



How to Repair a 1/4", Minor Swivel using kit #12864

These instructions will demonstrate how to replace components of an AccuStream Style 1/4" Swivel with kit #12864

Written By: Adam Dumas





TOOLS:

- 1-1/8" wrench (2)
- 11/16" wrench (1)
- 3/4" wrench (1)
- 5/8" wrench (1)



PARTS:

- 1/4" Minor Swivel Repair Kit #12864 (1)
- Seal, 1/4" Swivel #12867 (included in kit) (1)
- High-Pressure O-ring "Red" #12662-008 (Included in kit) (1)
- Back-up, 1/4" F-F Swivel #12872 (included in kit) (1)
- Wiper #12875 (included in kit) (1)
- Thrust Bearing, #12181 (included in kit) (1)
- Thrust Washer #12874 (included in kit) (1)
- 4-40 X 1.25 SHCS (included in kit) (2)
- High-Vacuum Grease #11447 (included in kit) (1)
- Dowel (1)
- Swivel Nut #12868 (1)
- Swivel Housing, Seal Half #12871 (1)
- Swivel Housing with Bearing #12870 (1)
- Swivel Shaft, 1/4 F-F #12869 (1)
- -123 O-ring #11679-123 (1)
- 1/4" High-pressure Collar #13157-60-4 (2)
- 1/4" High-Pressure Gland #13158-60-4 (2)
- Lithium Grease (1)
- O-ring Lube #13969 (1)
- Blue Goop #11111 (1)

Step 1 — How to Repair a 1/4", Minor Swivel using kit #12864



- Loosen [high-pressure gland](#) from swivel nut with a 5/8" and 11/16" wrench.
- Unthread the high-pressure gland from the swivel nut.
- Loosen high-pressure gland from base of swivel housing with a 1-1/8" and 5/8" wrench.

Step 2



- Unthread the high-pressure gland from the base of the swivel housing.
- Loosen the bearing half of the swivel housing from the seal half of housing with two 1-1/8" wrenches.
- Unthread the bearing half of the swivel housing from the seal half of the swivel housing.

Step 3



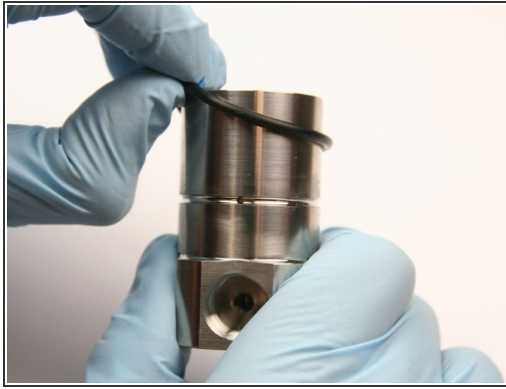
- Loosen the swivel nut from the swivel shaft with a 3/4" and 11/16" wrench.
- Unthread the swivel nut from the swivel shaft.
- Remove the thrust washers and the thrust bearing from the swivel shaft.

Step 4



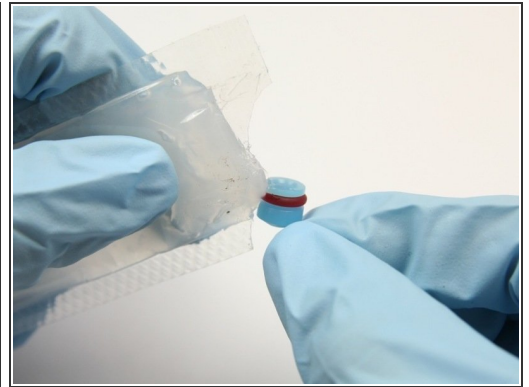
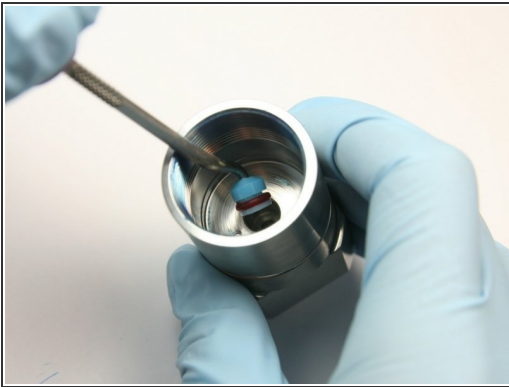
- Clean the swivel of all Blue Goop and lithium grease with isopropyl alcohol or a similar cleaning agent.
- Clean the swivel nut of all Blue Goop with isopropyl alcohol or a similar cleaning agent.
- Remove the wiper from the top of the bearing half of the swivel housing with a pick.

