Rotating unions are rotary connections, feeding pressure to fixtures while allowing full 360° rotation of the fixture with or without pressure. A machine or independent indexer may do this indexing. Rotating unions allow “live” hydraulic power to be supplied to fixtures during the machining cycle.

- Single, dual, quad, 6, 8 and 12 path models are available to fit your application.
- SAE 6 models are required for major fluid distribution and all remote valve systems. SAE 4 models may be used on double acting systems and small single acting systems where speed of retraction is not critical.
- Most units may be either manifold mounted or used with standard fittings.
- Slip Rings are electrical rotary connections which can be operated with some models below.

The leak free design eliminates the need for a drain or vent line required by standard industrial models. This feature also reduces the demand for pressure present in industrial models that can cause pump cycling.

All units include internal bearings to increase life under loaded applications. Quad path models are often installed in machine doors to feed two independent dual path models on fixtures, making VektorFlo® the choice for all of your machine clamping needs. Integral mounting holes and multiple plumbing options make VektorFlo® designs easier to use than specialized larger industrial model.

### Maximum RPM at Various Pressures with Petroleum Based Fluids

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Configuration</th>
<th>500 psi</th>
<th>1000 psi</th>
<th>2000 psi</th>
<th>3000 psi</th>
<th>4000 psi</th>
<th>5000 psi</th>
</tr>
</thead>
<tbody>
<tr>
<td>32-1261-00</td>
<td>Single Path</td>
<td>915</td>
<td>460</td>
<td>230</td>
<td>150</td>
<td>115</td>
<td>90</td>
</tr>
<tr>
<td>32-1241-00</td>
<td>Single Path</td>
<td>460</td>
<td>230</td>
<td>115</td>
<td>75</td>
<td>60</td>
<td>50</td>
</tr>
<tr>
<td>32-1461-01</td>
<td>Single Path</td>
<td>380</td>
<td>190</td>
<td>95</td>
<td>65</td>
<td>50</td>
<td>40</td>
</tr>
<tr>
<td>32-2242-02</td>
<td>Dual Path</td>
<td>380</td>
<td>190</td>
<td>95</td>
<td>65</td>
<td>50</td>
<td>40</td>
</tr>
<tr>
<td>32-2242-03</td>
<td>Quad Path</td>
<td>380</td>
<td>190</td>
<td>95</td>
<td>65</td>
<td>50</td>
<td>40</td>
</tr>
<tr>
<td>32-4244-01</td>
<td>6 Path</td>
<td>180</td>
<td>140</td>
<td>80</td>
<td>50</td>
<td>40</td>
<td>30</td>
</tr>
<tr>
<td>32-4244-02</td>
<td>6 Path with</td>
<td>100</td>
<td>100</td>
<td>80</td>
<td>50</td>
<td>40</td>
<td>30</td>
</tr>
<tr>
<td>32-8248-00</td>
<td>8 Path</td>
<td>180</td>
<td>140</td>
<td>80</td>
<td>50</td>
<td>40</td>
<td>30</td>
</tr>
<tr>
<td>32-8248-01</td>
<td>8 Path with</td>
<td>100</td>
<td>100</td>
<td>80</td>
<td>50</td>
<td>40</td>
<td>30</td>
</tr>
<tr>
<td>32-1224-12</td>
<td>12 Path</td>
<td>150</td>
<td>110</td>
<td>60</td>
<td>40</td>
<td>30</td>
<td>20</td>
</tr>
<tr>
<td>32-1224-13</td>
<td>12 Path with</td>
<td>100</td>
<td>100</td>
<td>60</td>
<td>40</td>
<td>30</td>
<td>20</td>
</tr>
</tbody>
</table>
Operating Parameter Guidelines
- Max. Hydraulic Pressure: 5,000 psi
- Max. Air Pressure: 200 psi
- Max. Vacuum: 28 Hg
- Max. Temperature: 400°F
- Max. RPM see table page I-3

NOTE: Hoses alone should never be used to control the movement of a rotating union.
**Single Path Dimensions**

