Rotating Unions

<table>
<thead>
<tr>
<th>Series</th>
<th>6500</th>
<th>6600</th>
<th>6700</th>
</tr>
</thead>
</table>
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1 For your Safety

This chapter provides information on the safe handling of DEUBLIN rotating unions.

- For your own safety and the safety of other people read this operating manual carefully and completely prior to working on or with DEUBLIN rotating unions.
- This operating manual exclusively describes the rotating unions of the manufacturer DEUBLIN. In the further description/explanation the name “DEUBLIN” is left out for a better readability.
- This operating manual is a material part of the specified rotating unions. The operator is responsible for the personnel to take note of this manual.
- The operator of the rotating unions shall not make any modifications or attachments to and retrofitting of the rotating union without the manufacturer’s consent.
- Please follow the additional instruction „Installation“ for a secure and correct installation of the rotating union. The installation instruction is included with the delivered union.

1.1 Intended Use

The rotating unions of the series 6500, 6600 and 6700 supply the feeding of the following media: Water and Thermal oil.

<table>
<thead>
<tr>
<th>Series</th>
<th>Model</th>
<th>Max. Temperature (°C)</th>
<th>Max. Pressure (Bar)</th>
<th>Max. Speed (U/min)</th>
<th>Medium</th>
</tr>
</thead>
<tbody>
<tr>
<td>6500</td>
<td>6501 - 6506</td>
<td>160°</td>
<td>10</td>
<td>1300</td>
<td>Water ●</td>
</tr>
<tr>
<td>6500</td>
<td>6507 - 6510</td>
<td>160°</td>
<td>10</td>
<td>750</td>
<td>●</td>
</tr>
<tr>
<td>6600</td>
<td>6601 - 6606</td>
<td>160°</td>
<td>12</td>
<td>1300</td>
<td>●</td>
</tr>
<tr>
<td>6600</td>
<td>6607 - 6610</td>
<td>160°</td>
<td>12</td>
<td>750</td>
<td>●</td>
</tr>
<tr>
<td>6700</td>
<td>6701 - 6706</td>
<td>230° *</td>
<td>10</td>
<td>1300</td>
<td>●</td>
</tr>
<tr>
<td>6700</td>
<td>6707 - 6710</td>
<td>230° *</td>
<td>10</td>
<td>750</td>
<td>●</td>
</tr>
</tbody>
</table>

* For applications with higher temperatures please ask DEUBLIN.

The rotating unions referred to are designed for non-potentially explosive environments and non-combustible media. Details on the operating range of the rotating unions are provided in the catalogue and/or the model-specific installation drawing.

The rotating unions of the series 6500, 6600 and 6700 can be used as one-way or two-way version depending on the type of connection.
1.1.1 Application one-way version (Mono)

For the one-way version, models are available which can be installed at the machine shaft from the outside or in the machine shaft.

Rotating union externally mounted

![Diagram of Rotating Union Externally Mounted]

Fig. 1: Schematic diagram one-way version (Mono – externally mounted)

A one-way version of the rotating union is mounted at each of the two ends of the roller. The rotating union (A) conveys the medium flow into the roller. The rotating union (B) conveys the medium flow into the piping system of the machine.

1.1.2 Application two-way version (Duo)

The rotating unions of the 6500, 6600 and 6700 series are also available as two-way model (Duo).

Through the elbow fitting, the medium flow is guided through a supply tube into the machine shaft. The escaping medium flow is collected by the same rotating union and fed into the piping system of the machine through the radial connection.

1.2 Misuse

This chapter provides information on known misuse of rotating unions of the 6500, 6600 and 6700 series.

The rotating unions are not suitable for the areas and applications described herein. Use in such areas or for such applications constitutes a misuse endangering people and machines and is therefore prohibited.

Prohibition for the following areas:

- **Potentially explosive areas**
  The rotating unions of the 6500, 6600 and 6700 series shall not be used in potentially explosive areas, as they are not approved for the requirements in potentially explosive areas. Operation in such areas may cause explosions.

