



# 800SR SERIES INSTALLATION, OPERATION AND MAINTENANCE INSTRUCTIONS



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## STRAIGHT TYPE

## RADIAL TYPE

SIZE	MODEL
1/4"	808SR
3/8"	810SR



### WARNING

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

**Medium:** Water, Coolant, Cutting Fluid

**Max. Pressure:** 70 bar (1,050 psi)

**Max. Temperature:** 120°C (250°F)

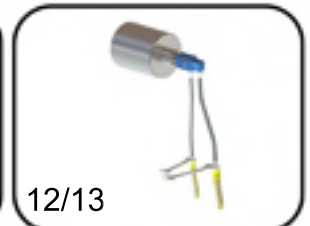
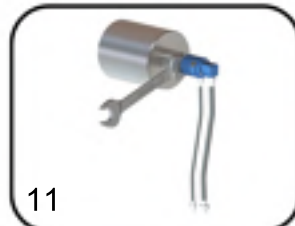
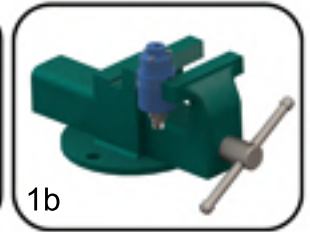
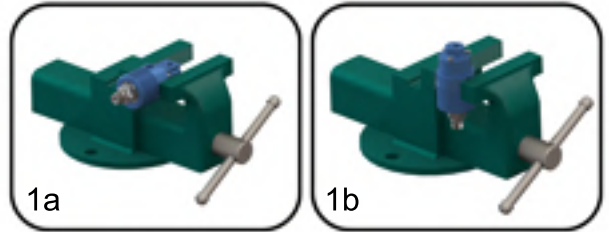
**Max. Speed:** 20,000 RPM

- Do not work with max. pressure at max. speed.
- All of ROTOFLUID products are leakage tested before shipment. Disassembling or dismantling invalidates the warranty.
- Operator should not make any modification or attachments and retrofitting of the rotary joint without manufacturers' consent.
- 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 parts.
- For safe operation only use hoses which are appropriate for the media.
- Follow engineering specifications of the machine builder.
- Do not use 800SR Series Rotary Joints for pressurized air. Seals will be damaged very fast.
- 800SR Series are designed to work "Dry Run". Dry run is only permissable without pressurized medium.

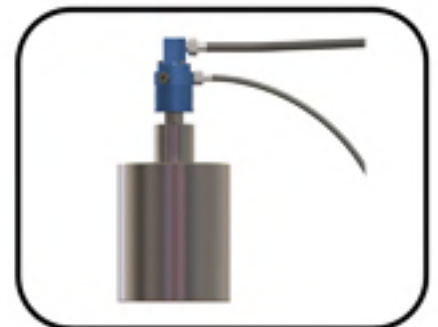
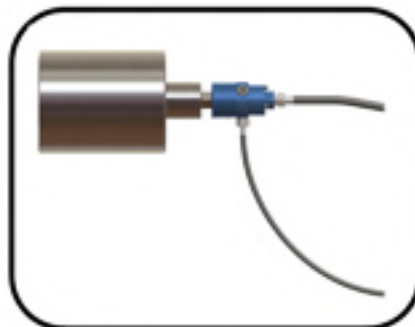
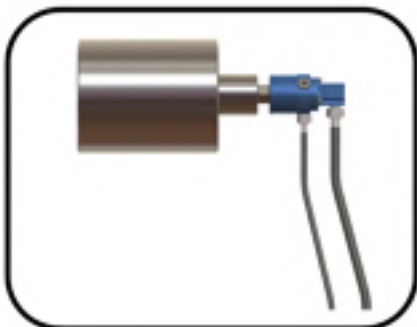
### INSTALLATION

- 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.
- All 800SR Rotary Joints are shipped as P-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.
- If 800SR Series are assembled to the machine in horizontal position, fix drain hose with nipple to the bottom vent hole of the housing. Drain path must be continuous downward. Use pipe plugs to plug the other two drain holes on the housing.

1. First hold the housing of the joint with a bench wise. Do not clamp too tightly, it will damage housing or bearings.
2. Apply sealant or teflon tape to the threads of the inlet hose and assemble it to the housing.
3. There are 3 drain ports on the housing. For this reason; drain hose must be assembled to one drain port and other 2 drain ports must be plugged.
4. Loosen housing from the bench wise, rotate it until drain line comes up and hold the housing again with the bench wise.
5. Apply sealant or teflon tape to the drain hose and install it to the drain port.
6. Loosen housing from the bench wise and rotate 120° and hold the housing again with the bench wise.
7. Apply sealant or teflon tape to the threads of the pipe plug and assemble it to the second drain port.
8. Apply step 6 and 7 for the last drain port.
9. Clean machine bore surface before assembling.
10. Apply grease on the shaft o-ring.
11. Apply sealant or teflon tape to the thread of the shaft and install the joint to the machine. When installing, pay attention not to install eccentricly.
12. Connect inlet hose to the supply line. Use flexible hoses and never install joint directly to the pipes.
13. Connect drain hose to the drain line. Pay attention that the drain line always be continuous downwards.
14. 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.



