



# 600+1 SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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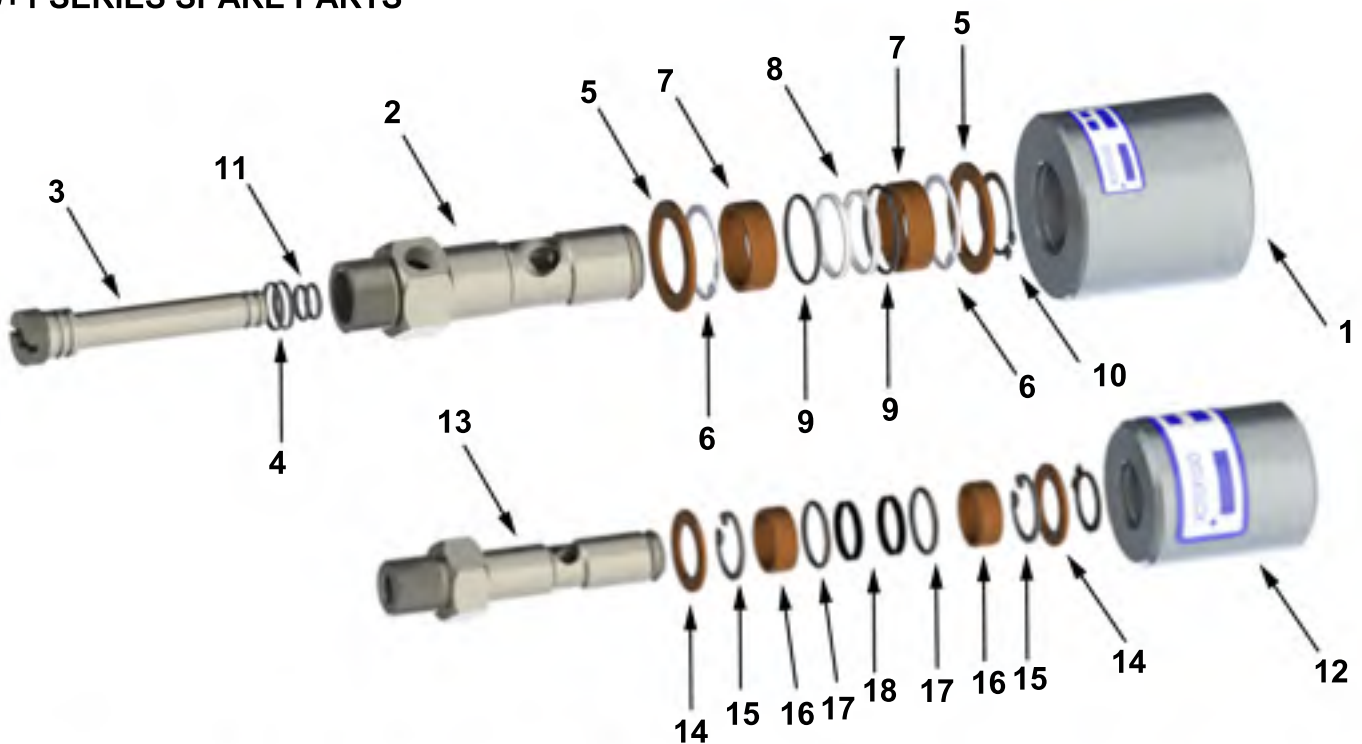
SIZE	MODEL
1/2" x 1/8"	605
3/4" x 1/4"	607
1" x 3/8"	610



## WARNING

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

## 600+1 SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	INNER SHAFT	1
4	INNER SHAFT FRONT O-RING	2
5	BRONZE WASHER	2
6	INT. RETAINING RING	2
7	BRONZE BEARING	2
8	BACK-UP	2
9	SEAL O-RING	2
10	EXT. RETAINING RING	1

NO	PART NAME	QTY
11	INNER SHAFT O-RING	1
12	HOUSING	1
13	SHAFT	1
14	BRONZE WASHER	2
15	INT. RETAINING RING	2
16	BRONZE BEARING	2
17	BACK-UP	2
18	SEAL O-RING	2
19	EXT. RETAINING RING	1



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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- Disassemble shaft from the machine with appropriate tool.
- 4- Hold the housing(1) of the front joint with a bench wise and take out the inlet hose from the housing.
- 5- Hold the housing(12) of the rear joint with a bench wise and take out the second inlet hose from the housing.
- 6- Be careful not to damage the housings while holding it with the bench wise.
- 7- Hold the front shaft(2) with a bench wise and separate two joints from each other.
- 8- Prepare a clean place on the table where planned to make the maintenance.
- 9- Place the joint on the table onto the shaft side and control visually if there is any damage or defects.
- 10- Disassemble the external retaining ring(10) of the shaft and take out the rear bronze washer(5).
- 11- Hold the shaft from the threaded side and take it out from the housing slowly.
- 12- Be careful not to damage internal parts when taking out the shaft from the housing.
- 13- Take out the front bronze washer(5) from the shaft.
- 14- Remove internal retaining rings(6) from both sides of the housing.
- 15- Take out bronze bearings(7) from both sides of the housing. Inspect them and if necessary replace them with new ones.
- 16- Take out the seal o-rings(9) and back-ups(8) from the sockets inside the housing.
- 17- Clean shaft and inspect for corrosion and deformation. If necessary change it with new one.
- 18- Clean all internal surfaces of the housing and seal sockets.
- 19- First place new seal o-rings(9) inside the sockets of the housing.
- 20- Be careful not to twist when installing teflon back-up rings(8) under the seal o-rings.
- 21- Assemble bronze bearings(7) to the sockets from both sides of the housing and place internal retaining ring(6) on top.
- 22- Apply light oil to internal surfaces of the housing.
- 23- Hold the shaft(2) from hexagon surface and take out the inner shaft(3) slowly.
- 24- Control inner shaft for corrosion and deformation, if necessary replace it with new one.
- 25- Control inner shaft o-rings(4-11); if necessary replace them with new ones.
- 26- Apply light oil to the inner shaft o-rings and place the inner shaft into the shaft(2)
- 27- Place bronze washer(5) onto the shaft.
- 28- Apply light oil on the surfaces of the shaft.
- 29- Be careful not to damage the seals while installing shaft into the housing slightly.
- 30- Assemble the rear bronze washer(5) and fix the shaft with shaft retaining ring(10).
- 31- Check rotation of the joint, if any knocking or noise show up, go to step 9 and follow the steps.
- 32- Apply steps 9-31 to second joint.
- 33- Hold the front shaft with a bench wise and connect second joint to the first joint.
- 34- Hold the housing of the front joint with a bench wise and assemble inlet hose to the housing.
- 35- Hold the housing of the second joint with a bench wise and assemble the second hose to the housing.
- 36- Assemble the joint to the machine roll. Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
- 37- Assemble the inlet hoses to the supply pipes or valves.
- 38- Now the joint is ready for work.