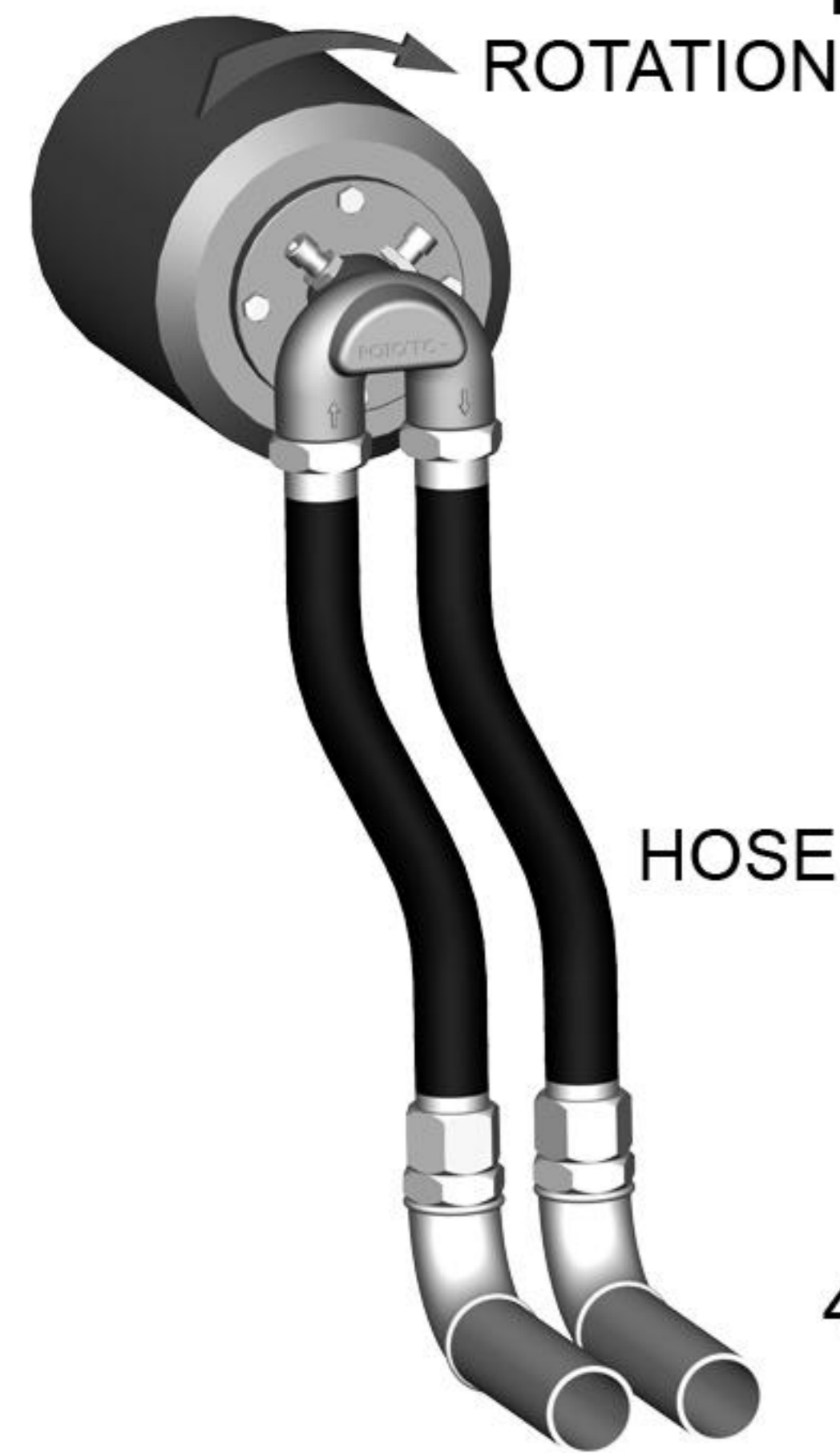


**INSTALLATION, OPERATION,  
MAINTENANCE INSTRUCTIONS**

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**1000A SERIES, 1000B SERIES  
1000C SERIES**

 SIZE: 1/2", 3/4", 1"  
 SINGLE FLOW, DUAL FLOW  
**INSTALLATION INSTRUCTIONS**


1. Do not anchor rotary joint. Rotary joints are designed to float with the flexible hoses.
2. Do not pipe directly. Always use flexible hoses.
3. Install hose with curve in direction of rotation.
4. 1000 Series are designed for max. 10 bar(150 PSI) ve 120°C.

5. All 1000 Series have standard type housing. Single flow and dual flow joints consists of standard housing and the appropriate elbow type.

6. Always flood the Rotary Joint and purge any entrapped air in the system before operating the machine to improve joint performance and longer joint life.