<table>
<thead>
<tr>
<th>Model No.</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>H</th>
<th>J</th>
<th>K</th>
<th>L</th>
<th>M</th>
</tr>
</thead>
<tbody>
<tr>
<td>32-1241-00</td>
<td>2.36</td>
<td>0.69</td>
<td>SAE 2</td>
<td>0.38</td>
<td>1.30</td>
<td>SAE 4</td>
<td>1.30</td>
<td>0.97</td>
<td>2.25</td>
<td>2.75</td>
<td>1.37</td>
<td>0.39</td>
</tr>
<tr>
<td>32-1261-01</td>
<td>2.60</td>
<td>0.97</td>
<td>SAE 2</td>
<td>0.50</td>
<td>1.58</td>
<td>SAE 6</td>
<td>1.44</td>
<td>1.03</td>
<td>2.38</td>
<td>3.00</td>
<td>1.35</td>
<td>0.67</td>
</tr>
</tbody>
</table>

**Adapter Cavities**

- Adapter 30-8711-40 (SAE 4 Port) and 30-8711-60 (SAE 6 Port) are not furnished with the rotary union and must be ordered separately.
- SAE 2 Port plugged at assembly. To manifold mount, order adapter 30-8711-23 and discard plug.
- For proper sealing, mating surface must be flat within 0.003 in. with a maximum 32 µ in. Rₐ surface finish.

**Operating Parameter Guidelines**

- Operating Temperature Range: 40°F - 160°F
- Max. RPM see table page I-3

**For proper sealing, mating surface must be flat within 0.003 in. with a maximum 32 µ in. Rₐ surface finish.**

**Adapter Cavities generated with a standard SAE port tool.**

**C Port Plugged at assembly. To manifold mount, order adapter 30-8711-23 & discard plug.**

- 4X Counterbored & Drilled for 1/4 Cap Screws on Ø J Bolt Circle
- 2X Counterbored & Drilled for 1/4 Cap Screws on Ø J Bolt Circle

**Locator Hole Ø .218 Thru Base**

**J Bolt Circle**

**Base Port**

**Port Plugged at assembly. To manifold mount, order adapter 30-8711-23 & discard plug.**

**Adapter Cavities generated with a standard SAE port tool.**

**Operating Parameter Guidelines**

- Operating Temperature Range: 40°F - 160°F
- Max. RPM see table page I-3

**For proper sealing, mating surface must be flat within 0.003 in. with a maximum 32 µ in. Rₐ surface finish.**

**Adapter Cavities generated with a standard SAE port tool.**

**C Port Plugged at assembly. To manifold mount, order adapter 30-8711-23 & discard plug.**

- 4X Counterbored & Drilled for 1/4 Cap Screws on Ø J Bolt Circle
- 2X Counterbored & Drilled for 1/4 Cap Screws on Ø J Bolt Circle

**Locator Hole Ø .218 Thru Base**

**J Bolt Circle**

**Base Port**

**Port Plugged at assembly. To manifold mount, order adapter 30-8711-23 & discard plug.**

**Adapter Cavities generated with a standard SAE port tool.**

**C Port Plugged at assembly. To manifold mount, order adapter 30-8711-23 & discard plug.**

- 4X Counterbored & Drilled for 1/4 Cap Screws on Ø J Bolt Circle
- 2X Counterbored & Drilled for 1/4 Cap Screws on Ø J Bolt Circle
Dual Path Rotating Unions

For proper sealing, mating surface must be flat within 0.003 in. with a maximum 32 µ in. Ra surface finish.

Operating Parameter Guidelines
- Operating Temperature: 40°-160° F
- Air may be run in any available passage
- Max. RPM see table page I-3

Dual Path Dimensions

<table>
<thead>
<tr>
<th>Model No.</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>H</th>
<th>J</th>
<th>K</th>
<th>L</th>
<th>M</th>
<th>N</th>
<th>P</th>
<th>Q</th>
</tr>
</thead>
<tbody>
<tr>
<td>32-2242-02</td>
<td>2.97</td>
<td>2.28</td>
<td>1.56</td>
<td>1.06</td>
<td>0.50</td>
<td>0.28</td>
<td>SAE 2</td>
<td>3.00</td>
<td>1.51</td>
<td>1.156</td>
<td>1.25</td>
<td>SAE 4</td>
<td>2.312</td>
<td>1.46</td>
<td>0.77</td>
</tr>
<tr>
<td>32-2262-02</td>
<td>3.34</td>
<td>2.56</td>
<td>1.73</td>
<td>1.13</td>
<td>0.63</td>
<td>0.38</td>
<td>SAE 2</td>
<td>3.47</td>
<td>1.82</td>
<td>1.375</td>
<td>1.50</td>
<td>SAE 6</td>
<td>2.750</td>
<td>1.68</td>
<td>0.84</td>
</tr>
</tbody>
</table>

Models 32-2242-03 and 32-2262-03 are not adaptable for manifold mounting.

