



Rotary Couplings

supported by ball bearings



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1 Description of the product

1.1 Description

The oil supply at the housing is made by radial pipe threads that end in circular slots of the rotary piston. From there, the hydraulic oil is led upwards through axial bore holes. The pipe connection at the rotary piston can optionally be effected radially or axially. Alternatively, a manifold-mounting type with O-ring seals is available. The starting torque is reduced by the following measures:

- The rotary piston is supported by ball bearings.
- The running surfaces for the seals are nitrated, ground and polished.
- The special seals have low friction and are abrasion resistant.

A radial shaft seal protects the interior against dirt and coolants. At the leakage port the little leakage can be led away in a controlled manner.

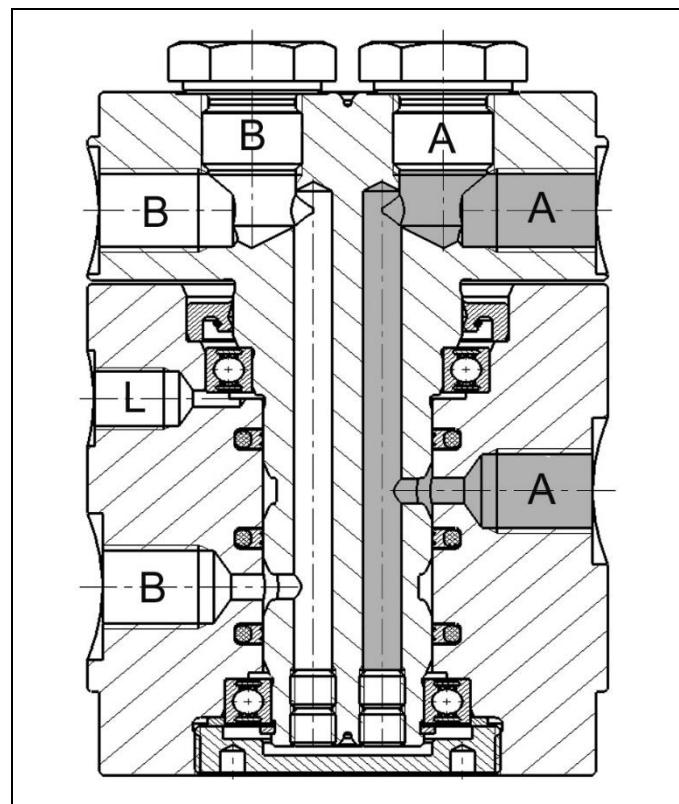


Figure 1: Representation of the oil flow through the rotary coupling

1.2 Application

Rotary couplings transfer liquid or gaseous media from a stationary to a rotating or swivelling machine part. The most important fields of application are:

- Swivelling fixtures to be connected by hoses.
- Rotating fixtures that rotate with a determined number of rotations.
- Rotary indexing tables that move in one direction of rotation more than 360 degree.

- Machine tables with swivel movements in both directions.

1.3 Hydraulic applications

As hydraulic medium HLP as per DIN 51524-2 is prescribed. For the use of other media please contact us. The diagrams (see data sheet) show the starting torque and the admissible continuous number of rotations as a function of the operating pressure.

If the rotary coupling is operated at the limit of performance (pressure + number of rotations), pay attention to sufficient supply of cooling air (see data sheet).

1.4 Use of pneumatics

A prerequisite for pneumatic use is oiled compressed air free from water. Thus, numbers of rotations up to 10 rpm are possible. A continuous operation with constant high number of rotations is not admissible, because the seals will become too hot for lack of lubrication.

1.5 Hydraulics and pneumatics

Mixed use of the individual passages is possible, e.g. air – oil – oil – air.

