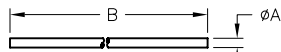


TRUARC PLIERS

MODEL	PLIERS NO.
55	3
155	5
255	5
355	5
525	5
555	5R
655	J4

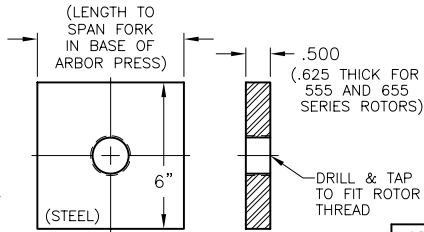
DISASSEMBLY ROD



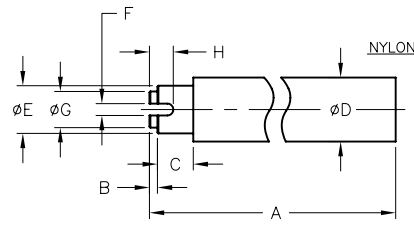
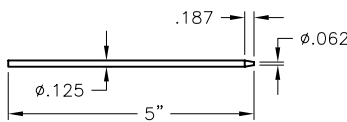
MODEL	phi "A"	"B"
55	5/16	5"
155	3/8	6"
255	1/2	7"
355	3/4	8"
525	1"	10"
555	1"	10"
655	1"	15"

TOOLING - BY CUSTOMER

ROTOR ASSEMBLY REMOVAL PLATE



SPRING RETAINING PIN



SPRING COMPRESSOR

MODEL	DEUBLIN PART NO.	"A"	"B"	"C"	phi "D"	phi "E"	"F"	phi "G"	"H"
55	55-666	5"	1/4	1/2	3/4	.490	3/16	.325	1/2
155	155-810	6"	1/8	9/16	1"	.740	3/16	.485	3/8
255	251-075	6"	1/8	3/4	1 1/4	.990	3/16	.735	3/8
355	350-921	6"	3/16	7/8	1 3/4	1.430	1/4	.985	7/16
525	525-491	6"	3/16	7/8	1 3/4	1.555	1/4	1.205	7/16
555	450-896	6"	3/16	7/8	2 1/8	1.862	1/4	1.415	7/16
655	655-534	8"	1/4	3/4	2 1/8	2.000	1/4	1.500	1 1/8

ASSEMBLY

DA 10

REBUILDING KIT PARTS LIST

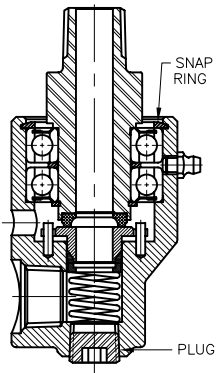
- ROTOR (PRE-ASSEMBLED)
- (2) BALL BEARINGS
- BEARING SPACER
- ROTOR SNAP RING
- TEFLON SEAL WEDGE OR O-RING (L)
- SEAL GUIDE
- COIL SPRING

NOTE:

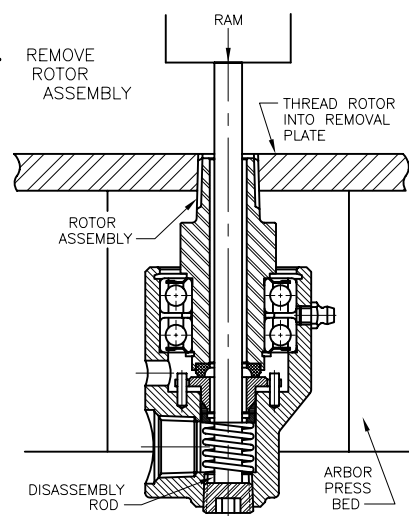
WHEN ASSEMBLING DEUBLIN UNIONS, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. THE PARTS MAY BE CLEANED WITH CARBON TETRA-CHLORIDE, DENATURATED ALCOHOL, OR ANY GOOD CLEANING SOLVENT.

DISASSEMBLY

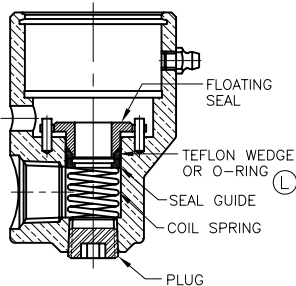
1. REMOVE HOUSING SNAP RING AND PLUG HOUSING.



2. REMOVE ROTOR ASSEMBLY



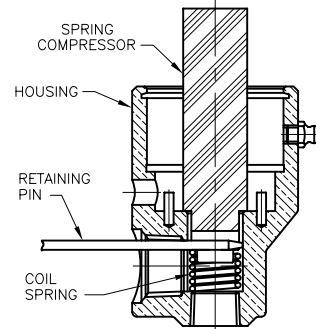
3. REMOVE FLOATING SEAL, (L) TEFLON WEDGE (OR O-RING), SEAL GUIDE, COIL SPRING AND PLUG.