- **Food**
  Food, cleaning and disinfectant residues cannot be removed from the rotating unions. People may suffer poisoning.
Prohibition for the following applications:

- **Conveying of combustible media or hydrocarbons**
  Combustible media or hydrocarbons may ignite or cause explosions.
  **Exception:** Thermal oil within the admissible temperature range. Please observe the safety data sheet of the used thermal oil.

- **Connection to a piping system with excessive pressure**
  If excessive pressure is applied to the rotating unions, supply pipes can come off and cause personal injury or property damage.

- **Use of a centralised lubrication system**
  If the grease for relubrication is supplied by a central lubrication system to the rotating unions, the grease may lose its essential characteristics. The bearings of the rotating unions will be damaged.

- **Operation without lubrication**
  Dry operation (without medium) of the rotating union causes damage to the axial face seals.

- **Connection to fixed pipes**
  In case of connection to fixed pipes, the rotating unions may leak and the ball bearing may be damaged.

- **Conveying of media which are too hot**
  If the media exceed the maximum admissible temperature for the rotating union, the static seals (elastomeric seals) can be damaged which may result in leaky rotating unions and personal injury or property damage.

- **Conveying of vapour**
  Escaping vapour may injure people seriously.

This list is not comprehensive and will be updated with results from product observation.

### 1.3 Safety Instructions

This chapter provides information on the hazards through rotating unions.

#### 1.3.1 Hazards due to hot surfaces

The rotating unions are heated by the temperature of the medium. Skin contact with heated rotating unions can cause injuries.

- Use safety gloves and PPE (Personal Protective Equipment) protecting against heat when handling the rotating union.

- Attach a clearly visible danger sign visibly on/next to the rotating union in order to warn of danger.

#### 1.3.2 Hazards by improper hoses

For the connection of the rotating union to the machine, you have to choose appropriate hoses for the respective medium, which meet, the specifications for the application.

If you use incorrect hoses, they may become porous or burst. This can cause personal injury and/or property damage to components of the machine.

- In case of the media water and thermal oil, use hoses which are suitable for the maximum system pressure of the machine and the maximum temperature of the media.
1.3.3 Hazards due to the media
When working on the rotating union, injuries can be caused by skin or eye contact with the media.
- Observe the safety instructions for the flow media.

1.3.4 Hazards by faulty installation
If the rotating unions are installed incorrectly, hoses and connections may become leaky. The medium can escape. Depending on the medium, personal injury or property damage to the components of the machine may occur.
- Before installing the rotating union ensure that no feed pressure and no residual pressure is applied to the pipeline system of the machine.
  - Please follow the additional instruction “Installation” for a secure and correct installation of the rotating union. The installation instruction is included with the delivered union.
- Install the rotating union on the machine using hoses only, in order to avoid stress on the rotating union.
- Install the hoses free from stress.
- Install the rotating union in a way that the leaking medium can be carried away securely downward at the lowest point and that the drain line shows a fall (min. 15°).
- Install the hoses to the rotating union prior to mounting it at the machine shaft. Hoses with SAE connection are excluded.

1.4 Structure of Pictograms
This chapter provides information on the meaning of the pictograms used in the manual.

- **Warning**
  Potentially dangerous situation, which may result in death or serious injury.

- **Note**
  Potentially harmful situation in which the product or surrounding objects can be damaged.

- **Application notes**
  and other useful information.

2 Information as to this Manual
The copyright as to this manual remains with DEUBLIN. Subject to changes!
- You can download the latest version of this manual under www.deublin.com.
- Always use the latest version of the operating manual.
3 Information on the Name Plate

Fig. 3: Name plate

The coding of the model number is described in the catalogue. The model number corresponds to the order number.

4 Information on the Design

This chapter provides information as to which items have to be observed in the design in order to have a positive effect on the service life of the rotating union.

You can obtain the drawings of the rotating unions from DEUBLIN in order to integrate the rotating union in your drawing. You will need the model-specific installation drawing of your rotating unions for a secure set-up and operation of the rotating unions.

