



# 10 SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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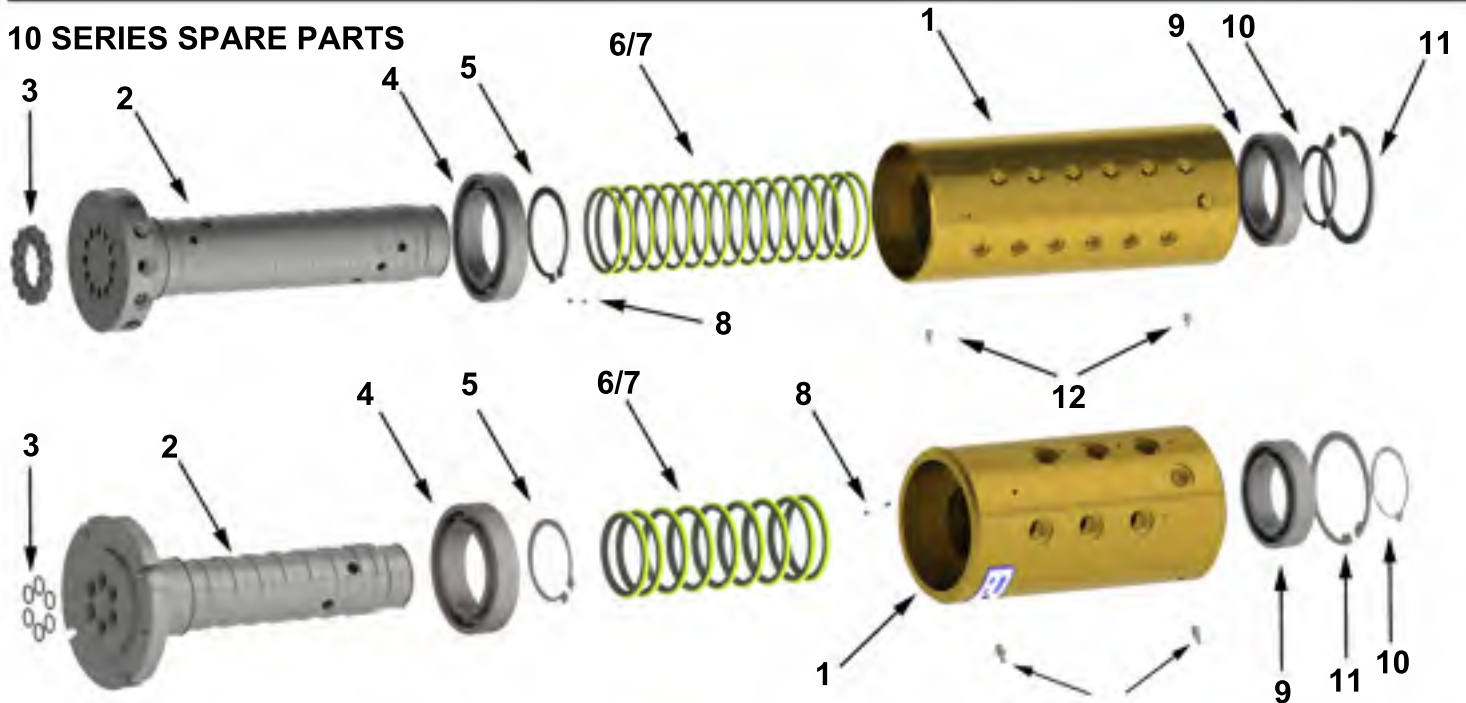
PORT #	PORT SIZE
2	1/8"
3	1/4"
4	3/8"
5	1/2"
6	3/4"
8	1"
12	



## WARNING

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

## 10 SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT - RADIAL	1
3	PIPE PLUG	n
4	FRONT BALL BEARING	1
5	EXT. RETAINING RING	2
6	SEAL O-RING	n
7	TEFLON BACK-UP	n
8	CAP SCREW	1
9	REAR BALL BEARING	1
10	EXT. RETAINING RING	1
11	INT. RETAINING RING	1
12	GREASE RING	1

NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT - AXIAL	1
3	FLANGE O-RING	n
4	FRONT BALL BEARING	1
5	EXT. RETAINING RING	2
6	SEAL O-RING	n
7	TEFLON BACK-UP	n
8	CAP SCREW	1
9	REAR BALL BEARING	1
10	EXT. RETAINING RING	1
11	INT. RETAINING RING	1
12	GREASE RING	1

n changes according to number of ports



## 10 SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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- 1- Before disassembling the joint from the machine, close inlet valves and wait for all the medium to be drained completely. Be sure that there is no pressure and no residual pressure is applied to the pipe line system of the machine.
- 2- Disconnect inlet hoses from supply pipes or valves.
- 3- If shaft flange outlets are threaded, disconnect outlet hoses from outlet pipes or valves.
- 4- Remove bolts of the shaft flange and disassemble the rotary joint from the machine.
- 5- Hold the housing(1) of the joint with a bench wise and take out the inlet hoses from the housing.
- 6- If shaft flange outlets are threaded; disassemble outlet hoses from the shaft flange.
- 7- Be careful not to damage the housing while holding it with the bench wise.
- 8- Prepare a clean place on the table where planned to make the maintenance.
- 9- Place the joint on the table onto the shaft side and control visually if there is any damage or defects.
- 10- If shaft connection is with o-rings, take out all o-rings(3) and if necessary replace them with new ones.
- 11- Remove housing retaining ring(11) and shaft retaining ring(10) from backside of the rotary joint.
- 12- Turn the joint upside down and take out the shaft(2) from the housing slowly.
- 13- Be careful not to damage internal parts when taking out the shaft from the housing.
- 14- Take out the front retaining ring(5) and disassemble the front ball bearing(4).
- 15- Disassemble the rear ball bearing(9) from the housing.
- 16- Take out the seal o-rings(6) and back-ups(7) from the sockets inside the housing.
- 17- Clean all internal surfaces of the housing and seal sockets.
- 18- First place new seal o-rings(6) inside the sockets of the housing.
- 19- Be careful not to twist when installing teflon back-up rings(7) under the seal o-rings.
- 20- Apply light oil to internal surfaces of the housing.
- 21- Clean shaft and inspect for corrosion and deformation. If necessary change it with new one.
- 22- First assemble the front ball bearing(2) to the shaft and fix it with retaining ring(5).
- 23- Assemble rear ball bearing(9) to the housing and fix it with retaining ring(11).
- 24- Apply light oil to the shaft sealing surfaces.
- 25- Hold the shaft from flanged side and place it inside the housing until it is fully in place.
- 26- Be careful not to damage the seals while installing shaft to housing slowly.
- 27- Fix the shaft with retaining ring(10).
- 28- Check rotation of the joint, if any knocking or noise show up, go to step 9 and follow the steps.
- 29- Hold the housing of the joint with a bench wise and assemble inlet hoses to the housing.
- 30- If shaft outlets are threaded; connect outlet hoses to the shaft flange outlets.
- 31- If shaft outlets are without threads; place new o-rings(3) into the sockets of the flange.
- 32- Assemble the joint to the machine roll. Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
- 33- Assemble the inlet hoses to the supply pipes or valves.
- 34- If threaded shaft outlets are used, connect outlet hoses to the outlet pipes or valves.
- 35- Now the joint is ready for work.