



# 700 SERIES INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS

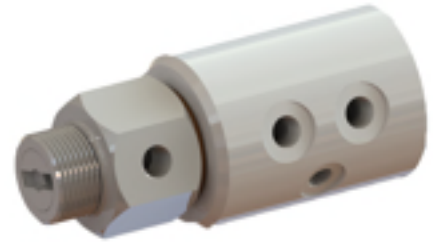


Document No: TL 7 67 EN

Release Date: 01.01.2015

Rev No: 0

SIZE	MODEL
2 x 1/4"	725
2 x 3/8"	737
2 x 1/2"	750
2 x 3/4"	775



## 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. Hydraulic Pressure:** 200 bar (2,900 psi) at 10 RPM

**Max. Hydraulic Pressure:** 60 bar (870 psi) at 250 RPM

**Max. Pneumatic Pressure:** 10 bar (150 psi)

**Max. Vacuum:** 6.7 kPa (2" Hg)

**Max. Temperature:** 120°C (250°F)

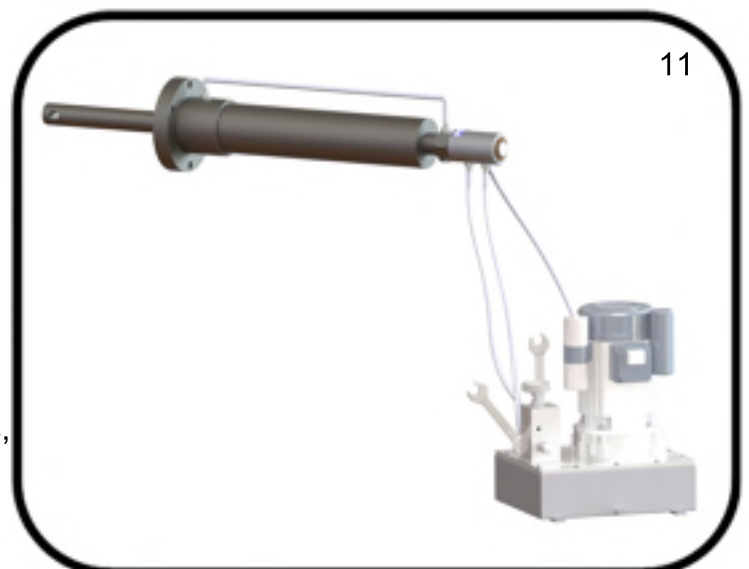
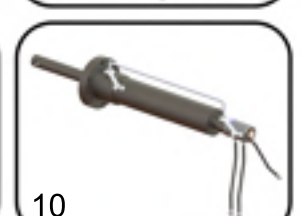
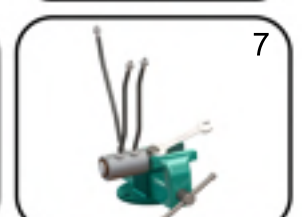
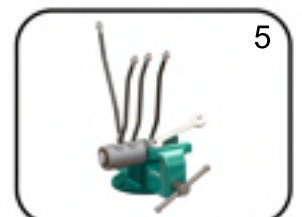
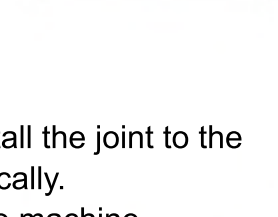
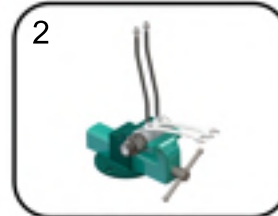
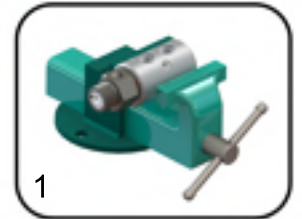
**Max. Speed:** 250 RPM

