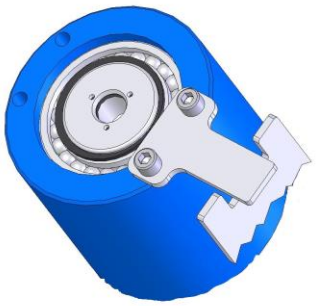
Vektek, Inc. 1334 East Sixth Ave. P.O. Box 625 Emporia, Ks. 66801 U.S.A.	Instruction Sheet	IS-	3205	
		REV.	F, I.A.W. ECN5870	
		REVISED BY/DATE:	JDW	12/09/25
		ECN APPR/DATE:	BCD	12/09/25
TITLE: INSTALLATION, ROTARY UNION, 6, 8 AND 12 PORT				

General Installation Instructions for Vektek Rotating Union Assemblies With Six, Eight and Twelve Ports

Note: These instructions are intended to be used as a general guide, please consult the factory to discuss any specific questions related to your installation.

Preparation: Remove the rotating 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.

Recommended rotating union Installation Practice: The rotating union assembly should never be mounted 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. Using only the supply lines or hoses to fix the stationary component in place is not recommended. Mounting an anti-rotation arm that attaches to the stationary part of the rotating union assembly and rests against part of the equipment framework is recommended (see below).



When mounting a rotating union with an electrical slip ring: make sure the electrical wiring is fixed in place and protected from contact with other components of the equipment.

Shaft Mounting, Manifold type: When mounting the shaft face using the o-ring manifold option, make sure the rotating 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 centerline of the rotating union shaft to assure proper function. Install face mount o-rings into groove or counter-bore in rotating union shaft face. Align rotating union shaft with equipment pilot bore and flow passages, then insert into place. Bolt assembly into place using tapped holes or mounting flange on rotating union face.

Shaft Mounting, Threaded connections: When mounting the shaft using threaded connections, make sure all fittings are properly tightened. Equipment mounting surface needs to be concentric to the centerline of the rotating union shaft to assure proper function. After all fittings are in place, bolt assembly into place using tapped holes or mounting flange on rotating union shaft.

Housing Mounting: When installing threaded connections, make sure all fittings are properly tightened. Tapped holes on the end of the rotary union housing can be utilized as needed for mounting.

Initial start-up: After rotating union is properly 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 rotating union assembly due to misalignment.

Troubleshooting Guide

PROBLEM	POSSIBLE CAUSE	ACTION
Rotating union will not turn or requires more force to turn than anticipated	Customer may not be familiar with required torque to rotate, request required torque specs for the specific part # from factory	Test rotary union to make sure it is within the torque spec, return to factory for evaluation & repair if unit is out of spec.
Leaking found at connection point.	Proper fittings were not installed in ports Fittings were not properly tightened Manifold mount o-ring was damaged during installation	Confirm proper fittings are used. Confirm fittings are tight. Inspect o-rings for damage..
Minor leaking found at drain ports in union housing (when new)	Internal seals are not properly seated	"Dry-run" the assembly by Rotating the shaft of the rotary union with no media in passages at approx. 100 rpm for several minutes until housing is warm to the touch from seal friction. Re-test assembly. Return to Vektek for repair.
Slip ring leads do not have conductivity	Tested wire colors do not match Wires were damaged during shipping or installation	Make sure matching wires are being tested. Return to Vektek for repair.

Warranty:

Vektek Inc Warrants, for a period of one year from the date of original delivery, it's products to be free from defects in material and workmanship. Vektek's obligation under this warranty is limited to repair or replacement at it's factory of any part or parts of said products which shall be returned to Vektek Inc. with transportation charges prepaid and which Vektek Inc.'s examination shall disclose to it's satisfaction to have been defective. Under no circumstances shall Vektek Inc. be held liable for loss, damage, cost of repair of consequential damages of any kind, in connection with the sale, use or repair of any product purchased from Vektek Inc.

