

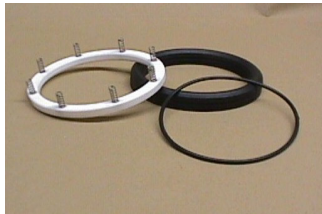


## 90 Series Swivel Joint "V" Ring Seal Replacement Instructions

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STEP 1: Remove the ball retainer screws. Add a sufficient amount of solvent into each raceway to flush out the lubricant. Rotate the sleeve, catching the balls as they fall out. When all the balls have been removed, the body and sleeve may be separated. Discard old seals. Thoroughly clean both body and sleeve.



STEP 2: Assemble spring adapter and collect 3 "V" rings and appropriate dust seal. Note: Both vitex and Teflon compounds require additional springs for proper installation.



STEP 3: Lubricate sealing area of body and insert spring adapter and 3 "V" ring seals.



STEP 4: Place dust seal on sleeve and grease remaining body and sleeve with Molylube grease or equivalent.



STEP 5: Insert sleeve into body, careful to avoid pinching the seals. When the sleeve is fully inserted, feed the ball bearings into the raceways. Insert a screwdriver and rotate the joint to make space for the balls (be careful not to damage the threads). Then reverse rotation to insert remaining balls.



STEP 6: Reinstall the grease fitting and ball retainer screws until tight. If this prevents smooth rotation, back off 1/8 turn. A thread locking sealant is recommended to prevent screws from backing off. After pressure testing, the unit is ready for installation.