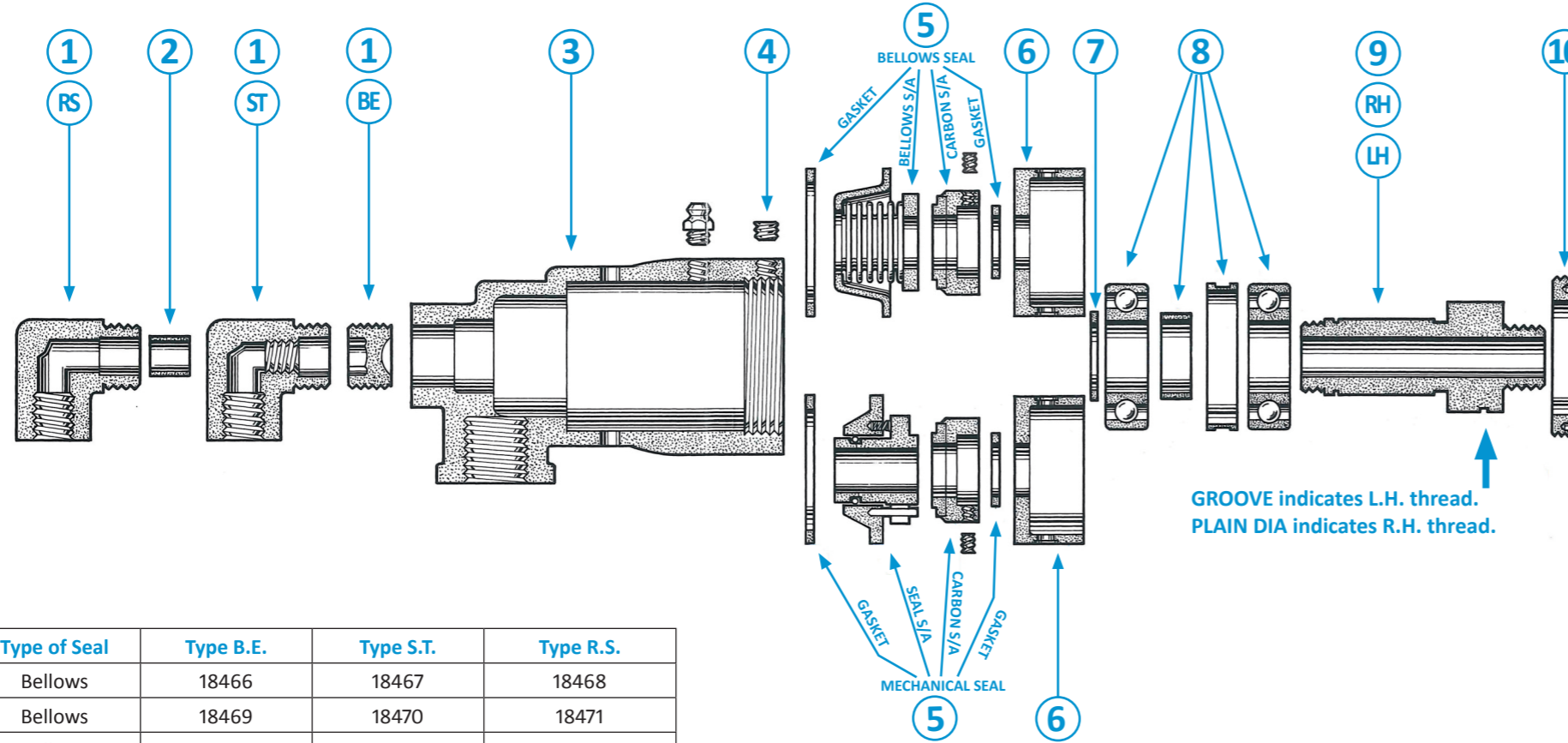


SPARE PARTS FOR ROTARY (P.B.) UNIONS

OVERHAUL



- Remove Locking Screw 4 which allows the removal of Locking Ring 10.
- Remove Spindle 9 complete with Bearing Kit 8, Circlip 7 and Carbon sub assembly of Seal Kit 5.
- Remove Spacer 6 and Seal sub assembly and Gasket of Seal Kit 5 from the Body 3.
- If the type RS, unscrew End Fitting 1.RS from the body, remove and replace C/T Bush 2.
- Hold spindle 9 in a vice, remove locking screws to enable Carbon sub assembly of Seal Kit 5 to be unscrewed, then remove gasket.
- Remove Circlip 7 and press off Bearing Kit 8 from Spindle 9.
- Discard and replace Seal Kit 5 and Bearing Kit 8. (Handle Seal Kits very carefully to avoid damaging the precision lapped seal faces).
- Thoroughly clean all parts before re-assembly which is virtually the reverse of the above.
- After re-assembly, run in as indicated in the installation instructions and test to ensure the seals are working correctly before re-fitting to the machine.

MAINTENANCE

The Filton Bellows Seal fitted to the **Rotary (P.B) Union** is self-adjusting within its working life.

Before despatch we lubricate the ball bearings with Total Multis Complex EP2 grease. This is a lithium complex soap/thickener and is miscible with most other conventional soap greases. The ball bearings will need occasional greasing with the frequency depending on the working conditions. We recommend that you contact the grease manufacturer for specific lubrication or compatibility information.

Note: For sub-zero temperatures check with our Technical Department that the Rotary Union you are considering is acceptable for the temperature and fluid.

Nominal Size	Type of Seal	Type B.E.	Type S.T.	Type R.S.
15(½")	Bellows	18466	18467	18468
20(¾")	Bellows	18469	18470	18471
25 (1")	Bellows	18472	18473	18474
15(½")	Mechanical	18466MS	18467MS	18468MS
20(¾")	Mechanical	18469MS	18470MS	18471MS
25 (1")	Mechanical	18472MS	18473MS	18474MS

