

CONFIDENTIAL

THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION AND IS NOT TO BE TRANSMITTED, REPRODUCED USED OR DISCLOSED TO ANYONE WITHOUT THE WRITTEN PERMISSION OF THE DEUBLIN COMPANY

# DISASSEMBLY / ASSEMBLY INSTR. 5000 - SERIES UNIONS

DA-51

**DISASSEMBLY:**

STEP 1: (DRAWING 1) REMOVE (3) SOCKET HEAD CAP SCREWS AND END CAP.

STEP 2: (DRAWING 1) REMOVE FLOATING SEAL, O-RING, SPRING GUIDE AND COIL SPRING FROM END CAP AND DISCARD. THE BORE OF THE END CAP SHOULD BE INSPECTED FOR DAMAGE OR MINERAL BUILD UP AT THE AREA WHERE THE O-RING CONTACTS IT. LIGHT SCRATCHES AND MINERAL DEPOSITS CAN BE REMOVED WITH A 360 GRIT OR FINER EMERY CLOTH.

STEP 3: (DRAWING 1) REMOVE SILICON CARBIDE SEAL AND O-RING. CHECK THE ROTOR BEARING FIT BY ROTATING THE HOUSING. IF THE HOUSING DOES NOT ROTATE FREELY OR EXCESSIVE MOVEMENT IS DETECTED, BOTH BEARING AND ROTOR MAY REQUIRE REPLACEMENT.

STEP 4: (DRAWING 2) DISASSEMBLE THE ROTOR FROM THE HOUSING FOR FURTHER INSPECTION. THESE PARTS ARE REUSABLE, THE O-RING AND

THRUST WASHER SHOULD BE REPLACED AND THE ROTOR REASSEMBLED INTO THE HOUSING BEARING ASSEMBLY.

**ASSEMBLY:**

STEP 5: (DRAWING 2) INSTALL THE O-RING AND APPLY GREASE OVER THE O-RING TO HOLD THE SILICON CARBIDE SEAL IN PLACE DURING ASSEMBLY. NOW ASSEMBLE THE SILICON CARBIDE SEAL, PRESSING IT FIRMLY INTO POSITION. THE SILICON CARBIDE SEAL FACE SHOULD NOW BE CLEANED WITH CHLORITHERE, CARBON TETRACHLORIDE, OR ALCOHOL, USING A LINT FREE PAPER CLOTH.

STEP 6: (DRAWING 3) RETRACT THE COIL SPRING AND HOLD IT IN POSITION WITH A PIN AS SHOWN. ASSEMBLE THE SEAL, GUIDE O-RING AND CARBON SEAL INTO POSITION AS SHOWN AND CLEAN THE SEAL FACE WITH THE SAME PROCEDURE AS USED ON THE SILICON CARBIDE SEAL. NOW, LUBRICATE THE CARBON GRAPHITE SEAL FACE WITH CLEAN 20W MOTOR OIL.

STEP 7: (DRAWING 4) ASSEMBLE HOUSING ROTOR

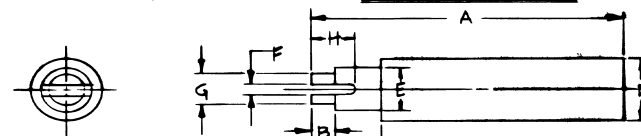
ASSEMBLY ONTO END CAP AND HOLDING THE TWO PARTS TOGETHER, TURN THEM OVER SO THAT THE SOCKET HEAD CAP SCREWS CAN BE INSTALLED FIRMLY. NOW REMOVE THE SPRING RETAINING PIN AND THE UNION IS READY FOR USE.

