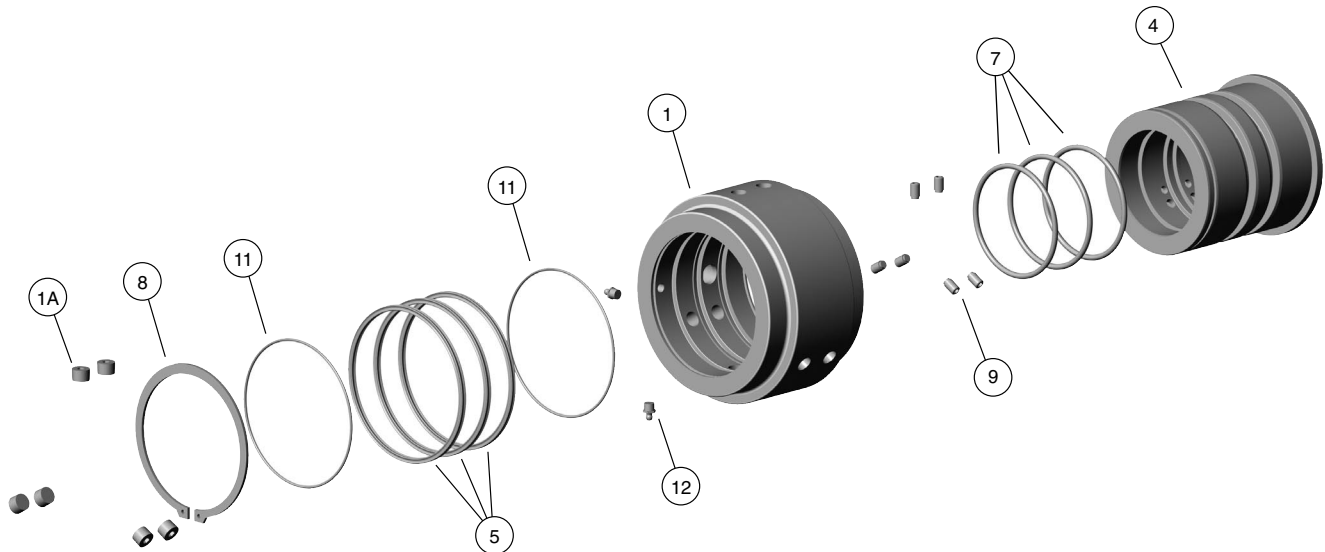


Disassembly and Repair of Type Over-The-Shaft (OTS) Joints



When ordering a repair kit specify the joint size, style and Part ID located on flange.

ROTARY JOINT REPAIR KITS AVAILABLE:

Joint Size	Repair Kit Ordering Number
4"	RK-0400-OTS
4"	RK-M0400-OTS (Metric Threads)

REPAIR KITS ARE AVAILABLE CONSISTING OF:

Item #	Qty	Description
1A	6	Pipe Plugs
5	3	Quad Seal*
7	3	O-Rings
9	6	Set Screw
11	2	O-Ring
12	2	Grease Fitting
	2	CSS800-1 Lubricant

*Registered trademark of Minnesota Rubber Co.

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 Kadant Johnson Representative or Kadant Johnson.

This procedure is written to ensure maximum possible life expectancy of the rotary joint through proper assembly of critical components. The OTS joint must be reassembled using new Quad Seals.

DISASSEMBLY:

STEP 1.

Close the inlet and outlet valves.

STEP 2.

Remove all covers and drive components between the OTS Joint and the end of the shaft.

STEP 3.

Remove the six pipe plugs (1A) and discard.

STEP 4.

Loosen the six set screws (9). This will allow the joint to be removed from the shaft.

STEP 5.

Remove retaining ring (8). Check the set screws (9). If required, turn them in so they do not damage the body (1) during nipple (4) removal. Push the nipple (4) through the body (1).

STEP 6.

Remove the Quad Seals (5) and o-rings (11) from the body (1), being careful not to damage the groove they are installed in.

Remove the o-rings (7) from the nipple (4), being careful not to damage the groove they are installed in.

Remove the six set screws (9) and two grease fittings (12) and discard.

Clean all parts with a solvent and scrubbing pad. Dry thoroughly. Inspect the nipple (4) for wear. If nipple tube is worn where the Quad Seals run, replace the nipple (4).

Inspect the bore of the body where the nipple turns and the Quad Seal grooves. Replace body (1) if there is wear in these areas.

REASSEMBLY:

STEP 7.

Install the grease fittings (12) . Install three new Quad Seals (5) into the body grooves and coat the body I.D. and the very end of the nipple with CSS800-2 lubricant.

STEP 8.

Using CSS800-2 lubricant, lubricate two new o-rings (11) and install into body (1) grooves.

STEP 9.

Using CSS800-1 lubricant, lubricate three new o-rings (7) and install into the nipple (4) grooves.

STEP 10.

Install six set screws (9) into the nipple (4). Set screws must not protrude either the I.D. or O.D. surface of the nipple (4).

STEP 11.

Slide the nipple (4) through the body (1).

STEP 12.

Secure with retaining ring (8).

STEP 13.

At the time of installation on the machinery, check outside surface of shaft for burrs that may damage the o-rings (7) inside of the nipple (4). Apply sealant to the six pipe plugs (1A) and install.

Please refer to Kadant Johnson Drawing Number A37640 for torque specifications. CSS800-2 grease is available in tubes on request and will be enough to rebuild many joints.

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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