

Documentation Swivel Joint

Typ: HT-DN80-Sched.40

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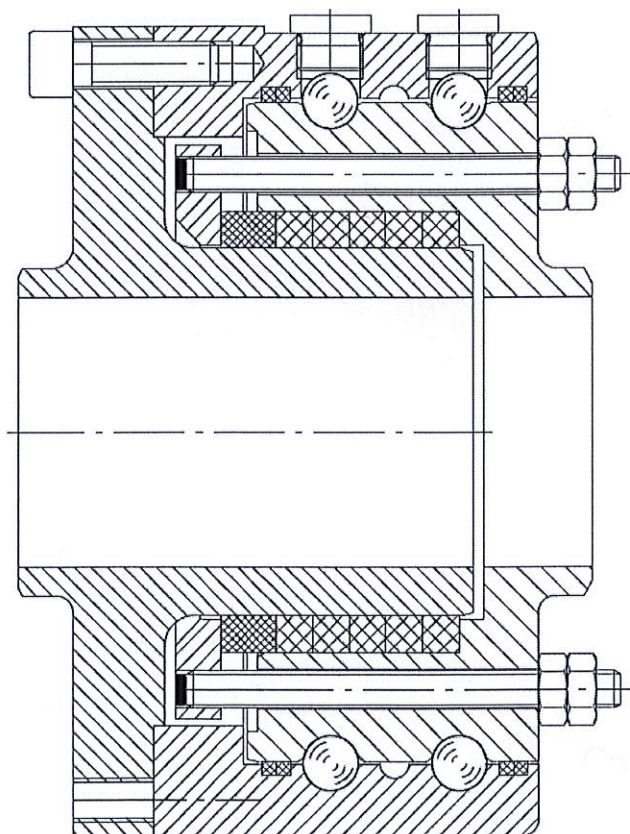
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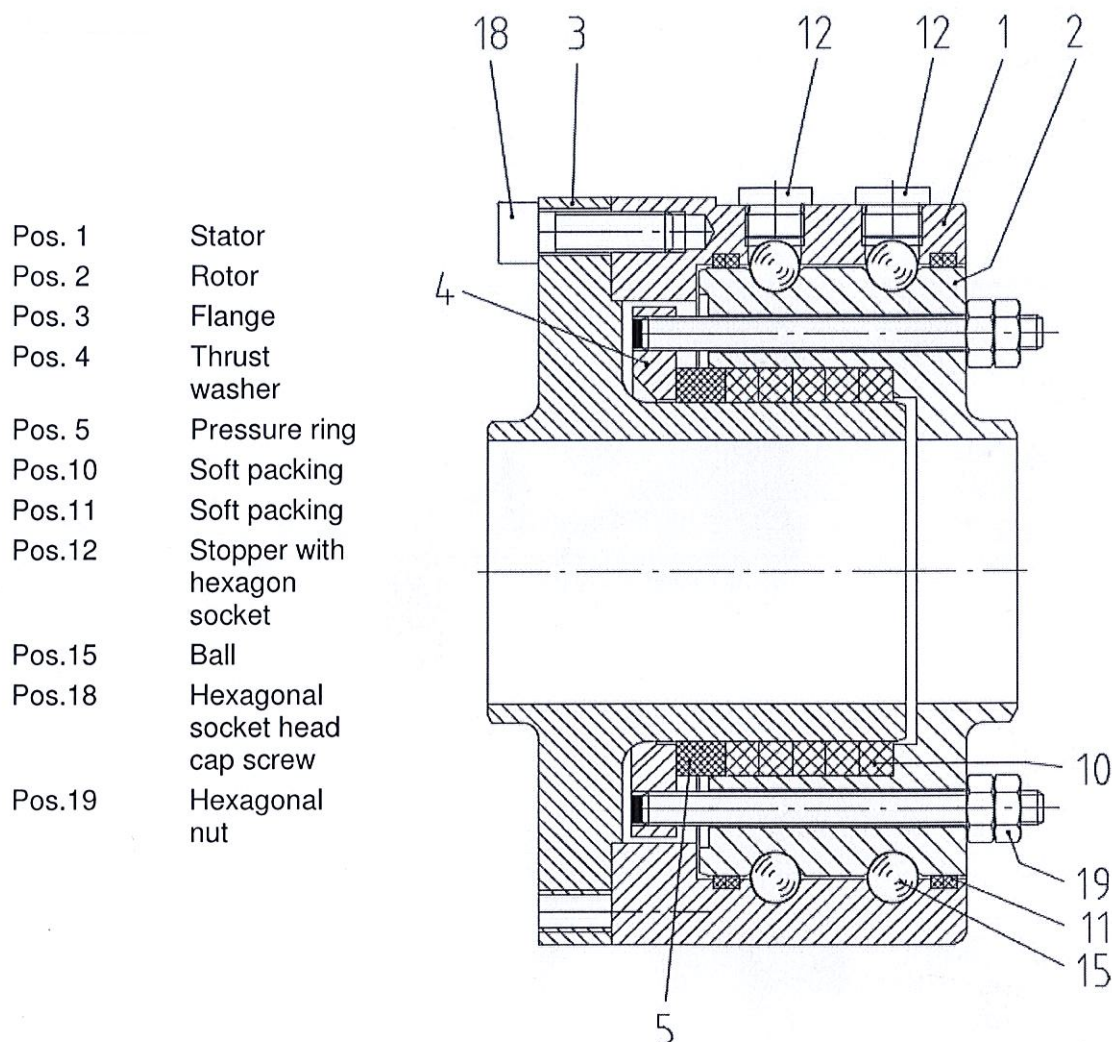
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1. Assembly and disassembly instructions for swivel joints Typ HT



This manual describes the swivel joint supplied by us. It does not represent a description of the entire system and does not consider the necessary operation of fittings and devices which do not belong to the pipe swivel joints.

