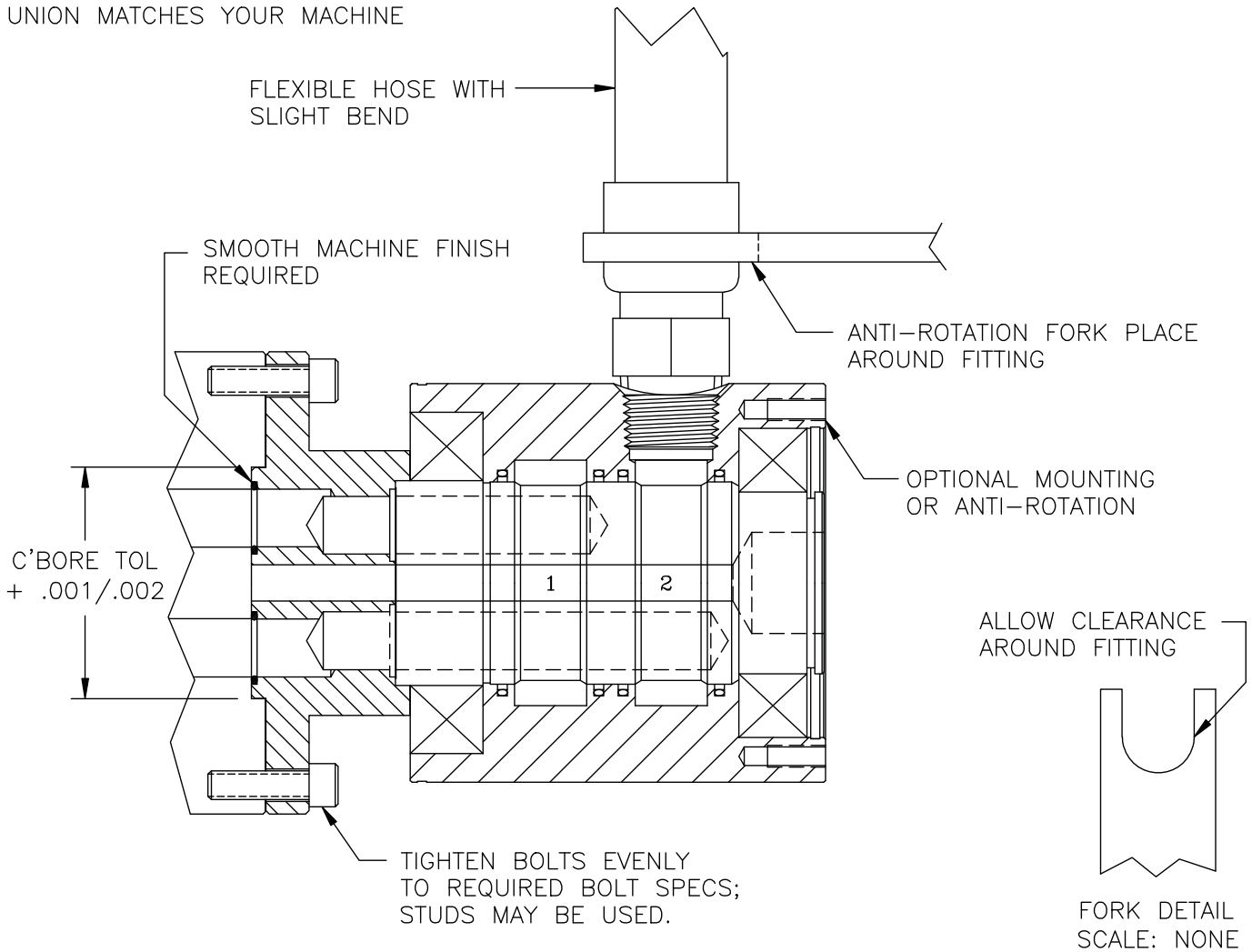


INSTALLATION GUIDE - SERIES 013, 015, 017, 019, 021, 023, 025, 027

MAKE SURE BOLT PATTERN ON UNION MATCHES YOUR MACHINE



PROPER USE AND MOUNTING INSTRUCTIONS

1. Connect all fittings to housing prior to installation.
 - Do not use rigid piping as this will compromise the life of the union.
 - The hose should be flexible and have a slight bend.
 - Extreme bends can reduce the flexibility of the hose.
 - The rubber hose selected should be able to safely handle the working pressure.
 - The hose should be properly supported & should not side load the union.
2. Attach your preferred method of anti-rotation. Anti-rotation must allow the union to find its center. Do not hard mount both the rotor and housing of the union.
 - An anti-rotation fork placed around one of the housing fittings
 - An anti-rotation bracket mounted to the rear of the housing
3. Fasten the rotor flange to the machine.
 - Make sure the c'bore is machined to the proper depth and the finish is 32 RMS or better.
 - Tighten the fasteners evenly using a crisscross pattern to their required specification.



ROTARY
SYSTEMS INC