- 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.
- 700 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. Place new copper gaskets onto the nipple threads of the hydraulic hoses and fix them to the ports of the housing.
3. Place new copper gasket onto the nipple threads of the drain hose and assemble it to the drain port of the housing.
4. Hold the joint from the main shaft with bench vise.
5. Place a new copper washer onto the nipple thread of the hose and fix it to the side outlet port of the shaft.
6. Rotate the shaft 180° and hold the joint from the main shaft with a bench vise.
7. Place a new copper gasket onto pipe plug's thread and fix it to the second outlet port on the main shaft.
8. Clean machine bore surface before assembling.
9. Place a copper washer onto the main shaft thread and install the joint to the machine. When installing, pay attention not to install eccentrically.
10. Connect second outlet port hose to the second line on the machine.
11. Connect hoses on the housing to the supply lines.
12. There is no anti rotation socket on the housing. For this reason if the housing needs to be stopped from rotating; hold the fittings of the housing inlet and outlet hose with an anti rotation rod or bracket.
13. Rigid connection of the anti rotation rod will damage the joint.
14. After assembly, check rotating joint for leakage. A small amount of leakage may be seen in the starting period. Never use leaking joint.
15. 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.

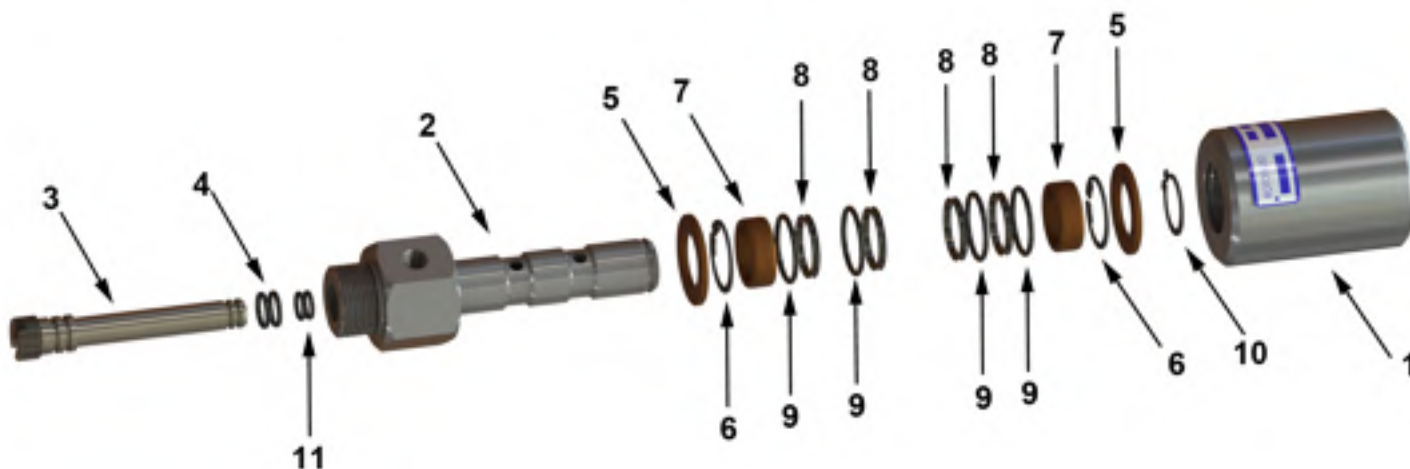


## LUBRICATION

- 700 Series Rotary Joints are equipped with bronze bearing and does not need lubrication while in operation.

## 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.



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	INNER SHAFT	1
4	INNER SHAFT FRONT O-RING	2
5	BRONZE WASHER	2
6	INT. RETAINING RING	2
7	BRONZE BEARING	2
8	BACK-UP	4
9	O-RING	4
10	EXT. RETAINING RING	1
11	INNER SHAFT O-RING	1

## SPARE PARTS KIT

- (4) Inner Shaft Front O-ring
- (6) Back-up
- (9) Seal O-ring
- (11) Inner Shaft O-ring

Repair kits are available for 700 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.