



How to Repair a Flow Style Parallel Swivel Using Kit #13546

These instructions will demonstrate how to replace components of a Flow Style Parallel Swivel with kit #13546

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INTRODUCTION

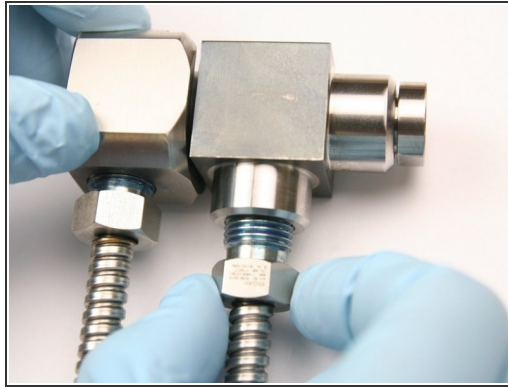
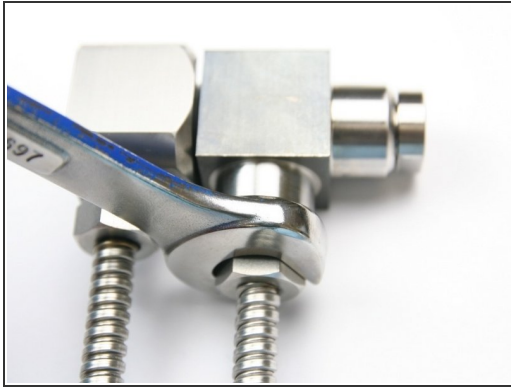
Hypertherm is in no way affiliated with the above mentioned manufacturer.

TOOLS:

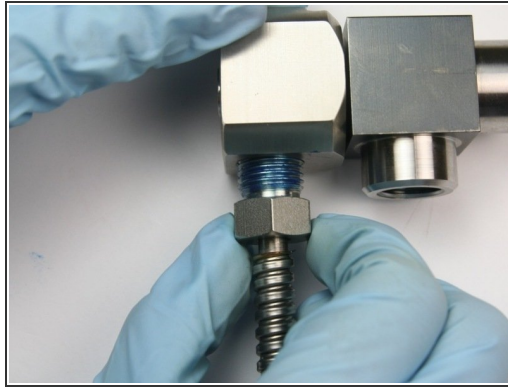
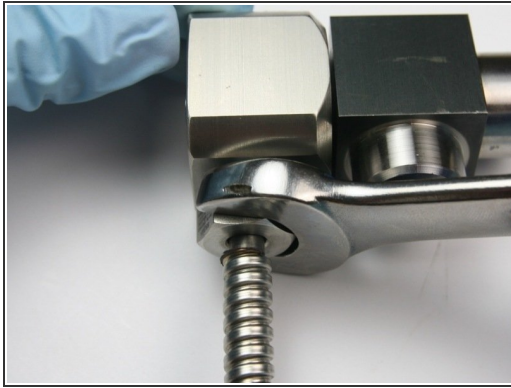
- [5/8" wrench](#) (1)
- [Vise](#) (1)

PARTS:

- [1/4" Swivel Repair Kit #13546](#) (1)
- [Back-up Ring #13337 \(included in kit\)](#) (1)
- [Hoop #11483 \(included in kit\)](#) (2)
- [High-Pressure Seal #11482 \(included in kit\)](#) (1)
- [Spacer #13330 \(included in kit\)](#) (1)
- [High-Vacuum Grease #11447 \(included in kit\)](#) (1)
- [Dowel \(included in kit\)](#) (1)
- [Collar #13329](#) (1)
- [Swivel Shaft #13331](#) (1)
- [Thrust Nut #13332](#) (1)
- [Swivel Housing #13333](#) (1)
- [Swivel Plug #13334](#) (1)
- [Set Screw #13336](#) (1)
- [1/4" High-Pressure Gland Nut #13158-60-4](#) (2)
- [1/4" High-Pressure Collar #13157-60-4](#) (2)