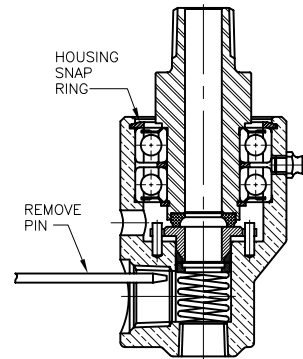
4. CHECK AREA OF BORE INDICATED FOR WEAR OR PITTING. THE BORE MUST BE SMOOTH (16-20 RMS FINISH) AND MAY BE ENLARGED TO THE DIAMETERS IN CHART BELOW.

MODEL	phi A MAX.
55	.504
155	.759
255	1.009
355	1.471
525	1.574
555	1.884
655	2.327

1. ASSEMBLE COIL SPRING. GREASE BEARING BORE. COMPRESS SPRING UNTIL RETAINING PIN CAN BE INSERTED THROUGH ENTRANCE PORT AS SHOWN. REMOVE SPRING COMPRESSOR.

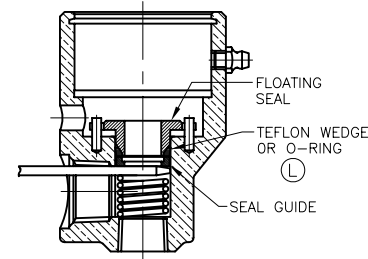


4. ASSEMBLE HOUSING SNAP RING.

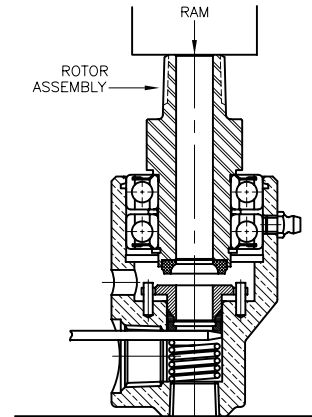


2. ASSEMBLE SEAL GUIDE, TEFLON WEDGE (OR O-RING) AND FLOATING SEAL.

NOTE: CLEAN FLOATING SEAL FACE AND LUBE WITH LIGHT VISCOSITY OIL. ALSO LUBE TEFLON WEDGE OR O-RING.

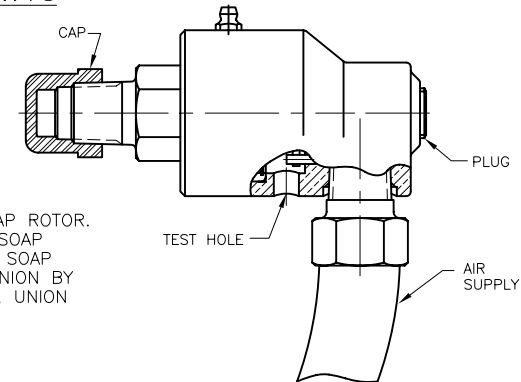


3. CLEAN ROTOR CARBON SEAL FACE AND ASSEMBLE ROTOR ASSEMBLY.



TESTING

TEST UNION WITH 50 PSI MINIMUM AIR PRESSURE BEFORE PERMANENT INSTALLATION.



PLUG DUOFLOW PORT AND CAP ROTOR. APPLY AIR PRESSURE. PUT SOAP WATER SOLUTION OR BUBBLE SOAP OVER TEST HOLE. ROTATE UNION BY HAND. IF NO BUBBLE RISES, UNION IS O.K.

EQUIPMENT REF:				SOLE	FULL	 <b>DEUBLIN COMPANY</b> WAUKEGAN, ILLINOIS, U.S.A.
				DRW	LG	
				05/05/97		
				ENGR		
L	ADDED O-RING TO NOTES	010103	05/10	NR		TITLE: <b>55 SERIES REPAIR INSTRUCTIONS = 31-010</b> UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN ( ) ARE IN MILLIMETERS.
K	DIA. "E" 1.430 WAS 1.452 ON 355 ONLY	8603	09/07	JK		
J	"O-RING FOR 055 & 655" WAS 055 ONLY		03/02	LG		
H	REVISED TOOL SIZES TO SUIT DWG 55-685		11/99	MF		
G	REDRAWN ON CAD; REPL. REV.F		05/97	LG		
LET.	REVISION	ECO	DATE	SIGN		NO. <b>DA 10</b> CADD DRAWING