



# 100 SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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Rev No: 0

SIZE	MODEL
1/8"	106
1/4"	108
3/8"	110
1/2"	115
3/4"	120
1"	125
1 1/4"	132
1 1/2"	140
2"	150

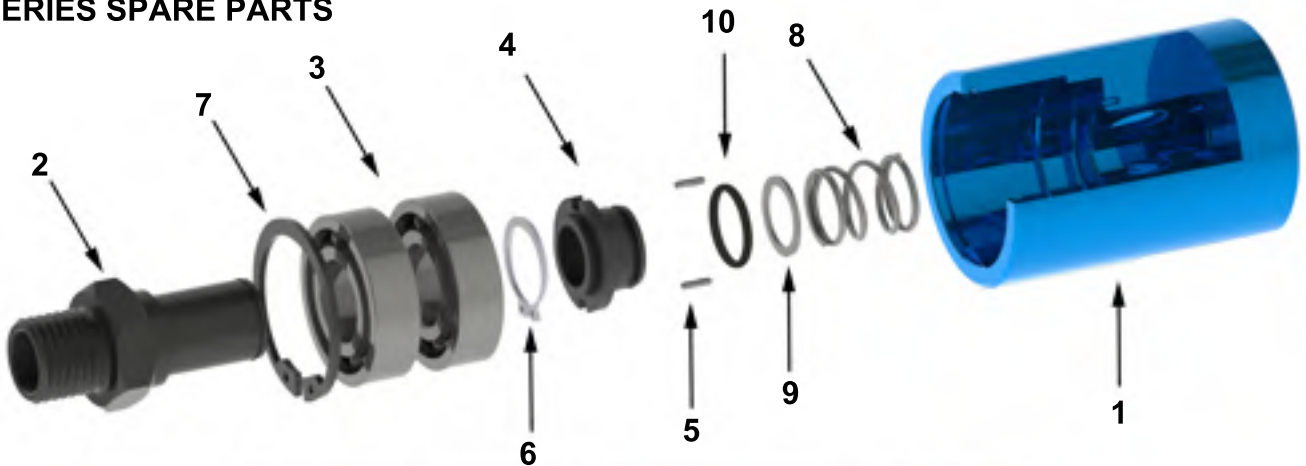


## WARNING

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

- All 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.
- 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.

## 100 SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	BALL BEARING	2
4	SEAL RING	1
5	PIM	2
6	EXT. RETAINING RING	1
7	INT. RETAINING RING	1
8	SPRING	1
9	SPACER	1
10	O-RING	1



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- 1- Before disassembling the joint from the machine, close inlet valve 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 pipeline system of the machine.
- 2- Disconnect inlet hose from the supply pipe or supply valve.
- 3- Disassemble shaft(2) from the machine with appropriate tool.
- 4- Hold the rear of the housing(1) of the joint with a bench vice and take out the inlet hose from the housing.
- 5- Be careful not to damage the housing while holding it with the bench vice.
- 6- Prepare a clean place on the table where planned to make the maintenance.
- 7- Place the joint on the table onto the housing.
- 8- Control visually if there is any damage or defects.
- 9- Do not forget that there is spring(8) inside the joint. All internal parts may pop out from the housing because of the force of the spring.
- 10- Hold the shaft(2) from the threaded side and press through to the housing.
- 11- Take out the internal retaining ring(7) with snap ring pliers.
- 12- Take out the shaft(2) with bearings(3) assembly slowly.
- 13- Take out the seal ring(4), washer(9) and spring(8) from the housing.
- 14- Control ball bearings, if they need to be changed, first take out the shaft retaining ring(6) with snap ring pliers and disassemble ball bearings from the shaft.
- 15- Do not damage shaft sealing surface while disassembling ball bearings from the shaft.
- 16- Inspect shaft; if sealing surface shows excessive wear, change it with new one.
- 17- Assemble ball bearings(3) onto the shaft and fix them with shaft retaining ring(6).
- 18- Clean all internal surfaces of the housing, check for corrosion and deformation. If o-ring sealing surfaces are damaged, change the housing with new one.
- 19- Place the joint on the table onto the backside of the housing.
- 20- Clean the spring(8) and inspect for deformation; if necessary change it with new one.
- 21- Place the spring(8) inside the housing with a washer(9) on top.
- 22- Place a new seal ring(4) with a new o-ring(10) on top of the washer. Microlapped surface of the seal ring must face upwards.
- 23- Hold the shaft from the threaded side; assemble it into the housing.
- 24- Press the shaft(2) through the housing and fix it with housing retaining ring(7).
- 25- Check rotation of the joint, if any knocking or noise show up, go to step 7 and follow the steps.
- 26- Ball bearings are life lubricated and do not lubrication before assembling.
- 27- Hold the rear of the housing with a bench vice and connect inlet hose.
- 28- Assemble the joint to the machine roll. Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
- 29- Assemble the inlet hose to the supply pipe.
- 30- Now the joint is ready for work.