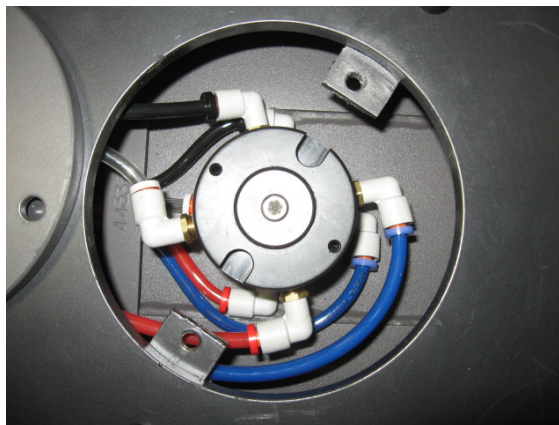


## How to Install SMC Rotary Air Union (Part # 736305)

1. Remove power and air to equipment. Lock out according to Lock Out/ Tag Out procedures.
2. Remove the center cover of the turntable by removing the two 3/8" Flat Head Cap Screws. Pressing on one side of the union should tip it up so that it can be grasped.



3. Remove existing air union taking note of how colored air lines line up. This is done by removing two 10/24 Socket Head Cap Screws.
4. Align colors on old union.
5. Match colored ends on new union. This may entail removing colored ends off of push connect fittings and matching to old union.



6. Fit new union over center shaft.
7. Replace colored hoses into matching colored push connect fittings.



## Technical Bulletin

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8. Replace two center capture bolts. Prior to placement place one drop blue Loctite onto last 4 threads of bolt.
9. Run bolts in **just until they touch the plastic of the rotary union. No further.** Loctite should be expected to maintain bolt integrity as the union is not being held down. The bolts are there only to keep the inside of the union from rotating.
10. Replace center cover on turntable.
11. Remove locks and restore power and air to machine.
12. Using manual functions on touchscreen, work through cycle on film clamp. At each position of clamp, listen for air leaks. If leaks are present shut equipment down and investigate.
13. After manual check is clear for no leaks, Check machine in automatic mode. If all is well return machine to service.