NOTE: Torque requirements may vary depending on port configuration and pressure run through ports. Testing of your specific application may be required.

For proper sealing, mating surface must be flat within 0.003 in. with a maximum 32 µ in. Ra surface finish.

Operating Parameter Guidelines
- Operating Temperature: 40°-160° F
- Air may be run in any available passage
- Max. RPM see table page I-3

Dual Path Dimensions

<table>
<thead>
<tr>
<th>Model No.</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>H</th>
<th>J</th>
<th>K</th>
<th>L</th>
<th>M</th>
<th>N</th>
<th>P</th>
<th>Q</th>
</tr>
</thead>
<tbody>
<tr>
<td>32-2242-02</td>
<td>2.97</td>
<td>2.28</td>
<td>1.56</td>
<td>1.06</td>
<td>0.50</td>
<td>0.28</td>
<td>SAE 2</td>
<td>3.00</td>
<td>1.51</td>
<td>1.156</td>
<td>1.25</td>
<td>SAE 4</td>
<td>2.312</td>
<td>1.46</td>
<td>0.77</td>
</tr>
<tr>
<td>32-2262-02</td>
<td>3.34</td>
<td>2.56</td>
<td>1.73</td>
<td>1.13</td>
<td>0.63</td>
<td>0.38</td>
<td>SAE 2</td>
<td>3.47</td>
<td>1.82</td>
<td>1.375</td>
<td>1.50</td>
<td>SAE 6</td>
<td>2.750</td>
<td>1.68</td>
<td>0.84</td>
</tr>
</tbody>
</table>

Models 32-2242-03 and 32-2262-03 are not adaptable for manifold mounting.

NOTE: Torque requirements may vary depending on port configuration and pressure run through ports. Testing of your specific application may be required.
Quad Path Dimensions

For proper sealing, mating surface must be flat within 0.003 in. with a maximum 32 µ in. Rₜ surface finish.

<table>
<thead>
<tr>
<th>Model No.</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
<th>E</th>
<th>F</th>
<th>G</th>
<th>H</th>
<th>J</th>
<th>K</th>
<th>L</th>
<th>M</th>
<th>N</th>
<th>P</th>
<th>Q</th>
<th>R</th>
</tr>
</thead>
<tbody>
<tr>
<td>32-4244-01</td>
<td>4.00</td>
<td>2.65</td>
<td>1.65</td>
<td>0.96</td>
<td>0.50</td>
<td>0.52</td>
<td>SAE 2</td>
<td>2.15</td>
<td>3.15</td>
<td>1.56</td>
<td>1.56</td>
<td>SAE 4</td>
<td>1.47</td>
<td>1.81</td>
<td>3.75</td>
<td>0.65</td>
</tr>
<tr>
<td>32-4264-01</td>
<td>4.50</td>
<td>3.01</td>
<td>1.81</td>
<td>1.08</td>
<td>0.56</td>
<td>0.52</td>
<td>SAE 2</td>
<td>2.41</td>
<td>3.61</td>
<td>1.69</td>
<td>1.75</td>
<td>SAE 6</td>
<td>1.52</td>
<td>1.94</td>
<td>4.00</td>
<td>0.79</td>
</tr>
</tbody>
</table>

**Operating Parameter Guidelines**
- Operating Temperature Range: 40° - 160°F.
- Max. RPM see table page I-3.
- Rotational torque required when no ports pressurized: 50 in-lbs.
- Max rotational torque required when ports are pressurized to 5,000 psi: 180 in-lbs.
- Torque requirements may vary depending on port configuration and pressure run through ports.
- Testing your specific application may be required.
- Air may be run in any available passage.

