



# How to Repair a High-Pressure Swivel, 1/4"

## Using Kit #12608

These instructions will demonstrate how to replace components of an AccuStream High-Pressure Swivel, 1/4" with kit #12608

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## TOOLS:

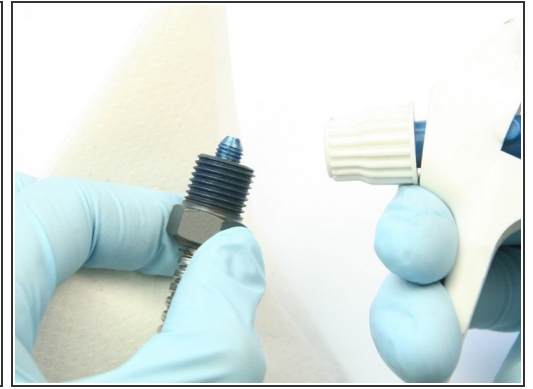
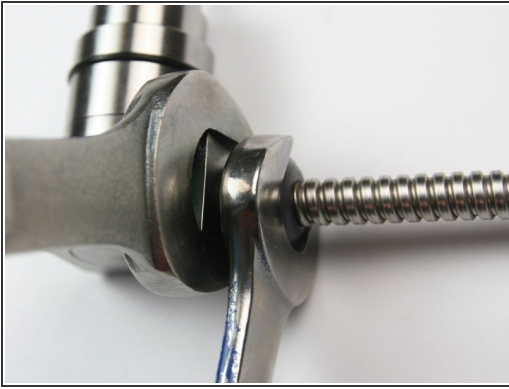
- [3/4" wrench](#) (1)
- [5/8" wrench](#) (1)
- [Pick](#) (1)
- [Gauge pin .300-.360](#) (1)



## PARTS:

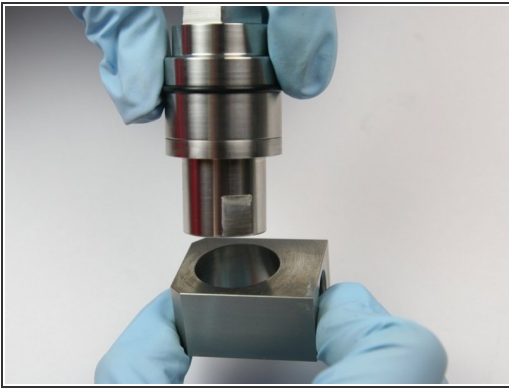
- [Minor Swivel, 1/4" Repair Kit #12608](#) (1)
- [Swivel Bearing Back-up #13642](#)  
(included in kit) (1)
- [Thrust Bearing Washer #13645](#) (included  
in kit) (2)
- [Thrust Bearing #13644](#) (included in kit)  
(1)
- [Seal, 1/4" Swivel #12867](#) (included in kit)  
(1)
- [O-ring, "Red" #12662-008](#) (included in  
kit) (1)
- [O-ring #11679-022](#) (included in kit) (1)
- [High-Vacuum Grease #11447](#) (included  
in kit) (1)
- [Swivel Shaft #13633](#) (1)
- [Wiper, .250 ID X .500 OD 70D #13651](#)  
(1)
- [Swivel Bearing #13646](#) (1)
- [Swivel Housing, Bearing Half, 1/4"  
#13650](#) (1)
- [Swivel Housing, Seal Half #13641](#) (1)
- [Swivel Collar #13643](#) (1)
- [Blue Goop #11111](#) (1)
- [Lithium Grease](#) (1)
- [Isopropyl Alcohol](#) (1)

## Step 1 — How to Repair a High-Pressure Swivel, 1/4" Using Kit #12608



- Loosen the high-pressure gland nut from swivel collar with 5/8" and 3/4" wrench.
- Unthread the high-pressure gland nut from the swivel collar.
- Clean the high-pressure gland nut and the high-pressure tubing cone with isopropyl alcohol or a similar cleaning agent.

