



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

Written By: Adam Dumas



 **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



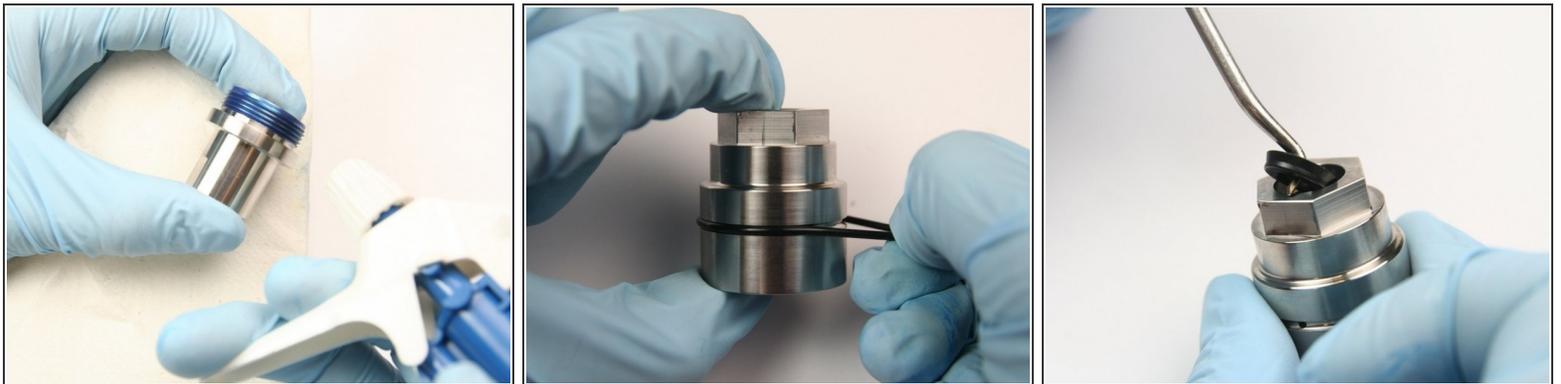
- Use two 3/4" wrenches to separate the bearing half and seal half of the swivel housing.
- Unthread bearing half from seal half of the swivel housing.
- Remove the swivel shaft from the bearing half of the swivel housing by pushing down through the wiper.
 - When removing the swivel shaft, the top thrust 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 to not scratch the ID of the swivel housing with a pick.**

Step 6



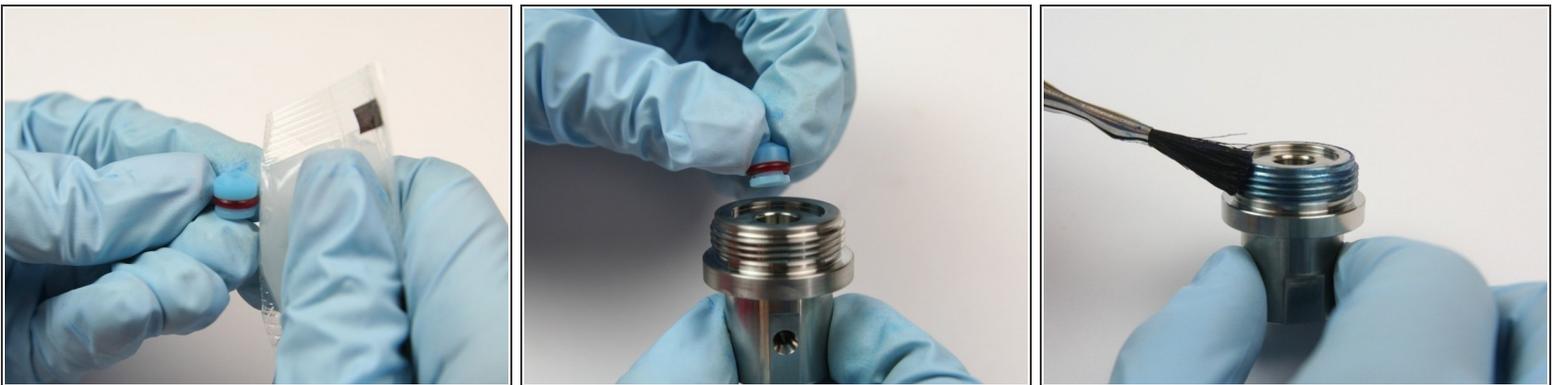
- Clean the seal half of the swivel housing of all Blue Goop with isopropyl alcohol or a similar cleaning agent.
- Remove the O-ring from the bearing half of the swivel housing.
- Remove the wiper from the top of the bearing half of the swivel housing with a pick.

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.