The model-specific installation drawing of the respective rotating union contains e.g.:
- torque moments of the union
- technical data
- tolerances
- approved media

4.1 Filtering of the Medium

Unfiltered media with a particle size of more than 60 μm, increased wear of the rotating union.

The larger the particles in the media, the higher the wear of the rotating union is. The higher the total of all particles (polluting load), the higher the wear is.

- Insert a filter in front of the rotating union which filters particles with a size of 60 μm and larger from the media.
4.2 Connecting Options of the Rotating Union at the Machine Shaft

The rotating unions can be fastened on the machine shaft by screwing (A) or by means of a flange (B) depending on the rotating union.

4.3 Options of Hose Installation

The following examples show how to install the hoses at the rotating unions. These connecting options ensure that the hoses do not transfer stress to the rotating unions when the machine shaft moves.

- Please pay attention to the chapter “1.3 Security Advices” regarding the design.

4.3.1 Connection of hose to the rotating union

The hoses must be installed without stress and bends so that they do not apply any forces to the rotating union. The following figures show examples of installation.

If the hoses are to be guided away from the rotating unions vertically and bent by 90°, connect the hoses as shown.

Fig. 4: Options for the installation on the machine shaft

Fig. 5: Hoses bent by 90°
4.3.2 Hose connection for hoses with SAE flange

Only possible, if the rotating union is ordered with SAE connections.

The hoses are fastened at the rotating union by means of its SAE flanges using four screws.

Fig. 6: Flange connection

5 Installation

The union installation is described in an additional manual which is supplied with each rotating union. Please follow the additional instruction “Installation” for a secure and correct installation of the rotating union. The instruction “Installation” is available online under www.deublin.com.

- Ensure that the person installing the rotating union receives the following information:
  - Position and location of the rotating union in the machine
  - Plan for connection of hoses
  - Position of leakage line
  - Information on the media
  - Information on the drain (optional)
  - Model specific installation drawing

6 Information on the Operation

Damage to components due to missing lubrication (Dry run)
The axial face seals of the rotating unions are lubricated by the medium. If the rotating unions are operated without medium present they are not lubricated and will thus be damaged.

- Ensure that the rotating unions are operated with a lubricating medium.
- Switch off the plant/machine, if the rotating unions are operated without medium.
7 Storage

Damage of component due to incorrect storage
If you store the rotating unions incorrectly, they become leaky or get damaged.

- Store the rotating unions in a dry space between 3 °C and 40 °C.
- Store rotating unions for two years at the most.

8 Maintenance

This chapter provides information on how to extend the service life of the rotating unions by means of maintenance.

8.1 Maintenance Intervals
You can avoid early wear of the rotating unions, if you adhere to the maintenance intervals described herein.

Risk of injury due to hot surfaces
The rotating unions are heated by the temperature of the medium. Skin contact with these heated rotating unions can cause severe injuries.

- Before starting to work on the rotating union, allow the machine to cool down.
- Use safety gloves and PPE (Personal Protective Equipment) protecting against heat or cold depending on the application of the rotating unions.

8.2 Daily Inspection
Check the rotating unions for tightness.

Risk of injuries due to applied line pressure
If you have to work on the rotating union and feed pressure of the medium is applied or there is residual pressure in the piping system of the machine, the medium can escape under pressure when releasing the connections. You and other people may suffer severe injuries.

- Ensure that no feed pressure is applied.
- Ensure that there is no residual pressure in the piping system.

During operation of the machine, leakages may occur at the connections and hoses depending on the requirements to the rotating unions.

1. Carry out daily visual inspections in order to check whether leakages occurred at the connections (see arrows).

If you detect leakage:
1. Stop the machine.
2. Replace the defective hoses with new ones.
3. Seal leaking connections.
4. If the rotating union is worn and leaks, replace it with a new one. Repair kits for various models can be obtained from DEUBLIN.
8.3 Maintenance after Operating Hours

This chapter describes how to relubricate the rotating unions.

The indicated volumes of grease and intervals for relubrication are based on experience resulting from the information of the manufacturer of the lubricant and the operating parameters of the rotating unions. The information given herein refers to operating hours depending on the respective speed.