## Step 2



- Remove the swivel collar from the swivel housing.
- Loosen the high-pressure gland from the coupling with 1-1/16" and 5/8" wrench.
- Unthread the high-pressure gland at the top of the swivel shaft from the coupling.

### Step 3



- Uthread the high-pressure collar from the threads of the swivel shaft.
- Remove the high-pressure gland and collet from the swivel shaft.
- Clean the high-pressure gland of all Blue Goop with isopropyl alcohol.

### Step 4



- Use two 3/4" wrenches to separate the bearing half and seal half of the swivel housing.
- Unthread bearing half from seal half of the swivel housing.
- Remove the swivel shaft from the bearing half of the swivel housing by pushing down through the wiper.
- When removing the swivel shaft, the top thrust washer could stick to the inside top of the bearing half.

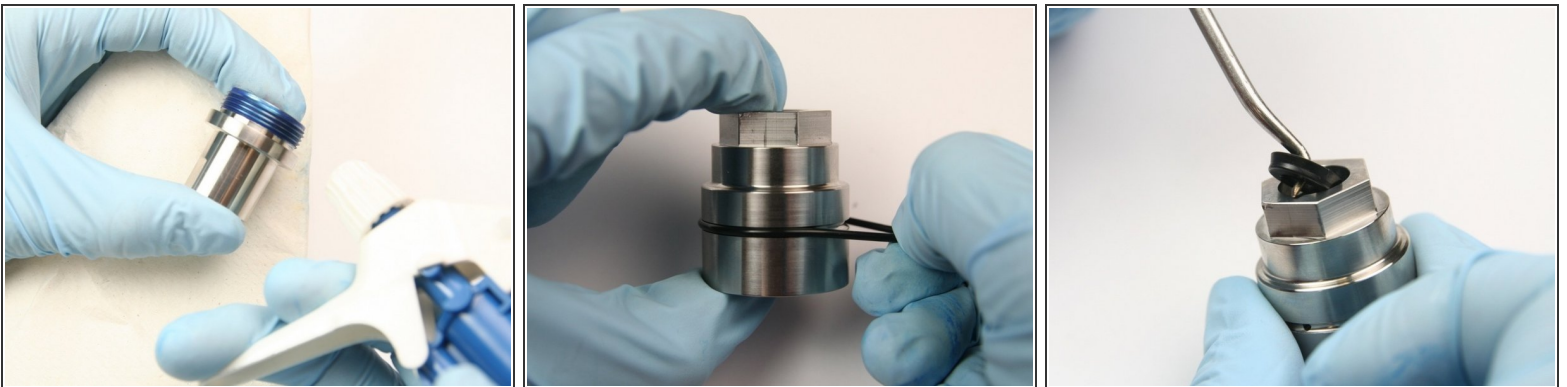


## Step 5



- Remove the thrust washers and the thrust bearing from the swivel shaft.
- Remove the bearing back-up from the seal half of the swivel housing.
- Remove the high pressure seal assembly from the seal half of the swivel housing with a pick.  
**⚠ Be sure not to scratch the ID of the swivel housing with a pick.**

