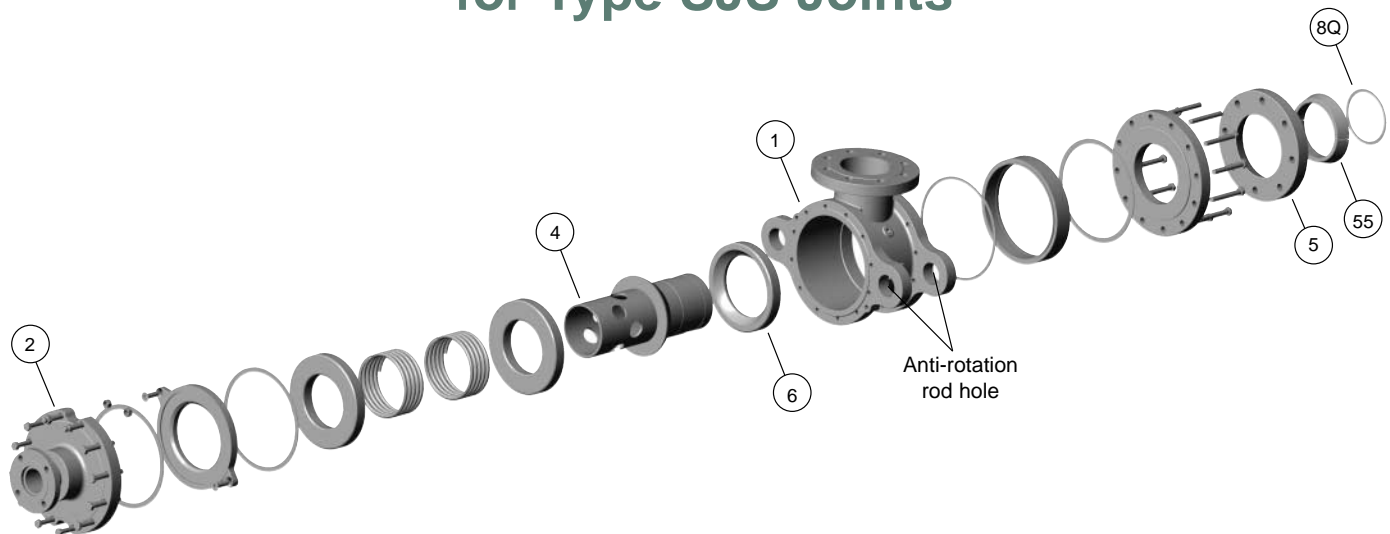


Installation Instructions for Type SJS Joints



Type 1000SJSFYRPQ

NOTE: Please follow your company's safety procedures whenever working on Kadant Johnson rotary joints and read all of the instructions completely before proceeding.

Please refer to the assembly drawings supplied with your Kadant Johnson rotary joint for part identification. If you have any questions, please contact your Representative or Kadant Johnson.

STEP 1.

Check to make sure that all core sand, dirt, weld beads, pipe turnings, metal dust and other foreign matter has been removed from the piping, roll, or cylinder before installing joint. This will help eliminate carbon seal ring scoring and damage to internal joint parts which could cause unnecessary downtime and maintenance.

STEP 2.

Thread horizontal pipe into the head (2).

IMPORTANT: THE HORIZONTAL PIPE MUST BE STRAIGHT AND TRUE. THIS WILL PREVENT EXCESSIVE PIPE WEAR AND PIPE BREAKAGE.

STEP 3.

Place a new copper gasket (8Q) into the recess of the journal flange. Slide quick release nipple flange (5) over rotary joint nipple (4) with its taper facing outward. Place the two split taper wedges (55) into the recess of the nipple tube and slide the quick release flange (5) over them to hold in place. Lift the joint up and slide nipple (4) into

the journal flange recess and secure to the studs with nuts provided, tightening evenly. Note that the quick release nipple flange (5) will not seat tightly against the face of the journal flange. When tight, there will be a 1/8" to 3/16" space between the two flanges. Measure the gap to make sure it is even.