**INSTALLATION**


1. First hold the single flow or dual flow elbow on a bench wise and assemble the inlet and return hoses.

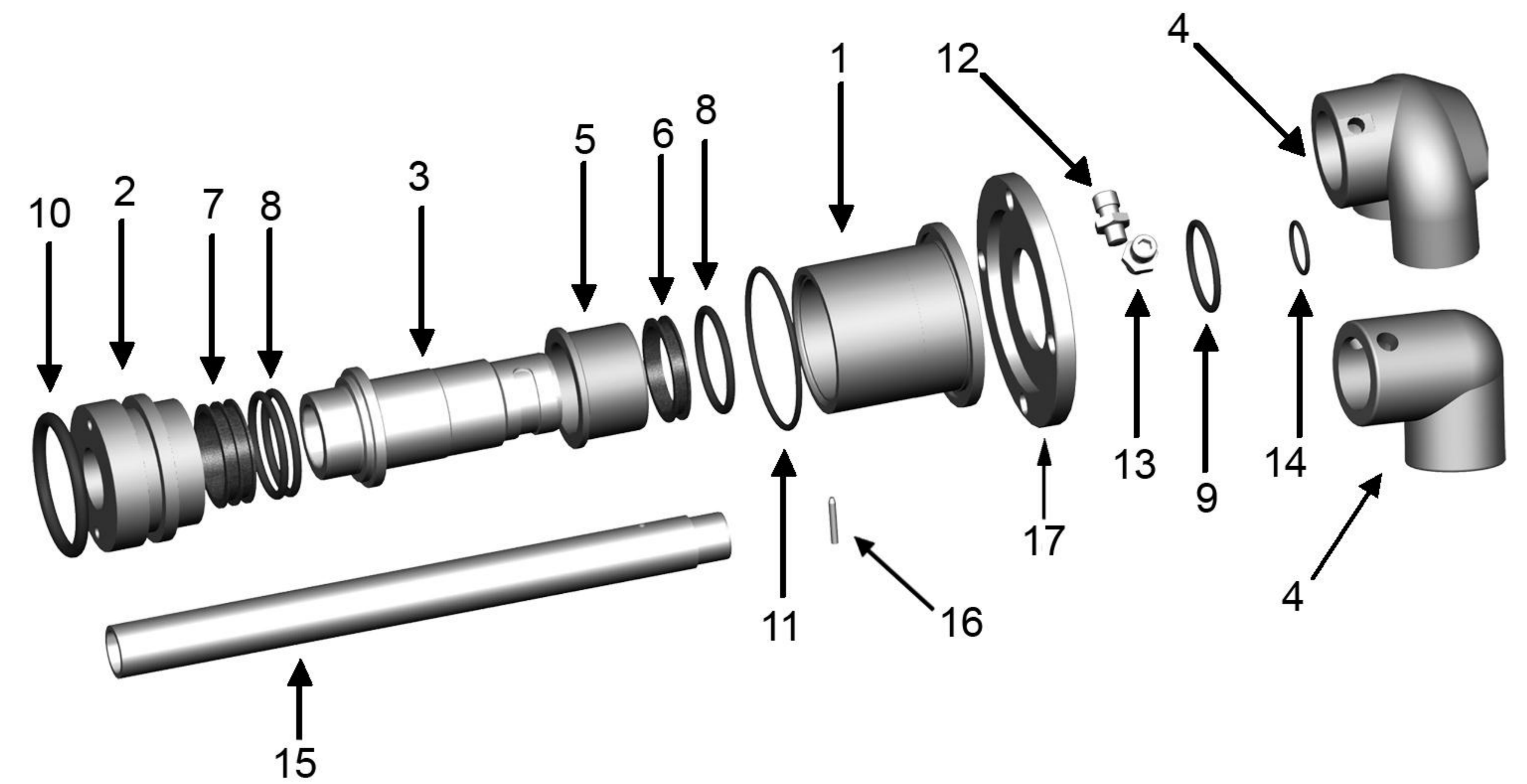
2. Assemble the standard 1000A/B/C type housing into the machine. For 1000A and 1000B Series, fix the housing to the machine with appropriate assembly flange and tighten all bolts correspondingly.

3. 1000C type joints do not need assembly flange. Fix the flange on the housing to the machine with appropriate bolts and tighten all bolts correspondingly.

4. Install the elbow to the shaft. Before tightening both bolts be sure that the bolts on the elbow is facing to the channel on the shaft

5. Connect supply and return lines to the hoses. Control the flexibility of the hoses. Be sure that the hoses are flexible and will be flexible under the pressure and temperature of the medium. Never install the joint directly to the supply and return pipes.

6. After assembling, check if running is smooth. If not, disassemble the joint and assemble it again.

**1000B SERIES SPARE PARTS LIST**


| NO | PART NAME         | QTY | NO | PART NAME             | QTY |
|----|-------------------|-----|----|-----------------------|-----|
| 1  | 1000B HOUSING     | 1   | 9  | ELBOW O-RING**        | 1   |
| 2  | 1000B END CAP     | 1   | 10 | HOUSING O-RING**      | 1   |
| 3  | SHAFT             | 1   | 11 | FLANGE O-RING**       | 1   |
| 4  | SINGLE FLOW ELBOW | 1   | 12 | BOLT                  | 2   |
|    | DUAL FLOW ELBOW   |     | 13 | NUT                   | 2   |
| 5  | BEARING           | 1   | 14 | SIPHON PIPE O-RING ** | 1   |
| 6  | SINGLE U-CUP **   | 1   | 15 | SIPHON PIPE *         | 1   |
| 7  | DOUBLE U-CUP **   | 1   | 16 | PIM *                 | 1   |
| 8  | SEAL O-RING **    | 3   | 17 | ASSEMBLY FLANGE       | 1   |

\* Supplied by customer

\*\* Spare parts set

**SEALING**

In 1000 Series sealing is assured with double u-cup and double o-rings in the back and single u-cup and single o-ring in the front. In case where the joint starts to leak, both sets of sealing must be changed. Before assembling the joint to the machine, housing o-ring and flange o-ring must be controlled. After every disassembly from the machine, elbow and siphon o-ring must be changed.

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