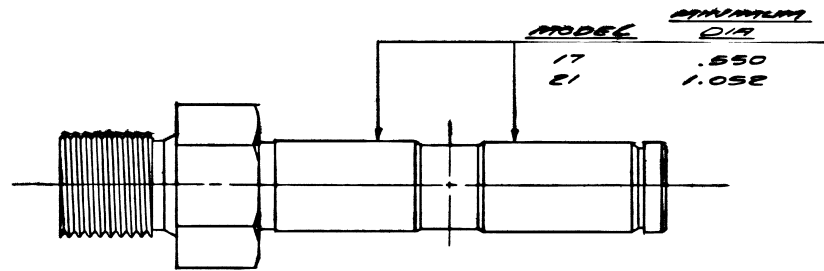
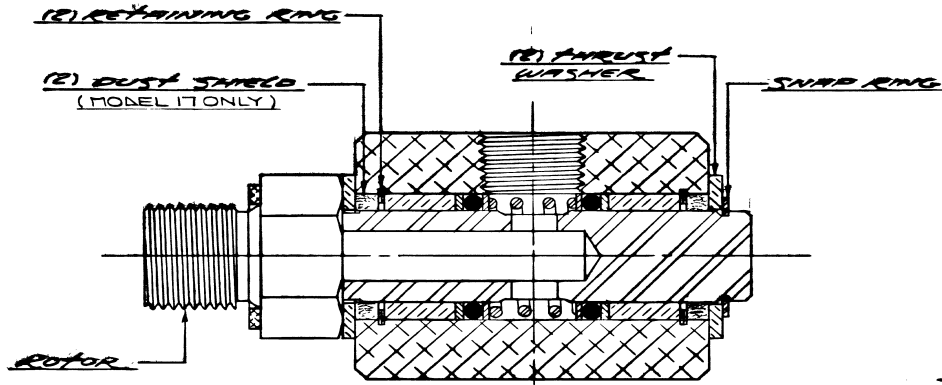
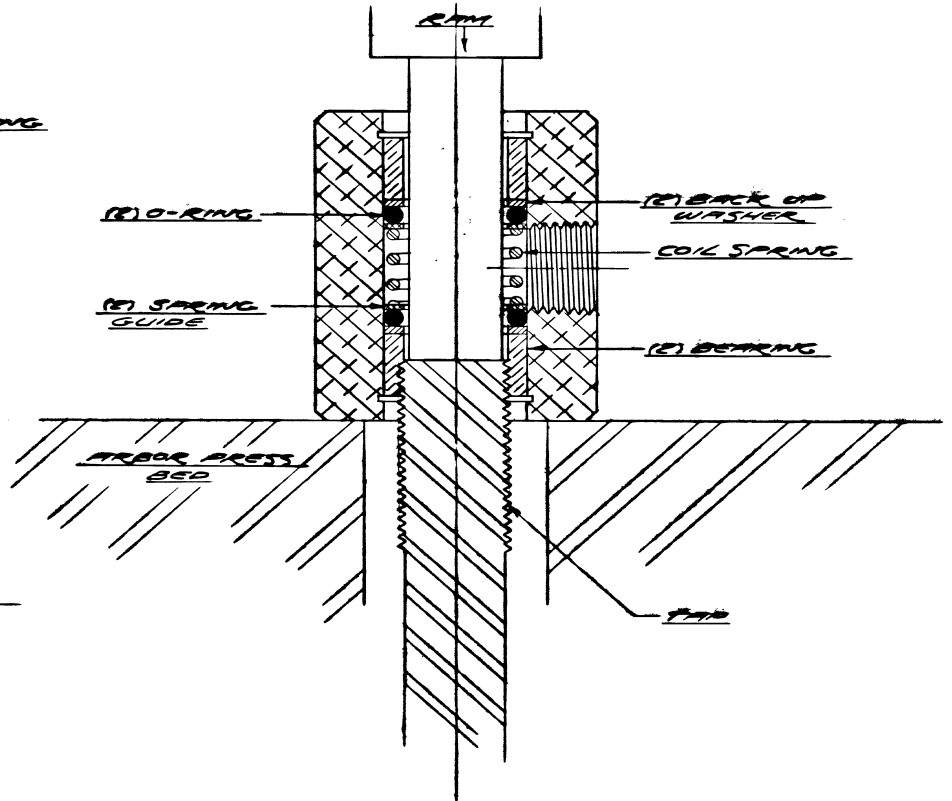


- ① REMOVE ROTOR SNAP RING
MODEL 17 - USE SQUARE PIER #2
MODEL 21 - USE SQUARE PIER #4
- ② REMOVE THRUST WASHER, ROTOR AND DUST SHIELDS
- ③ REMOVE (2) RETAINING RINGS (A SMALL SCREWDRIVER MAY BE USED TO HELP PULL THE RETAINING RING FROM THE GROOVE)



