

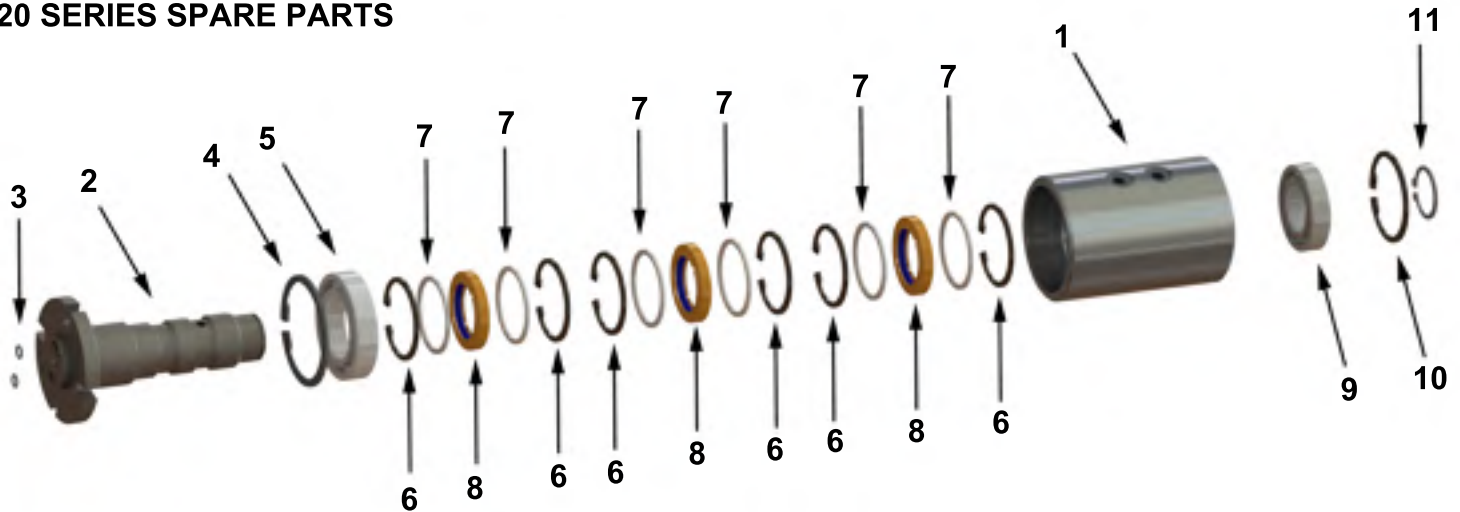
PORT #	PORT SIZE
2	1/8"
3	1/4"
4	3/8"
	1/2"
	3/4"



WARNING

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

20 SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	FLANGE O-RING	n
4	FRONT INT. RET. RING	1
5	FRONT BALL BEARING	1
6	INT. RET. RING	n
7	SPACER	n
8	SEAL	n
9	REAR BALL BEARING	1
10	REAR INT. RET. RING	1
11	EXT. RET. RING	1

n changes according to number of ports



20 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 the supply pipes or valves.
- 3- Remove bolts of the shaft flange and disassemble the rotary joint from the machine.
- 4- Hold the housing(1) of the joint with a bench wise and take out the inlet hoses from the housing.
- 5- Be careful not to damage the housing while holding it with the bench wise.
- 6- Prepare a clean place on the table where planned to make the maintenance.
- 7- Place the joint on the table onto the shaft side and control visually if there is any damage or defects.
- 8- If shaft connection is with o-rings, take out all o-rings(3) and if necessary replace them with new ones.
- 9- Remove housing retaining ring(10) and shaft retaining ring(11) from backside of the rotary joint.
- 10- Turn the joint upside down and take out the shaft(2) from the housing slowly.
- 11- Be careful not to damage internal parts when taking out the shaft from the housing.
- 12- Take out the front retaining ring(4) and disassemble the front ball bearing(5).
- 13- Disassemble the rear ball bearing(9) from the housing.
- 14- Take out internal retaining rings(6), spacers(7) and seals(8) slowly.
- 15- Clean all internal surfaces of the housing, check for corrosion and deformation. If sealing surfaces are damaged, change the housing with new one.
- 16- Apply light oil to internal surfaces of the housing.
- 17- Starting from the middle of housing, first place retaining ring(6) to its socket.
- 18- Place spacer onto the retaining ring(7).
- 19- Apply grease around the seal(8) and place it onto the spacer.
- 20- Place second spacer(7) on to the seal and fix seal group in position with internal retaining ring(6).
- 21- Apply steps (18-21) to all other seal groups.
- 22- Clean shaft and inspect for corrosion and deformation. If necessary change it with new one.
- 23- First assemble the rear ball bearing(9) to the housing and fix it with retaining ring(10).
- 24- Rotate housing upside down and assemble front ball bearing(5) to the housing and fix it with retaining ring(4).
- 25- Apply light oil to the shaft sealing surfaces.
- 26- Hold the shaft from flanged side and place it inside the housing slowly until it is fully in place.
- 27- Be careful not to damage the seals while installing shaft to housing slowly.
- 28- Fix the shaft with shaft retaining ring(11).
- 29- Check rotation of the joint, if any knocking or noise show up, go to step 9 and follow the steps.
- 30- Hold the housing of the joint with a bench wise and assemble inlet hoses to the housing.
- 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- Now the joint is ready for work.