## Step 6



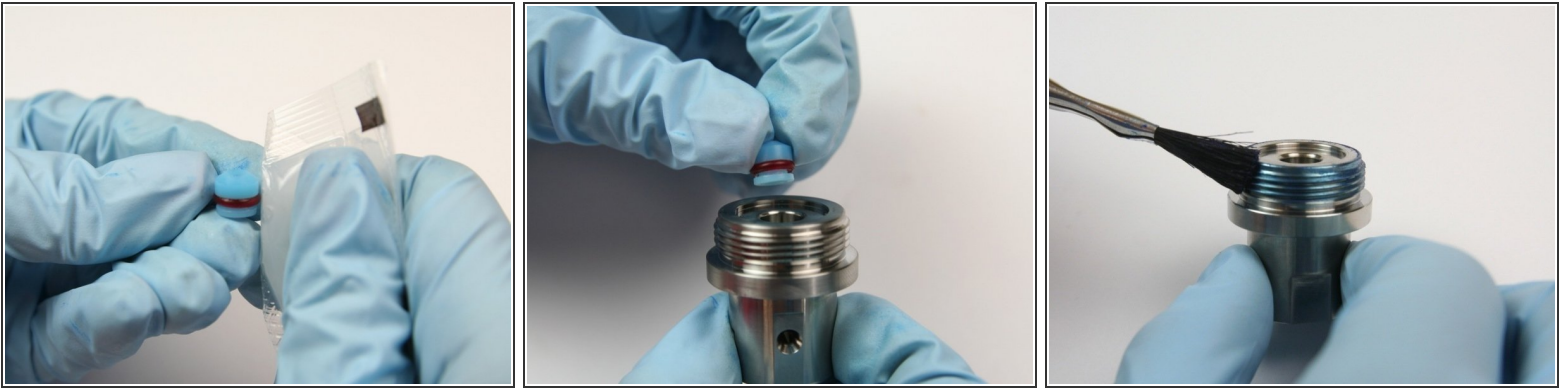
- Clean the seal half of the swivel housing of all Blue Goop with isopropyl alcohol or a similar cleaning agent.
- Remove the O-ring from the bearing half of the swivel housing.
- Remove the wiper from the top of the bearing half of the swivel housing with a pick.

## Step 7



- Remove the swivel bearing from the bearing half of the swivel housing by pushing a .300-.360 gauge pin through the bearing half.
- Clean the bearing half of the swivel housing with isopropyl alcohol or a similar cleaning agent.
- Apply a layer of [high vacuum grease](#) into the cavity of the seal half of the swivel housing.

## Step 8



- Apply a layer of high vacuum grease to the high-pressure seal from the kit.
- Put the high-pressure seal from the kit, with the O-ring down, into the cavity of the seal half of the swivel housing.
- Apply a layer of [Blue Goop](#) to the threads of the seal half of the swivel housing.

## Step 9



- Put the bearing back-up into the seal half of the swivel housing on the top of the high-pressure seal with a .300-.360 gauge pin until it bottoms out.
- Be sure that the swivel bearing is flush with the bottom of the cavity of the bearing half of the swivel housing.
- Clean the swivel shaft of all lithium grease and Blue Goop with isopropyl alcohol or a similar cleaning agent.

## Step 10



- Apply lithium grease to the shelf of the swivel shaft.
- Put the first thrust washer from the kit onto the swivel shaft.
- Apply lithium grease to the top of the first thrust washer.

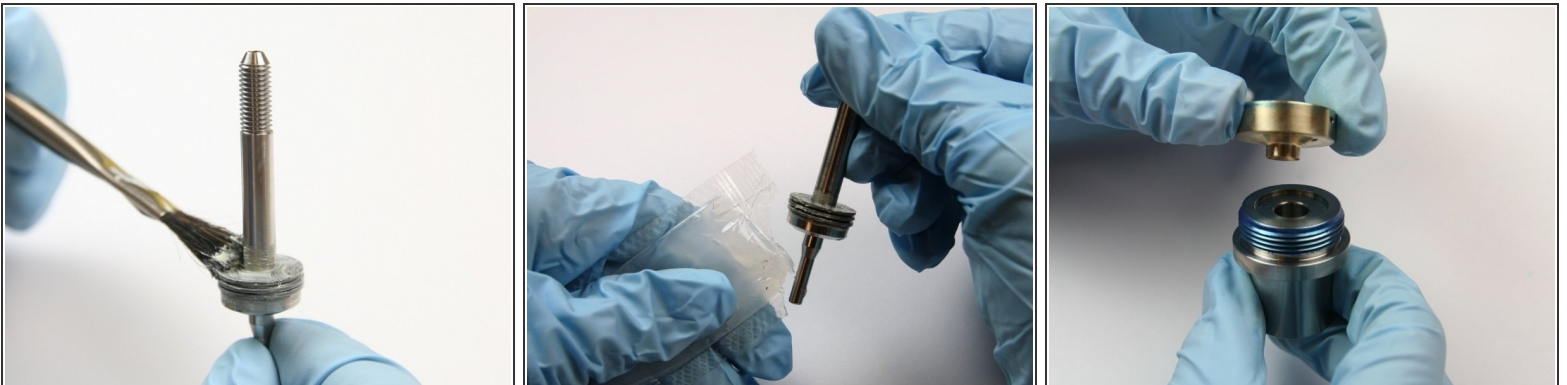


## Step 11



- Put the thrust bearing onto the swivel shaft.
- Apply lithium grease to the top of the thrust bearing.
- Put the second thrust washer onto the swivel shaft.