**REPAIR KIT PARTS LIST**

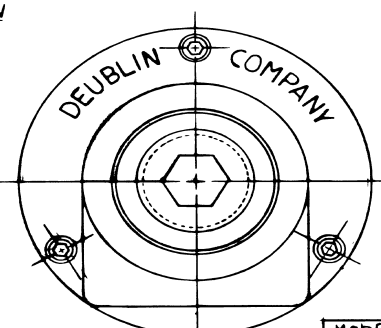
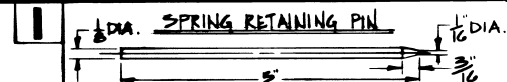
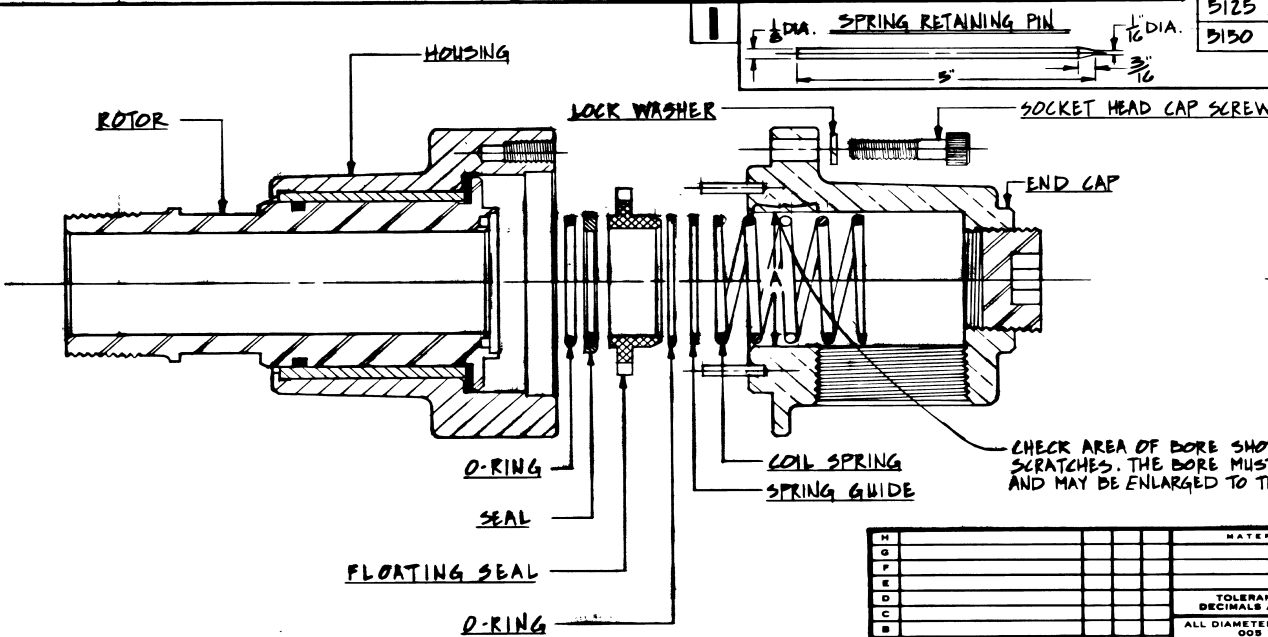
VITON - O-RING, SILICON CARBIDE - SEAL, CARBON GRAPHITE - FLOATING SEAL, VITON - O-RING, BRASS - SPRING GUIDE, STAINLESS STEEL - COIL SPRING, (3) SOCKET HEAD CAP SCREWS WITH LOCK WASHERS

**TOOLING:**

**SPRING COMPRESSOR**



MODEL	A	B	C	D	E	F	G	H
5075	6	5/8	3/8	1 1/2"	.995 .990	3/16	.760 .758	3/8"
5100	"	3/8	3/8	1 3/4"	1.221 1.22	1/4"	1.115 1.11	7/8
5125	"	"	"	"	1.560 1.555	"	1.210 1.205	"
5150	"	"	"	2 1/8"	1.861 1.862	"	1.465 1.460	"



CHECK AREA OF BORE SHOWN FOR WEAR OR SCRATCHES. THE BORE MUST BE SMOOTH (40 R.M.S.) AND MAY BE ENLARGED TO THE DIAMETERS SHOWN IN CHART.