All Part Numbers will have an additional suffix for –R for right hand and –L for left hand thread.

- CHECK THE LABEL FOR PART NO.
- IDENTIFY THE SIZE AND TYPE FROM THE TABLE.
- REFER TO PARTS LISTED UNDER NOMINAL SIZE AND SPINDLE THREAD.

Nom Size	Spindle Thread	1			2	3	4	5		6		7	8	9	10
		End Fitting			C/T Bush (RS only)	Body	Locking Screw	Seal Kit		Spacer		Circlip	Bearing Kit	Spindle	Locking Ring
		BE	ST	RS				Bellows	Mechanical	Bellows	Mechanical				
15 (½")	G ½"	M244/4	18467/2	18468/1	14699/4	18467/1	M6 x 5	S1100/2	S1400/2	14534/3	15166/6A	M184/3	S1234/2	14535/1	18470/3
20 (¾")	G ¾"	M224/4	18470/2	18471/1	14543/1	18470/1	M6 x 5	S1100/2	S1400/2	14534/3	15166/6A	M184/3	S1234/2	14534/2	18470/3
25 (1")	G 1"	M244/5	18473/2	18474/1	14502/3	18473/1	M6 x 5	S1100/3	S1400/3	14396/3	15355/5A	M184/15	S1234/3PB	18473/5	18473/3

HEALTH & SAFETY

The Rotary Unions shown in this leaflet should not present any hazard when correctly fitted and used.

To ensure satisfactory performance, every Rotary Union is run-in and leakage tested before despatch.

It is essential to use the correct hand of rotary connection thread to ensure the Rotary Union will not unscrew (see the Installation Instructions). If a shaft reverses rotation then a flanged connection rather than a screw thread is strongly recommended.

At some time the seals in the Rotary Union will leak, so inspect regularly, also, ensure that leakages are not hazardous to personnel and that the Rotary Union is removed for repair immediately. If leakages are not attended to promptly, bearing seizure may occur causing flexible hose failure and massive leakage. Fit protective guards if leakages or the rotating spindle are likely to be hazardous to personnel.

With oil systems minor leakages occur due to the natural characteristics of oil preventing seal faces from contacting fully.

WE MANUFACTURE MANY SPECIALS. IF YOU HAVE ANY DOUBT CONTACT US GIVING THE PART No. AND SERIAL No. FROM THE IDENTIFICATION LABEL FITTED.

