

## Installation & Mounting

### PREPARATION:

Remove the rotary union from the shipping container. Inspect the entire assembly, including all passage connections to make sure that they are clean and no visual damage occurred during transport. If the assembly is a rotary union/electrical slip ring, the electrical slip ring may be packaged separately to protect during shipping. If this is the case, mount the electrical slip ring to the rotating union assembly using the supplied hardware.

### RECOMMENDED INSTALLATION PRACTICE:

DSTI does not recommend mounting the rotary union with both the shaft & housing components solidly bolted into place. One of the two components should be mounted in a manner that allows for some movement in the event of misalignment or run-out during rotation. Using only the supply lines or hoses to fix the stationary component in place is also not recommended. An anti-rotation arm that attaches to the stationary part of the rotary union assembly and rests against part of the equipment framework is recommended (see figure 1).

### MOUNTING A ROTARY UNION W/ AN ELECTRICAL SLIP RING:

Make sure the electrical wiring is fixed in place and protected from contact with other components or equipment. Care should be taken to make sure the slip ring area remains clean and dry during use.

### SHAFT MOUNTING, O-RING FACE SEAL CONNECTIONS:

Make sure the rotary union shaft face & equipment mounting surface is clean and free from dents or chips to insure proper installation. Equipment pilot bore needs to be concentric to the center line of the rotary union shaft to assure proper function. Install face mount O-rings into groove or counter bore in rotating union shaft face. General assembly grease can be used as needed to hold O-rings into place during assembly. Align rotary union shaft with equipment pilot bore and flow passages, then insert into place. Bolt assembly into place using tapped holes on the face of the rotating union shaft or purchase an optional shaft flange (F2) for help mounting the union.

THESE INSTRUCTIONS ARE INTENDED TO BE USED AS A GENERAL GUIDE, PLEASE CONSULT DSTI TO DISCUSS ANY SPECIFIC QUESTIONS RELATED TO YOUR INSTALLATION.

### SHAFT MOUNTING, THREADED PORT CONNECTIONS:

When mounting the shaft using threaded connections, make sure all fittings are properly tightened & pipe thread sealant is used as required. Equipment mounting surface needs to be concentric to the center line of the rotary union shaft to assure proper function. After all fittings are in place, bolt assembly into place using tapped holes on the face of the rotating union shaft or purchase an optional shaft flange (F2) for help mounting the union.

### HOUSING MOUNTING

If using the housing to secure the union into a piece of equipment, bolt the assembly into place using the tapped holes on the back of the housing or purchase an optional housing flange (F1) for help mounting the union.

### INITIAL START-UP:

After rotary union is installed, a dry run is recommended to assure proper mounting of the rotating union assembly. Begin rotation of the equipment, and verify that while rotating at the maximum operating speed there is no visible movement of the rotary union assembly due to misalignment.



- ① SE HOUSING
- ② SE SHAFT
- ③ ANTI-ROTATE DEVICE EXAMPLE
- ④ O-RINGS FOR OPTIONAL FACE SEAL MOUNTING
- ⑤ OPTIONAL FLANGE FOR MOUNTING AND/OR FACE CONNECTION