

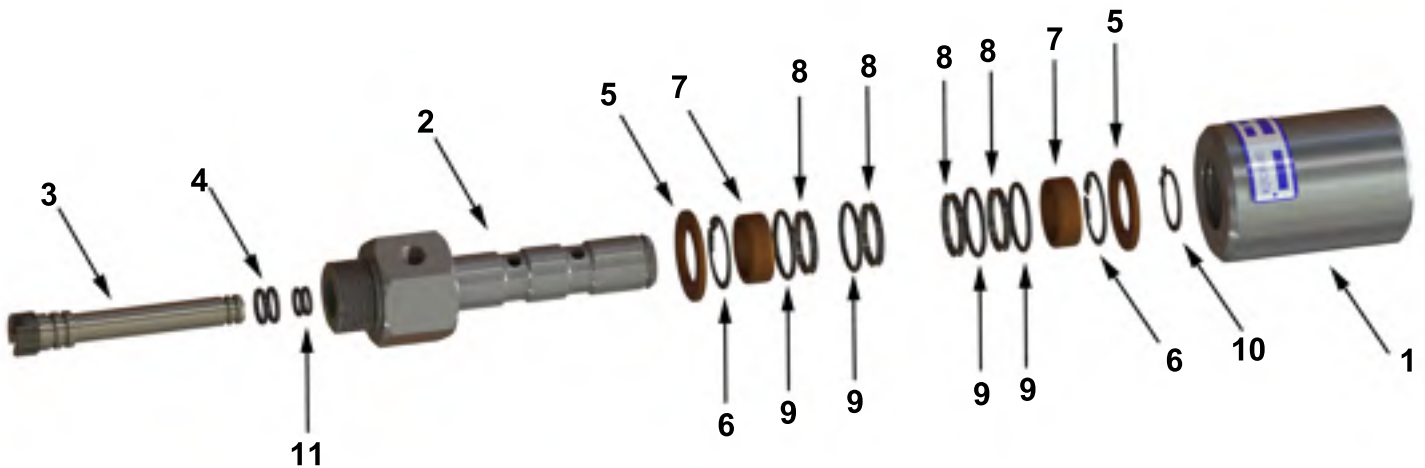
SIZE	MODEL
2 x 1/4"	725
2 x 3/8"	737
2 x 1/2"	750
2 x 3/4"	775



### WARNING

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

### 700 SERIES SPARE PARTS



NO	PART NAME	QTY
1	HOUSING	1
2	SHAFT	1
3	INNER SHAFT	1
4	INNER SHAFT FRONT O-RING	2
5	BRONZE WASHER	2
6	INT. RETAINING RING	2
7	BRONZE BEARING	2
8	BACK-UP	4
9	O-RING	4
10	EXT. RETAINING RING	1
11	INNER SHAFT O-RING	1



## 700 SERIES DISASSEMBLY & MAINTENANCE INSTRUCTIONS



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- 1- Before disassembling the joint from the machine, close inlet 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- Disconnect inlet hose from the supply pipe or valve.
- 3- Disconnect outlet hose or pipe from the outlet pipe.
- 4- Disassemble shaft from the machine with appropriate tool.
- 5- Hold the housing(1) of the joint with a bench vice and take out the inlet hoses from the housing.
- 6- Be careful not to damage the housing while holding it with the bench vice.
- 7- Prepare a clean place on the table where planned to make the maintenance.
- 8- Place the joint on the table onto the shaft side and control visually if there is any damage or defects.
- 9- Disassemble the external retaining ring(10) of the shaft and take out the rear bronze washer(5).
- 10- Hold the shaft from the threaded side.
- 11- Be careful not to damage internal parts when taking out the shaft from the housing.
- 12- Take out the front bronze washer(5) from the shaft.
- 13- Hold the shaft(2) with a bench vice and take out the inner shaft(3). Do not hold the shaft from the sealing surfaces.
- 14- Remove front(4) and rear o-rings(11) from the inner shaft.
- 15- Remove internal retaining rings(6) from both sides of the housing.
- 16- Take out bronze bearings(7) from both sides of the housing. Inspect them and if necessary replace them with new ones.
- 17- Take out the seal o-rings(9) and back-ups(8) from the sockets inside the housing.
- 18- Clean both shafts and inspect for corrosion and deformation. If necessary change it with new one.
- 19- Place new front(4) and rear o-rings(11) onto the inner shaft and apply grease slightly.
- 20- Hold the shaft with a bench vice and assemble the inner shaft into the outer shaft.
- 21- Clean all internal surfaces of the housing and seal sockets.
- 22- First place new seal o-rings(9) inside the sockets of the housing.
- 23- Be careful not to twist when installing teflon back-up rings(8) under the seal o-rings.
- 24- Apply light oil to internal surfaces of the housing.
- 25- Place front bronze washer(5) onto the shaft.
- 26- Apply light oil on the surfaces of the shaft.
- 27- Be careful not to damage the seals while installing shaft to housing slightly.
- 28- Assemble the rear bronze washer(5) and fix the shaft with shaft retaining ring(10).
- 29- Check rotation of the joint, if any knocking or noise show up, go to step 8 and follow the steps.
- 30- Hold the housing of the joint with a bench vice and assemble inlet hoses to the housing.
- 31- Assemble the joint to the machine roll. Control rotation of the joint; if any eccentricity seems, disassemble it and assemble it again.
- 32- Connect outlet pipe or hose to the second line.
- 33- Assemble inlet and outlet hoses to the supply&return pipes or valves.
- 34- Now the joint is ready for work.