



900R SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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Rev No: 0

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

STYLE 20



STYLE 30



STYLE 40



STYLE 50



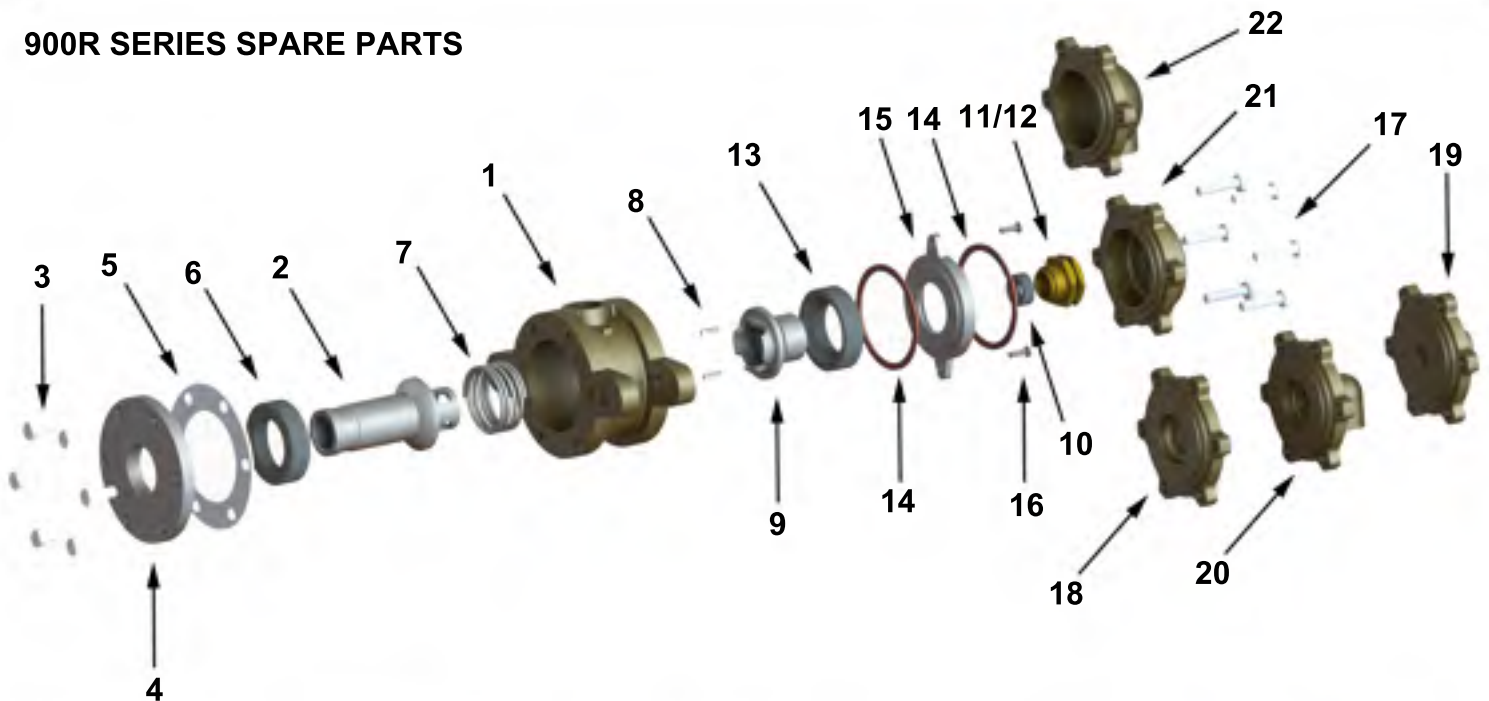
STYLE 60



WARNING

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

900R SERIES SPARE PARTS



NO	PART NAME	QTY	NO	PART NAME	QTY
1	HOUSING	1	12	LOCK NUT	1
2	SHAFT	1	13	SEAL RING	1
3	BOLTS	n	14	HOUSING GASKET	1
4	FRONT HOUSING FLANGE	1	15	ASSEMBLY FLANGE	1
5	HOUSING GASKET	1	16	SCREWS	2
6	SEAL RING	1	17	BOLTS	n
7	SPRING	1	18	END CAP - STYLE 20	1
8	WEDGES	2	19	END CAP - STYLE 30	1
9	THRUST WASHER	1	20	END CAP - STYLE 40	1
10	SIPHON PACKING	n	21	END CAP - STYLE 50	1
11	PACKING GLAND	1	22	END CAP - STYLE 60	1

- n changes according to size of the joint
 - No:10-11-12 is only for RSP models



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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- Loosen rod lock nuts with appropriate tools and take out the nuts.
- 4- Disconnect inlet and outlet hoses from the supply and return pipes or valves.
- 5- Disassemble shaft from the machine with appropriate tool.
- 6- Single flow joints will be separated directly from the machine.
- 7- Dual flow joints will be separated from the machine with the siphon pipe.
- 8- Dual flow rsp type joints will be separated from the machine and siphon pipe will remain with the machine.
- 9- Be careful not to damage the internal siphon pipe and internal parts when separating the dual flow joint from the machine.
- 10- Hold the housing(1) of the joint with a bench vice and take out the inlet and outlet hoses.
- 11- Be careful not to damage internal parts of the dual flow joint when taking out the internal siphon pipe of the joint from the end cap
- 12- Be careful not to damage the housing while holding it with the bench vice.
- 13- Prepare a clean place on the table where planned to make the maintenance.
- 14- Place the joint on the table onto the housing flange(4) as shown on Fig.1.
- 15- Control visually if there is any damage or defects.
- 16- 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.
- 17- Remove hex bolts(17) from the end cap(18-19-20 21-22) and separate end cap from the housing and place it on the table.
- 18- Separate copper gasket(14) from the assembly plate(15).
- 19- Push assembly plate(15) from top and loosen screws(16) of the assembly plate.
- 20- Take out assembly plate slowly from the housing, internal parts will come out.
- 21- After taking out the assembly plate, remove internal parts; rear seal ring(13), thrust collar(9) with siphon packing(10) and gland&nut(11/12), spring(7), wedges(8) , front shaft(2) and front seal ring(6).
- 22- Rotate housing upside down and place it on the table.
- 23- Remove hex bolts(3) of the front housing flange(4) and separate housing flange from the housing.
- 24- Separate front housing gasket(5) from the housing.
- 25- If RSP type is used; loosen lock nut(12) and take out the siphon packing gland(11).
- 26- Separate all siphon packing(10) from the thrust collar(9).