## Step 12



- Apply lithium grease to the top of the thrust washer.
- Apply high vacuum grease to the short end of the swivel shaft.
- Put the back-up bearing into the top of the seal half of the swivel housing.



## Step 13



- Put the short end of the swivel shaft into the back-up bearing until it bottoms out.
- Thread the bearing half of the swivel housing onto the seal half of the swivel housing.
- Tighten both seal half and bearing half of the swivel housing using two 3/4" wrenches.

## Step 14



- Put the wiper over the swivel shaft and down into the top of the bearing half of the swivel housing.
- Put the O-ring over the swivel shaft and into the groove of the swivel body.
- Put the swivel housing into the swivel collar with the high-pressure inlet hole facing through the collar hole.

## Step 15



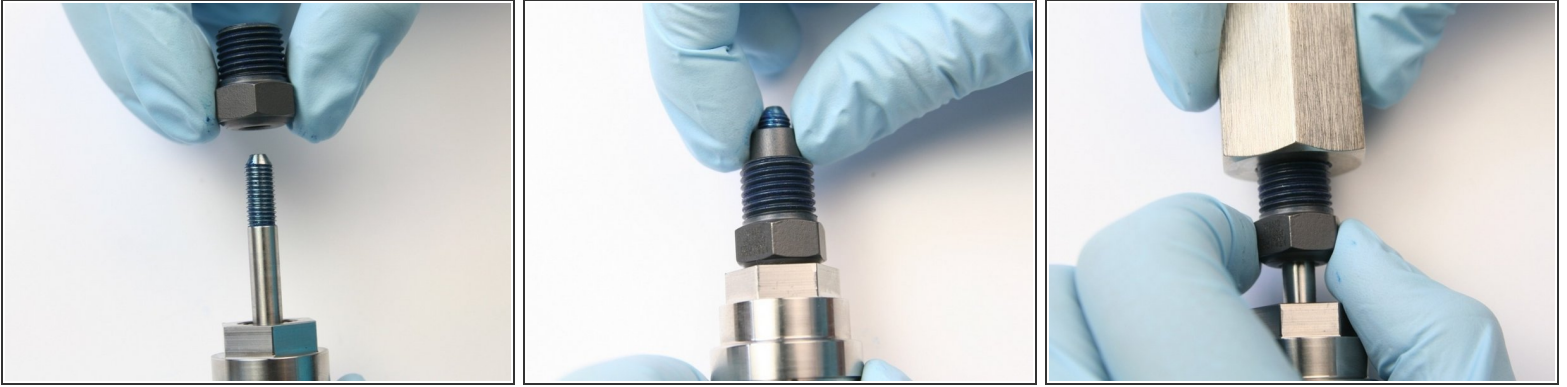
- Apply Blue Goop to the high-pressure gland nut threads.
- Thread the high-pressure gland nut into the swivel collar.
- Tighten the high-pressure gland nut with 3/4" and 5/8" wrench.

## Step 16



- Apply Blue Goop to the high-pressure gland nut threads.
- Put the collet with the tapered side down into the high-pressure gland nut.
- Apply Blue Goop to the swivel shaft threads.

## Step 17



- Slide the high-pressure gland with the collet onto the swivel shaft.
- Thread on the collar to the bottom of the threads of the swivel shaft.
- Thread the high-pressure gland into the coupler.

## Step 18



- Tighten the high-pressure gland into the coupler with 1-1/16" and 5/8" wrench.