

Technical Service Bulletin 05T09
 5RP Rotary Union Drain

There is a drain on the side of the rotary union of your 5RP. (See the left hand picture below.) It is not installed correctly. The drain must be sloped to function as a gravity drain (See the center picture below) and the tubing size must be increased from 1/4" OD to 3/8" OD.

Snip the wire ties that secure the existing plastic tube. Remove the existing fitting from the union. Install a similar fitting sized for 3/8" OD tubing. The SSI PN is HF-5000-468. The complete fitting description is Prestolok 1169-6-2S, 1/8" NPT by 3/8" OD tube 90° male swivel adapter. This type of fitting can be tightened in any position. The tubing should be 3/8" OD x 24" long clear vinyl tubing (SSI PN: HF-5000-469).

To install the tubing, push it into the fitting about 3/4". (To remove the tubing depress the ring while pulling the tube.) The tubing end should be cut square and the outside should be smooth so it seats and seals properly. The tubing must slope down as shown and must not contact the edge of the guard or otherwise pull on the union. Use wire ties to secure the tube to the vertical coolant pipe. Do not overly tighten the ties or pinch the tubing. Route the tube down the pipe and angle the discharge toward the back. The fitting should be centered in the slot in the guard. To accomplish this it might be necessary to loosen the red hose and twist it about the barbed fitting in the top of the union. Raise and lower the spindle to confirm all is well.

The union is capable of dry-running. When dry, its rotary seal faces are disengaged. Under normal flow conditions the rotary faces are engaged to prevent leakage. Under low-flow conditions the seal faces may be disengaged and leak and hence the need for the drain. Avoid the low flow condition that causes the seal to leak. Adjust the flow either off or high enough to prevent the leakage.

There are a total of 4 drain ports around the union. One port must drain and the other 3 must remain plugged. Failure to implement this change will void the warranty on the union.

