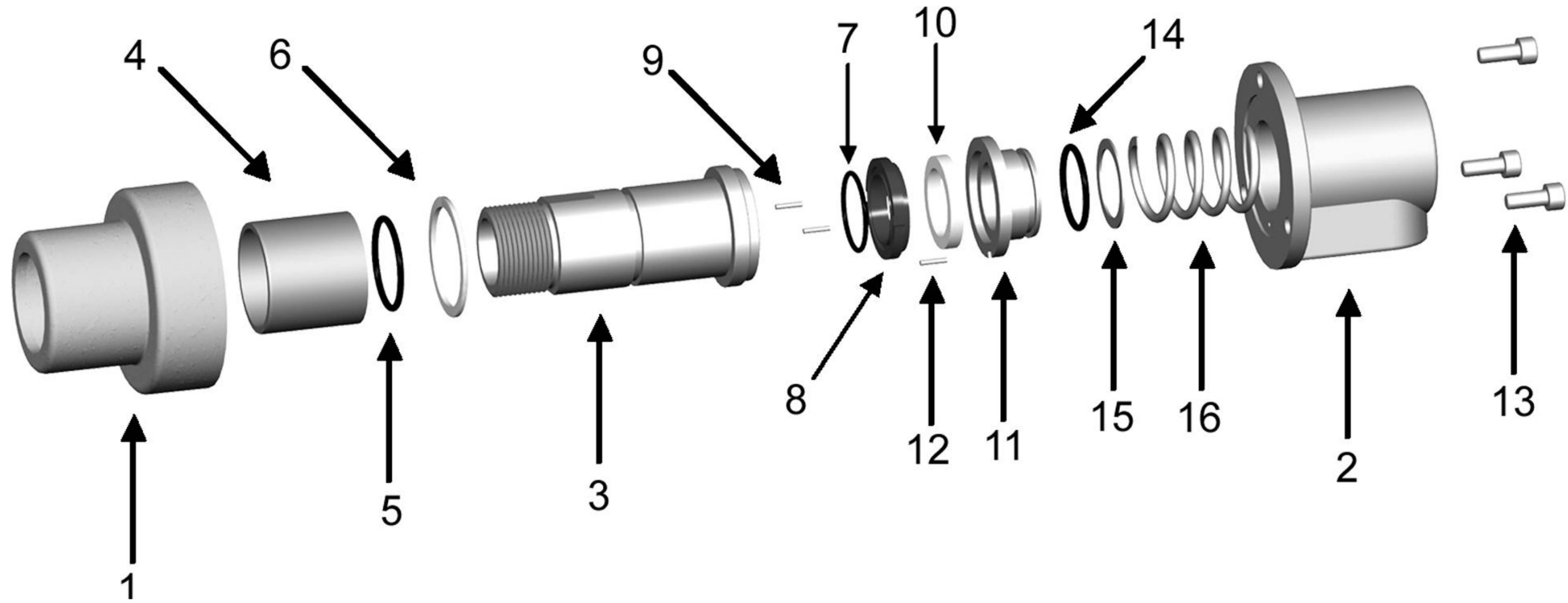


# 400 Series Rotary Joint Disassembly & Maintenance Instructions

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## Spare Parts Set

NO	PART NAME	QTY
5	O-RING	1
7	O-RING	1
8	SEAL RING	1
10	FLOATING SEAL RING	1
14	O-RING	1
15	SPACER	1
16	SPRING	1

Not: Read all of the maintenance instructions and safety procedures before proceeding.

1. Close outlet and inlet valves and wait for all the medium in the system to be drained completely. If hot medium is used, wait for the rotary joint to cool down to normal temperature.
2. First of all, disconnect the inlet and outlet hoses from the pipes or valves without applying force on the housing.(1)
3. Disconnect the shaft (3) from the machine. Now the joint is ready for maintenance.
4. Hold the end cap of the rotary joint with a bench wise.
5. Disconnect the inlet and outlet hoses from the rotary joint.
6. Put the rotating joint on a clean table.
7. Because of the force of the spring(16), first press the end cap and while pressing, remove the end cap bolts(13).
8. Because of the pressurized spring inside, in order not to pop of the internal parts; control the internal parts while separating the end cap from the housing.
9. Take out the seal groups (7-8-10-11) and control them; if necessary replace them with new ones.

10. Take out the shaft (3) from the housing and clean it.

11. Take out the PTFE bearing(6) and the bronze bearing (4) from the housing.

12. Inspect the shaft, PTFE bearing and bronze bearing. Replace them with the new ones if necessary.

13. Clean the internal part of the housing with a clean material. Pay attention not the leave any dirt, burr, etc. inside the housing.

14. Place the bronze bearing inside the housing. After assembling the PTFE bearing and a new o-ring on to the shaft, assemble the shaft into the housing. Be careful not to damage the o-ring while assembling the shaft.

15. Place the o-ring(7) inside the seal ring. Pay attention to the pims while assembling the seal ring into its place on the shaft.

16. Place the spring, spacer and the floating seal group inside the end cap.

17. While pressing the housing group on to the end cap, tighten the bolts.

18. Hold the end cap of the housing with a bench wise and connect the inlet and outlet hoses.

19. Pay attention not to assemble the joint eccentrically when assembling the joint to the machine.

20. Now the joint is ready to be placed back in service

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