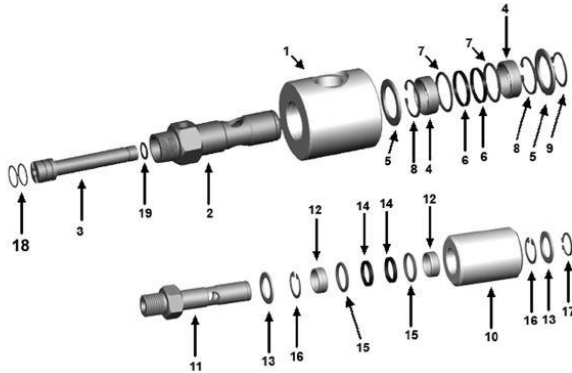




6000 Series Rotary Joint Disassembly & Maintenance Instructions

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Spare Parts Set

NO	PART NAME	QTY
6	BACK-UP*	2
7	O-RING*	2
14	BACK-UP*	2
15	O-RING*	2
18	O-RING*	2
19	O-RING*	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.
2. Disconnect the inlet and outlet hoses from the pipes or valves without applying force on both of the housings.(1-10)
3. Disconnect the shaft (2) from the machine. Now the joint is ready for maintenance.
4. Hold the rear of the housing (1) of the front joint with a bench vise and disconnect the inlet hose.
5. Hold the housing(10) of the second rotary joint with a bench vise and disconnect the inlet hose.
6. First separate the two joints from each other.
7. Put front housing(1) on a clean table, remove external retaining ring(9) and the bronze ring(5).
8. Take out the shaft (2) from the housing and pay attention not to damage the internal parts. Inspect the shaft and if shows excessive wear than replace it with a new one.
9. Hold the shaft from the hexagon part and take out the internal shaft(3). Inspect the o-rings(18-19) and if necessary replace them with new ones.
10. Clean the internal of the shaft and use a good adhesive on the internal shaft threads and assemble it into the shaft.

11. Remove the internal retaining rings (8) and bronze bearings from both sides of the housing.
12. Take out the back-ups(5) and o-rings(6) from their sealing sockets carefully with an appropriate tool.
13. Inspect all internal parts and if they are deformed,replace them with new ones.
14. Clean the internal part of the housing with a clean material. Pay attention not the leave any dirt, burr, etc. inside the housing.
15. Put the housing on one side on the table and place new back-ups and o-rings inside the sealing sockets.
16. Than place the bronze bearings inside the housing and assemble the internal retaining rings.
17. Clean the shaft carefully and place the bronze ring on the shaft.
18. Lubricate the internal parts of the housing with good quality grease. Be careful not to damage internal parts of the housing when assembling shaft into the housing.
19. Place the bronze ring on the shaft and assemble the external retaining ring.
20. Repeat the steps 7-19 for the back joint.
- 21. Assemble the joint on the back to the front joint.**
- 22.Hold the housings of the both joints with bench vise in order and connect the inlet and outlet hoses.
23. Pay attention not to assemble joint eccentricly when assembling the joint to the machine.
24. The joint is ready to be placed back in service.