400B SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS

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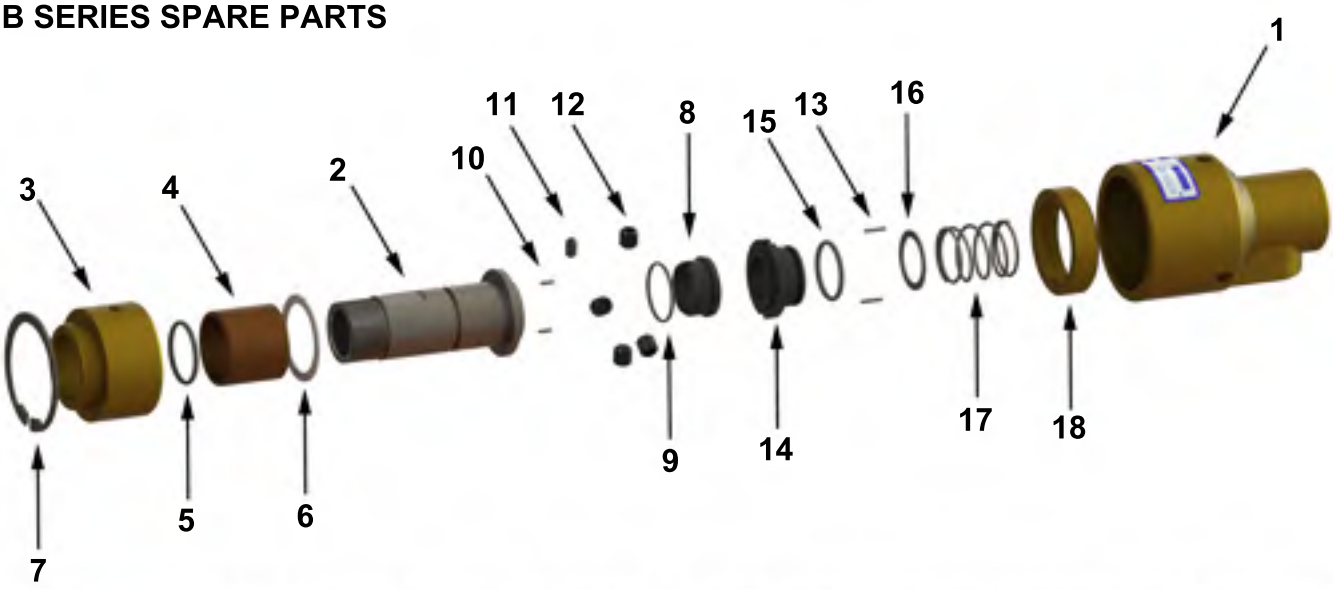
SIZE	MODEL
1/4"	402B
3/8"	403B
1/2"	405B
3/4"	407B
1"	410B
1 1/4"	412B
1 1/2"	415B
2"	420B

WARNING

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

400B SERIES SPARE PARTS



NO	PART NAME	QTY
1	400B HOUSING	1
2	SHAFT - THREADED	1
3	BEARING CASING	1
4	BEARING	1
5	BEARING O-RING	1
6	TEFLON WASHER	1
7	INT. RETAINING RING	1
8	ROTARY SEAL RING	1
9	SEAL O-RING	1

NO	PART NAME	QTY
10	PIM	2
11	SET SCREW	2
12	SET SCREW	4
13	PIM	2
14	FLOATING SEAL RING	1
15	FLOATING SEAL O-RING	1
16	WASHER	1
17	SPRING	1
18	BRASS BRACKET	1

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 the supply and return pipe or valve.
4- Disassemble shaft from the machine with appropriate tool.
5- If dual flow is used, becareful not to damage the internal siphon pipe when seperating the dual flow joint from the machine.

6- Hold the housing(1) of the joint with a bench wise 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- Becareful not to damage the housing while holding it with the bench wise.
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(17) inside the joint. All internal parts may pop out from the housing because of the force of the spring.
13- Disassemble housing set screws(11-12) from the housing.
14- Hold the shaft(2) from the threaded side and press through the housing.
15- Take out the internal retaining ring(7) with snap ring pliers.
16- Take out the shaft(2) with bearings group slowly. Seperate shaft(2) and teflon washer(6) from the bearing casing(3).
17- Disassemble the seal ring(8) from the shaft. Becareful not to damage the sealing socket.
18- Take out the seal o-ring(9) from the shaft sealing socket.
19- Inspect bearing(4) inside the casing, if necessary replace it with new one.
20- Take out the bearing o-ring(5) from the shaft.
21- Clean shaft and inspect for corrosion and deformation. If necessary change it with new one.
22- Control anti rotation pims(10), if necessary change them with new ones.
23- Place new seal o-ring(9) into the socket inside the shaft and apply grease on the seal socket.
24- Becareful when placing seal ring(8) into the shaft; sockets of the seal ring must correspond to anti rotation pims(10).
25- Place a new bearing o-ring(5) onto the shaft and apply few grease around the o-ring.
26- Take out the floating seal ring(14), washer(16) and spring(17) from the housing.
27- Inspect brass bracket(18), if necessary replace it with new one and fix it inside the housing.
28- 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.
29- Clean the spring(17) and inspect for deformation; if necessary change it with new one.
30- Place the spring inside the housing with a washer(16) on top.
31- Place a new floating seal ring(14) with a new o-ring(15) on top of the washer. Microlapped surface of the seal ring must face upwards.
32- Place a new teflon washer(6) onto the shaft from the threaded side.
33- Hold the shaft(2) from the sealing side and assemble it into the bearing casing(3).
34- Hold the shaft from the threaded side together with bearing casing and place it inside the housing. Becareful anti rotation sockets of the bearing casing must face to housings setscrew holes.
35- Press the shaft through the housing and fix it with housing retaining ring(7).
36- Assemble set screws(11-12) to the housing.
37- Check rotation of the joint, if any knocking or noise show up, go to step 14 and follow the steps.
38- Bearing doesn’t need lubrication, do not lubricate.
39- Hold the housing of the joint with a bench wise and assemble inlet hose to the housing.
40- 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.
41- Assemble the joint to the machine roll. Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
42- Assemble inlet and outlet hoses to the supply and return pipes or valves.
43- Now the joint is ready for work.