Follow your company’s safety procedures whenever working on Kadant Johnson products. Read all of the instructions before proceeding with the installation or repair.

Please refer to the Kadant Johnson assembly drawing for part identification. Assembly drawings are available on request from Kadant Johnson.

Lubricate all fasteners with anti-seize compound. Tighten all fasteners in a star pattern. Torque specifications are listed on the product assembly drawing and are available from Kadant Johnson.

Allow equipment to cool and disconnect piping. Please consult Kadant Johnson if you have any questions.

**NOTE:** Do not use anti-seize or petroleum-based products on o-rings. Only lubricate the o-rings with the silicone lubricant supplied with the Kadant Johnson repair kit. Prior to handling lubricants, consult MSDS information.

**STEP 1.**
Make sure mounting pad for the new rotary joint is clean and that the mounting holes are in their proper location. Check the footprint on the drawing that is supplied with the rotary joint.

**STEP 2.**
Install journal adapter flange (2A) and gasket (2B) if required. Tighten the fasteners (2C) to the specified torque value listed on the drawing accompanying the Kadant Johnson rotary joint.

**STEP 3.**
Install wear plate (16) and wear plate gasket (8A) on to the journal flange. Tighten the fasteners (16A) to the specified torque value listed on the drawing accompanying the Kadant Johnson rotary joint.

**PRE-SETTING THE “X” DIMENSION AND ALIGNING THE ROTARY JOINT**

**STEP 4.**
Remove bolts (8), elbow (7), and gasket (9), if equipped. Remove hex nuts (1C), head (1), and o-ring (26) if installed. Be careful not to damage the o-ring, it will be reused. Remove four socket head cap screws (3C) and remove end cap assembly (3, 3A, and 4). Place installation tool (J97599PTX-IT, 3/4” spacer) over the studs (1B) and reinstall the end cap assembly, holding it in position with four hex nuts (1C) that are equally spaced.

**STEP 5.**
Place the seal ring (6) into the recess of the wear plate (16) and hold it in position.

**STEP 6.**
Place the end cap and bracket assembly (3, 3A, 4, and 10) into position on the mounting pad. Push the end cap and bracket assembly against seal ring (6). Adjust the end cap and bracket assembly as necessary making sure the joint is square to the journal end and the seal ring is centered on the nipple (4). After aligning the end cap and bracket assembly, secure it into position with the mounting bolts (5).

**STEP 7.**
Prevent the seal ring (6) from falling out of position during this step. Remove four nuts (1C). Remove the end cap assembly (3, 3A, and 4) and the installation tool. Reinstall the end cap assembly and seal ring and secure into position with four socket head cap screws (3C). Tighten the screws evenly.

**NOTE:** The end flange (3) will not rest against the bracket (10) until the socket head cap screws (3C) are tightened. As the caps screws are tightened the springs will compress, loading the seal ring (6). Double check the seal ring alignment. Check
the “X” dimension. It should be 0.5” (13 mm) +/- 0.25” (6 mm). See Figure 1. Adjust bracket if the seal ring alignment or “X” dimension is not to specifications.

STEP 8.
Lubricate the o-ring (26) with silicon o-ring lubricant and position it into the o-ring groove in the head (1). Install the head (7) making sure the o-ring stays in position while sliding the head over the studs (1B). Secure with hex nuts (1C). If equipped, install elbow (7) and gasket (9) and secure with bolts (8). Attach the flexible hoses and piping to the rotary joint. The rotary joint is now ready for service.

NOTE: Store the Installation Tool in a safe place. The tool is required if the bracket (10) is moved to replace a bearing, etc.

Dimensions are for reference only and subject to change. Certified drawings are available on request. Please refer to Kadant Johnson Drawing Number A37640 for torque specifications.

The Kadant Johnson Warranty
Kadant Johnson products are built to a high standard of quality. Performance is what you desire: that is what we provide. Kadant Johnson products are warranted against defects in materials and workmanship for a period of one year after date of shipment. It is expressly understood and agreed that the limit of Kadant Johnson’s liability shall, at Kadant Johnson’s sole option, be the repair or resupply of a like quantity of non-defective product.