Step 5



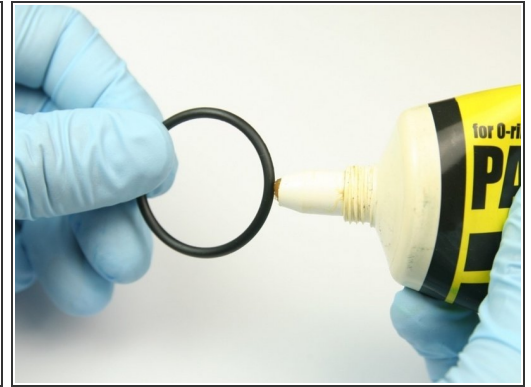
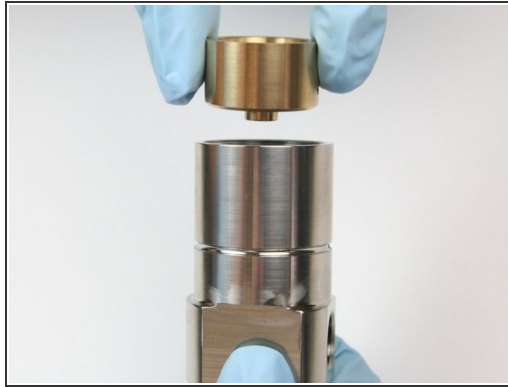
- Clean all Blue Goop from the bearing half of the swivel housing with isopropyl alcohol or a similar cleaning agent.
- Remove the O-ring from the outside of the seal half of the swivel housing.
- Remove the back-up bearing from the seal half of the swivel housing.
 - ❗ If the back-up sticks in the housing, thread included 4-40 x 1.25 SHCS in to the back-up to remove from the housing.

Step 6



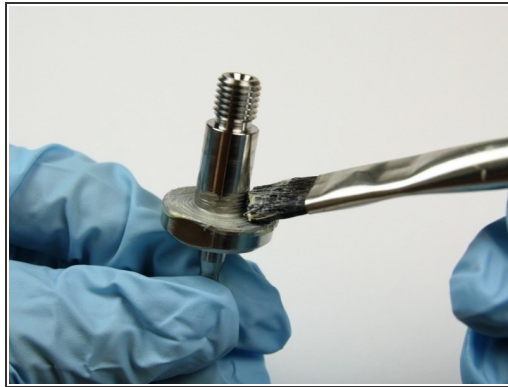
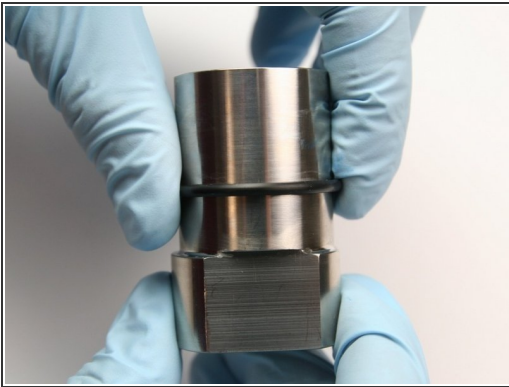
- Remove the high-pressure seal from the inside of the seal half of the swivel housing with a pick.
 - ⚠ Be sure to not scratch the ID of the housing with a pick.
- Clean the seal half of the swivel housing of all Blue Goop and any extra lubricants with isopropyl alcohol or a similar cleaning agent.
- Apply [high vacuum grease](#) to the high-pressure seal.

Step 7



- Put high-pressure seal, with the O-ring first, into the bore of the seal half of the swivel housing using a dowel.
- Place the back-up bearing into the seal half of the swivel housing with the small stepped end down.
- Apply a layer of O-ring lube to the O-ring.