**Rotational Torque Resistance Chart**
- Rotational Torque Resistance (in-lb) vs. Input Pressure (psi)

**Operating Limits Chart**
- Speed (rpm) vs. Input Pressure (psi)

*Note: Torque requirements may vary depending on port configuration and pressure run through ports. Testing of your specific application may be required.*
### 6 Path Rotating Unions

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Hydraulic Input Connection</th>
<th>Electrical Slip Ring Option</th>
<th>Maximum Current/Circuit</th>
<th>Maximum Volts/Circuit</th>
<th>Lead Wire Length</th>
<th>Optional Mounting Flange Model No.**</th>
<th>Optional Cord Set***</th>
</tr>
</thead>
<tbody>
<tr>
<td>32-6246-00</td>
<td>SAE 4</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td></td>
<td></td>
</tr>
<tr>
<td>32-6246-00-ES6A</td>
<td>SAE 4</td>
<td>6 Circuit</td>
<td>2 Amp</td>
<td>120 VAC</td>
<td>48”</td>
<td>93-2620-00</td>
<td>27-6424-01</td>
</tr>
<tr>
<td>32-6246-00-ES12A</td>
<td>SAE 4</td>
<td>12 Circuit</td>
<td>2 Amp</td>
<td>120 VDC</td>
<td>48”</td>
<td></td>
<td>27-6424-02</td>
</tr>
<tr>
<td>32-6246-01</td>
<td>O-Ring Face Seal*</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>93-2620-00</td>
<td>N/A</td>
</tr>
<tr>
<td>32-6246-01-ES6A</td>
<td>O-Ring Face Seal*</td>
<td>6 Circuit</td>
<td>2 Amp</td>
<td>120 VAC</td>
<td>48”</td>
<td></td>
<td>27-6424-01</td>
</tr>
<tr>
<td>32-6246-01-ES12A</td>
<td>O-Ring Face Seal*</td>
<td>12 Circuit</td>
<td>2 Amp</td>
<td>120 VDC</td>
<td>48”</td>
<td></td>
<td>27-6424-02</td>
</tr>
</tbody>
</table>

* O-Rings furnished: -010, 70A, NBR Part No. 55-2500-01  
** Optional Mounting Flange includes:  
  - 6 SHCS 1/4-20 x 1/2 Part No. 21-4100-63  
  - 6 O-Rings - 010, 70A NBR Part No. 55-2500-01  
  - 1 O-Rings - 012, 70A NBR Part No. 39-0020-09  
  - 1 O-Rings - 013, 70A NBR Part No. 39-0000-72  
*** Order cord set separately.

For proper sealing, mating surface should be flat to 0.003 in. with a maximum 32 µ in. Rₚ surface finish.

### Operating Parameter Guidelines:
- Max. Pressure with or without slip ring: 5,000 psi
- Max. Vacuum with or without slip ring: 30 Hg
- Max. RPM under vacuum with or without slip ring: contact factory
- Max. RPM under pressure with or without slip ring, see table on page I-3
- Operating Temperature Range with slip ring 0° - 176°F
- Operating Temperature Range without slip ring 0° - 220°F
- Air may be run in any available passage

** Installation instructions available. Request IS326205 or visit our online catalog for a link to this document.**
## 8 Path Rotary Unions

<table>
<thead>
<tr>
<th>Model No.</th>
<th>Hydraulic Input Connection</th>
<th>Electrical Slip Ring Option</th>
<th>Maximum Current/Circuit</th>
<th>Maximum Volts/Circuit</th>
<th>Lead Wire Length</th>
<th>Optional Flange Model No.</th>
<th>Optional Cordset***</th>
</tr>
</thead>
<tbody>
<tr>
<td>32-8248-00</td>
<td>SAE 4</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>93-2820-00</td>
</tr>
<tr>
<td>32-8248-00-ES6A</td>
<td>SAE 4</td>
<td>6 Circuit</td>
<td>2 Amp</td>
<td>120 VAC</td>
<td>48&quot;</td>
<td>27-6424-01</td>
<td>N/A</td>
</tr>
<tr>
<td>32-8248-00-ES12A</td>
<td>SAE 4</td>
<td>12 Circuit</td>
<td>2 Amp</td>
<td>120 VDC</td>
<td>48&quot;</td>
<td>27-6424-02</td>
<td>N/A</td>
</tr>
<tr>
<td>32-8248-01</td>
<td>O-Ring Face Seal*</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>93-2820-00</td>
<td>N/A</td>
</tr>
<tr>
<td>32-8248-01-ES6A</td>
<td>O-Ring Face Seal*</td>
<td>6 Circuit</td>
<td>2 Amp</td>
<td>120 VAC</td>
<td>48&quot;</td>
<td>27-6424-01</td>
<td>N/A</td>
</tr>
<tr>
<td>32-8248-01-ES12A</td>
<td>O-Ring Face Seal*</td>
<td>12 Circuit</td>
<td>2 Amp</td>
<td>120 VDC</td>
<td>48&quot;</td>
<td>27-6424-02</td>
<td>N/A</td>
</tr>
</tbody>
</table>