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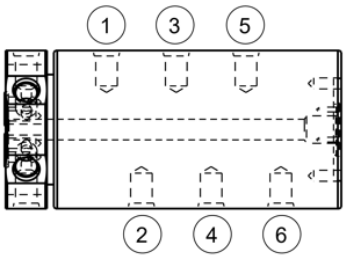
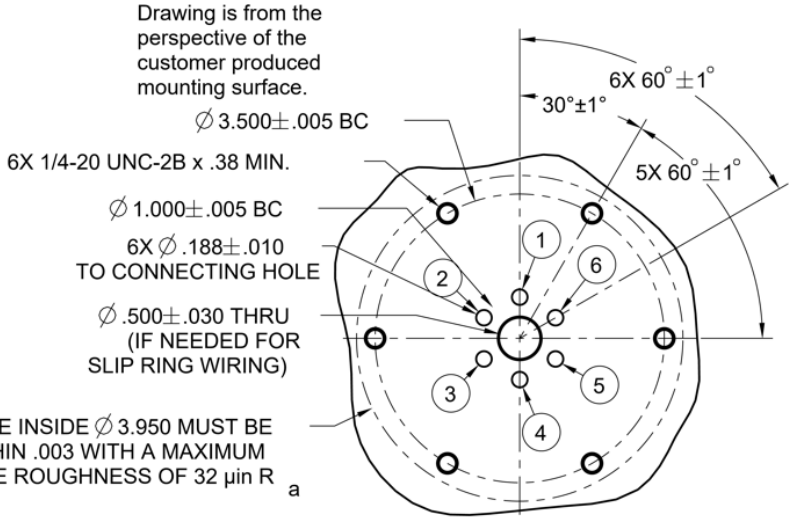
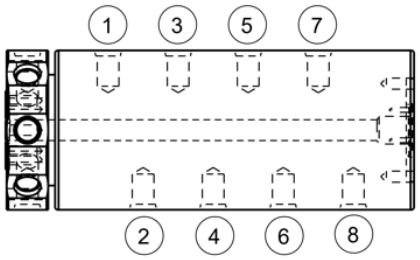
MOUNTING HOLE PATTERN FOR
OPTIONAL STEEL PLATE 93-2620-00
USED WITH SIX-PORT ROTARY UNION



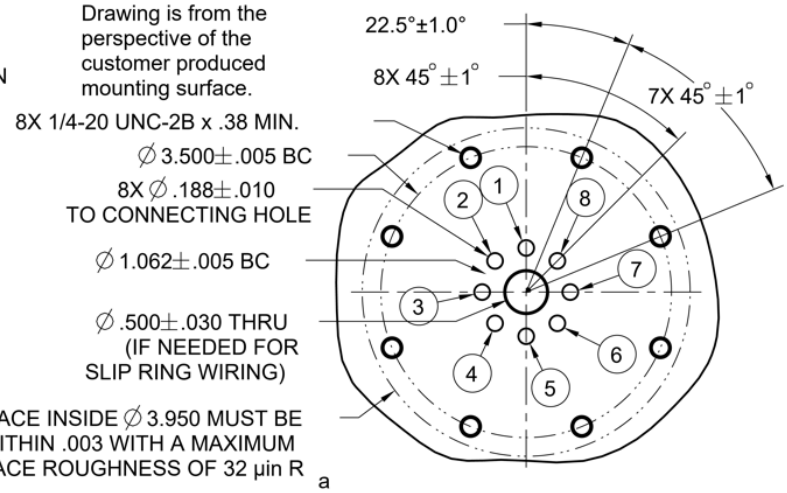
Drawing is from the perspective of the customer produced mounting surface.



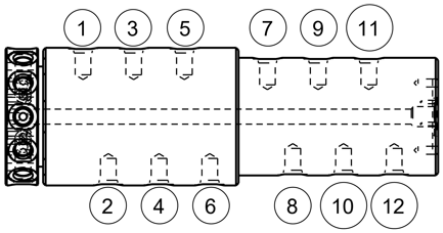
MOUNTING HOLE PATTERN FOR
OPTIONAL STEEL PLATE 93-2820-00
USED WITH EIGHT-PORT ROTARY UNION



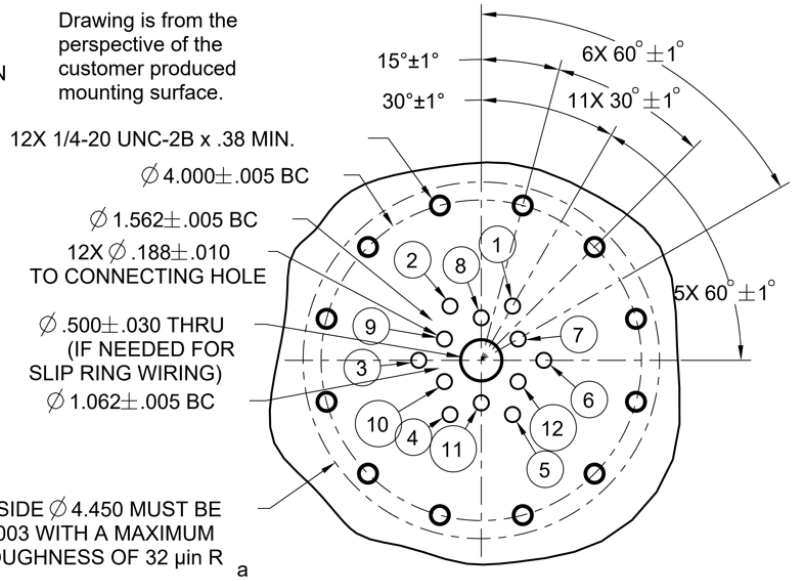
Drawing is from the perspective of the customer produced mounting surface.