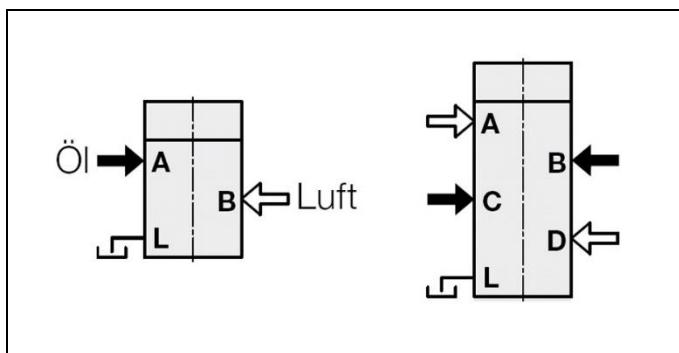


Figure 2: Examples

Please note the following:

- The leakage of high-pressure seals can enter into the adjacent air passage.
- If the hydraulic pressure is lower than the air pressure, air diffuses into the adjacent hydraulic passage and this can lead to malfunctions (air in oil).

NOTE

Therefore, ROEMHELD recommends to separate the different media by means of an intermediate leakage passage (see figure 3):

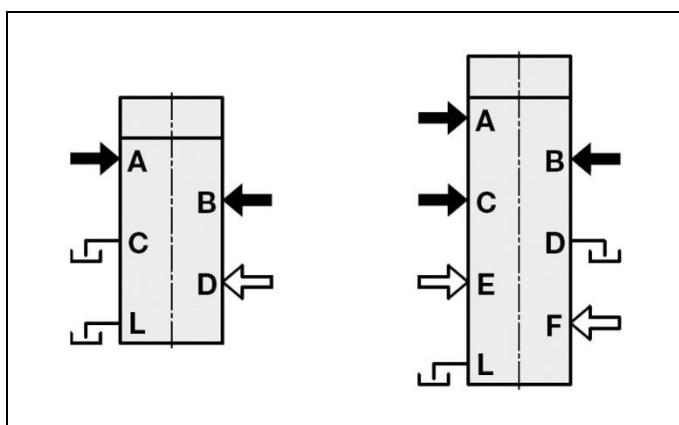


Figure 3: Example separate different media by means of a leakage level

2 Validity of the documentation

This document applies to the following products:

Rotary couplings of data sheet F 9.281. The following types or part numbers are concerned:

Twin passage rotary couplings ND5

- Pipe thread 9281 105
- Manifold-mounting connection 9281 205

Four passage rotary couplings ND5

- Pipe thread 9284 205
- Manifold-mounting connection 9284 305

Six passage rotary couplings ND5

- Pipe thread 9286 205
- Manifold-mounting connection 9286 305

3 Target group of this document

- Specialists, fitters and set-up men of machines and installations with hydraulic expert knowledge.

Qualification of the personnel

Expert knowledge means that the personnel must

- be in the position to read and completely understand technical specifications such as circuit diagrams and product-specific drawing documents,
- have expert knowledge (electric, hydraulic, pneumatic knowledge, etc.) of function and design of the corresponding components.

An **expert** is somebody who has due to its professional education and experiences sufficient knowledge and is familiar with the relevant regulations so that he

- can judge the entrusted works,
- can recognize the possible dangers,
- can take the required measures to eliminate dangers,
- knows the acknowledged standards, rules and guidelines of the technology.
- has the required knowledge for repair and mounting.

4 Symbols and signal words

WARNING

Person damage

Stands for a possibly dangerous situation.

If it is not avoided, death or very severe injuries will result.

CAUTION

Easy injuries / property damage

Stands for a possibly dangerous situation.

If it is not avoided, minor injuries or material damages will result.

Hazardous to the environment

The symbol stands for important information for the proper handling with materials that are hazardous to the environment.

Ignoring these notes can lead to heavy damages to the environment.



Note

This symbol stands for tips for users or especially useful information. This is no signal word for a dangerous or harmful situation.

5 For your safety

5.1 Basic information

The operating instructions serve for information and avoidance of dangers when installing the products into the machine as well as information and references for transport, storage and maintenance.

Only in strict compliance with these operating instructions, accidents and property damages can be avoided as well as trouble-free operation of the products can be guaranteed.