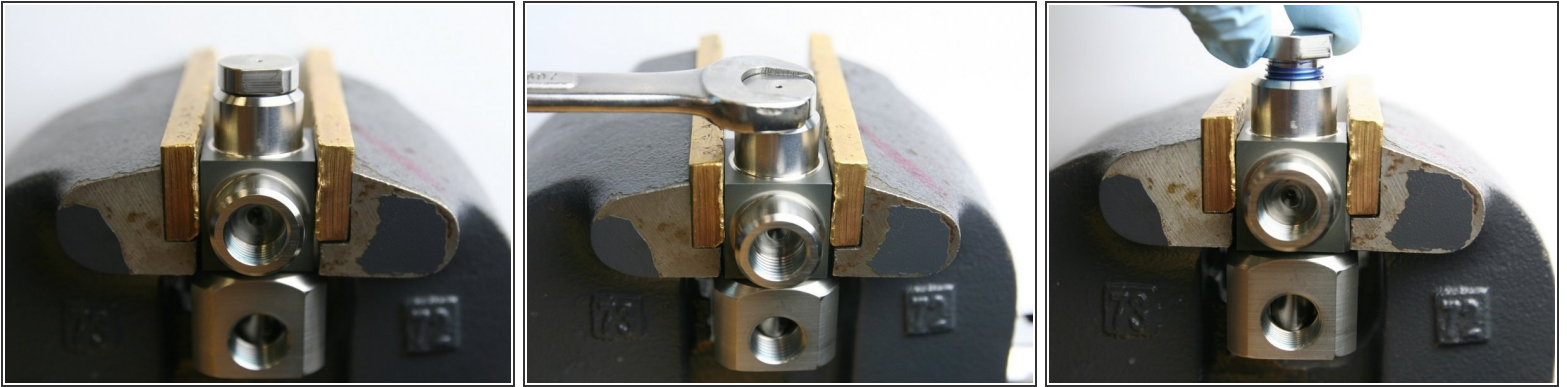
Step 1 — How to Repair a Flow Style Parallel Swivel Using Kit #13546

- Loosen the high-pressure gland nut from the swivel housing with 5/8" wrench.
- Unthread the high-pressure gland nut from the swivel housing.
- Clean the gland threads of all Blue Goop with isopropyl alcohol.

Step 2

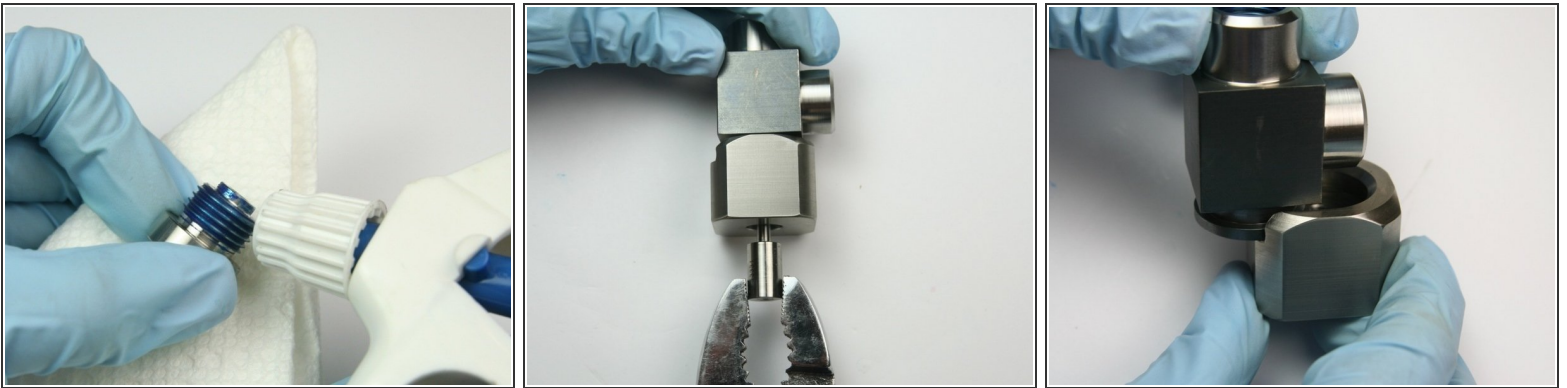
- Loosen the high-pressure gland nut from the collar using a 5/8" wrench.
- Unthread the high-pressure gland nut from the collar.
- Clean the high-pressure gland nut of all Blue Goop with isopropyl alcohol.

