



20 SERIES INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

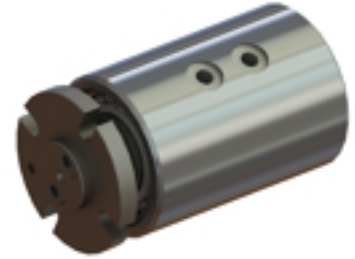


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PORT #	PORT SIZE
2	1/8"
3	1/4"
4	3/8"
	1/2"
	3/4"



WARNING

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

Medium: Hydraulic, Pneumatic, Vacuum

Max. Pressure: 10 bar (150 psi)

Max. Vacuum: 94 kPa (700mm Hg)

Max. Temperature: 120°C (250°F)

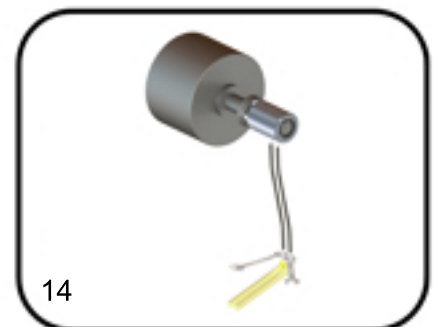
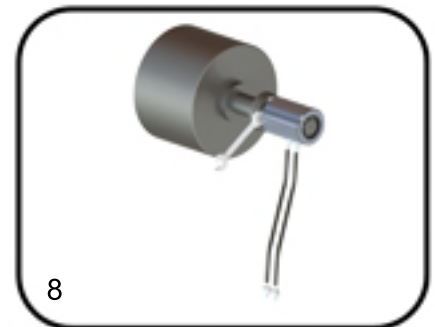
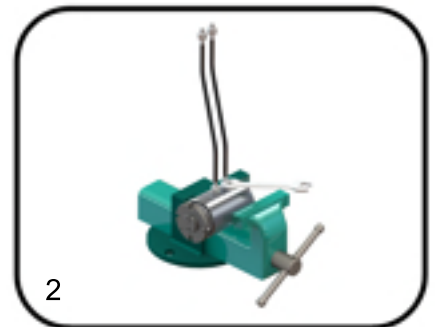
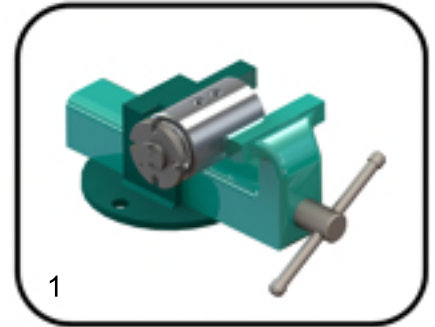
Max. Speed: 3,000 RPM

- Do not work with max. pressure at max. speed.
- All ROTOFLUID products are leakage tested before shipment. Disassembling or dismantling the joint invalidates the warranty.
- Operator should not make any modification or attachments and retrofitting of the rotary joint without manufacturers' consent is prohibited.
- It is important to use correct hand of rotary connection thread to ensure the Rotary Joint will not unscrew.
- ROTOFLUID Rotary Joints may only be installed by personel who have experience and knowledge about rotary joints and plumbing systems.
- For safe operation only use genuine ROTOFLUID spare parts.
- For safe operation only use hoses which are appropriate for the media.
- Follow engineering specifications of the machine builder.
- 20 Series Rotary Joints are designed to work with the interpassing medium. Do not run dry very long time. If application needs dry running, please consult factory.
- For SAE3000&6000 connections, please consult factory.
- Medium filtration must be lower than 60µ. Life of the joint increases with higher filtration.

INSTALLATION

- Do not connect Rotary Joint directly to piping. Rotary Joints are designed to float with the flexible hoses.
- Install hose with curve in direction of rotation.
- Flexible hoses must not be twisted during operation. Use proper pipe fittings.
- For air and hydraulic use rubber or steel flexible hoses.