Furthermore, the consideration of the operating instructions will:

- avoid injuries
- reduce down times and repair costs,
- increase the service life of the products.

5.2 Safety instructions

The product was manufactured in accordance with the generally accepted rules of the technology.

Observe the safety instructions and the operating instructions given in this manual, in order to avoid personal damage or material damage.

- Read these operating instructions thoroughly and completely, before you work with the product.
- Keep these operating instructions so that they are accessible to all users at any time.
- Pay attention to the current safety regulations, regulations for accident prevention and environmental protection of the country in which the product will be used.
- Use the ROEMHELD product only in perfect technical condition.
- Observe all notes on the product.
- Use only accessories and spare parts approved by the manufacturer in order to exclude danger to persons because of not suited spare parts.
- Respect the intended use.
- You only may start up the product, when it has been found that the incomplete machine or machine, in which the product shall be mounted, corresponds to the country-specific provisions, safety regulations and standards.
- Perform a risk analysis for the incomplete machine, or the machine.
Due to the interactions between the product and the machine/fixture or the environment, risks may arise that only can be determined and minimized by the user, e.g. :
 - generated forces,
 - generated movements,
 - Influence of hydraulic and electrical control,
 - etc.

6 Application

6.1 Intended use

The rotary couplings are used in industrial applications to transmit hydraulic or pneumatic pressure for one or several fixtures to rotating or swivelling equipments.

They are mounted in the centre of rotation of the equipment (e.g. rotary indexing tables).

Furthermore the following are possible uses:

- Use within the capacity indicated in the technical characteristics (see data sheet).
- Use as per operating instructions.
- Compliance with service intervals.
- Qualified and trained personnel for the corresponding activities.
- Mounting of spare parts only with the same specifications as the original part.

6.2 Misapplication

WARNING

Injuries, material damages or malfunctions!

- Do not modify the product!

The use of these products is not admitted:

- For domestic use.
- On pallets or machine tool tables in primary shaping and metal forming machine tools.
- If due to physical / chemical effects (vibrations, welding currents or others) damages of the products or seals can be caused.
- In machines, on pallets or machine tool tables that are used to change the characteristics of the material (magnetise, radiation, photochemical procedures, etc.).
- In areas for which special guidelines apply, especially installations and machines:
 - For the use on fun fairs and in leisure parks.
 - In food processing or in areas with special hygiene regulations.
 - For military purposes.
 - In mines.
 - In explosive and aggressive environments (e.g. ATEX).
 - In medical engineering.
 - In the aerospace industry.
 - For passenger transport.
- For other operating and environmental conditions e.g.:
 - Higher operating pressures than indicated on the data sheet or installation drawing.
 - With hydraulic fluids that do not correspond to the specifications.

Special solutions are available on request!

7 Installation

⚠ WARNING

Heavy weight can fall down

- Some product types have a considerable weight. These have to be secured against working free during transport.
- Weight specifications see chapter "Technical characteristics".

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

- Improper connection can lead to escapes of oil under high pressure at the connections.
- Mounting or dismantling of the element must only be made in depressurised mode of the hydraulic system.
- Connection of the hydraulic line as per DIN 3852/ISO 1179.
- Unused connections have to be locked professionally.
- Use all mounting holes.

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

Wear, damage of the seals, ageing and incorrect mounting of the seal kit by the operator can lead to escapes of oil under high pressure.

- Before using them make a visual control.

Poisoning due to contact with hydraulic oil!

Wear, damage of the seals, ageing and incorrect mounting of the seal kit by the operator can lead to escapes of oil.

Incorrect connection can lead to escapes of oil at the ports.

- For handling with hydraulic oil consider the material safety data sheet.
- Wear protection equipment.