## DRAIN LINE SLOPE ALWAYS CONTINUOUSLY DOWNWARDS

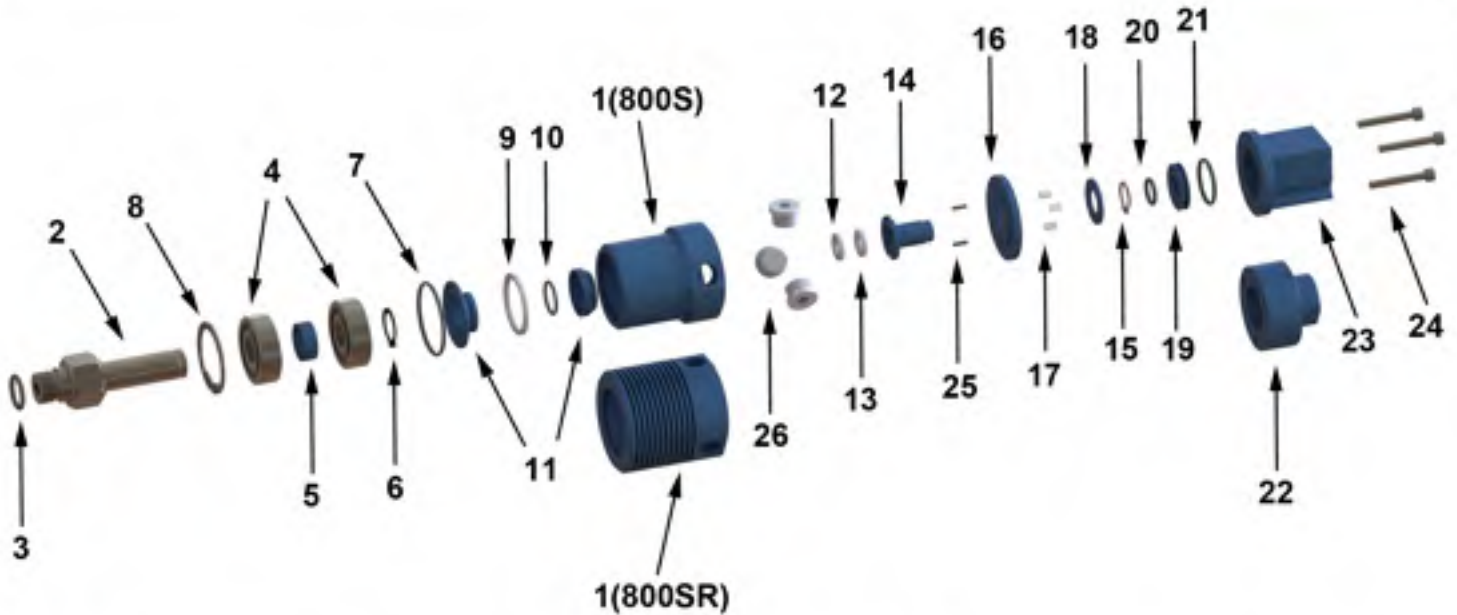


## LUBRICATION

- 800SR Series Rotary Joints are life lubricated and do not need lubrication during operation.

## MAINTENANCE

- 800SR Series Rotary Joints are maintenance free.
- 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	SHAFT O-RING	1
4	BALL BEARING	2
5	WASHER	1
6	EXT. RETAINING RING	1
7	HOUSING O-RING	1
8	INT. RETAINING RING	1
9	WAVE SPRING	4
10	SLINGER O-RING	1
11	SLINGER SET	1
12	SEAL RING	1
13	FLOATING SEAL RING	1

NO	PART NAME	QTY
14	FLOATING SEAL HOLDER	1
15	EXT. RETAINING RING	1
16	HOUSING FLANGE	1
17	SPRING	3
18	SUPPORT WASHER	1
19	SUPPORT	1
20	O-RING	1
21	O-RING	1
22	END CAP - AXIAL	1
23	END CAP - RADIAL	1
24	BOLTS	3
25	PIM	2
26	PIPE PLUG	3

### Small Spare Parts Kit

- (3) Shaft O-ring
- (7) Housing O-ring
- (9) Wave Spring
- (10) Slinger O-ring
- (12) Seal Ring
- (13) Floating Seal Ring
- (17) Spring
- (20) O-ring
- (21) O-ring

### Spare Parts Kit

- (2) Shaft
- (3) Shaft O-ring
- (4) Ball Bearings
- (5) Washer
- (6) External Retaining Ring
- (7) Housing O-ring
- (9) Wave Spring
- (10) Slinger O-ring
- (11) Slinger Set
- (12) Seal Ring
- (13) Floating Seal Ring
- (14) Floating Seal Holder
- (15) External Ret. Ring
- (17) Spring
- (20) O-ring
- (21) O-ring

Repair kits are available for 800SR 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.