Step 8



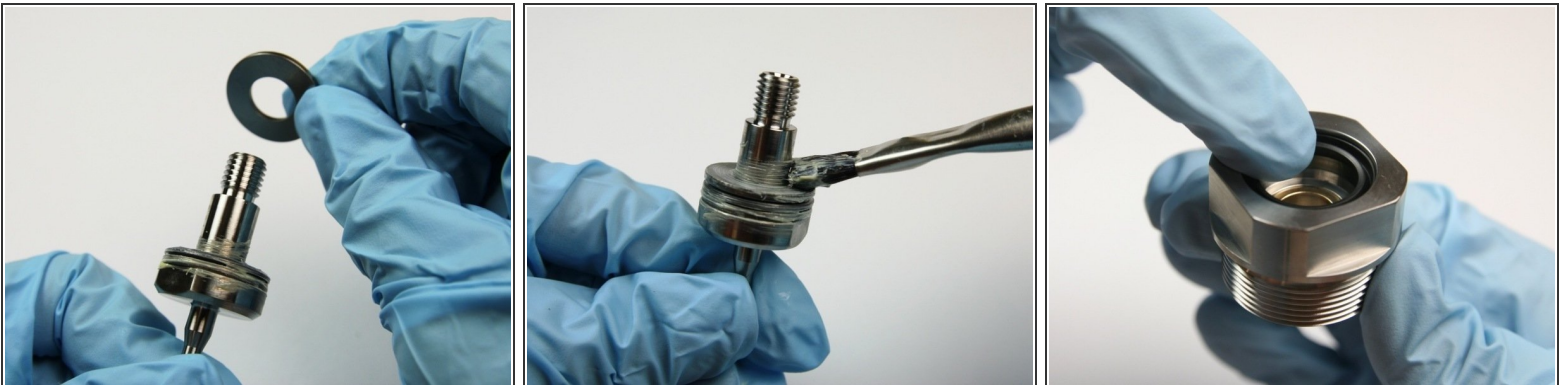
- Place the O-ring onto the seal half of the swivel housing in the groove.
- Apply lithium grease to the base of the swivel shaft.
- Place the first thrust washer onto the swivel shaft.

Step 9



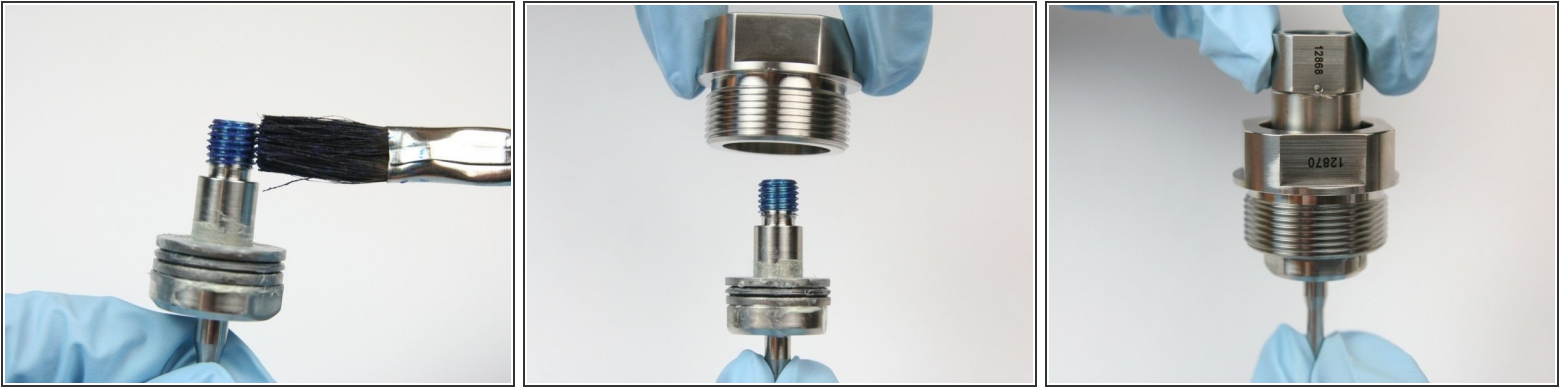
- Apply lithium grease to the top of the thrust washer.
- Place the thrust bearing onto the swivel shaft.
- Apply lithium grease to the top of the thrust bearing.