In case of doubt, consult DEUBLIN.

Lubricate the ball bearings of the rotating unions at the stated lubricating intervals using the listed volume of grease suitable for the operating conditions. If you do not adhere to these instructions, the service life of the ball bearings is reduced.

8.3.1 Allowed lubricants

<table>
<thead>
<tr>
<th>Series</th>
<th>allowed lubricants</th>
</tr>
</thead>
<tbody>
<tr>
<td>6500, 6600</td>
<td>DU PONT COSTENOBLE KRYTOX XHT-RUF</td>
</tr>
<tr>
<td></td>
<td>KLÜBER BARRIERTA L55/2</td>
</tr>
<tr>
<td></td>
<td>LUBCON TURMOTEMP II/400</td>
</tr>
<tr>
<td>6700</td>
<td>contains no lubricant, lubricated by media</td>
</tr>
</tbody>
</table>

8.3.2 Volume of grease for lubrication

The rotating unions of the 6500 and 6600 series will be delivered with an initial lubrication.

Damage to the component due to excessive grease
If you put too much grease in the ball bearings, they can be damaged.

Adhere to the stated volumes of grease for lubrication, e.g. by weighing the necessary amount of grease.

Damage of part by loss of grease quality
If e.g. the grease for relubrication is supplied by a central lubrication system to the rotating unions, the grease may lose its essential characteristics. The bearings of the rotating unions will be damaged.

Make sure only fresh new grease is fed to the bearings.

Comply with the specifications for service life of the grease manufacturer.

<table>
<thead>
<tr>
<th>Models</th>
<th>Volume of grease</th>
<th>Models</th>
<th>Volume of grease</th>
<th>Models</th>
<th>Volume of grease</th>
</tr>
</thead>
<tbody>
<tr>
<td>6501, 6601</td>
<td>5 g</td>
<td>6505, 6605</td>
<td>19 g</td>
<td>6509, 6609</td>
<td>100 g</td>
</tr>
<tr>
<td>6502, 6602</td>
<td>9 g</td>
<td>6506, 6606</td>
<td>25 g</td>
<td>6510, 6610</td>
<td>144 g</td>
</tr>
<tr>
<td>6503, 6603</td>
<td>16 g</td>
<td>6507, 6607</td>
<td>40 g</td>
<td></td>
<td></td>
</tr>
<tr>
<td>6504, 6604</td>
<td>16 g</td>
<td>6508, 6608</td>
<td>63 g</td>
<td></td>
<td></td>
</tr>
</tbody>
</table>
8.3.3 Relubrication intervals for series 6500, 6600

The relubrication intervals depend upon the conditions of use of the rotating unions. This engineering instruction applies to rotating unions of the 6500 and 6600 Series and shows the recommended relubrication intervals and amount of grease. Either KLÜBER BARIERTA L55/2, LUBCON TURMOTEMP II/400 or DU PONT COSTENOBLE KRYTOX XHT-RUF must be used.

![Graph showing relubrication intervals](image)

The values mentioned in 8.3.2 are estimates supplied by the grease manufacturer and are for reference only. Actual grease service life and relubrication intervals vary by application and need to be determined by field experience depending on the specific application, starting with conservative intervals and increasing gradually based on previous results.

8.3.4 Special instruction of models

**6506-230-131032, 6507-230-131032, 6507-231-131032 and 6507-232-131033**

This engineering instruction is valid for the rotating unions 6506-230-131032, 6507-230-131032, 6507-231-131032 and 6507-232-131033 for “Hot Media” up to 160 °C and shows the subsequent relubrication intervals and the necessary volume of grease for KLÜBER BARIERTA KM 192.

Relubrication of the Rotating Union is required after 8,000 h.