If the nipple is threaded, apply pipe sealer to the threads, place it into the roll end, and tighten securely.

STEP 4.

Connect piping to joint using Kadant Johnson flexible metal hose. The hose(s) should be long enough so there is no binding or tension to move the joint off the journal centerline of the roll. The joint must be free to move outward to compensate for carbon seal ring wear. See recommended minimum hose length chart in this instruction sheet – Table 1.

IMPORTANT: CONNECT THE HOSE AS CLOSE TO THE JOINT AS POSSIBLE. MINIMIZE THE USE OF FITTINGS AND PIPE, AS THIS INCREASED WEIGHT CAN AFFECT THE PERFORMANCE OF THE JOINT. PROVIDE SUITABLE SUPPORT FOR THE PIPE AND FITTING BEYOND THE HOSE.

STEP 5.

Install anti-rotation rod using one set of body lug holes. **NOTE:** Only install the anti-rotation device on one side of the body. Attach bracket to rod between lugs and extend bracket to an anchor point. Reference Figures 1 and 2.

NEVER APPLY OIL OR GREASE TO KADANT JOHNSON JOINTS. THE SATURATED STEAM, CONDENSATE OR LIQUID PASSING THROUGH IS THE ONLY LUBRICATION REQUIRED FOR THE CARBON-GRAPHITE PARTS.

MINIMIZE RUNNING KADANT JOHNSON JOINTS DRY. EXCESSIVE CARBON SEAL WEAR MAY OCCUR.

CAUTION

Check the rotary joint regularly to determine carbon seal ring wear. Should the carbon seal ring (6) wear away completely, the metal nipple can wear into the joint wear plate, and eventually through it. This will result in significant leakage, creating a possibly hazardous condition, and may require replacement of the entire joint instead of just the seal ring. See Table 2 in this bulletin for allowable carbon seal wear.

Dimensions and specifications are for reference only and subject to change. Certified drawings are available on request. Please refer to Kadant Johnson Drawing Number A37640 for torque specifications.

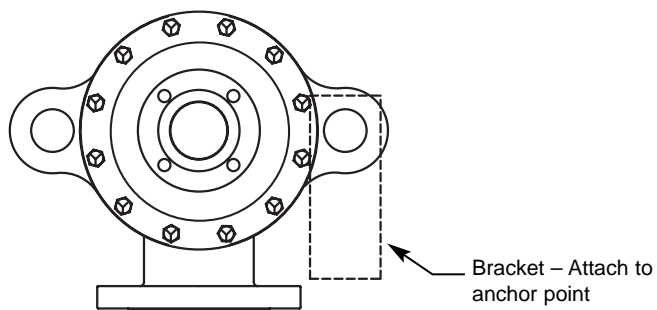


Figure 1

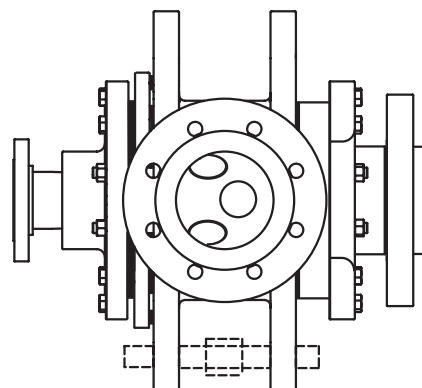


Figure 2

TABLE 1

RECOMMENDED MINIMUM HOSE LENGTHS

Hose Size	Minimum Length
2"	21"
2-1/2"	24"
3"	27"
4"	28"
5"	30"
6"	33"
8"	36"

TABLE 2

Joint Size	Seal Wear
4"	9/16"
5"	9/16"
6"	7/16"
7-1/2"	11/16"
8"	13/16"

The Kadant Johnson Warranty

Kadant Johnson products are built to a high standard of quality. Performance is what you desire: that is what we provide. Kadant Johnson products are warranted against defects in materials and workmanship for a period of one year after date of shipment. It is expressly understood and agreed that the limit of Kadant Johnson's liability shall, at Kadant Johnson's sole option, be the repair or resupply of a like quantity of non-defective product.



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