Step 10



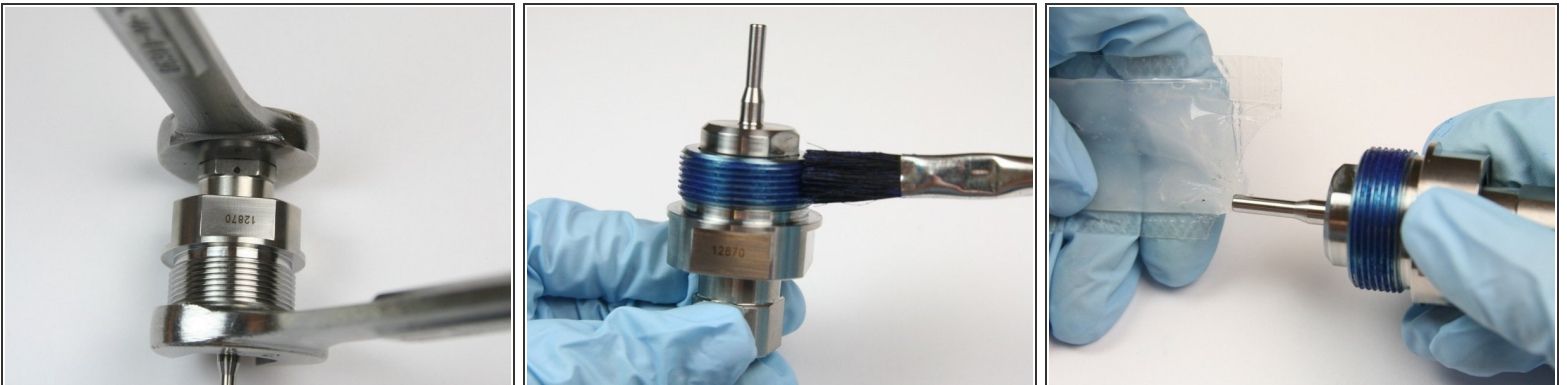
- Put the second thrust washer onto the swivel shaft.
- Apply lithium grease to the top of the thrust washer.
- Put the wiper into the top of the bearing half of the swivel housing with the tapered end down.

Step 11



- Apply Blue Goop to threads of swivel shaft
- Put swivel shaft ,threads first, through bottom (thread side) of bearing half of swivel housing
- Thread swivel nut onto swivel shaft

Step 12



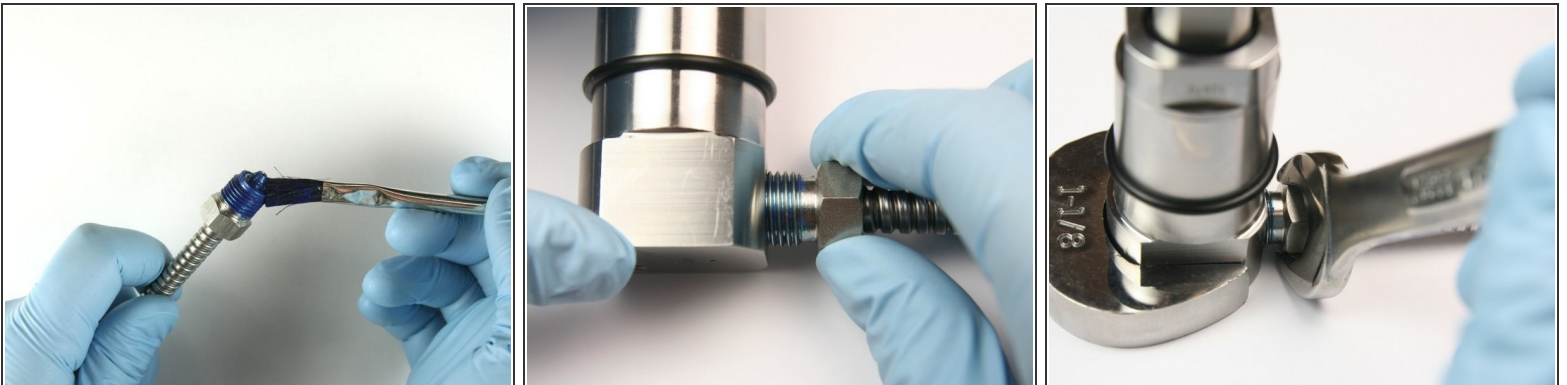
- Tighten swivel nut to swivel shaft
- Apply Blue Goop to threads of bearing half of swivel housing
- Apply high vacuum grease to stem of swivel shaft

Step 13



- Thread bearing half of swivel housing into seal half of swivel housing.
- Tighten bearing half of swivel housing to seal half of swivel housing with two 1-1/8" wrenches.
- Clean high-pressure gland of all Blue Goop.

Step 14



- Apply Blue Goop to threads of high-pressure gland.
- Thread high-pressure gland into seal half of swivel housing.
- Tighten high-pressure gland into seal half of swivel housing with 1-1/8" and 5/8" wrench.

Step 15



- Clean high-pressure gland of all Blue Goop with isopropyl alcohol
- Apply Blue Goop to threads of high-pressure gland.
- Thread high-pressure gland into swivel nut.

Step 16



- Tighten high-pressure gland into swivel nut with 5/8" and 11/16" wrenches.