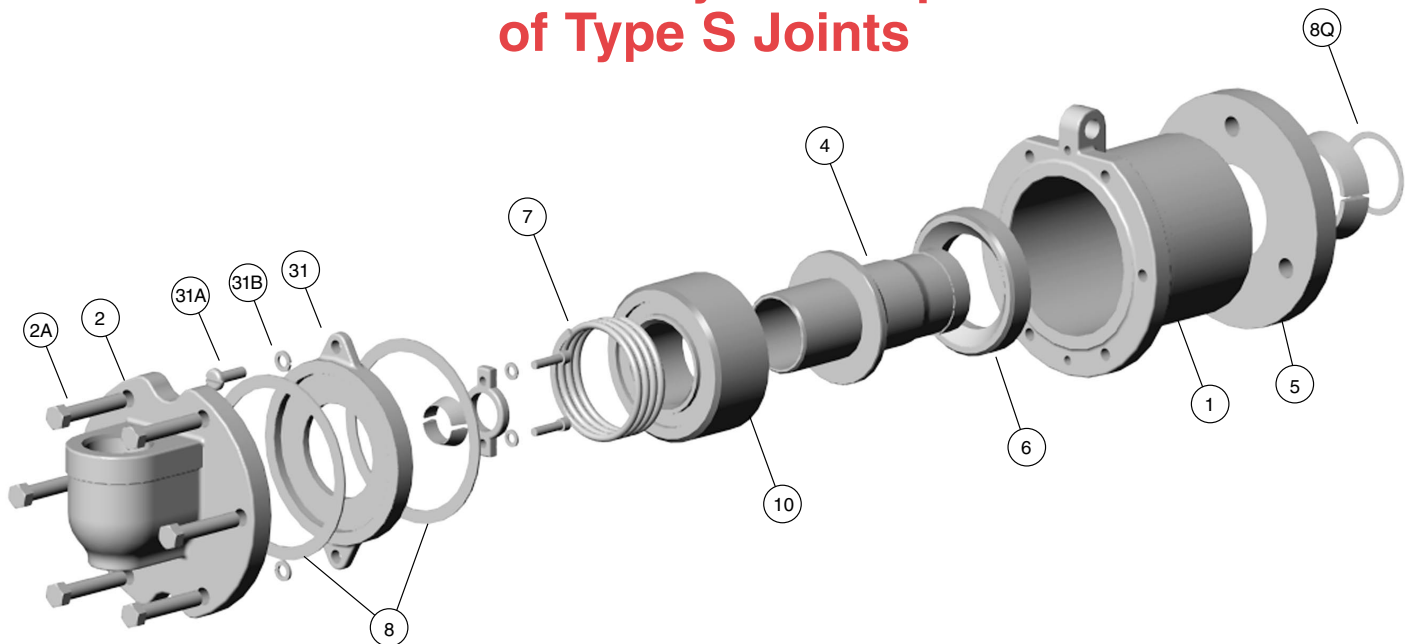


Disassembly and Repair of Type S Joints



Type SBP

REPAIR KITS ARE AVAILABLE CONSISTING OF:

<u>Item #</u>	<u>Qty</u>	<u>Description</u>
6	1	Carbon Seal
8	*2	Gasket
8Q	1	Gasket
10	1	Carbon Guide

*Only 1 required without an assembly plate such as a Type SA Joint.

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 further questions, please contact your Representative or Kadant Johnson.

REMOVAL:

STEP 1.

Close the inlet and outlet valves and allow the joint to cool down.

STEP 2.

Remove the hex nuts from the studs at 'Q' nipple flange (5).

STEP 3.

The joint is now free to be removed from the machine.

STEP 4.

If equipped with a horizontal pipe, unscrew it at this time and set aside.

STEP 5.

Set the rotary joint upright on a workbench as shown in Figure 2.

STEP 6.

Remove hex head bolts (2A) freeing head casting (2). Set the head casting aside.

STEP 7.