1. First hold the housing of the joint with a bench vise. Do not clamp too tightly, it will damage housing or bearings.
2. Apply sealant/adhesive or teflon tape to the threads of the hoses and assemble them to the housing.
3. If housing connections are SAE Flange, place o-rings into the grooves and fix flanges of the hoses with appropriate bolts.
4. If shaft outlets are threaded, apply sealant/adhesive or teflon tape to the threads of the outlet hoses and assemble to the shaft.
5. Clean rotating joint flange face and machine bore surface before assembling.
6. If shaft outlets are with o-rings&grooves; place o-rings into the grooves of the shaft flange and apply grease slightly to fix the o-rings inside the grooves.
7. Align rotating joint flange and machine bore flange.
8. If shaft outlets are with o-rings&grooves; align flange plot bore and flow channels to the machine bore and flow channels; fix the shaft to the machine with appropriate bolts.
9. If shaft outlets are threaded, align shaft outlets with machine connections and fix the shaft to the machine with appropriate bolts.
10. Do not pipe directly. It may create excessive side loads and damage the joint.
11. Attach an anti rotation rod to anti rotation connection of the housing. Be sure that one end of the rod is fixed to the housing and the other end floats freely.
12. Rigid connection of the anti rotation rod will damage the joint.
13. If shaft flange connections are threaded; connect hoses on the shaft to the machine connections.
14. Connect hoses on the housing to the supply lines.
15. After assembly, check rotating joint for leakage. A small amount of leakage may be seen in the starting period. Never use leaking joint.
16. After assembly; control rotation of joint. If any wobble, vibration, knocking or noise show up or if any eccentricity seems; disassemble the joint from the machine and assemble it again.



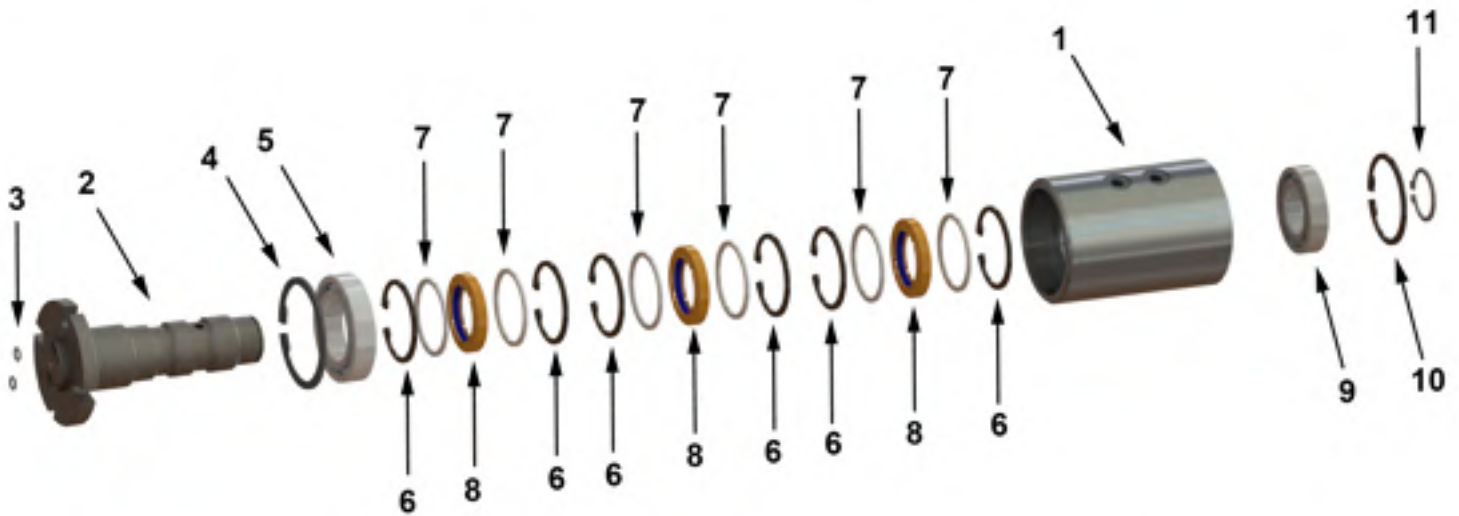
LUBRICATION

- 20 Series rotary Joints are designed to work with ball bearings need lubrication periodically while in operation.
- Do not apply too much grease on ball bearings. Over greasing will result damage of the bearings.
- All 20 Series Rotary Joints are equipped with grease relief valve to protect ball bearings from over greasing.
- Always use fresh grease to the ball bearings.

MAINTENANCE

- Before maintenance, be sure that no feed pressure is applied.
- If the rotary joint is defected and leaking occurs, replace seals with new ones and do not work with leaking joints.

20 SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	FLANGE O-RING	n
4	FRONT INT. RET. RING	1
5	FRONT BALL BEARING	1
6	INT. RET. RING	n
7	SPACER	n
8	SEAL	n
9	REAR BALL BEARING	1
10	REAR INT. RET. RING	1
11	EXT. RET. RING	1

n changes according to number of ports

Small Spare Parts Kit

- (3) Flange O-ring
- (8) Seal

Repair kits are available for 20 Series and can be supplied by ROTOFLUID.

If you don't want to repair your rotary joints, ROTOFLUID will disassemble the joints, clean and replace worn out parts and all sealing tests will be made and joints will be shipped as good as a new joint.