NOTES

FILTON ROTARY (P.B.) UNIONS

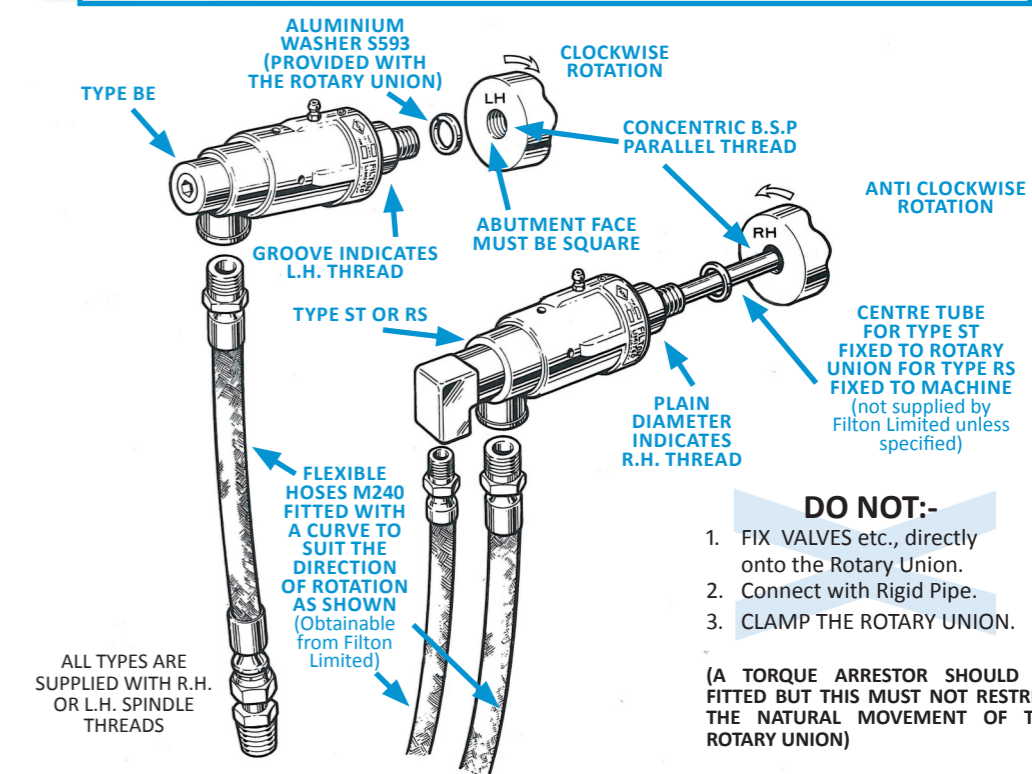
NOMINAL SIZES 15 (½") TO 25 (1") WORKING CONDITIONS (maximum)

Safety	- see back page
Fluids	- Abrasives free -air (not dry), oil, steam and water
Pressure	- 17 bar Vacuum - 740mm Hg
Temperature	- range -20° to 160° C
Speed	- 1000 r.p.m when Bellows seal is fitted - 1500 r.p.m. when the Mechanical seal is fitted

DO NOT EXCEED OR COMBINE MAXIMUMS – IF IN DOUBT ASK. ALL OF THESE PRODUCTS HAVE BEEN LEAKAGE TESTED – DISMANTLING INVALIDATES THE WARRANTY.

INSTALLATION

Run in before fitting – rotate at 300 r.p.m. for 15 minutes.
Add system liquid if the seals squeak.



DO NOT:-

1. FIX VALVES etc., directly onto the Rotary Union.
2. Connect with Rigid Pipe.
3. CLAMP THE ROTARY UNION.

(A TORQUE ARRESTOR SHOULD BE FITTED BUT THIS MUST NOT RESTRICT THE NATURAL MOVEMENT OF THE ROTARY UNION)

	MINIMUM LENGTH FOR FLEXIBLE HOSE				
Nom Size	8(¼")	10(⅜")	15(½")	20(¾")	25(1")
Length (mm)	150	230	305	305	380
FILTON HOSE	M240/1	M240/2	M240/3	M240/4	M240/5

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