* O-Rings furnished: -009, 70A, NBR Part No. 39-0500-36
** Optional Mounting Flange includes:
- 8 SHCS 1/4-20 x 1/2 Part No. 21-4100-63
- 8 O-Rings - 009, 70A NBR Part No. 39-0500-36
- 1 O-Ring - 012, 70A NBR Part No. 39-0020-09
- 1 O-Ring - 013, 70A NBR Part No. 39-0000-72

*** Order cord set separately.

### Operating Parameter Guidelines:
- Max. Pressure with or without slip ring: 5,000 psi
- Max. Vacuum with or without slip ring: 30 Hg
- Max. RPM under vacuum with or without slip ring: contact factory.
- Max. RPM under pressure with or without slip ring, see table on page I-3
- Operating Temperature Range with slip ring 0° - 176° F
- Operating Temperature Range without slip ring 0° - 220° F
- Air may be run in any available passage

For proper sealing, mating surface should be flat to 0.003 in. with a maximum 32 µ in. Ra surface finish.
12 Path Rotary Unions

For Proper sealing, mating surface should be flat to 0.003 in. with a maximum 32 μ in. Rₐ surface finish.

Operating Parameter Guidelines:
- Max. Pressure with or without slip ring: 5,000 psi
- Max. Vacuum with or without slip ring: 30 Hg
- Max. RPM under vacuum with or without slip ring: contact factory
- Max. RPM under pressure with or without slip ring, see table on page I-3
- Operating Temperature Range with slip ring: 0° - 176° F
- Max Operating Temperature Range without slip ring 0° - 220° F
- Air may be run in any available passage

Installation instructions available. Request IS3205 or visit our online catalog for a link to this document.

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<table>
<thead>
<tr>
<th>Model No.</th>
<th>Hydraulic Connection</th>
<th>Electrical Slip Ring Optional</th>
<th>Maximum Current/Circuit</th>
<th>Maximum Volts/Circuit</th>
<th>Lead Wire Length</th>
<th>Optional Flange Model No.</th>
<th>Optional Cord Set***</th>
</tr>
</thead>
<tbody>
<tr>
<td>32-1224-12</td>
<td>SAE 4</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>27-6424-01</td>
</tr>
<tr>
<td>32-1224-12-ES6A</td>
<td>SAE 4</td>
<td>6 Circuit</td>
<td>2 Amp</td>
<td>120 VAC</td>
<td>48&quot;</td>
<td>93-2120-00</td>
<td>N/A</td>
</tr>
<tr>
<td>32-1224-12-ES12A</td>
<td>SAE 4</td>
<td>12 Circuit</td>
<td>2 Amp</td>
<td>120 VDC</td>
<td>48&quot;</td>
<td>27-6424-02</td>
<td>N/A</td>
</tr>
<tr>
<td>32-1224-13</td>
<td>O-Ring Face Seal*</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>N/A</td>
<td>27-6424-01</td>
</tr>
<tr>
<td>32-1224-13-ES6A</td>
<td>O-Ring Face Seal*</td>
<td>6 Circuit</td>
<td>2 Amp</td>
<td>120 VAC</td>
<td>48&quot;</td>
<td>27-6424-02</td>
<td>N/A</td>
</tr>
<tr>
<td>32-1224-13-ES12A</td>
<td>O-Ring Face Seal*</td>
<td>12 Circuit</td>
<td>2 Amp</td>
<td>120 VDC</td>
<td>48&quot;</td>
<td>27-6424-02</td>
<td>N/A</td>
</tr>
</tbody>
</table>

---

* O-Rings furnished: -009, 70A, NBR Part No. 39-0500-36
** Optional Mounting Flange includes:
  - 12 SHCS 1/4-20 x 1/2 Part No. 21-4100-03
  - 1 O-Rings - 009, 70A NBR Part No. 39-0500-36
  - 1 O-Rings - 012, 70A NBR Part No. 39-0020-09
  - 1 O-Rings - 013, 70A NBR Part no. 39-0000-72
*** Order cord set separately.

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