



# 800SR SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



Document No: TL 7 77 EN

Release Date: 01.09.2015

Rev No: 0

STRAIGHT TYPE

RADIAL TYPE

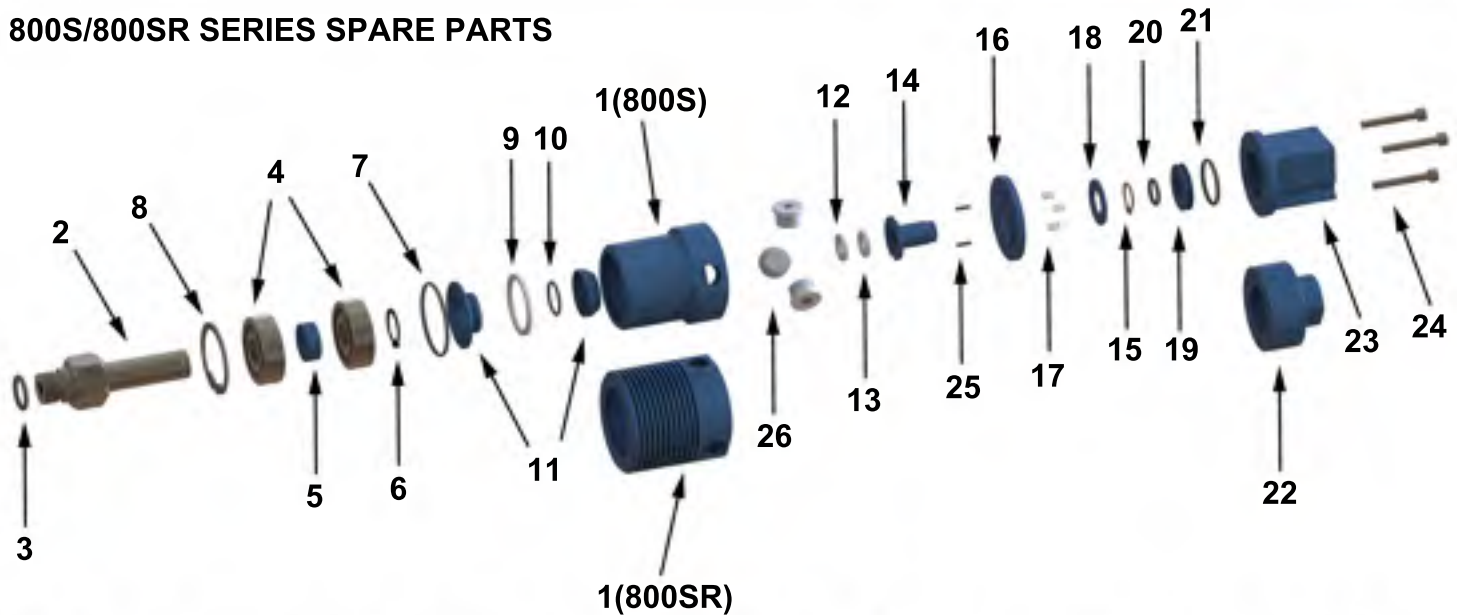
SIZE	MODEL
1/4"	808SR
3/8"	810SR



## WARNING

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

## 800S/800SR SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	SHAFT O-RING	1
4	BALL BEARING	2
5	WASHER	1
6	EXT. RETAINING RING	1
7	HOUSING O-RING	1
8	INT. RETAINING RING	1
9	WAVE SPRING	4
10	SLINGER O-RING	1
11	SLINGER SET	1
12	SEAL RING	1
13	FLOATING SEAL RING	1

NO	PART NAME	QTY
14	FLOATING SEAL HOLDER	1
15	EXT. RETAINING RING	1
16	HOUSING FLANGE	1
17	SPRING	3
18	SUPPORT WASHER	1
19	SUPPORT	1
20	O-RING	1
21	O-RING	1
22	END CAP - AXIAL	1
23	END CAP - RADIAL	1
24	BOLTS	3
25	PIM	2
26	PIPE PLUG	3



## 800SR SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



Document No: TL 7 15

Release Date: 01.09.2014

Rev No: 0

- 5- Hold the housing(1) of the joint with a bench vise and take out the inlet and drain hoses from the housing.
- 6- Be careful not to damage the housing while holding it with the bench vise.
- 7- Place the joint on the table onto the housing and control visually if there is any damage or defects, take out the shaft o-ring(3).
- 8- Remove end cap bolts(24) and separate end cap(22-23) with housing flange group from the housing.
- 9- Hold the shaft(2) from the threaded side and press through the housing.
- 10- Take out the internal retaining ring(8) with snap ring pliers; take out the shaft with bearings slowly.
- 11- Take out the bearing spring group(9) and housing o-ring(7).
- 12- Inspect for corrosion and deformation, if necessary replace them with new ones.
- 13- Disassemble the seal ring(12) from the shaft. Be careful not to damage the sealing socket.
- 14- Disassemble the bearing slinger set(11) and take out the slinger o-ring(10) from the shaft.
- 15- Take out the shaft retaining ring(6) with appropriate snap ring pliers.
- 16- Disassemble ball bearings(4) and washer(5) from the shaft. Do not damage seal ring socket.
- 17- Clean shaft and inspect for corrosion and deformation. If necessary change it with new one.
- 18- Separate floating seal group and housing flange(16) from the end cap(22-23).
- 19- Take out the support(19) from the floating seal holder(14).
- 20- Remove retaining ring(15) from the holder and take out support washer(18) and springs(17).
- 21- After separating housing flange and floating seal group, take out the floating seal ring(13) from the holder. Take out inner(20) and outer(21) o-rings of the support.
- 22- Clean all internal surfaces of the housing, check for corrosion and deformation. If sealing surfaces are damaged, change the housing with new one.
- 23- Assemble bearings(4) and washer(5) onto the shaft and fix it with retaining ring(6).
- 24- Place a new slinger o-ring(10) and apply grease slightly.
- 25- Assemble the slinger set(11) onto the shaft.
- 26- Place new seal ring(12) into the socket of the shaft. Be careful not to damage sealing surface.
- 27- Assemble a new housing o-ring(7) into the socket of the housing and apply grease slightly.
- 28- Place a new bearing spring set(9) into the housing.
- 29- Hold the shaft from the threaded side; assemble it into the housing, fix with retaining ring(8).
- 30- Control anti rotation pins(25) on the housing flange, if needed, replace them with new ones.
- 31- Assemble a new floating seal ring(13) into the sealing socket of the floating seal holder(14).
- 32- Place new inner(20) and outer o-ring(21) into the sockets of the support(19) and apply grease.
- 33- Apply grease into the spring sockets of the housing flange(16) and place springs(17) in them.
- 34- Assemble floating seal holder(14) to the housing flange from the surface with pins and pin sockets facing together.
- 35- Place support washer(18) onto the floating seal holder and fix with retaining ring(15).
- 36- Assemble support(19) onto the floating seal holder until it is fully in place.
- 37- Align bolt holes of end cap and housing flange. Assemble floating group together into the end cap.
- 38- Align bolt holes and fix the end cap group and housing together with bolts(24).
- 39- Check rotation of the joint, if any knocking or noise show up, go to step 7 and follow the steps.
- 40- Place a new shaft o-ring(3) and apply grease slightly.
- 41- Hold the housing of the joint with a bench vise and assemble inlet and drain hose to the housing.
- 42- Assemble the joint to the machine roll. Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
- 43- Assemble the inlet and drain hose to the lines; now the joint is ready for work.