Step 3



- Put the parallel swivel into a vise.
- Using a 5/8" wrench, loosen the thrust nut from the swivel housing.
- Unthread the thrust nut from the swivel housing.

Step 4



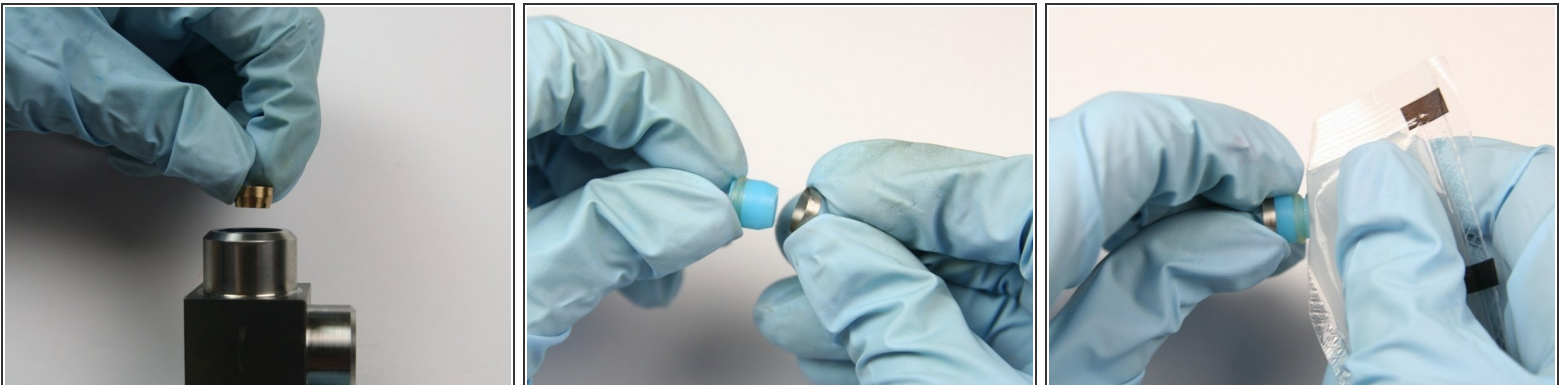
- Clean the thrust nut of all Blue Goop with isopropyl alcohol.
- Remove the swivel shaft from the collar by grasping with a set of pliers and pulling.
- Slide the collar out from the swivel housing.

Step 5



- Use the included dowel to push the components out from the inside of the swivel housing.
- Clean the swivel housing of all Blue Goop with isopropyl alcohol.
- Clean the collar of any residue from the assembly with isopropyl alcohol.

