



300A SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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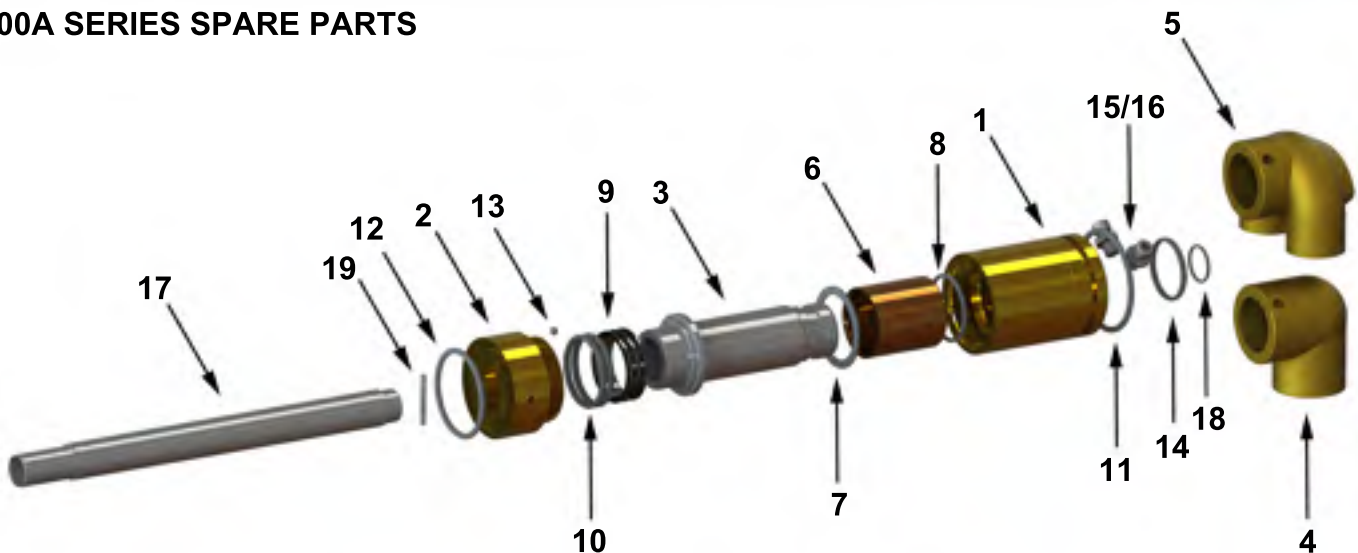
SIZE	SINGLE FLOW MODEL	DUAL FLOW MODEL
1/2"	Q15-1/2"	Q20-1/2"
3/4"	Q20-3/4"	Q25-3/4"
1"	Q25-1"	Q40-1"
1 1/2"	Q40-1 1/2"	-----



WARNING

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

300A SERIES SPARE PARTS



NO	PART NAME	QTY
1	300A HOUSING	1
2	300A END CAP	1
3	SHAFT	1
4	SINGLE FLOW ELBOW	1
5	DUAL FLOW ELBOW	1
6	BEARING	1
7	TEFLON WASHER	1
8	HOUSING O-RING	1
9	U-CUP	1
10	SEAL O-RING	2

NO	PART NAME	QTY
11	HOUSING OUTER O-RING	1
12	HOUSING FRONT O-RING	1
13	CAP SCREW	1
14	ELBOW O-RING	1
15	BOLT	2
16	NUT	2
17	INTERNAL PIPE	1
18	PIPE O-RING	1
19	PIM	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- Disconnect inlet and outlet hoses from the supply and return pipes or valves.
- 3- Disassemble bolts(15) and nuts(16) of the elbow and take out elbow(4-5) together with hoses and if dual flow with internal pipe(17).
- 4- Loosen bolts of the assembly flange and separate it from the machine.
- 5-Take out the housing of the joint slightly from the machine.
- 6- Prepare a clean place on the table where planned to make the maintenance.
- 7- Hold the housing(1) of the joint with a bench vise.
- 8- Take out the antirotation cap screw(13) between the housing(1) and end cap(2).
- 9- Be careful not to damage the housing while holding it with the bench vise.
- 10- Separate the end cap from the housing with an appropriate tool.
- 11- Remove seal u-cup(9) and seal o-ring(10) together from the end cap.
- 12- Remove front o-ring(12) from the end cap and if necessary change it with new one.
- 13- Take out the shaft(3) from the housing and remove teflon washer(7) from the shaft.
- 14- Be careful not to damage the socket when taking out the housing internal o-ring(8).
- 15- Inspect bearing(6) inside the housing, if necessary replace it with new one.
- 16- Take out the housing o-ring(11), do not damage the o-ring socket.
- 17- Clean all internal surfaces of the housing, check for corrosion and deformation. If sealing surfaces are damaged, change the housing with new one.
- 18- Clean shaft(3) and inspect for corrosion and deformation. If necessary change it with new one.
- 19- Place a new o-ring(8) into the internal socket of the housing and apply grease slightly.
- 20- Assemble a new teflon washer(7) onto the shaft and apply grease around the shaft.
- 21- Insert shaft into the housing slightly, be careful not to damage o-ring(8) and the bearing(6).
- 22- Apply grease inside the end cap and place a new seal u-cup(9) with new o-rings(10).
- 23- First install sealing surface of the shaft into the seal u-cup inside the end cap.
- 24- Be careful not to damage inside surface of the seal u-cup.
- 25- Hold the housing of the joint with a bench vise. and install end cap into the housing, tighten slowly.
- 26- Assemble anti rotation cap screw(13) and be sure that it is fixed.
- 27- Place a new o-ring(11) into the outer socket of the housing.
- 28- Install a new front o-ring(12) into the socket of the end cap.
- 29- If dual flow elbow is used, separate pipe(17) from elbow(5) and inspect pipe and pim(19) for corrosion and deformation. If necessary replace them with new ones.
- 30- Inspect elbow o-ring(14) and pipe o-ring(18)(if dual flow) inside the elbow and if necessary replace them with new ones.
- 31- If dual flow, install internal pipe to the socket of the elbow slightly. Be sure that it is fixed.
- 32- Assemble bolt(15) and nut(16) to the elbow do not fix all through.
- 33- Do not forget to apply grease onto the outer o-ring and front o-ring.
- 34- Clean bore of the machine and assemble housing of the joint inside the bore.
- 35- Place assembly flange onto the shaft and fix the housing to the machine with appropriate bolts.
- 36- Apply grease into the o-ring of the elbow.
- 37- Install elbow onto the shaft until bolts of the elbow are facing to the channel of the shaft.
- 38- Tighten bolts and fix them with nuts.
- 39- Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
- 40- Assemble inlet and outlet hoses to the supply and return pipes or valves.
- 41- Now the joint is ready for work.