



300A SERIES INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

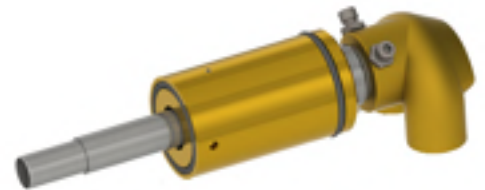


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SIZE	SINGLE FLOW MODEL	DUAL FLOW MODEL
1/2"	Q15-1/2"	Q20-1/2"
3/4"	Q20-3/4"	Q25-3/4"
1"	Q25-1"	Q40-1"
1 1/2"	Q40-1 1/2"	-----



WARNING

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

Medium: Water

Max. Pressure: 10 bar (150 psi)

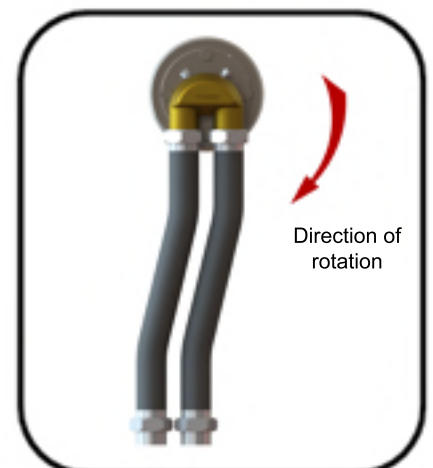
Max. Temperature: 120°C (250°F)

Max. Speed: 100 RPM

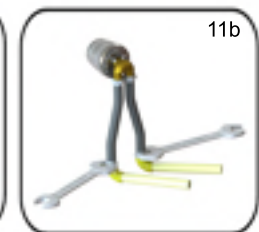
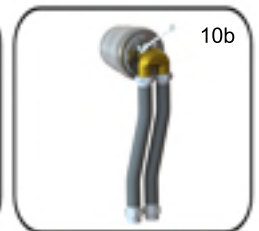
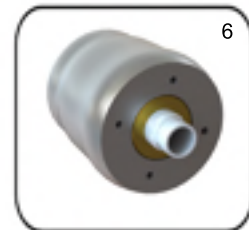
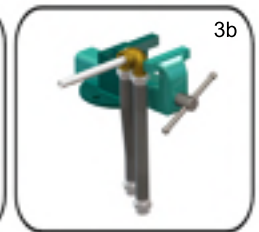
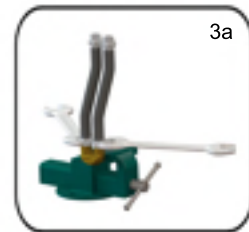
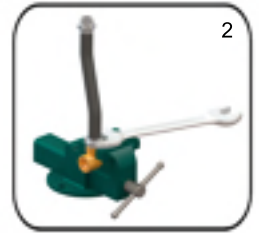
- Do not work with max. pressure at max. speed.
- All ROTOFLUID products are leakage tested before shipment. Disassembling or dismantling the joint invalidates the warranty.
- Operator should not make any modification or attachments and retrofitting of the rotary joint without manufacturers' consent is prohibited.
- 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 parts.
- For safe operation only use hoses which are appropriate for the media.
- Follow engineering specifications of the machine builder.
- 300 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.

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.
- Assemble hoses without sharp bends or without stress. Rotary joints are designed to float with the hoses.
- Flexible hoses must not be twisted during operation. Twisted hoses lose flexibility. Use pipe fittings for proper installation.
- If rotating joint and pipe axis are not on the same axis, hose must be installed with a smooth curve.
- Flexible hoses must not be twisted during operation. Use proper pipe fittings.



1. First hold the elbow with a bench wise;
2. If single flow;
 - Assemble the inlet hose
3. If dual flow;
 - Assemble the inlet and outlet hoses
 - Place pim into the pim hole of the internal pipe
 - Assemble the internal pipe to the elbow, be sure that the internal pipe is fixed to the dual flow elbow
4. Clean machine bore surface before assembling.
5. Apply grease slightly inside the machine bore.
6. Be careful not to damage the o-rings on the housing when assembling the housing to the machine.
7. Fix the housing with appropriate assembly flange to the machine, tighten bolts in a star shape.
8. Apply grease inside the surfaces of the elbow.
9. Assemble the elbow onto the shaft until bolts and bolt channel on the shaft are aligned.
10. Fix the elbow to the shaft by tightening two bolts on the elbow. Fix the nut on the bolts so that bolts won't loosen.
11. Connect hoses to the supply and return lines. Use flexible hoses and never install joint directly to the pipes.
12. After assembly; control rotation of joint. If any noise, wobble, vibration, knocking or noise show up or if any eccentricity seems; disassemble the joint from the machine and assemble it again.