Step 6



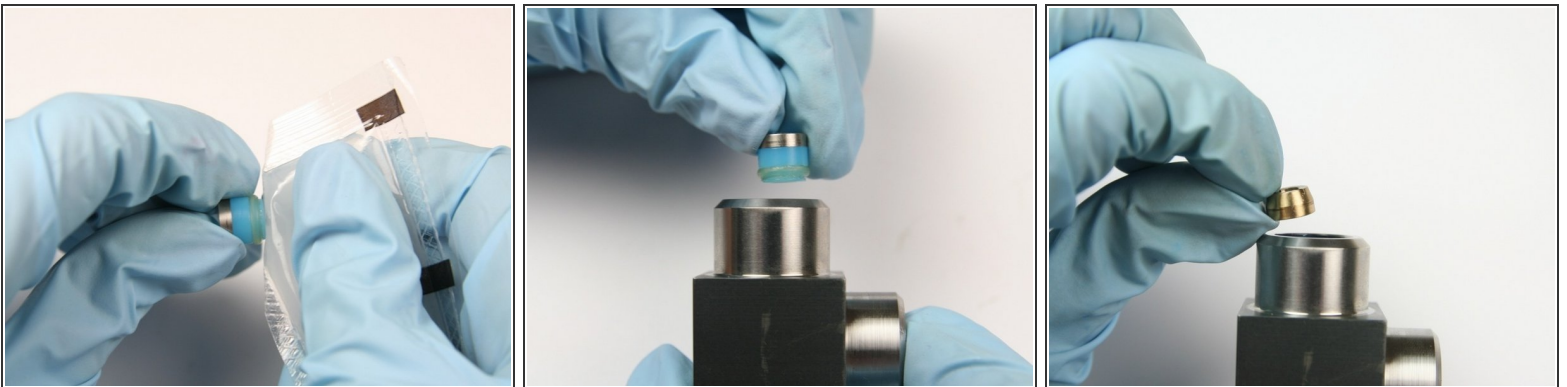
- Put the back-up ring with the smaller face down into the non-lipped side of the swivel housing.
- Put the hoop with the sharp (tapered) end onto the non O-ring side of the high-pressure seal.
- Apply [high-vacuum grease](#) to the high-pressure seal.

Step 7



- Put the high-pressure seal assembly into the swivel housing, with the hoop first, behind the back-up ring.
- Put the spacer into the swivel housing behind the high-pressure seal assembly.
- Place the second hoop with the sharp (tapered) end onto the non O-ring side of the second high-pressure seal.

Step 8



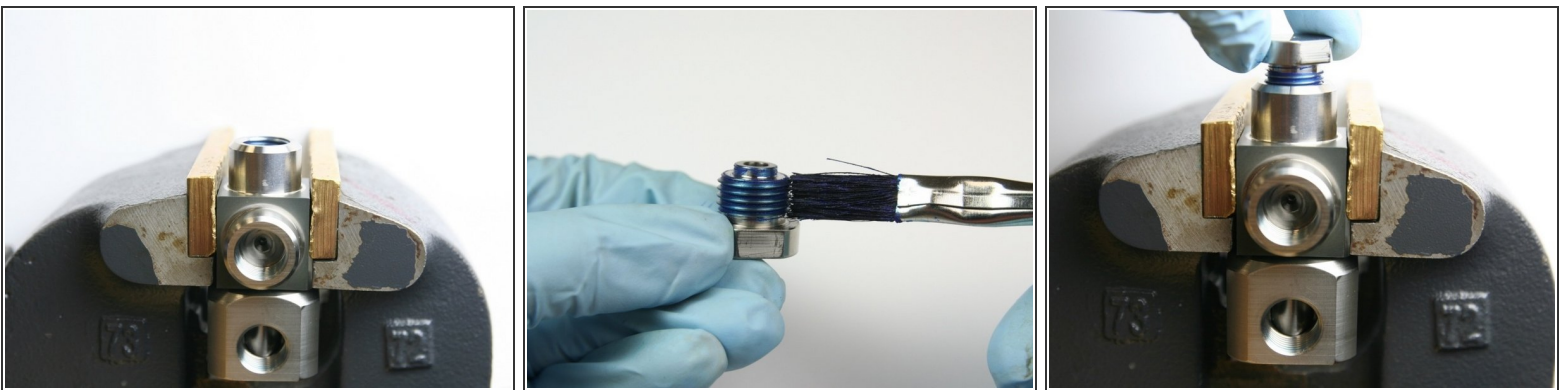
- Put a high-vacuum grease onto the high-pressure seal.
- Put the second high-pressure seal assembly into the swivel housing with the O-ring first.
- Put the second back-up ring into the swivel housing behind the high-pressure seal assembly with the larger face down.

