

## INSTALLATION INSTRUCTIONS

### "H40 Self supported Steam Joint with Bent Siphon Pipe" Style "SF" Stationary Siphon

*Note: It is advisable to use some type of anti-seize compound on all bolts and screws in this installation.*

*Note: These instructions are general installation instructions only. Please refer to the installation drawing for specific information pertaining to each installation.*

#### Preparation

1. Clean all threads and bores to remove any grease and metal chips which may be left from machining.
2. When installing a bent pipe it should be threaded and bent to the desired shape.

#### Installation

1. Remove existing steam joint and journal flange if one is present. Clean the end of the dryer journal or journal flange, removing any residual gasket material.
2. With the steam joint on the bench, measure the length of the siphon size required
3. Remove the end cap and save.
4. With the steam joint on the bench, slide the siphon

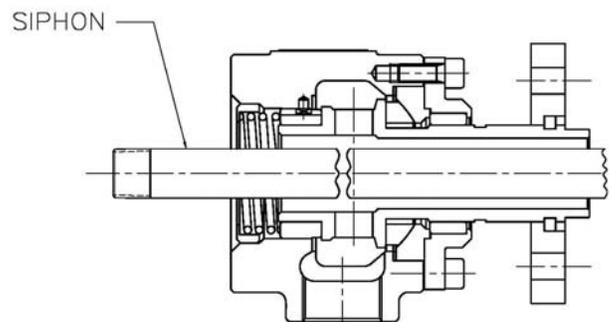


Figure 3S

pipe into the union from the open rotor end. See Figure 3S

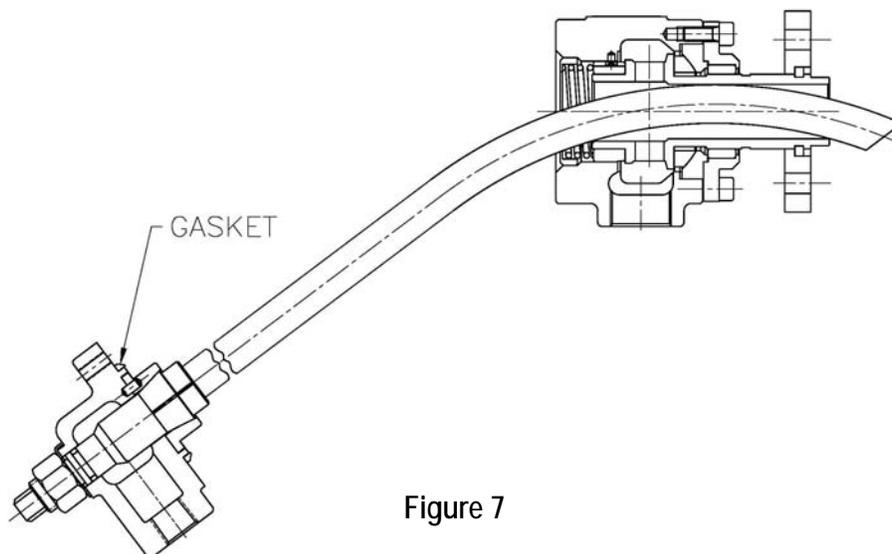


Figure 7

5. Place the copper gasket as shown in the end cap with the tapered side against the housing of the steam joint. See Figure 7.

6. With the siphon extending through the steam joint as shown in **Figure 4S**, thread the tapered siphon bushing into the threaded end of the siphon pipe. Tighten the siphon bushing hand tight and align the wrench flats in the end of the bushing in the downward leg direction as the end of the siphon pipe. See **Figure 4S**
7. Place the O-ring in the siphon bushing groove. See **Figure 4S**

