



# 400B SERIES INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

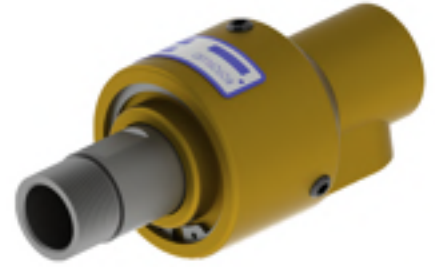


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SIZE	MODEL
1/4"	402B
3/8"	403B
1/2"	405B
3/4"	407B
1"	410B
1 1/4"	412B
1 1/2"	415B
2"	420B



## 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)

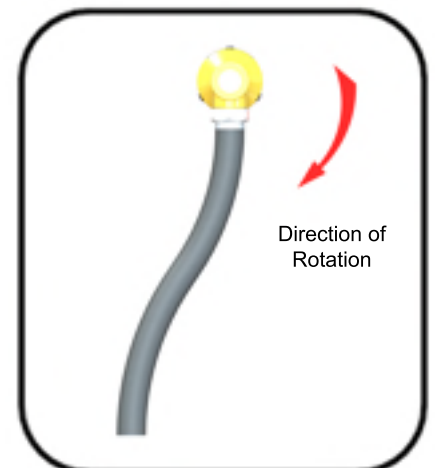
**Max. Temperature:** 120°C (250°F)

**Max. Speed:** 100 RPM

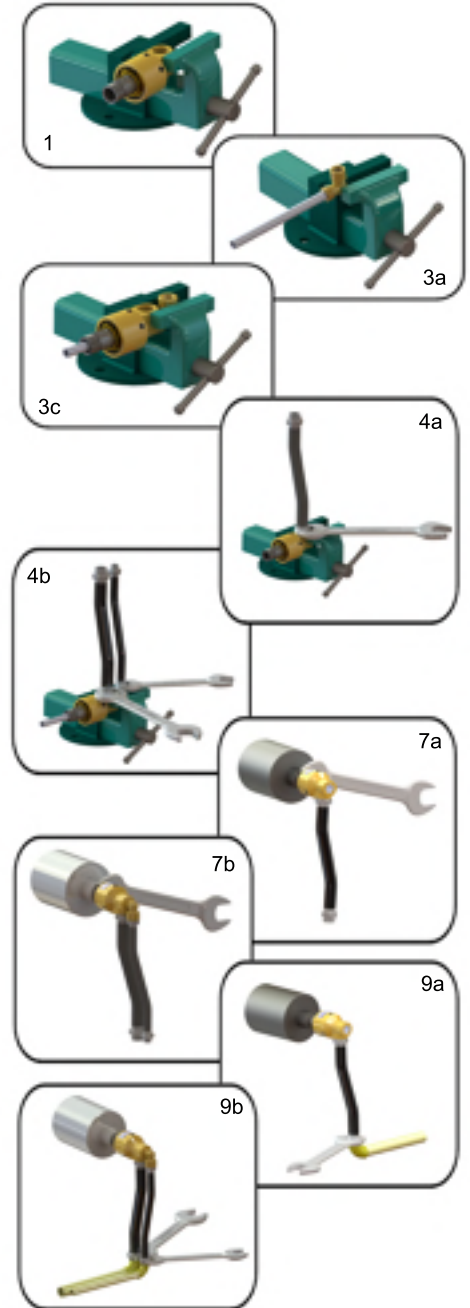
- Do not work with max. pressure at max. speed.
- All ROTOFLUID products are leakage tested before shipment. Disassembling or dismantling the joint invalidates the warranty.
- Operator should not make any modification or attachments and retrofitting of the rotary joint without manufacturers' consent is prohibited.
- It is important to use correct hand of rotary connection thread to ensure the Rotary Joint will not unscrew. If shaft rotates forward & reverse; flanged connection is recommended.
- 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.
- 400B 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.
- Unless specified, all 400B Rotary Joints are shipped as P-type.
- All 400B Rotary Joints has a standard P type housing. S type and RSP type joints consists of P-type housings with the appropriate elbow (S or RSP) type.
- Always flood the Rotary Joint and purge any entrapped air in the system before operating the machine to improve joint performance and longer joint life.