7.1 Design

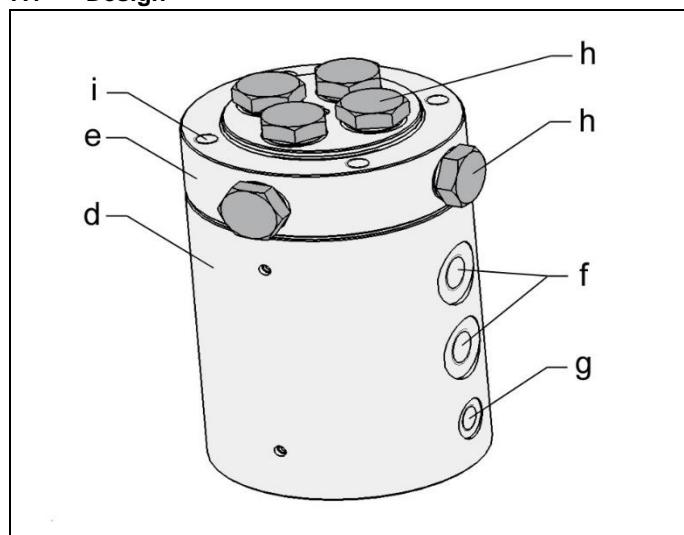


Figure 4: Components and accessories

i Threaded holes for fixing	f Hydraulic ports radial
d Housing of rotary coupling	g Leakage re-circulation
e Rotary piston	h Ports optionally axial or radial

7.2 Installation and connecting possibilities

NOTE

- Fix rotary couplings only through the provided bore holes.
- An anti-rotation key must be mounted. It must be observed that no deformation will be introduced to the rotary coupling (see figure installation examples).

Fixing is made precisely in axial direction at the housing or at the flange of the rotary piston. The firmly-screwed component can be connected with pipes. To compensate the torque, the other part is connected to an anti-rotation key that offers sufficient freedom of motion and avoids forced conditions as well as axial forces. That is the reason why also here high-pressure hoses have to be used instead of pipes.

⚠ CAUTION

The leakage port at the housing must not be closed to avoid malfunctions.

Installation and connecting possibilities - Pipe thread:

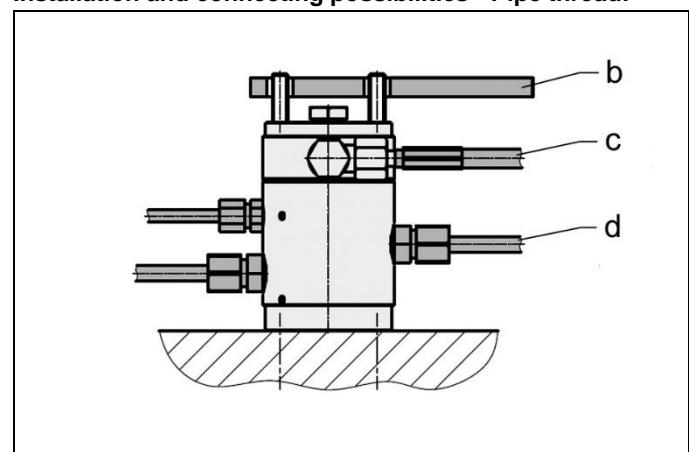


Figure 5: Installation and connecting possibilities - Pipe thread:

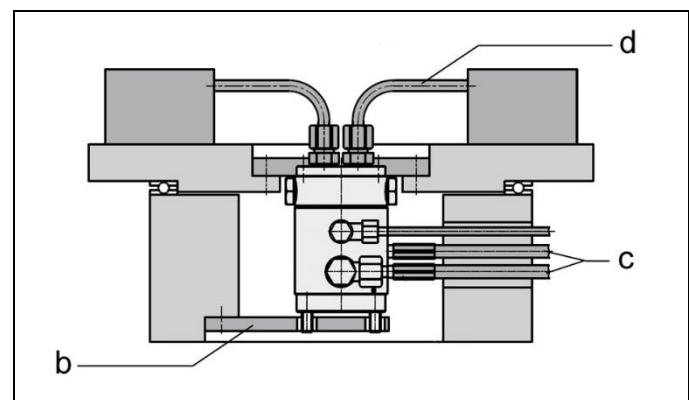


Figure 6: Installation and connecting possibilities - Pipe thread:

b Anti-rotation key	c Hydraulic hose
d Hydraulic pipe	

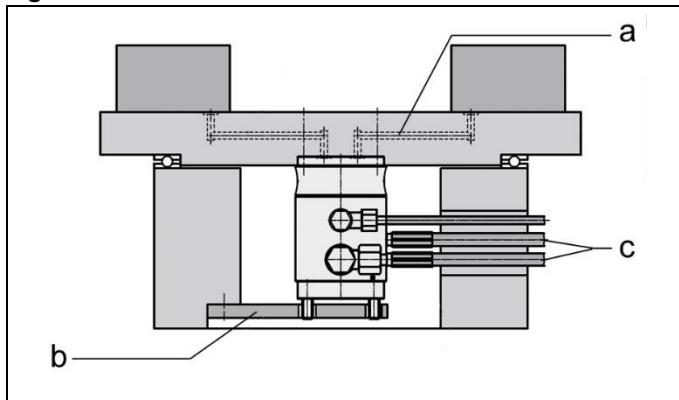
Installation and connecting possibilities - Manifold-mounting connection:


Figure 7: Installation and connecting possibilities - Manifold-mounting connection

b Anti-rotation key	a Drilled channels
	c Hydraulic hoses

Compensation of moments with minimum deformation:

Installation example for compensation of moments with minimum deformation at the rotary piston. Supply hydraulic oil or air through hoses.

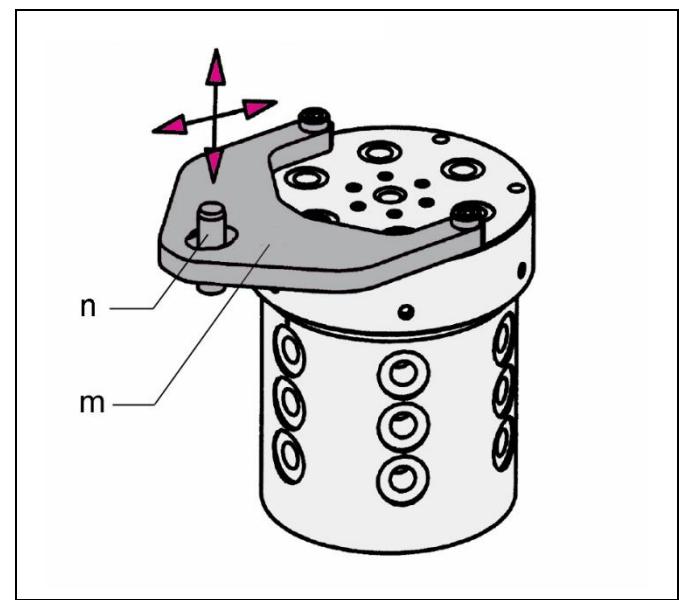


Figure 8: Installation example for compensation of moments with minimum deformation

m Compensation of moments with screws (customer's accessory)	n Anti-rotation key
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NOTE

- All figures are schematic figures.

7.3 Connection of the hydraulic equipment

The flange-mounted component of the rotary coupling is connected with pipes.

The other component must be connected with high-pressure hoses. There are two reasons:

- 1 Despite of the anti-rotation key forced conditions would be generated by the piping, i.e. the pipes would generate torsional stress and bending stress. The safety of pipe connections would not be guaranteed.
- 2 Because of the pipe lines side loads would be introduced into the bearing of the rotary piston, and this can lead to a reduced service life.

8 Start up
⚠ WARNING
Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

- Improper connection can lead to escapes of oil under high pressure at the connections.
- Mounting or dismounting of the element must only be made in depressurised mode of the hydraulic system.
- Connection of the hydraulic line as per DIN 3852/ISO 1179.
- Unused connections have to be locked professionally.
- Use all mounting holes.

Injury by high-pressure injection (squirting out of hydraulic oil under high pressure)!