<table>
<thead>
<tr>
<th>Models</th>
<th>Volume of grease (g) after 8,000 working hours</th>
</tr>
</thead>
<tbody>
<tr>
<td>6506-230-131032</td>
<td>36 g</td>
</tr>
<tr>
<td>6507-230-131032</td>
<td>40 g</td>
</tr>
<tr>
<td>6507-231-131032</td>
<td>36 g</td>
</tr>
<tr>
<td>6507-232-131033</td>
<td>36 g</td>
</tr>
</tbody>
</table>

8.3.5 Special instruction of models

**6506-230-131032, 6507-230-131032 and 6507-231-131032**

This engineering instruction is valid for the rotating unions 6506-230-131032, 6507-230-131032 and 6507-231-131032 for “Hot Media” up to 160 °C and shows the subsequent relubrication intervals and the necessary volume of grease for KLÜBER BARIERTA L55/2, LUBCON TURMOTEMP II/400, DU PONT COSTENOBLE KRYTOX XHT-RUF.
Please adhere to the chart and table below for the relubrication of the rotating union:

![Chart showing the relationship between operating hours and temperature for different models of rotating unions.]

<table>
<thead>
<tr>
<th>Models</th>
<th>Volume of grease (g)</th>
</tr>
</thead>
<tbody>
<tr>
<td>6506-230-131032</td>
<td>36 g</td>
</tr>
<tr>
<td>6507-230-131032</td>
<td>40 g</td>
</tr>
<tr>
<td>6507-231-131032</td>
<td>36 g</td>
</tr>
</tbody>
</table>

The values mentioned in 8.3.4 and 8.3.5 are estimates supplied by the grease manufacturer and are for reference only. Actual grease service life and relubrication intervals vary by application and need to be determined by field experience depending on the specific application, starting with conservative intervals and increasing gradually based on previous results.

8.3.6 Lubricate the rotating union

The following paragraphs describe how to place the grease gun and inject the stated volume of grease into the ball bearing.

1. Attach the grease gun to the lubricating nipple (see arrow).
2. Ensure that the connector of the grease gun is placed correctly on the lubricating nipple.
3. Actuate the grease gun in order to inject the stated volume of grease into the ball bearing.
4. Count the operating hours for the following lubrication interval.

Fig. 8: Attach grease gun for relubrication
9 Trouble Shooting

This chapter provides the following information:
1. Which problem may occur?
2. What can be the cause of the problem?
3. How can you eliminate this problem?

9.1 Potential Causes for Errors and their Elimination

**Risk of injuries due to applied line pressure**
If you have to work on the rotating union and feed pressure of the medium is applied or there is residual pressure in the piping system of the machine, the medium can escape under pressure when releasing the connections. You and other people may suffer serious injuries.

- Ensure that no feed pressure is applied.
- Ensure that there is no residual pressure in the piping system.

<table>
<thead>
<tr>
<th>Error</th>
<th>Potential causes</th>
<th>Elimination</th>
</tr>
</thead>
<tbody>
<tr>
<td>Rotating union is leaky after installation</td>
<td>Incorrect installation</td>
<td>1. Stop the machine.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2. Ensure that the connections are sealed according to the manual “Installation”.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. Ensure that all hoses are installed without stress.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4. Ensure that all seal faces are clean.</td>
</tr>
<tr>
<td>Seal faces of the rotating union are damaged</td>
<td></td>
<td>1. Pack rotating union (see Pack rotating union for transport, page 15).</td>
</tr>
<tr>
<td>Rotating union is defective</td>
<td></td>
<td>2. Send rotating union to DEUBLIN for maintenance.</td>
</tr>
<tr>
<td>Rotating union leaks before the end of the</td>
<td>Medium is contaminated</td>
<td>1. Stop the machine.</td>
</tr>
<tr>
<td>expected service life</td>
<td></td>
<td>2. Drain medium.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. Send rotating union to DEUBLIN for maintenance, if required.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4. Mount new filter.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>5. Flush the piping system of the machine.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>6. Refill with new medium.</td>
</tr>
<tr>
<td>Rotating union is not designed for the</td>
<td></td>
<td>1. Ensure that the correct DEUBLIN Rotating Union is used.</td>
</tr>
<tr>
<td>respective application</td>
<td></td>
<td>2. Contact DEUBLIN if required.</td>
</tr>
<tr>
<td>Rotating union runs untrue or wobbles</td>
<td>Thread and/or concentricity</td>
<td>1. Stop the machine.</td>
</tr>
<tr>
<td></td>
<td>outside the admissible tolerance.</td>
<td>2. Remove rotating union.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. Manufacture new thread or flange.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4. Install rotating union.</td>
</tr>
<tr>
<td></td>
<td>Rotating union is mounted incorrectly.</td>
<td>1. Stop the machine.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>2. Remove rotating union.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>3. Manufacture new thread or flange.</td>
</tr>
<tr>
<td></td>
<td></td>
<td>4. Install rotating union.</td>
</tr>
</tbody>
</table>
9.2 Pack Rotating Union for Transport

