



900P SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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Rev No: 0

SIZE	MODEL
1/2"	905P
3/4"	907P
1"	910P
1 1/4"	912P
1 1/2"	915P
2"	920P
2 1/2"	925P
3"	930P
3 1/2"	935P
4"	940P
5"	950P

STYLE 20



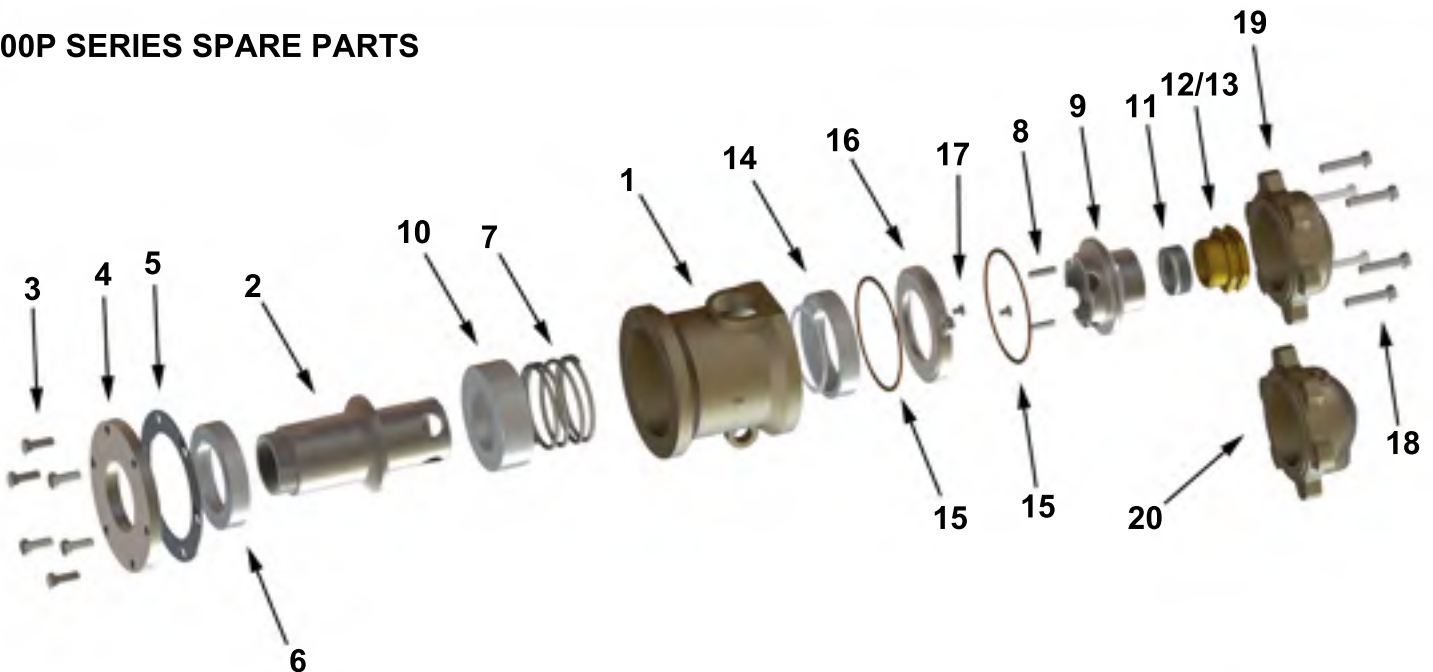
STYLE 30



WARNING

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

900P SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	BOLTS	n
4	FRONT HOUSING FLANGE	1
5	HOUSING GASKET	1
6	SEAL RING	1
7	SPRING	1
8	WEDGES	2
9	THRUST COLLAR	1
10	GRAPHITE BEARING	1