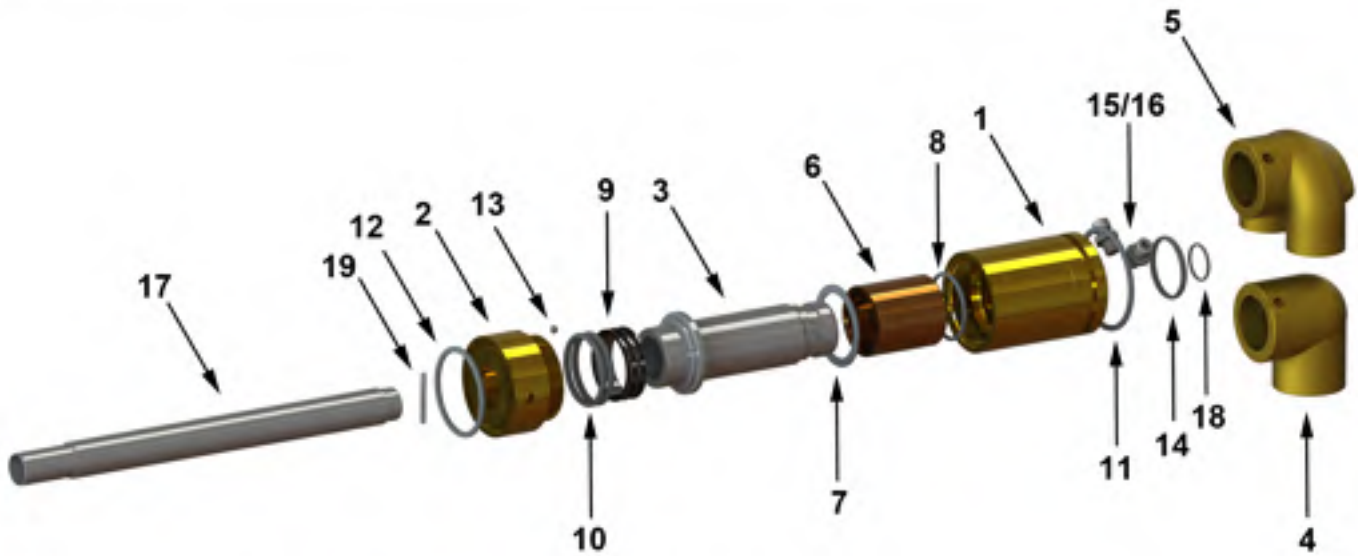


LUBRICATION

- 300 Series Rotary Joints are designed to work with composite or bronze bearings and do not need lubrication during operation.

MAINTENANCE

- 300 Series Rotary Joints are maintenance free.
- 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.



NO	PART NAME	QTY
1	300A HOUSING	1
2	300A END CAP	1
3	SHAFT	1
4	SINGLE FLOW ELBOW	1
5	DUAL FLOW ELBOW	1
6	BEARING	1
7	TEFLON WASHER	1
8	HOUSING O-RING	1
9	U-CUP	1
10	SEAL O-RING	2

NO	PART NAME	QTY
11	HOUSING OUTER O-RING	1
12	HOUSING FRONT O-RING	1
13	CAP SCREW	1
14	ELBOW O-RING	1
15	BOLT	2
16	NUT	2
17	INTERNAL PIPE	1
18	PIPE O-RING	1
19	PIM	1

Spare Parts Kit

- (7) Teflon Washer
- (8) Housing O-ring
- (9) U-Cup
- (10) Seal O-ring
- (11) Housing Outer O-ring
- (12) Housing Front O-ring
- (14) Elbow O-ring
- (18) Pipe O-ring

Repair kits are available for 300A 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.