Remove the two round head cap screws (31A) which hold assembly plate (31) onto the body housing (1). Caution is advised as this item retains the internal spring force. You may have to apply some force to break the gasket loose.

STEP 8.

Remove the internal items – spring (7), carbon guide (10), nipple (4) and carbon seal (6). Discard the carbon seal and guide.

STEP 9.

Inspect the nipple's wear surface for wear and scratches – if necessary, replace. Also check the inside of the body housing for wear. Usually the spring will not require replacement unless it has taken a set or cracked.

STEP 10.

Clean all gasket surfaces.

REASSEMBLY:

STEP 11.

Insert a new carbon seal (6) into the body housing concave side out followed by nipple tube (4).

STEP 12.

Install carbon guide (10) with its spring groove facing outward over the nipple end and down into the body.

STEP 13.

Place spring (7) into the machine groove in the end of the carbon guide.

STEP 14.

Using a new gasket set assembly plate (8) over the spring and bolt in place with the two round head cap screws.

STEP 15.

Using the second gasket (8) bolt head casting (2) to the body with fasteners (2A). To achieve proper gasket loading, lubricate the bolts before installation.

STEP 16.

Thread the syphon pipe back into the head.

STEP 17.

Install a new gasket (8Q) in the 'Q' journal flange and reattach the joint and the nipple flange (5) to the journal flange.

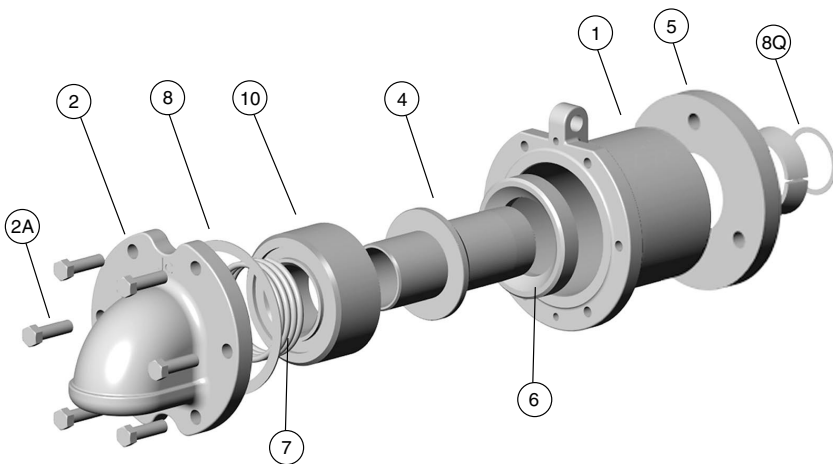
STEP 18.

Reattach the piping and turn on the valves. The joint is ready to be placed back into service.

STEP 19.

Never tie more than two joints together with an anti-rotation rod and leave the rotation rod loose so both joints are able to float freely.

Dimensions 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.



Type SA

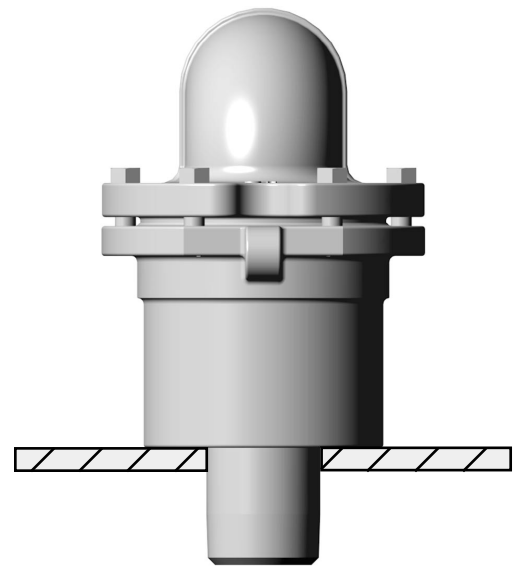


Figure 2

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.

KADANT
JOHNSON

www.kadantjohnson.com