Installation, Disassembly, and Repair of 6” Swivel™ Joints

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.

REPAIR KITS ARE AVAILABLE CONSISTING OF:

<table>
<thead>
<tr>
<th>Item #</th>
<th>Qty.</th>
<th>Description</th>
</tr>
</thead>
<tbody>
<tr>
<td>3</td>
<td>2</td>
<td>Seal</td>
</tr>
<tr>
<td>6</td>
<td>2</td>
<td>Guide</td>
</tr>
<tr>
<td>7</td>
<td>1</td>
<td>Spring</td>
</tr>
<tr>
<td>8</td>
<td>1</td>
<td>Gasket</td>
</tr>
</tbody>
</table>

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.

REMOVAL AND INSTALLATION:

STEP 1.
Release residual pressure in the system. Remove swivel joint by removing hex head cap screws (11 and 12). Remove swivel joint from between the pipe flanges.

STEP 2.
To reinstall the swivel joint, use site supplied gaskets. Position swivel joint between the pipe flanges and align the bolt holes. Tighten the hex head cap screws (11 and 12).

DISASSEMBLY:

STEP 1.
Place swivel joint on a work bench with the head (2) facing up. Remove the head by removing socket head cap screws (10).

STEP 2.
Remove thrust plate (5) by removing socket head cap screws (9). Caution: Expect spring tension behind this plate.

STEP 3.
Separate the nipple (4) from the body (1). Discard the following items: guides (6), spring (7), and seal assemblies (3). Set the washer (13) aside for reuse.

INSPECTION:

STEP 4.
Check thrust plate (5) for steam cuts or uneven wear. Inspect the surface where the guide (6) runs against the thrust plate. Replace if damaged.

STEP 5.
Inspect the nipple’s (4) guide surfaces for any scratches, grooves, or pits. Replace if damaged.

STEP 6.
Inspect the body’s (1) guide surfaces and seal assembly (3) grooves for any scratches or pits. Clean the grooves with Scotch-brite® pads and solvent. Replace body if damaged.
STEP 7.
Clean and inspect all gasket surfaces. Replaced if damaged.

REASSEMBLY:

STEP 8.
Install new seal assemblies (3) into the grooves of the body (1). Please note that the seal assemblies consist of an O-ring and Teflon ring. Insert the O-ring into the groove first followed by the Teflon ring. To insert the Teflon ring, compress it into a kidney shape like Figure 1. Then place it into the groove against the O-ring. Please note: After installing the Teflon ring, the ring may still have a bulge from putting into the kidney shape. Using a round tool, roll the ring into the groove until it is fully relaxed into position.

Note: It may be necessary to place the swivel joint into a press to assist in assembling.

STEP 9.
Place nipple (4) back on the work bench with thrust plate (5) mounting surface facing up. In the following order, gently place a guide (6), washer (13), and spring (7) onto the shaft of the nipple. Place the body (1) over the shaft of the nipple and let it rest on the spring. Place the second guide into the gap between the nipple and body. Compress the assembly by placing the thrust plate onto the guide and tighten the socket head cap screws (9) evenly in a star pattern.

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.