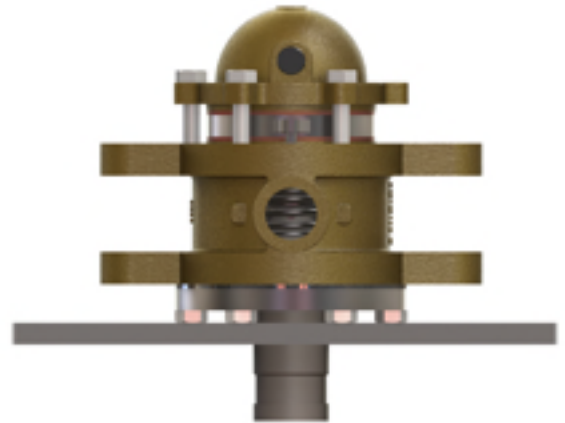


FIG 1



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- 27- Clean all internal parts and inspect for corrosion and deformation; if necessary replace them with new ones.
 - 28- Clean internal surfaces of the housing with a clean material. Pay attention not to leave dirt, burr, etc. inside the housing.
 - 29- Place housing onto the backside on a clean table and assemble a new housing gasket(5) onto the housing gasket surface.
 - 30- 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.
 - 31- Place housing flange onto the housing gasket(5) while microlapped surface facing inside the housing.
 - 32- Align bolt holes of the housing flange(4), housing gasket(5) and housing(1) and fix housing flange to the housing with appropriate bolts.
 - 33- Rotate housing upside down onto the housing flange(4) as shown Fig.1.
 - 34- Place seal ring(6) inside the housing with microlapped seal surface facing microlapped surface of the housing flange.
 - 35- Hold the shaft(2) from the wedges(8) side and place it into the housing with convex face facing concave face of the seal.
 - 36- Place the spring(7) onto the shaft.
- FOR SINGLE FLOW AND DUAL FLOW STATIONARY SIPHON PIPE
- 37- Be careful to align wedges(8) on the shaft and sockets on the thrust collar(9) and place thrust collar onto the shaft. Convex sealing surface will face upwards.
 - 38- Assemble the rear seal ring(13) onto the thrust collar while concave sealing face of seal ring will face convex sealing surface of thrust washer.
 - 39- Place a new copper gasket(14) onto the housing.
 - 40- Clean assembly plate(15) 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(15) on to the rear seal ring(13) 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(16) to the housing.
 - 44- Place a new copper gasket(14) onto the assembly plate.
 - 45- Assemble end cap to the housing and fix it with appropriate bolts.
 - 46- For styles 30-40; be careful to align inlet and outlets to supply lines when assembling the end cap to the housing.
 - 47- Hold the housing with a bench wise and assemble inlet and outlet hoses.
 - 48- If dual flow-s type joint is used; be careful not to damage internal parts when assembling siphon pipe inside the housing.



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49- Assemble the siphon pipe to the end cap.

50- Assemble the joint to the machine, be careful not to assemble it eccentrically.

51- 900R Series rotary joints are designed to be used without carbon bearings and supported with external rods.

52- Assemble inlet and outlet hoses to the supply and return lines.

53- Now the joint is ready for work.

FOR DUAL FLOW RSP SIPHON PIPE

37- Clean thrust collar(9) and control for deformation. If necessary replace it with new one.

38- Place new set of siphon packing(10) inside the thrust collar.

39- Assemble packing gland(11) and fix it with lock nut(12).

40- Be careful 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.

41- Assemble the rear seal ring(13) onto the thrust collar while concave sealing face of seal ring will face convex sealing surface of thrust collar.

42- Place a new copper gasket(14) onto the housing.

43- Clean assembly plate(15) and inspect it for corrosion and deformation. If sealing surface is deformed, apply microlapping proses or replace it with a new one.

44- Place the assembly plate on to the rear seal ring while microlapped surface facing microlapped surface of rear seal ring.

45- Align screw holes of the assembly plate and screw holes of the housing.

46- Push assembly plate to the housing and fix it with appropriate screws(16) to the housing.

47- Hold the housing with a bench wise and assemble inlet hose.

48- Hold the end cap with a bench wise and assemble the outlet hose.

49- Place the housing of the joint to the machine by sliding it onto the siphon pipe and assemble it to the machine.

50- 900R Series rotary joints are designed to be used without carbon bearings and supported with external rods.

51- Control gap between siphon pipe and siphon packing gland and check the gap between the shaft and front housing flange.

52- If any eccentricity is seen, disassemble the joint and assemble it again.

53- Place a new copper gasket(14) onto the assembly flange.

54- Assemble end cap onto the copper gasket and fix end cap to the housing with appropriate bolts.

55- Assemble inlet and outlet hoses to the supply and return lines.

56- Now the joint is ready for work.