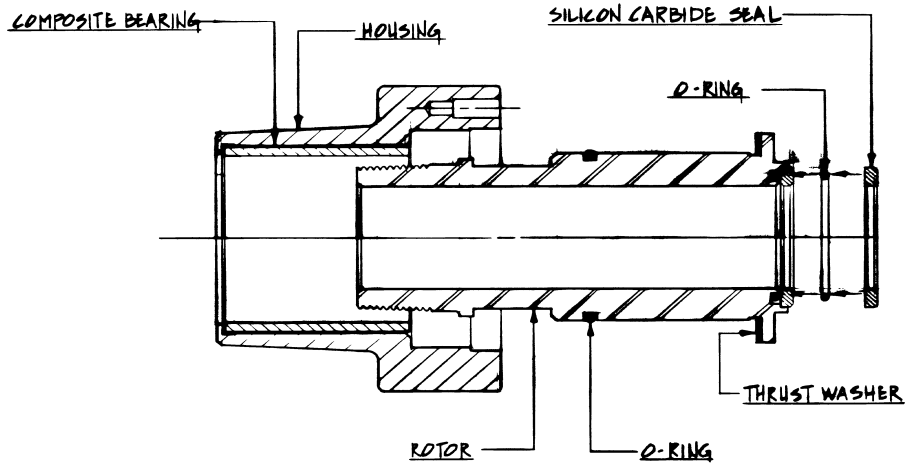
MODEL	A MAX.
5075	1.009
5100	.471
5125	1.574
5150	1.884

MATERIAL	SCALE NONE	<b>DEUBLIN COMPANY</b> NORTHROOK ILLINOIS U.S.A. 5000 SERIES REPAIR INSTRUCTIONS SHEET 1 OF 2 DA-51
DRAWN JJP	DATE 9-25-87	
APP'D		
TOLERANCES - FRACTIONS ± .010 DECIMALS AS SPECIFIED ANGLES ± 1/2°		FILMED
ALL DIAMETERS TO BE CONCENTRIC WITHIN .005 TIR OR AS SPECIFIED		NO
REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED REMOVE GREASE OR MACHINING OILS		
REVISION	ECO DATE SIGN	

**CONFIDENTIAL**

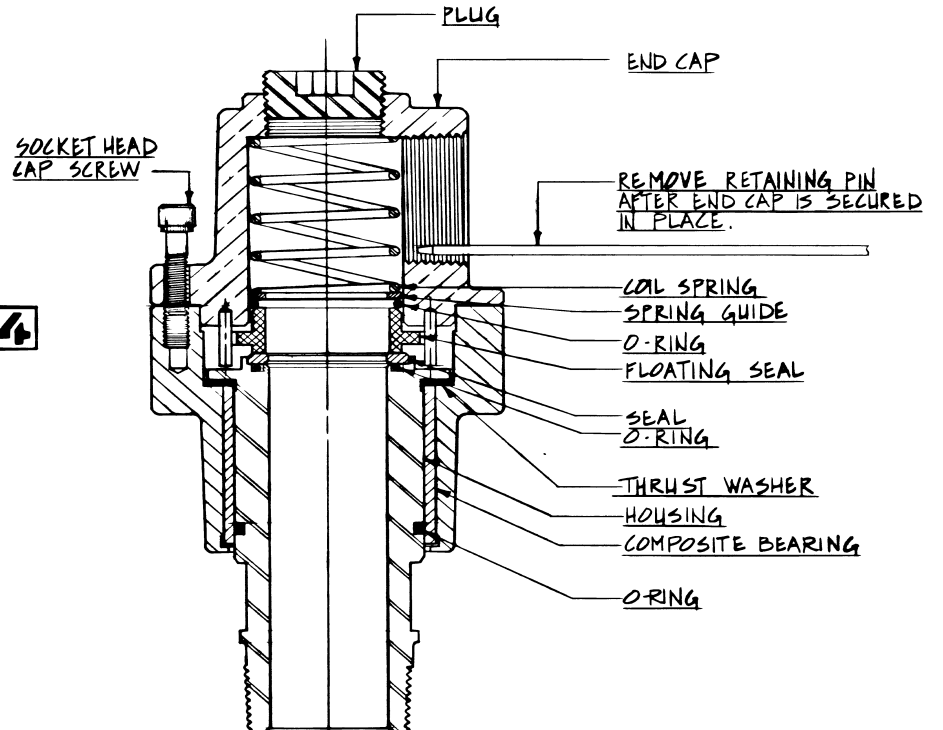
THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION AND IS NOT TO BE TRANSMITTED, REPRODUCED, USED, OR DISCLOSED TO ANYONE WITHOUT THE WRITTEN PERMISSION OF THE DEUBLIN COMPANY

