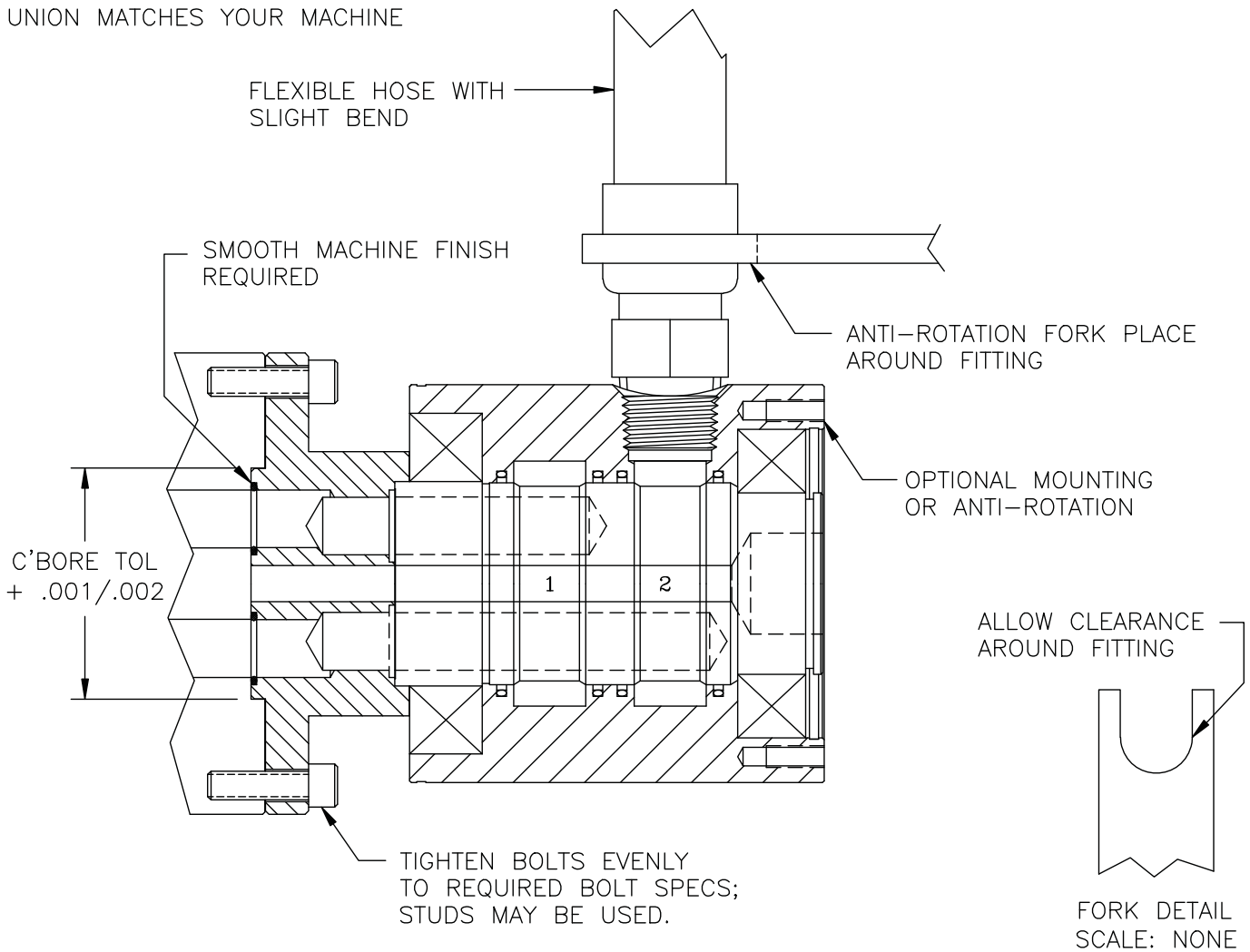


## INSTALLATION GUIDE - SERIES 013, 015, 017, 019, 021, 023, 025, 027

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