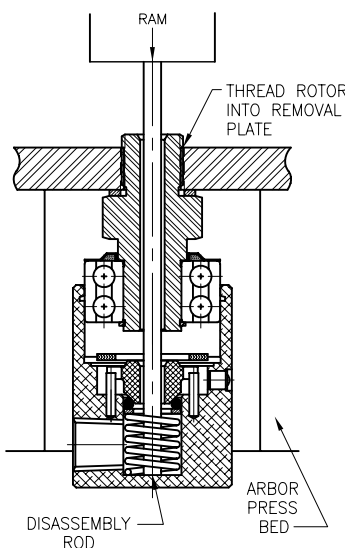


DISASSEMBLY

1. REMOVE HOUSING SNAP RING

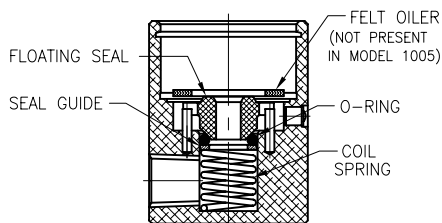


2. REMOVE ROTOR ASSEMBLY AS SHOWN



PREFERRED METHOD OF ROTOR REMOVAL

3. REMOVE FELT OILER, FLOATING SEAL, O-RING, SEAL GUIDE AND COIL SPRING FROM HOUSING.



TOOLING

TRUARC PLIERS

MODEL	PLIERS NO.
1005	L-0100
1102	0300
1115	0300
1205	0500

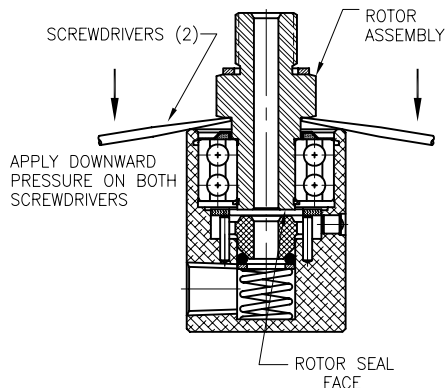
DISASSEMBLY ROD

MODEL	Ø"A"	"B"
1005	3/32	4"
1102	3/16	4"
1115	5/16	6"
1205	3/8	6"

ROTOR ASSEMBLY REMOVAL PLATE

MODEL	"A"	"B"
1005	3"	3/8
1102	3"	3/8
1115	4"	1/2
1205	4"	1/2

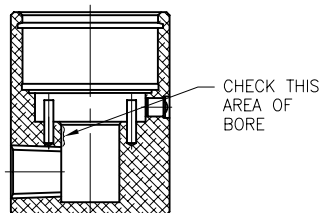
(LENGTH TO SPAN FORK IN BASE OF ARBOR PRESS)
"A" MIN.
DRILL & TAP TO FIT ROTOR THREAD
"B"



ALTERNATE METHOD

EXAMINE ROTOR SEAL FACE FOR SCORING. IF SEVERE SCORING IS EVIDENT THE ROTOR SHOULD BE REPLACED. IF LITTLE OR NO SCORING IS PRESENT, ROTOR CAN BE REUSED. INSPECT THE AMOUNT OF GREASE IN THE BALL BEARING(S); RELUBRICATE IF REQUIRED.

4. CHECK INDICATED AREA OF BORE; AREA TO CROSS HOLE MUST BE CLEAN AND FREE OF NICKS & SCRATCHES



ASSEMBLY

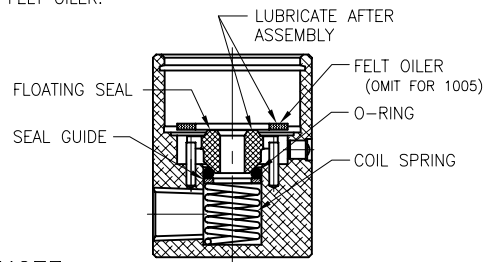
REBUILDING KIT PARTS LIST

- ROTOR (PRE-ASSEMBLED)
- FELT OILER (OMIT FOR MODEL 1005)
- DUEPLEX BALL BEARING WITH NILOS SHIELD (FOR MODEL 1102 ONLY)
- FLOATING SEAL
- O-RING
- SEAL GUIDE
- COIL SPRING
- (2) BALL BEARINGS WITH BEARING SPACER
- ROTOR SNAP RING
- ROTOR GASKET (IF REQ'D)