1.1 Assembly of the Swivel Joint:

Attention!

Do not damage sealing surfaces during assembly!

- Insert the Soft packing (pos.10) into the Rotor (pos.2).
- Insert Pressure ring (Pos.5) then thrust washer (Pos.4) into the rotor (Pos.2). Hand-tighten thrust washer (Pos.4) with one hexagon nut (Pos.19) per threaded rod. The lock nut (Pos.19) is screwed on after the soft packing (Pos.10) has been pretensioned.
- Insert the Soft packing (Pos.11) into the groove on Stator (Pos.1). Push the Stator (Pos.1) over the pre-assembled Rotor (Pos.2) and make sure that the Stator (Pos.1) does not jam.
- Fill in the full number of balls (Pos.15) via the screw plug holes, slowly turning the rotor (Pos.2). Then close the ball filling holes with the Stopper with hexagon socket (Pos.12).
- Install the flange (Pos.3) and fasten with the Hexagonal socket head cap screw (Pos.18). Tighten the soft packing (Pos.10) with the hexagon nuts (Pos.19) crosswise and secure with the lock nuts (Pos.19).

Attention!

The nuts must be tightened under pressure (air). Increase the preload on the soft packing until the swivel joint is tight and no more air escapes. Then tighten tightly with the lock nuts.

Leak test: 0.5 bar, medium: air, duration: 15 min

1.2 Changing the medium seal:

Attention!

In general, the components must be cleaned and then checked for damage.

- Loosen the Hexagonal socket head cap screw (Pos.18) on the flange (Pos.3), then remove the flange (Pos.3).
- After removing the hexagon nuts, remove the thrust washer (Pos.4) and Pressure ring (Pos.5).
- Remove the stuffing Soft packing (pos.10).
- Inserting the new seals.
- Insert the Pressure ring (Pos.5) and then insert the thrust washer (Pos.4) into the rotor (Pos.2). Tighten the thrust washer (Pos.4) by hand with one hexagon nut (Pos.19) per threaded rod.
- Install flange (Pos.3) and fasten with Hexagonal socket head cap screw (Pos.18). Pretension the soft packing (Pos.10) with the hexagon nuts (Pos.19) crosswise and secure with the lock nut (Pos.19).

Attention!

The nuts must be tightened under pressure (air). Increase the preload on the soft packing until the swivel joint is tight and no more air escapes. Then tighten tightly with the lock nuts..

Leak test: 0.5 bar, medium: air, duration: 15 min

Auftrag / Order		Benennung / Denomination		Zeichnungs-Nr. / Drawing-No.		Name	Artikel-Nr. / Item-code
Kunde / Customer		Rohrdrehgelenk HT- DN080 - Sched.40		10468-080-00-000		Fischer	
		Swivel Joint		Stücklisten-Nr. / Bill of mat.-No. 10468-080-00-000		Datum / Date 26.02.2019	G-Gew. / T-Weight 32,30



Pos.	Stck. / Quan.	Artikel-Nr.:	Benennung / Denomination	Zeichnungs-nr. / Drawing No.	Fertigmaß / Finished size	Werkstoff / Material	DIN-Ben. / Den.	DIN	Prüfgrundlage Techn. requirem.	Belegung / Verification	E-Gew. / S-Weight	G-Gew. / T-Weight
1	1		Aussenteil HT-DN080 Stator	10468-080-00-001	ø220 x 106	1.4571 (316Ti)					10,00	10,00
2	1		Innenteil HT-DN080 Rotor	10468-080-00-002	ø179 x 95	1.4571 (316Ti)					8,80	8,80
3	1		Flansch HT-DN080 Flange	10468-080-00-003	ø220 x 125	1.4571 (316Ti)					8,60	8,60
4	1		Druckscheibe HT-DN080 Thrust washer	10468-080-00-004	ø156 x 13	siehe Stückliste					1,30	1,30
5	1		Druckring HT-DN080 Pressure ring	00073-080-01-005	ø120 x ø100 x 15	1.4571 (316Ti)					0,50	0,50
10	5		Stopfbuchspackung Soft packing		ø120 x ø100 x 10	Graphit					0,02	0,10
11	4		Stopfbuchspackung Soft packing		ø187 x ø179 x 4	Graphit					0,01	0,04
12	2		Verschlußschraube Stopper with hexagon socket	01000-000-00-003/2	M 18 x 1,5 x 10 lg.	1.4571					0,02	0,04
15	74		Kugel Ball		ø 15 - G100	Ceramic					0,03	2,44
18	8		Zylinderschraube Hexagonal socket head cap screw		M 12 x 40	A4	912				0,05	0,40
19	8		Sechskantmutter Hexagonal nut		M 10	A4	934				0,01	0,08

