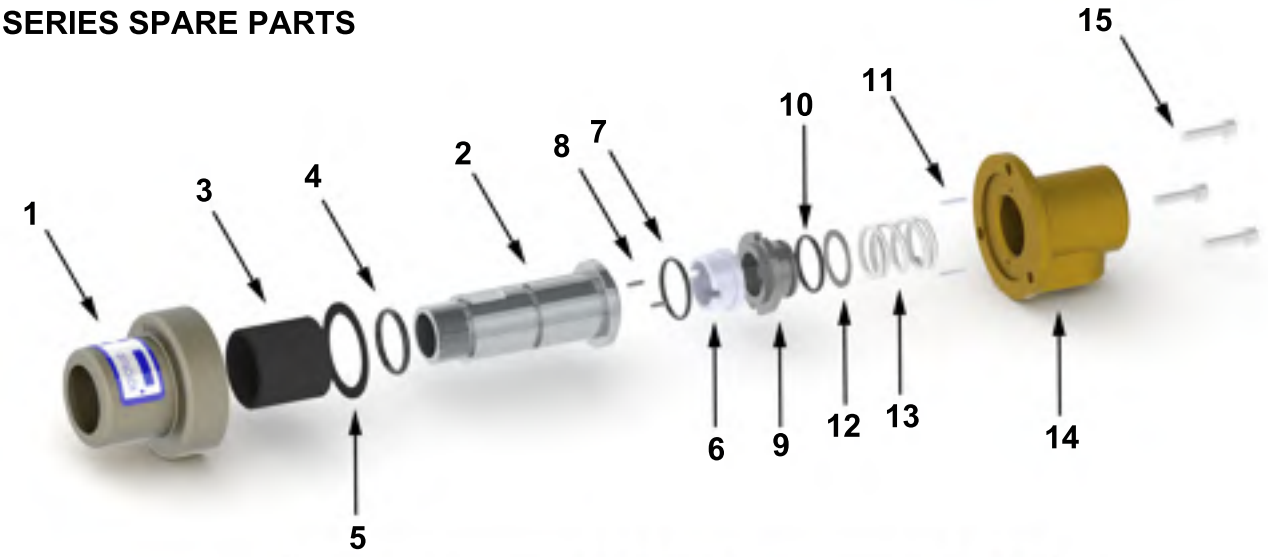
50 SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS

SIZE	MODEL
3/4”	53
1”	55

WARNING

Unless specified; ROTOFLUID rotary joints must not be used with Hydrocarbons or Flammable Mediums. Leaking may result explosion or fire.

50 SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	BEARING	1
4	O-RING	1
5	PTFE WASHER	1
6	SEAL RING	1
7	O-RING	1
8	PIM	2
9	FLOATING SEAL	1
10	O-RING	1
11	PIM	2
12	WASHER	1
13	SPRING	1
14	END CAP	1
15	BOLTS	3

1- Before disassembling the joint from the machine, close inlet and outlet valves and wait for all the medium to be drained completely. Be sure that there is no pressure and no residual pressure is applied to the pipe line system of the machine.
2- If hot medium is used, wait until all the system to be cooled down to normal temperature.
3- Disconnect inlet and outlet hoses from supply and return pipes or valves.
4- Disassemble shaft from the machine with appropriate tool.
5- If dual flow is used, becareful not to damage the internal siphon pipe when seperating the dual flow joint from the machine.
6- Hold the housing(1) of the joint with a bench wise and take out the inlet hose from the housing.
7- If dual flow is used, pay attention not to damage internal parts when taking out the dual flow elbow with siphon pipe.
8- Becareful not to damage the housing while holding it with the bench wise.
9- Prepare a clean place on the table where planned to make the maintenance.
10- Place the joint on the table onto the shaft side and control visually if there is any damage or defects.
11- Do not forget that there is spring(13) inside the joint. All internal parts may pop out from the housing because of the force of the spring.
12- Becareful when disassembling bolts(15) from the housing. Seperate end cap(14) and housing(1).
13- Take out the shaft(2) from the housing and seperate shaft(2) and teflon washer(5).
14- Disassemble the seal ring(6) from the shaft. Becareful not to damage the sealing socket.
15- Take out the seal o-ring(7) from the shaft sealing socket.
16- Inspect bearing(3) inside the housing, if necessary replace it with new one.
17- Take out the bearing o-ring(4) from the shaft.
18- Clean shaft and inspect for corrosion and deformation. If necessary change it with new one.
19- Control anti rotation pims(8), if necessary change them with new ones.
20- Place new seal o-ring(7) into the socket inside the shaft and apply grease on the seal socket.
21- Becareful when placing seal ring(6) into the shaft; sockets of the seal ring must correspond to anti rotation pims.
22- Place a new bearing o-ring(4) onto the shaft and apply few grease around the o-ring.
23- Take out the floating seal ring(9), washer(12) and spring(13) from the end cap.
24- Clean all internal surfaces of the end cap check for corrosion and deformation. If o-ring sealing surfaces are damaged, change the end cap with new one.
25- Clean the spring(13) and inspect for deformation; if necessary change it with new one.
26- Put the end cap(14) on the table. Place the spring(13) inside the end cap with a washer(12) on top.
27- Place a new floating seal ring(9) with a new o-ring(10) on top of the washer. Microlapped surfaces of the seal ring must face upwards.
28- Place a new teflon washer(5) onto the shaft from the threaded side.
29- Hold the shaft from the sealing side and assemble it into the housing.
30- Join the housing group and end cap group together with bolt holes facing correspondingly.
31- Fix the end cap and housing together with bolts(15).
32- Check rotation of the joint, if any knocking or noise show up, go to step 12 and follow the steps.
33- Bearing doesn’t need lubrication, do not lubricate.
34- Hold the housing of the joint with a bench wise and assemble inlet hose to the housing.
35- If dual flow is used, first assemble the siphon pipe with dual flow elbow to the housing. Then assemble the outlet hose to the dual flow elbow.
36- Assemble the joint to the machine roll. Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
37- Assemble the inlet and outlet hoses to the supply and return pipes or valves.
38- Now the joint is ready for work.