1. First hold the housing of the joint with a bench vise. Do not clamp too tightly, it will damage housing or bearings.
2. If the joint is used for single flow, apply adhesive or teflon tape to the threads of the pipe plug and fix it to the second port of the joint.
3. If the joint is used for dual flow,
  - 3.a) For S Types; apply adhesive or teflon tape to the thread of the siphon pipe and assemble it to the dual flow elbow.
  - 3 b) For RSP Types; apply grease into the bronze bearing inside the elbow and assemble siphon pipe gently inside the bearing.
  - 3.c) Apply adhesive or teflon tape to the thread of the dual flow elbow, be careful when assembling dual flow elbow with siphon pipe to the second port of the joint, internal siphon pipe may damage internal parts of the joint.
4. Apply sealant/adhesive or teflon tape to the threads of the hoses and assemble them to the housing.
5. If housing connections are SAE Flange, place o-rings into the grooves and fix flanges of the hoses with appropriate bolts.
6. Clean machine bore surface before assembling.
7. Apply adhesive or teflon tape to the thread of the shaft and install the joint to the machine. When installing, pay attention not to install eccentrically.
8. If the joint shaft is quick release; put a new copper washer into the bore of the roll, assemble qr flange onto the shaft, place split rings onto the socket on the shaft correspondingly, place qr flange onto the split wedges and fix the flange to the bore of the roll with appropriate bolts.
9. Connect hoses to the supply and return lines. Use flexible hoses and never install joint directly to the pipes.
10. 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.

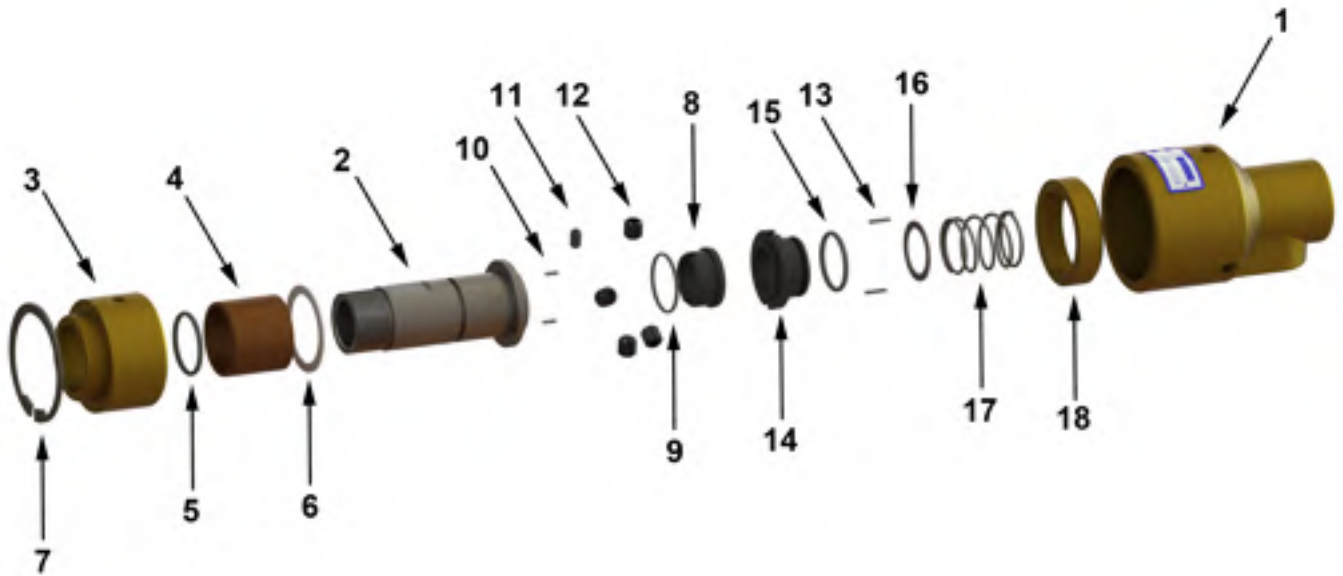


## LUBRICATION

- 400B Series Rotary Joints are equipped with composite bearing which are self lubricating bearings that does not need lubrication for life.

## MAINTENANCE

- 400B Series Rotary Joints are maintenance free.
- Before maintenance, allow the machine and media to cool down.
- 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	400B HOUSING	1
2	SHAFT - THREADED	1
3	BEARING CASING	1
4	BEARING	1
5	BEARING O-RING	1
6	TEFLON WASHER	1
7	INT. RETAINING RING	1
8	ROTARY SEAL RING	1
9	SEAL O-RING	1

NO	PART NAME	QTY
10	PIM	2
11	SET SCREW	2
12	SET SCREW	4
13	PIM	2
14	FLOATING SEAL RING	1
15	FLOATING SEAL O-RING	1
16	WASHER	1
17	SPRING	1
18	BRASS PLUG	1

### Small Spare Parts Kit

- (5) Bearing O-ring
- (6) Teflon Washer
- (8) Seal Ring
- (9) Seal Ring O-ring
- (14) Floating Seal Ring
- (15) Floating Seal O-ring
- (17) Spring

Repair kits are available for 400B 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 test will be made and joints will be shipped as good as a new joint.