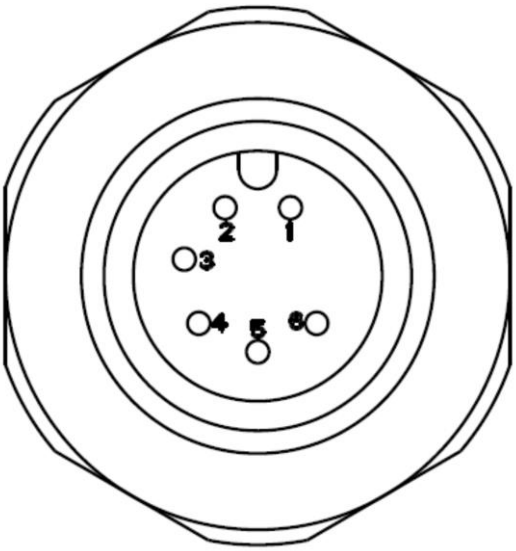
MOUNTING HOLE PATTERN FOR
OPTIONAL STEEL PLATE 93-2120-00
USED WITH TWELVE-PORT ROTARY UNION



Drawing is from the perspective of the customer produced mounting surface.



THE FOLLOWING PROVIDES WIRING CONNECTIONS FOR SLIP RING ES6A

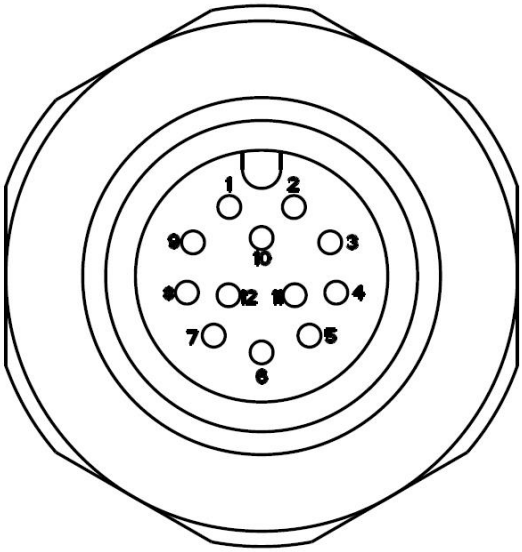


MALE PIN CONNECTOR FS 6-.5/18.25

SLIP RING ES6A		MALE PIN CONNECTOR FS 6-.5/18.25	
SLIP RING CIRCUIT No.	SLIP RING WIRE COLOR	CONNECTOR PIN No.	CONNECTOR WIRE COLOR
2	BROWN	1	BROWN
4	ORANGE	2	WHITE
6	GREEN	3	BLUE
1	BLACK	4	BLACK
5	YELLOW	5	GREY
3	RED	6	PINK

ES6A SLIP RING SPECS
CIRCUITS: 6
MAXIMUM OPERATING SPEED: 100 RPM CONTINUOUS
MAXIMUM VOLTAGE PER CIRCUIT AC or DC: 120V
MAXIMUM AMPS PER CIRCUIT: 2 AMPS
LEAD WIRE SIZE:26 GAUGE, SILVER PLATED COPPER
LEAD WIRE LENGTH: 48 INCHES
CONTACT MATERIAL: GOLD
TEMPERATURE RANGE: -40°F TO +176°F (-40°C TO +80°C)

THE FOLLOWING PROVIDES WIRING CONNECTIONS FOR SLIP RING ES12A



MALE PIN CONNECTOR FS 12-.5/18.25

SLIP RING ES12A		MALE PIN CONNECTOR FS 12-.5/18.25	
SLIP RING CIRCUIT No.	SLIP RING WIRE COLOR	CONNECTOR PIN No.	CONNECTOR WIRE COLOR
10	WHITE	1	WHITE
2	BROWN	2	BROWN
6	GREEN	3	GREEN
5	YELLOW	4	YELLOW
9	GREY	5	GREY
11	WHITE/BLACK	6	PINK
7	BLUE	7	BLUE
3	RED	8	RED
4	ORANGE	9	ORANGE
12	WHITE/BROWN	10	TAN
1	BLACK	11	BLACK
8	VIOLET	12	VIOLET

ES12A SLIP RING SPECS
CIRCUITS: 12
MAXIMUM OPERATING SPEED: 100 RPM CONTINUOUS
MAXIMUM VOLTAGE PER CIRCUIT AC or DC: 120V
MAXIMUM AMPS PER CIRCUIT: 2 AMPS
LEAD WIRE SIZE: 26 GAUGE, SILVER PLATED COPPER
LEAD WIRE LENGTH: 48 INCHES
CONTACT MATERIAL: GOLD
TEMPERATURE RANGE: -40°F TO +176°F (-40°C TO +80°C)