Wear, damage of the seals, ageing and incorrect mounting of the seal kit by the operator can lead to escapes of oil under high pressure.

- Before using them make a visual control.

Poisoning due to contact with hydraulic oil!

Wear, damage of the seals, ageing and incorrect mounting of the seal kit by the operator can lead to escapes of oil.

Incorrect connection can lead to escapes of oil at the ports.

- For handling with hydraulic oil consider the material safety data sheet.
- Wear protection equipment.

⚠ CAUTION
Operating pressure should not exceed

The max. operating pressure must not be exceeded (see technical characteristics).

- Check tight seating (check tightening torque of the fixing screws, see chapter "Technical characteristics").
- Check tight seating of hydraulic connections (check tightening torque of the hydraulic connections, see chapter "Technical characteristics").
- Bleed the hydraulic system.

NOTE
Important

- Before the first start up, pay attention to the increased torque - "breakaway torque"!
- The breakaway torque can be twice the indicated torque (technical characteristics).

9 Operation

NOTE

Safe operation

- Rotate rotary coupling only, if all passages are pressurised with oil, do not operate dry.
- Insert filter for continuous functioning.
- Swarf or contamination in the hydraulic oil lead to increased wear or damage at the guides, running surfaces and seals.
- As hydraulic medium HLP as per DIN 51524-2 is prescribed. For the use of other media please contact us.
- Pay attention to the indication for filtration and purity class 20/17/13 as per ISO 4406 of the hydraulic fluid.

10 Maintenance

WARNING

Burning due to hot surface!

- In operating conditions, surface temperatures of more than 70 °C can appear at the product.
- All maintenance and repair works must only be effected in cooled mode or with safety gloves.

Injury by crushing!

- Due to the stored energy, an unexpected start of the product can occur.
- Maintenance works at the product must only be made in depressurised mode!
- Keep hands and other parts of the body out of the working area!

10.1 Plan for maintenance

Maintenance works	Interval	Realisation
Cleaning	As required	Operator
Regular checks	daily	Operator
Repair/ change seal kit	1,000,000 cycles or 2 years	Qualified personnel

10.2 Cleaning

CAUTION

Avoid damages of the moved components

Avoid damages of the moved components (rods, plungers, bolts, etc.) as well as of wiper and seal.

Aggressive cleaning agents

The product must not be cleaned with:

- Corrosive or corroding components or
- Organic solvents as halogen or aromatic hydrocarbons and ketones (cellulose thinner, acetone, etc.), because this can destroy the seals.

The product must be cleaned from dirt, swarf and liquids at regular intervals.

In the case of heavy contamination, the cleaning has to be made in shorter intervals.

10.3 Regular checks

1. Check tightness of hydraulic connections (visual control).
2. Check components if there are damages.
3. Leakage control at the housing and the rotary piston.
5. Check the observance of the maintenance intervals.

10.4 Exchange seal kit

The exchange of the seal kit is made in case of external leakages. For high availability, the seals have to be changed at the latest after 1,000,000 cycles or 2 years.

The seal kit is available as spare part. An instruction for the exchange of the seal kit is available on request.

NOTE

Seal Kits

- Do not install seal kits which were exposed to light for a longer time.
- Pay attention to the storage conditions (see chapter "Technical characteristics").
- Only use original seals.

Mounting instructions for seals

- Pay attention to the general mounting instructions for seals, S 0.001.

11 Trouble shooting

Trouble	Cause	Remedy
Rotary piston does not rotate, or sluggish	Rotary (valve) coupling installed with deformation No hydraulic fluid or air is supplied	Correct installation situation pressurise all passages with oil pressure or air
Oil loss / pressure loss	Return line contaminated Wear Rotary (valve) coupling installed with deformation	Clean return line Return for repair Check installation situation
Loss of leakage oil higher than admissible leakage rate	Sealing worn	Return for repair
Switching function incorrect	Wrong allocation of ports	Check allocation of ports
Pressure drop in the system	Sealing worn Rotary (valve) coupling installed with deformation	Return for repair Correct installation situation
Air in the oil	Hydraulic pressure lower than air pressure	Separate different media by an intermediate leakage passage

12 Technical characteristics

Type	Maximum operating pressure [bar]	Adm. torque [Nm] at P max. *)	Max. flow rate [l / min]	Weight [kg]
9282 105	500	100	12	2.80
9282 205				2.80
9284 205	500	40	12	5.50
9284 305				5.50
9286 205	500	25	12	7.10
9286 305				7.10

*) Max. admissible number of rotations n and starting torque M as a function of the operating pressure p see data sheet.