Step 9



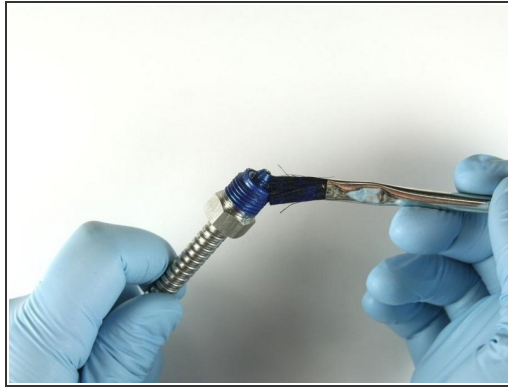
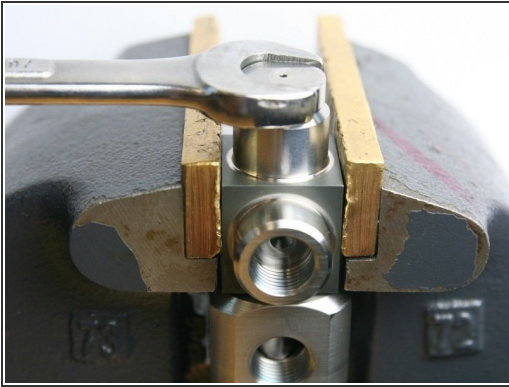
- Slide the collar onto the swivel housing so it fits into the groove.
- Apply a thin layer of high-vacuum grease to the swivel shaft.
- Put the swivel shaft into the collar end of the assembly with the swivel shaft holes aligned with the hole in the collar.
 - Press the swivel shaft into the assembly until it bottoms out.

Step 10



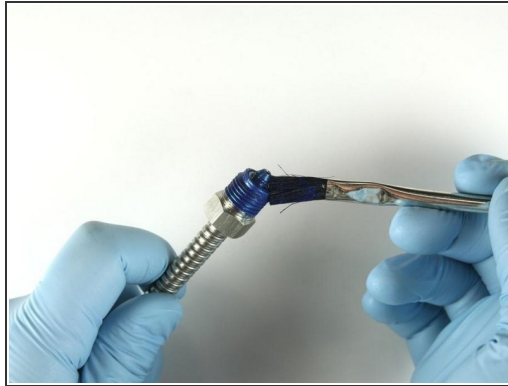
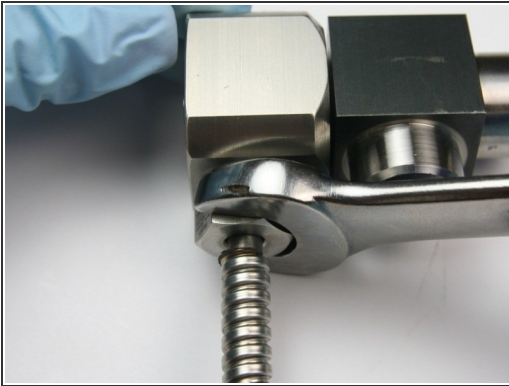
- Put the swivel housing into the vise.
- Apply Blue Goop to the thrust nut threads.
- Thread in the thrust nut into the top of the swivel housing.

Step 11



- Tighten the thrust nut into the swivel housing with a 5/8" wrench.
- Reapply Blue Goop to the threads of high-pressure gland nut.
- Thread in the high-pressure gland nut into the collar housing.

Step 12



- Tighten the high-pressure gland into the swivel collar using a 5/8" wrench.
- Reapply Blue Goop to the threads of the second high-pressure gland nut.
- Thread in the high-pressure gland nut into the swivel housing.

Step 13



- Tighten the high-pressure gland nut into the swivel housing with a 5/8" wrench.