The rotating union has to be protected against mechanical impact and humidity during transport to ensure that the rotating union will arrive at DEUBLIN without being damaged.

Risk of injury by high weight
The rotating unions are heavy (depending on the model > 25 kg). If you lift the rotating unions on your own or without a lifting device, you and other people may suffer injuries.
- Always install the rotating union with appropriate assistance.
- Use a crane or lifting device for transport and installation of the rotating union.

1. Dismount the rotating union in reverse order of the installation (see Installation).
2. Ensure that the rotating union is free from the respective media.
3. Use a cardboard box which is suitable for the weight of the rotating union.
4. Cushion the base of the cardboard box with a soft material, e.g. air bubble film.
5. Wrap the rotating union with a soft material, e.g. air bubble film.
6. Ensure that no packing material or dirt can penetrate the opening of the rotating union.
7. Position the rotating union in the middle of the cardboard box.
8. Fill the free space around the rotating union with newspaper or another suitable material.
9. Close the cardboard box by means of tape.

10 Disposal

Risk of injury by high weight
The rotating unions are heavy (depending on the model > 25 kg). If you lift the rotating unions on your own or without a lifting device, you and other people may suffer injuries.
- Always install the rotating union with appropriate assistance.
- Use a crane or lifting device for transport and installation of the rotating union.

10.1 Dispose of Packaging
- Dispose of the packaging (cardboard box and plastics) according to the national standards, regulations and directives.

10.2 Dispose of Rotating Union

Basically, the rotating unions consist of metals (aluminium, steel, brass, bronze, copper, cast) which can be reused within the reclamation of scrap. Dispose of materials in a way that the disposal is compatible regarding humans, nature and environment. In doing so, ensure that rotating unions to be disposed of are free from the respective flow media.
- Dismount the rotating union in reverse order the installation (see Installation).
- Flush the rotating union.
- Collect the dirty flushing media.
- Dispose of the collected flushing media according to the national standards, regulations and directives.
- If you use thermal oil, please observe the instructions of the thermal oil manufacturer.
- Dispose of the rotating union according to the national standards, regulations and directives.

In case of repair, DEUBLIN disposes of all used parts.
11 Spare Parts

The rotating unions have a limited service life and include wearing parts.

Repair kits are available for several models of the rotating unions and can be obtained from DEUBLIN. Please ask your DEUBLIN Service. You need special tools and repair instructions for repair of the rotating unions which can be obtained from DEUBLIN as well.

**Note**

If you do not want to repair your rotating union on your own, DEUBLIN will be pleased to help you. If requested, DEUBLIN will exchange all wearing parts and clean all components of the rotating union. Before repaired rotating unions leave the premises, they will be subjected to an operational check. The repaired rotating union is returned with a standard “DEUBLIN Warranty” valid for 12 months.
Reliability

Many years’ experience, ongoing liaison with customers, innovations sourced inhouse and from suppliers place DEUBLIN in a position providing reliable Rotating Unions at the highest level.

When it comes to concrete applications, maximum service life is guaranteed by matching the sealing to the respective medium.

The service life is also equally maximized by maintaining cleanliness when storing and handling the Rotating Union and by adhering to the guidelines issued by DEUBLIN in respect of the conditions on the customer’s premises.