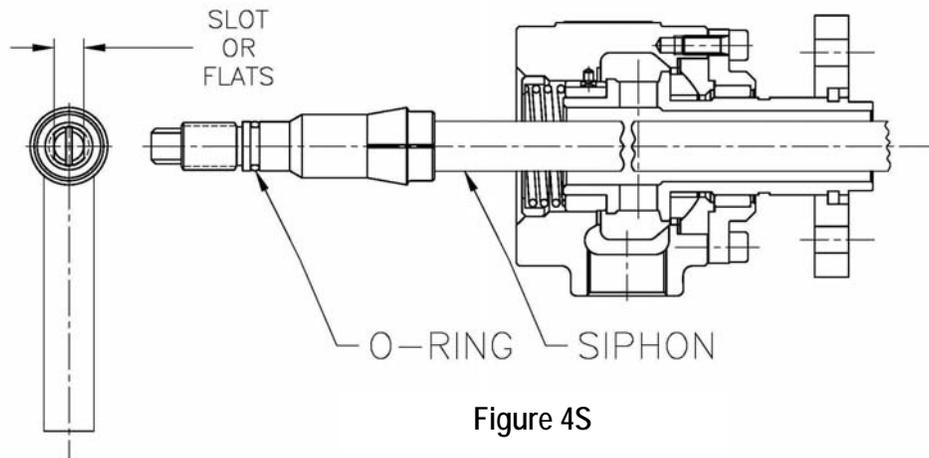
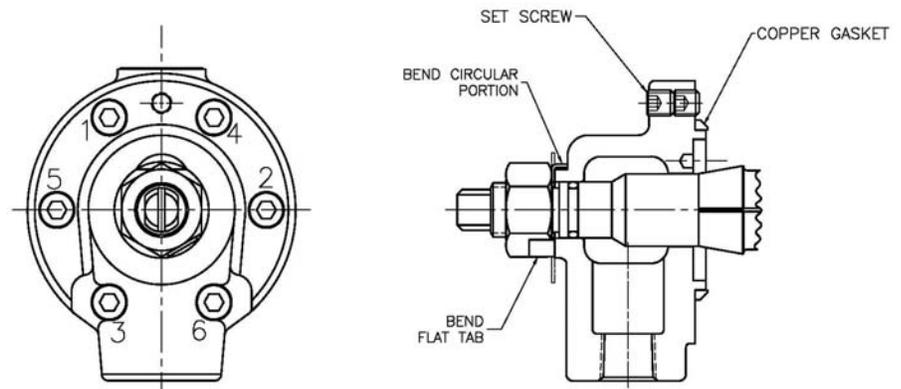


Figure 4S

8. Apply anti-seize paste in the tapered portion of the siphon bushing. Lubricate o-ring with silicone grease
9. Slide the siphon pipe through the end cap as noted in **Figure 5S** with the wrench tabs in the downward direction.
10. Place the tab washer and nut on the siphon bushing, and hand tightening making sure that the wrench tabs are in the downward direction
11. Slide the end cap with the siphon bushing through the center of the rotor and hand tighten the end cap to the housing using SHC. See **Figure 5S**.



STEP 1  
TORQUE BOLTS IN ORDER  
TO 12 FT/LBS.

STEP 2  
TORQUE BOLTS IN ORDER  
TO 25 FT/LBS.

Figure 5S

### Install the H 40 & Siphon to the Roll

1. Install new journal flange and gasket or bushing. (if required). If journal flange or bushing is required, make sure to insert the Copper gasket between the bushing and roll bore
2. Ensure that the siphon is installed in the steam joint as previously noted.
3. Place the rotor flange over the rotor. Position the split square rings in the rotor grooves. Slide the rotor flange forward, over the split square rings, securing the rings in place.
4. Place the Copper gasket in the recess of the journal flange or bushing bore.
5. Approach the union to the journal and carefully slide the rotor into the bore.
6. Secure the rotor flange to the journal flange or journal face with the four hex head bolts and lock washers using a uniform locking pattern.
7. Attach flexible hoses to the inlet and outlet ports of the union. The design of the flexible hoses must not restrain the natural movement of the union or place additional loads on the union. See the Recommended Hose Installation Guide.
8. Attach a torque restraining device which will allow axial and radial movement of 3/16" and 1/4" respectively.
9. After 2-3 hours of operation, verify that all connections remain secure.

### Stationary Siphon Clearance Adjustment

1. Remove the locking set screw at the top of the end cap and back out the adjusting set screw **until its flush with the end cap**.
2. With the wrench flats already positioned downward, while holding the flats, torque the nut to 40 ft-lbs. Make sure that the tab washer is aligned with the machined flats on the end cap
3. Bend the tab portion of the washer against one of the nut flats and the circular portion on the machined flat on the end cap
4. Back out all the SHCS. Slowly finger tighten the bolts number 2 and 5 as noted in **Figure 5S**
5. Rotate roll slowly to determine if the siphon tip is in contact with the roll surface.
6. Tighten the set screw until it touches the surface of the housing. Depending on the length of the siphon pipe use the table shown in **Figure 6S** to determine the number of required turns depending on the length of the siphon pipe to adjust the siphon clearance. Suggested clearance of .25"



Figure 6S

7. Once the siphon clearance has been adjusted, manually rotate the roll while closely listening for any rubbing noise from inside the roll. If siphon clearance is good, install and tighten the locking screw over the set screw.
8. Tighten all remaining bolts following the pattern shown to a 25Ft lb torque as shown in **Figure 5S**