



200 SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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Rev No: 0

SIZE	MODEL
1/2"	205
3/4"	207
1"	210
1 1/4"	212
1 1/2"	215
2"	220

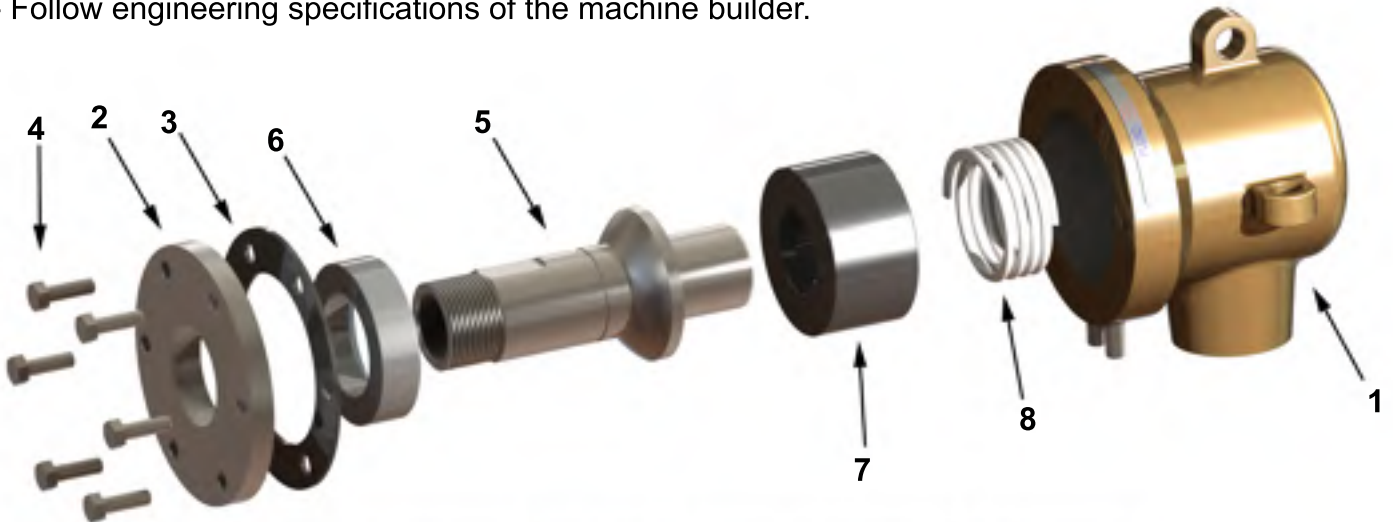


WARNING

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

200 SERIES SPARE PARTS

- 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 personnel 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.



NO	PART NAME	QTY	
1	HOUSING	1	
2	HOUSING FLANGE	1	
3	HOUSING FLANGE GASKET	1	
4	BOLTS	6	(1/2"-1 1/4")
		8	(1 1/2")
		10	(2")
5	SHAFT	1	
6	SEAL RING	1	
7	GRAPHITE BEARING	1	
8	SPRING	1	



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- 1- Before disassembling the joint from the machine, close inlet and outlet 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- If hot medium is used, wait until all the system to be cooled down to normal temperature.
- 3- Disconnect inlet and outlet hoses from supply and return pipes or valves.
- 4- Disassemble shaft from the machine with appropriate tool.
- 5- If dual flow is used, be careful not to damage the internal siphon pipe when separating the dual flow joint from the machine.
- 6- Hold the housing(1) of the joint with a bench vice and take out the inlet hose from the housing.
- 7- If dual flow is used, pay attention not to damage internal parts when taking out the dual flow elbow with siphon pipe.
- 8- Be careful not to damage the housing while holding it with the bench vice.
- 9- Prepare a clean place on the table where planned to make the maintenance.
- 10- Place the joint on the table onto the housing.
- 11- Control visually if there is any damage or defects.
- 12- 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.
13. Remove hex bolts(4) from the housing. Before last two bolts, hold the shaft(5) from the threaded side and press slightly to the housing.
14. Remove last 2 bolts while holding the shaft. Internal parts will come out of the housing.
15. Remove housing flange(2), seal ring(6), shaft(5), graphite bearing(7) and spring(8) from the housing.
- 16- Clean all internal surfaces of the housing, check for corrosion and deformation. If bearing surfaces and threads are damaged, change the housing with new one.
- 17- Place the joint on the table onto the backside of the housing.
- 18- Clean the spring(8) and inspect for deformation; if necessary change it with new one.
- 19- Place the spring into the socket inside the housing.
- 20- Inspect carbon graphite bearing(7), if necessary replace it with new one.
- 21- Place the carbon graphite bearing onto the spring with spring groove corresponding to spring.
- 22- Clean shaft(5) and inspect for corrosion and deformation. If necessary replace it with new one. Place the shaft into the graphite bearing while convex sealing surface facing upwards.
- 23- Place new seal ring(6) onto the shaft while concave sealing face facing convex surface of shaft.
- 24- Place a new housing gasket(3) onto the housing and align holes with bolt holes of housing.
- 25- Clean housing flange(2) and inspect it for corrosion and deformation. If sealing surface is deformed, apply microlapping process or replace it with a new one.
- 26- Place the housing flange onto the housing while microlapped face facing to the seal ring.
- 27- Press the shaft from the threaded side into the housing and fix the bolts correspondingly.
- 28- Hold the housing of the joint with a bench vice and assemble inlet hose to the housing.
- 29- If dual flow is used, first assemble the siphon pipe with dual flow to the housing. Then assemble the outlet hose to the dual flow elbow.
- 30- Assemble the joint to the machine roll. Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
- 31- Assemble the inlet hose and outlet hoses to the supply and return pipes or valves.
- 32- Now the joint is ready for work.