- ④ REMOVE (2) BEARINGS
MODEL 17 - USE 9/8-11 OR 9/8-12 TAP
MODEL 21 - USE 1/8-7 OR 1/8-12 TAP
(THREAD TAP INTO ONE BEARING AT A TIME, WITH THE UNION ON THE ARBOR PRESS BED, INSERT A ROD AND PUSH TAP OUT. BEARING CAN BE FREED FROM TAP BY CRACKING IT WITH A HAMMER. REPEAT THIS OPERATION ON THE SECOND BEARING.)
- ⑤ REMOVE (2) BACKUP WASHERS, (2) O-RINGS, (2) SPRING GUIDES AND COIL SPRING.



⑥ CLEAN ROTOR AND HOUSING. INSPECT THE ROTOR FOR GROOVES OR EXCESSIVE WEAR. IF THE ROTOR IS IN POOR CONDITION OR GROOVED DEEPER THAN GIVEN DIMENSIONS, A NEW ONE SHOULD BE PURCHASED BEFORE ASSEMBLING.

SHEET 11 OF 12

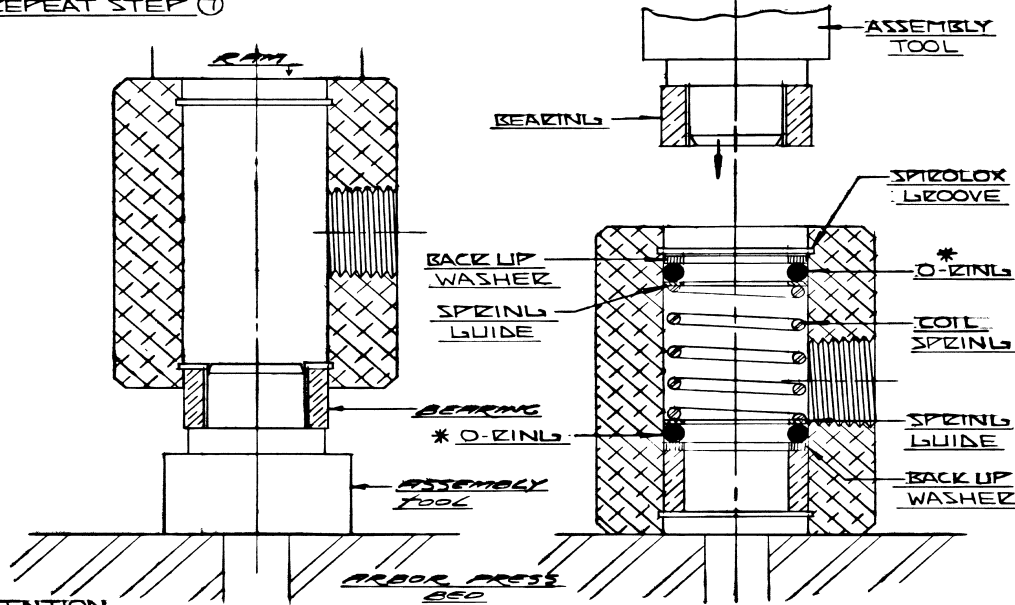
G				MATERIAL	SCALE 2:1	DEUBLIN COMPANY NORTHBROOK, ILLINOIS, U.S.A. MODEL 17 & 21 REPAIR
F					DRAWN V.S.S.	
E					DATE	
D					APP'D	
C						TOLERANCES
B						FRACTIONS ± .010
A						DECIMALS AS SPECIFIED
LET	REVISION	DATE	SIGN			ANGLES ± 1/2°

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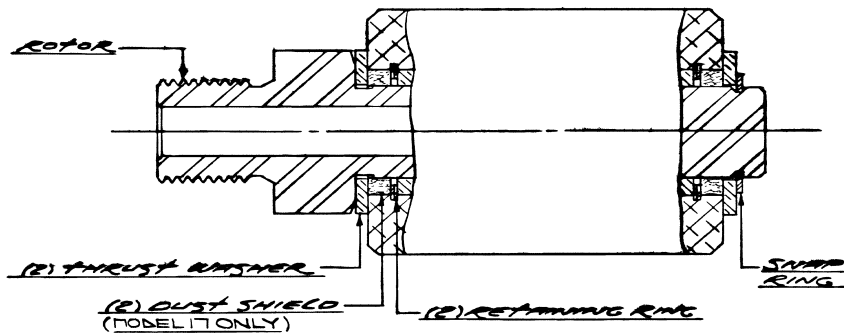
- ⑦ LOAD (1) BEARING ONTO ASSY TOOL AND INSERT INTO HOUSING. PRESS TOGETHER UNTIL ASSY TOOL BOTTOMS ON HOUSING.
- ⑧ REMOVE ASSY TOOL. LOAD PARTS AS ILLUSTRATED BELOW. (WHEN ASSEMBLING O-RING, CARE MUST BE TAKEN NOT TO CLIP O-RING. WHEN SLIDING PAST CROSS HOLE.) AFTER PARTS ARE INSTALLED, TOP BACK UP WASHER AND O-RING SHOULD BE BELOW SPIROLOX GROOVE. REPEAT STEP ⑦

(A)



ATTENTION *O-RINGS APPEAR TO BE LARGER THAN NECESSARY, BUT THIS IS PART OF THE DESIGN.

