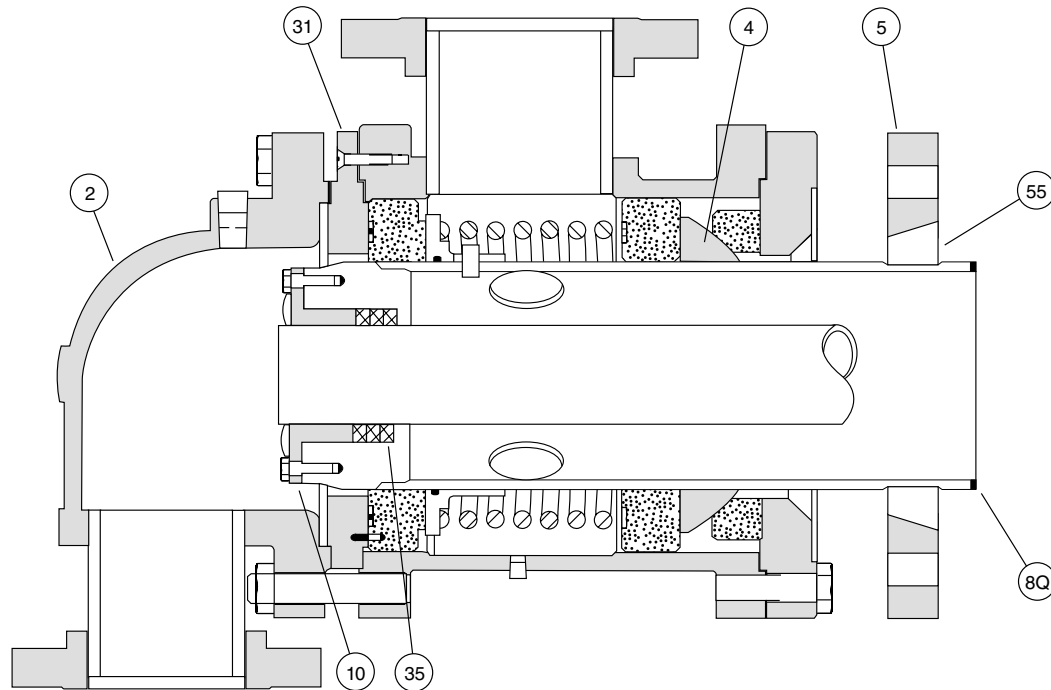


Installation Instructions for Type SJN Joints



Type SJNARPFYQ

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, dryer 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.

Remove the head (2) from the joint, leaving the assembly plate (31) attached. Remove packing gland (10) and packing (35).

Make sure the pipe is clean and smooth where it seals in the packing gland.

IMPORTANT: THE INNER PIPE MUST BE STRAIGHT, TRUE AND ATTACHED WITHIN THE ROLL SO IT ROTATES WITHOUT WOBBLING.

STEP 3.

Slide the quick release nipple flange (5) onto the rotary joint nipple (4) with its taper facing outward. Place the two split taper wedges (55) into the recess of the nipple and slide the quick release nipple flange over the wedges.

STEP 4.

Place a new metal gasket (8Q) into the recess of the journal.

STEP 5.

Slide the joint over the inner rotating syphon pipe, being careful when the pipe passes through the opening in the nipple end. The inner rotating pipe should extend slightly beyond the gland when installed (approximately 3/8").

STEP 6.

Secure the quick release nipple flange to the journal flange studs with nuts provided. Tighten evenly. Note that the quick release nipple flange will not seat tightly against the face of the journal flange. When tight, there will be approximately 1/8" to 3/16" space between the flanges.

STEP 7.

Reinstall the packing (35) and packing gland (10). Apply approximately 35 ft. lbs. of torque to the gland.

STEP 8.

Reattach the head casting to the joint body.

STEP 9.

Connect piping to joint using Kadant Johnson flexible metal hose. The hose(s) should be long enough so there is no binding or tension crowding the joint towards the roll or moving the joint off the journal centerline. The joint must be free to move outward to compensate for seal ring wear. (See recommended flexible metal hose length chart in Table 2).

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 10.

Install anti-rotation rod in the anti-rotation rod hole using 2-1/2" rod. Secure vertical bracket support to external frame as shown below. This joint is self-supporting and must be able to move freely. Do not support this joint with external rods.

NEVER APPLY OIL OR GREASE TO THIS SERIES OF 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 seal ring wear. Should the seal ring (6) wear away completely, the metal nipple can contact the joint body, and eventually wear through it. This will result in significant leakage, possibly creating a hazardous condition. Metal to metal contact of these parts may require replacement of the entire joint instead of just the seal rings.

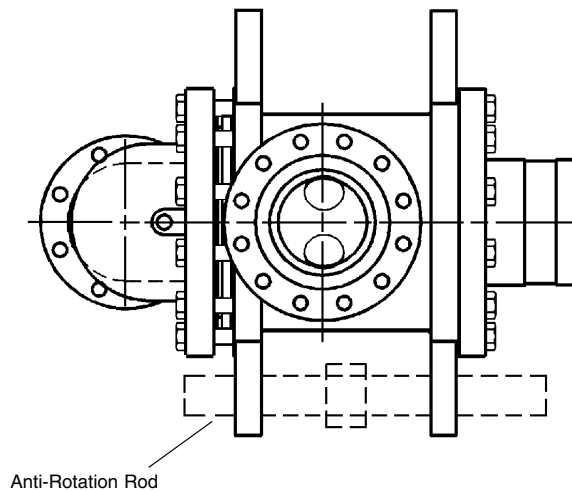
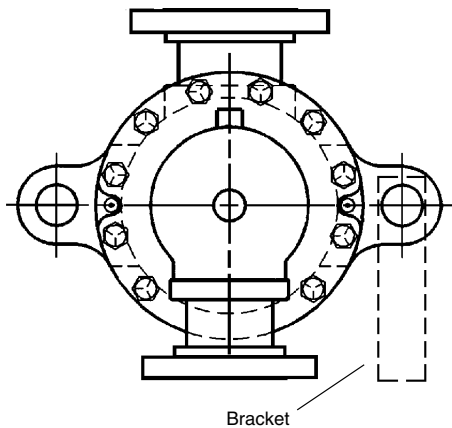
TABLE 1

Joint Size	Seal Wear
3/4"	1/4"
1"	1/3"
1-1/4"	3/8"
1-1/2"	5/16"
2"	1/3"
2-1/2"	3/8"
3"	7/16"
3-1/2"	7/16"
4"	9/16"
5"	9/16"
6"	7/16"
7-1/2"	11/16"
8"	13/16"

TABLE 2

RECOMMENDED MINIMUM HOSE LENGTHS

Hose Size	Minimum Length
1/4"	8"
3/8"	10"
1/2"	10"
3/4"	12"
1"	15"
1-1/4"	18"
1-1/2"	18"
2"	21"
2-1/2"	24"
3"	27"
4"	28"
5"	30"
6"	33"



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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