Proposal, tightening torques for screws of tensile strength 8.8, 10.9, 12.9

NOTE

The indicated values are approximate values and have to be interpreted according to the user's application!
See note!

Thread	Tightening torque [Nm]		
	8.8	10.9	12.9
M3	1,3	1,8	2,1
M4	2,9	4,1	4,9
M5	6,0	8,5	10
M6	10	15	18
M8	25	36	45
M10	49	72	84
M12	85	125	145
M14	135	200	235
M16	210	310	365
M20	425	610	710
M24	730	1050	1220
M30	1,450	2100	2450

Note: Valid for workpieces and set screws made of steel with metric thread and connecting surface dimensions as per DIN 912, 931, 933, 934 / ISO 4762, 4014, 4017, 4032

In the table values for tightening torques the following is considered:

Design steel/steel, friction value $\mu_{ges} = 0.14$ - not oiled, utilisation of the minimum yield point = 90%.

NOTE

Further information

- For further technical data see ROEMHELD data sheet.
F9281

13 Storage

CAUTION

Storage of components!

- The product may not be exposed to direct solar radiation, because the UV light can destroy the seals.
- A storage differing from the storage conditions is inadmissible.
- In case of improper storage, the seals can embrittle and resinification of the anti-corrosive oil or corrosion at the element can occur.

The elements are tested by default with mineral oil. The exterior of the elements is treated with a corrosion inhibitor.

The oil film remaining after the test provides for a six-month interior corrosion protection, if stored in dry and uniformly tempered rooms.

For longer storage times, the element has to be filled with a non-resinifying corrosion inhibitor and the outside surfaces must be treated.

14 Disposal

Hazardous to the environment

Due to possible environmental pollution, the individual components must be disposed only by an authorised expert company.

The individual materials have to be disposed as per the existing regulations and directives as well as the environmental conditions.

Special attention has to be drawn to the disposal of components with residual portions of hydraulic fluids. The instructions for the disposal at the material safety data sheet have to be considered.

For the disposal of electrical and electronic components (e.g. stroke measuring systems, proximity switches, etc.) country-specific legal regulations and specifications have to be kept.

15 Declaration of manufacture

Manufacturer

Römheld GmbH Friedrichshütte

Römheldstraße 1-5

35321 Laubach, Germany

Tel.: +49 (0) 64 05 / 89-0

Fax: +49 (0) 64 05 / 89-211

E-mail: info@roemheld.de

www.roemheld.com

Responsible person for the documentation:

Dipl.-Ing. (FH) Jürgen Niesner, Tel.: +49(0)6405 89-0.

Declaration of manufacture of the products

They are designed and manufactured in line with the relevant versions of the directives **2006/42/EC**(EC MSRL) and in compliance with the valid technical rules and standards.

In accordance with EC-MSRL, these products are components, that are not yet ready for use and are exclusively designed for the installation in a machine, a fixture or a plant.

According to the pressure equipment directives the products are not to be classified as pressure reservoirs but as hydraulic placing devices, since pressure is not the essential factor for the design, but the strength, the inherent stability and solidity with regard to static or dynamic operating stress.

The products may only be put into operation after it was assessed that the incomplete machine / machine, in which the product shall be installed, corresponds to the machinery directives (2006/42/EC).

The manufacturer commits to transmit the special documents of the products to state authorities on request.

The technical documentation as per appendix VII part B was prepared for the products.

Laubach, 16.03.2021