- ⑨ ASSEMBLE (2) RETAINING RINGS INTO HOUSING
- ⑩ LIGHTLY GREASE ROTOR, ASSEMBLE (1) THRUST WASHER AND (1) DUST SHIELD ON ROTOR AND INSTALL INTO HOUSING.
- ⑪ SLID OTHER DUST SHIELD AND THRUST WASHER ON ROTOR AND ASSEMBLE SNAP RING



REPAIR KIT PARTS LIST
NOTE: ALL PARTS SHOULD BE CLEAN BEFORE ASSEMBLY

REPAIR KIT (MODEL 17)

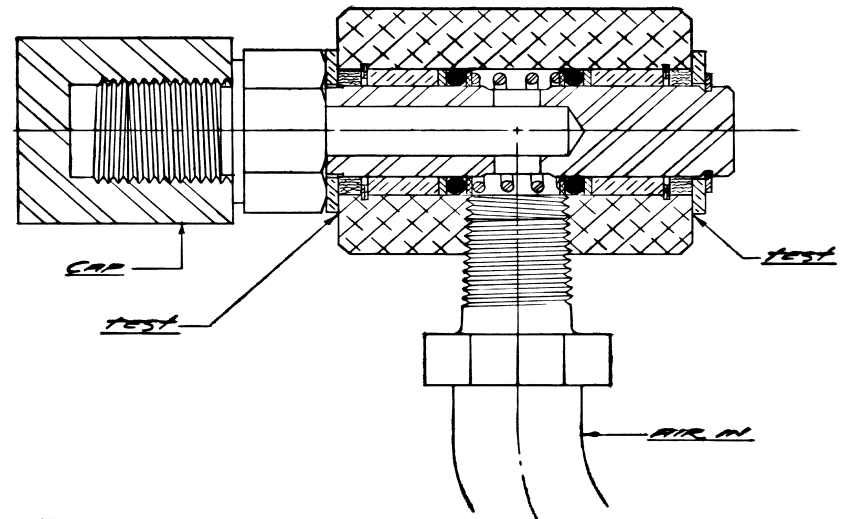
- (2) 17-B BEARING
- (2) 17-A THRUST WASHER
- (2) 17-5 SPRING GUIDE
- (2) 17-29 BACK UP WASHER
- (1) 17-36 COIL SPRING
- (2) 15-35 DUST SHIELD
- (2) 17-B O-RING
- (2) 17-9 RETAINING RING
- (1) 103-B SNAP RING
- (1) 17-29 ASSEMBLY TOOL

REPAIR KIT (MODEL 21)

- (2) 21-103 BEARING
- (2) 21-104 THRUST WASHER
- (2) 21-105 SPRING GUIDE
- (1) 21-106 COIL SPRING
- (2) 21-107 O-RING
- (2) 21-108 BACK UP WASHER
- (1) 20-19 SNAP RING
- (2) 25-22 RETAINING RING
- (1) 21-125 ASSEMBLY TOOL

TESTING:

TEST UNION BEFORE INSTALLATION
(TEST WITH A MILD SOLUTION OF SOAP WATER. IF AN AIR BUBBLE APPEARS, THE UNION HAS NOT BEEN REPAIRED CORRECTLY.)



MATERIAL		SCALE 2:1	DEUBLIN COMPANY NORTHBROOK, ILLINOIS, U.S.A.	
DRAWN V.S.S.		DATE 10-4-85	MODEL 17 & 21 REPAIR	
APP'D			TOLERANCES FRACTIONS ± 010 DECIMALS AS SPECIFIED ANGLES ± 1/2°	
B	SHORTENED ASSY TOOL	9/03 RM	ALL DIAMETERS TO BE CONCENTRIC WITHIN .005 TIR OR AS SPECIFIED	
A	REVISED EGO 101	PS 15A	REMOVE BURRS AND BREAK ALL SHARP CORNERS 010 OR AS SPECIFIED. REMOVE GREASE OR MACHINING OILS.	
LET	REVISION	DATE	SIGN	FILMED <input type="checkbox"/>
				NO DA 37