

ROTOSEAL SWIVEL JOINT INSTALLATION

Note: Two persons required for installation.

- Step 1: Insert two (2) 6" alignment studs (all thread) into the roto seal core. Utilize holes that are 180° apart.
- Step 2: Install o-rings into the underside of the top hat (bolted to the center of the turret base plate.) Utilize grease to hold the o-rings in place if required.
- Step 3: Raise roto seal barrel/core assembly into place near the top hat inside the pedestal. Ensure that the register on the underside of the top hat is aligned with the recess in the top of the core and lift the roto seal up until the alignment bolts pass through the top hat. 2nd person (above top hat) can now thread two (2) nuts onto the alignment bolts, allowing the barrel assembly to hang freely from the top hat.
- Step 4: Evenly tighten the two nuts to pull the barrel assembly up to the top hat. Ensure that the core contacts the top hat evenly and that the o-rings are not disturbed.
- Step 5: Install the supplied top hat to core retaining bolts. Tighten until snug.
- Step 6: Remove the two (2) alignment studs and replace with supplied retaining bolts. Tighten until snug.
- Step 7: Torque all retaining bolts to 20 ft-lbs utilizing a criss-crossing pattern.
- Step 8: If possible, rotate roto seal barrel to align the anti-rotation bar socket with the tabs on the I.D. of the pedestal.

NOTE: Due to tightness of the seals in a new roto seal, it may be necessary to connect all hoses and rotate crane under power to align socket with the tabs. Use caution to ensure hoses do not twist and/or kink as roto seal rotates inside pedestal.

- Step 9: Install anti-rotation bar in the socket and secure to roto seal with bolt and nut.

NOTE: If roto seal is mounted prior to installation of crane on pedestal, ensure the crane is lowered into place with the anti-rotation bar positioned between the tabs on the I.D. of the pedestal.