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, DENATURED ALCOHOL, OR ANY GOOD CLEANING SOLVENT.

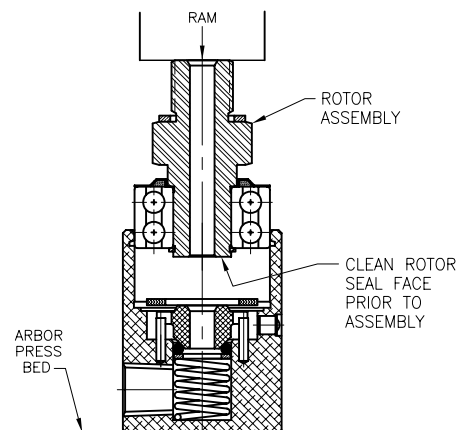
1. ASSEMBLE COIL SPRING, SEAL GUIDE, O-RING. CLEAN FACE OF FLOATING SEAL AND ASSEMBLE. ASSEMBLE FELT OILER.



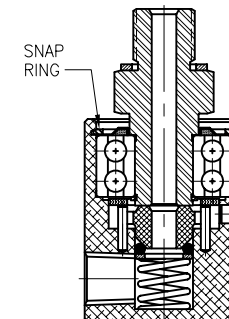
NOTE:

FOR MODELS 1115 & 1205, COIL SPRING MUST BE COMPRESSED DURING ASSEMBLY USING A SPRING COMPRESSION TOOL AND RETAINING PIN.

2. LUBRICATE FELT OILER AND ENTIRE FACE OF FLOATING SEAL WITH LOW VISCOSITY OIL.
3. CLEAN ROTOR SEAL FACE AND ASSEMBLE ROTOR ASSEMBLY AS SHOWN.



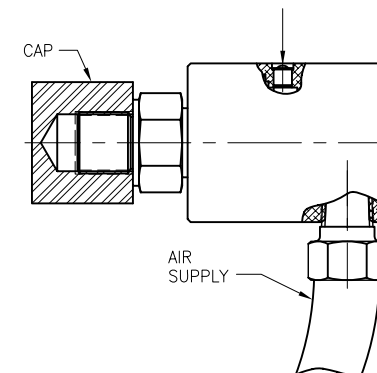
4. ASSEMBLE HOUSING SNAP RING.



TEST PROCEDURE

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

DEPRESS BALL AND APPLY BUBBLE SOAP (FOR MODEL 1005, THERE IS NO OILER - APPLY SOAP TO TEST HOLE)



CAP ROTOR AS SHOWN. APPLY AIR PRESSURE. PUT SOAP WATER SOLUTION OR BUBBLE SOAP OVER TEST HOLE. ROTATE ROTOR BY HAND. IF NO BUBBLE RAISES, UNION IS O.K.

EQUIPMENT REF:		SCALE	FULL	<p>DEUBLIN COMPANY WAUKEGAN, ILLINOIS, U.S.A.</p>
		DRW	LG 05/28/97	
		ENGR		
		APPD		
ASSY/TEST FIXTURES REQUIRED:		UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN () ARE IN MILLIMETERS.		<p>TITLE: DISASSEMBLY/ASSEMBLY INSTRUCTIONS FOR MODELS 1005, 1102, 1115, AND 1205</p> <p>NO. CAD DRAWING</p>
LET.	REVISION	ECO	DATE	SIGN