DA-51

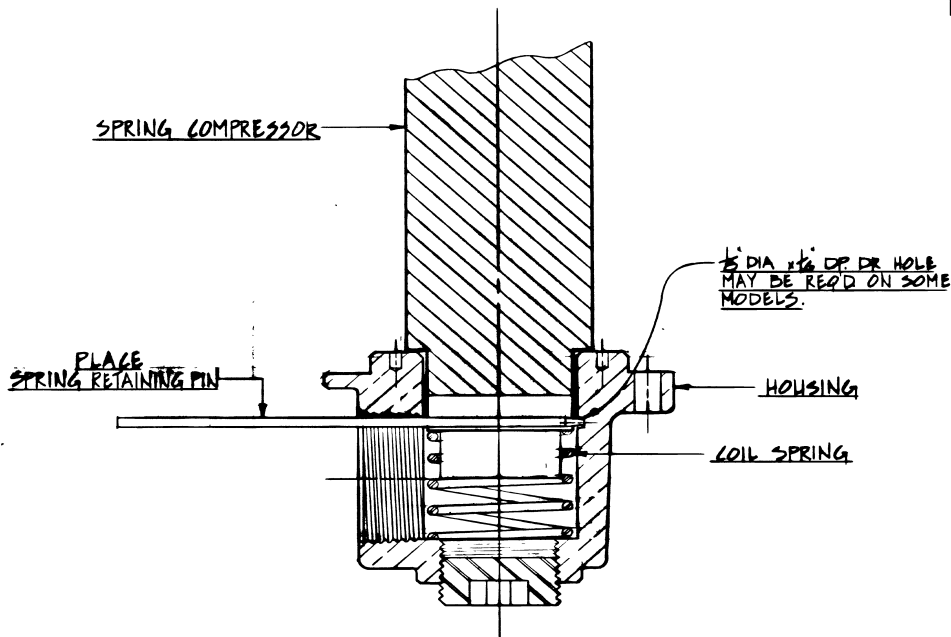


**IMPORTANT NOTE**

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



24  
3



M					MATERIAL	SCALE	NONE
D						DRAWN	J.J.P.
F						DATE	9-28-87
E						APPD	
D					TOLERANCES - FRACTIONS ± 0.10		
C					DECIMALS AS SPECIFIED ANGLES ± 1/8°		
B					ALL DIAMETERS TO BE CONCENTRIC WITHIN 0.05 TIR OR AS SPECIFIED		
A					REMOVE BURRS AND BREAK ALL SHARP CORNERS 0.10 OR AS SPECIFIED REMOVE GREASE OR MACHINING OILS		
REV	REVISION	ECO	DATE	DESIGN			

DEUBLIN COMPANY  
NORTHBROOK ILLINOIS U.S.A.

5000 SERIES REPAIR INSTRUCTIONS

FILMED SHEET 2 OF 2

NO

DA-51