NO	PART NAME	QTY
11	SIPHON PACKING	n
12	PACKING GLAND	1
13	LOCK NUT	1
14	SEAL RING	1
15	HOUSING GASKET	1
16	ASSEMBLY FLANGE	1
17	SCREWS	2
18	BOLTS	n
19	END CAP - STYLE 20	1
20	END CAP - STYLE 30	1

n: changes according to size of the rotary joints



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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 the supply and return pipes or valves.
- 4- Disassemble shaft from the machine with appropriate tool.
- 5- Dual flow rsp type joints will be separated from the machine and siphon pipe will remain with the machine.
- 6- Be careful not to damage the internal siphon pipe and internal parts when separating the dual flow joint from the machine.
- 7- Hold the housing(1) of the joint with a bench vice and take out the inlet and outlet hoses from the joint.
- 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 flange(4) as shown on Fig.1.
- 11- Control visually if there is any damage or defects.
- 12- Do not forget that there is spring(7) inside the joint.
All internal parts may pop out from the housing because of the force of the spring.
- 13- Remove hex bolts(18) from the end cap and separate end cap from the housing and place it on the table.
- 14- Separate copper gasket(15) from the assembly plate(16).
- 15- Push assembly plate from top and loosen screws(17) of the assembly plate.
- 16- Remove assembly plate slowly from the housing, internal parts will come out.
- 17- After taking out the assembly plate, remove internal parts; rear seal ring(14), thrust collar(9) with siphon packing(11) and gland(12)&nut(13), spring(7), graphite bearing(10), wedges(8), front shaft(2) and front seal ring(6).
- 18- Rotate housing upside down and place it on the table.
- 19- Remove hex bolts(3) of the front housing flange(4) and separate housing flange from the housing.
- 20- Separate front housing gasket(5) from the housing.
- 21- Loosen lock nut(13) and take out the siphon packing gland(12).
- 22- Separate all siphon packing(11) from the thrust washer.
- 23- Clean all internal parts and inspect for corrosion and deformation; if necessary replace them with new ones.
- 24- Clean internal surfaces of the housing with a clean material. Pay attention not to leave dirt, burr, etc. inside the housing.
- 25- Place housing onto the backside on a clean table and assemble a new housing gasket(5) onto the housing gasket surface.



FIG. 1



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- 26- Clean housing flange(4) and inspect it for corrosion and deformation. If sealing surface is deformed, apply microlapping proses or replace it with a new one.
- 27- Place housing flange onto the housing gasket while microlapped surface facing inside the housing.
- 28- Align bolt holes of the housing flange, housing gasket and housing and fix housing flange to the housing with appropriate bolts(3).
- 29- Rotate housing upside down onto the housing flange as shown Fig.1.
- 30- Place seal ring(6) inside the housing with microlapped seal surfaces facing microlapped surface of the housing flange.
- 31- Hold the shaft(2) from the wedges(8) side and place it into the housing with convex face facing concave face of the seal.
- 32- Place the graphite bearing(10) onto the shaft inside the housing while spring socket facing upwards.
- 33- Assemble the spring(7) onto the graphite bearing socket.
- 34- Clean thrust collar(9) and control for deformation. If necessary replace it with new one.
- 35- Place new set of siphon packing(11) inside the thrust collar.
- 36- Assemble packing gland(12) and fix it with lock nut(13).
- 37- Becareful to align wedges(8) on the shaft and sockets on the thrust collar and place thrust collar onto the shaft. Convex sealing surface will face upwards.
- 38- Assemble the rear seal ring(14) onto the thrust collar while concave sealing face of seal ring will face convex sealing surface of thrust collar.
- 39- Place a new copper gasket(15) onto the housing.
- 40- Clean assembly plate(16) and inspect it for corrosion and deformation. If sealing surface is deformed, apply microlapping proses or replace it with a new one.
- 41- Place the assembly plate on to the rear seal ring while microlapped surface facing microlapped surface of rear seal ring.
- 42- Align screw holes of the assembly plate and screw holes of the housing.
- 43- Push assembly plate to the housing and fix it with appropriate screws(18) to the housing.
- 44- Hold the housing with a bench wise and assemble inlet hose.
- 45- Hold the end cap with a bench wise and assemble the outlet hose.
- 46- Place the housing of the joint to the machine by sliding it onto the siphon pipe and assemble it to the machine.
- 47- Control rotation of the joint, if any eccentricity is seen, disassemble the joint and assemble it again.
- 48- Place a new copper gasket onto the assembly flange.
- 49- Assemble end cap(19-20) onto the copper gasket(15) and fix end cap to the housing with appropriate bolts(18).
- 50- Assemble inlet and outlet hoses to the supply and return lines.
- 51- All 900P Series housings have an anti rotation lug on the housing which is used to stop the housing from rotation.
- 52- Install the anti rotation rod into the hole on the lug on the housing. Never tie more than 2 joints with a single rod. Fix the rod to one of the holes of the joints and leave the rod to float.
- 53- Now the joint is ready for work.