

Before working on the rotary joints make sure to follow the security procedures imposed by current regulations. Read the instructions carefully before performing maintenance. Refer to the assembly drawings and / or consult Turian company or one of its authorized distributors. Make sure that the circuit is not pressurized and discharge any residual pressure. Wait until joint is cool. Use appropriate gloves.

## ORDINARY MAINTENANCE

Do lubrication periodically as attached **table 1** with relative quantity of grease OKS 432 or compatible as indicated in the **table 2** only for rotary joints with greaser. Perform daily a visual check of eventual leakage that may occur from the connections, if any, stop the operation of the machine and eliminate leakage; if the rotary joint leak, replace with a new one and proceed as follow for repairment after having required seal kit and a pair of bearings.

## REMOVAL AND REPLACEMENT OF BEARINGS AND SEALS

### REMOVAL

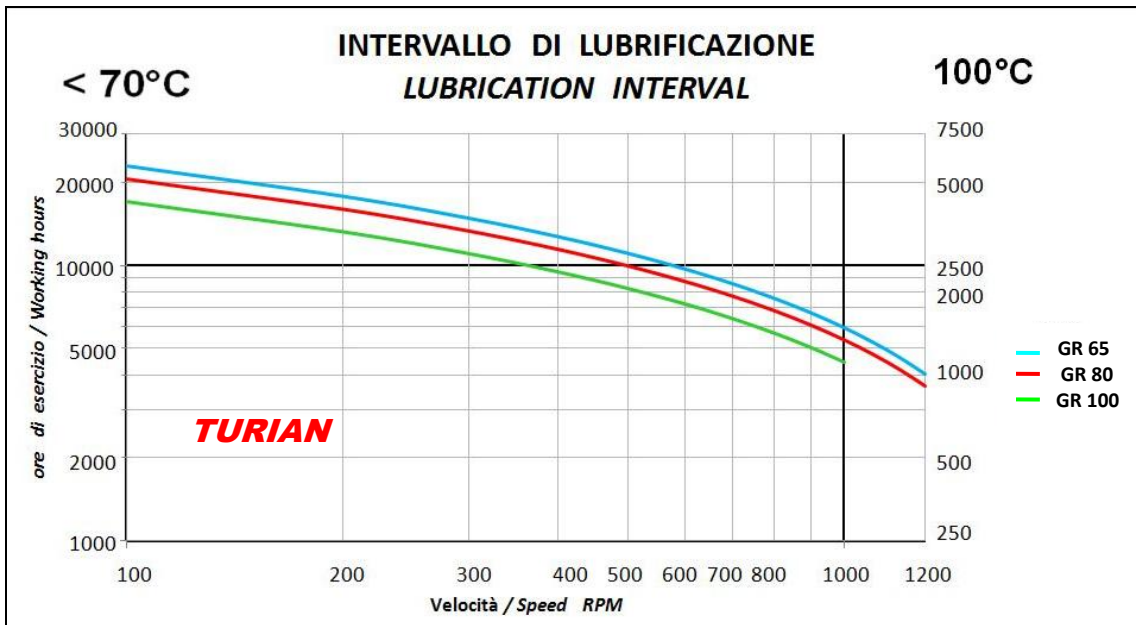
*Remember to use latex gloves when handling components lubricated.*

- First remove screws **16** and separate body **10** from ball bearings housing **12**
- Remove the two screws **20**, the static seal **8**, springs **7** and O-Ring **14**
- Check ball bearings, if they are not damaged You can replace only the rotating face seal **6** with O-Ring **5**
- If ball bearings have to be replaced
- Remove the snap ring **1** from bearings housing **12**
- Remove rotor **11** with bearings **12** using appropriate tools (education available on request)
- Remove the snap ring **4** and slide bearings **2** with relative spacer **3**

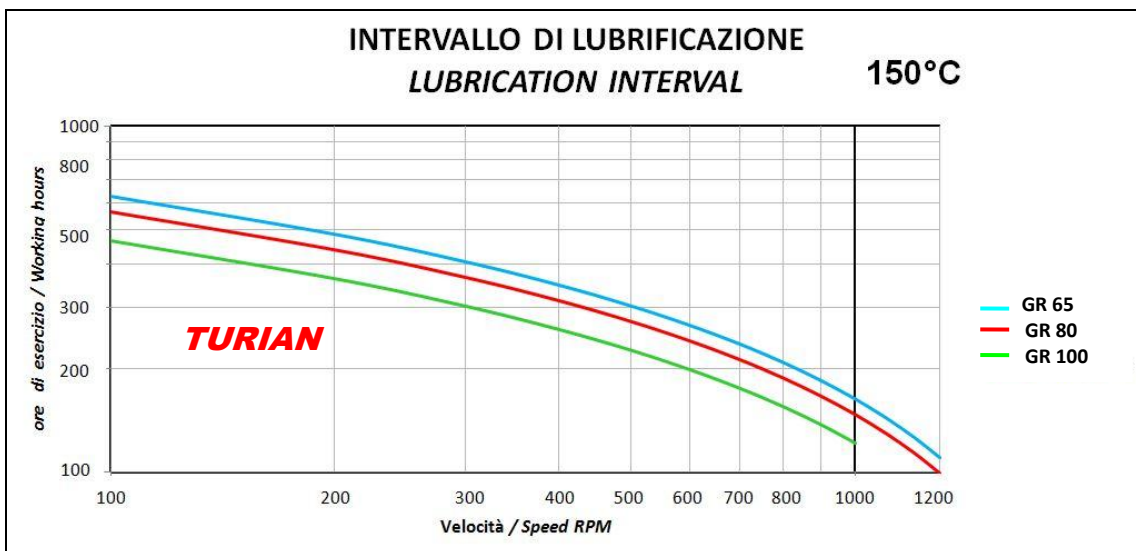
- Thoroughly clean and dry body **2**, rotor **1** and bearings housing **12**

### REPLACEMENT

- Check that the O-Ring **9** in the body **10** seat is smooth and without damage (cylindrical section positioned between radial entry and home anti-rotation screws **20**)
- Lubricate with silicone grease housing hole of the stationary seal **8** in the body **10** and O-Rings **9** and **14**
- Insert in the holes the springs **7**
- Insert the stationary seal **8** with O-Ring **9**, making sure that the holes on stationary seal are in position with holes in body and tighten the screws **20** using a threadlock product
- On the rotor **11** mount the first bearing **2** with the closed side facing the thread up to the stop, place the spacer **3**, mount the second bearing **2** with open side facing the first bearing
- Fit the snap ring **4**
- Mount the O-Ring **5** in its rotor seat and lubricate it with silicone grease
- Insert the rotating face seal **6** by placing the notch on the outside diameter is engaged by the anti-rotation pin **13** on rotor
- Wipe with a clean damp cloth with acetone flat the surfaces of the rotating seal **6** and the stationary **8**
- Then insert the rotor **11** in the bearings housing **12** in the vertical direction, applying a slight axial pressure on the rotor until it is brought in such a position as to uncover the circular groove for snap ring **1**
- Install the snap ring **1**
- Mount body **10** with bearings housing **12** using the screws **16**, check tightening torque to be **24,6 Nm**
- Test it before putting it into service



**TABELLA 1** - Operating temperature up to 100°C



**TABELLA 1** - Operating temperature up to 150°C

Modello Type	Quantità di grasso per lubrificazione periodica Grease quantity for lubrication interval cm <sup>3</sup>
GR-65	32
GR-80	42
GR-90	52
GR-100	52

**TABELLA 2** - Amount of grease lubricant