

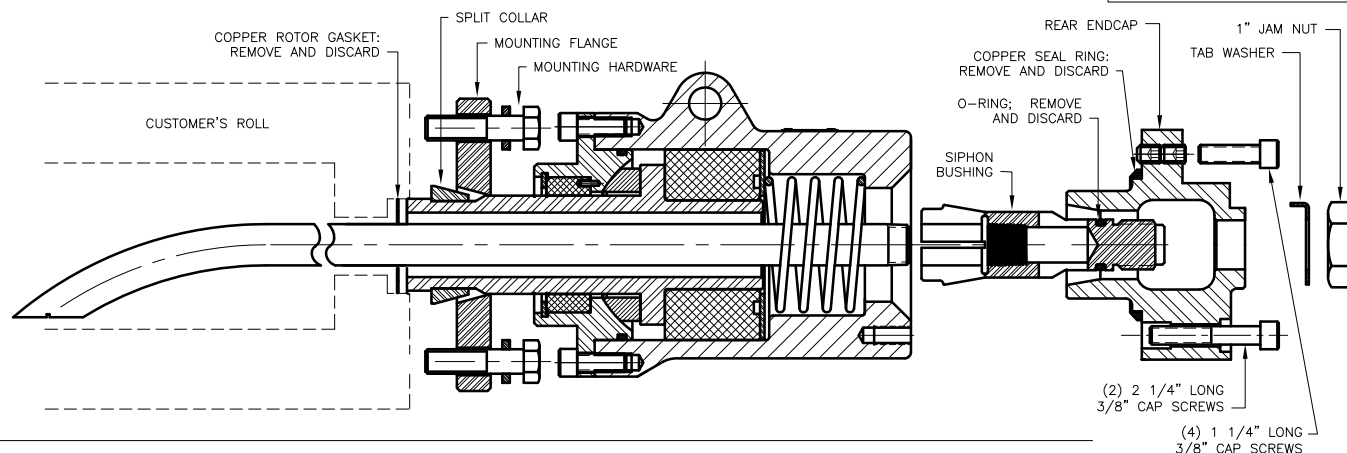
DISASSEMBLY

1. REMOVING JOINT FROM ROLL:

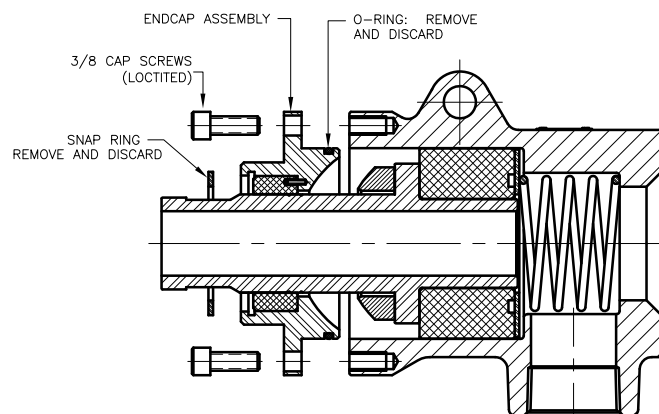
REMOVE 1" JAM NUT AND TAB WASHER. REMOVE (6) 3/8" CAP SCREWS AND REMOVE REAR ENDCAP. DISCARD COPPER SEAL RING. UN-THREAD SIPHON BUSHING FROM PIPE USING SCREWDRIVER SLOT IN END. REMOVE AND DISCARD O-RING.

REMOVE MOUNTING FLANGE HARDWARE. BACK OFF MOUNTING FLANGE AND REMOVE SPLIT COLLAR.

SLIDE JOINT AND GASKET OFF SIPHON PIPE; DISCARD COPPER ROTOR GASKET.

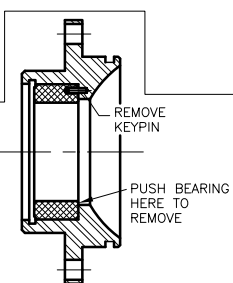


2. REMOVE 3/8" CAP SCREWS AND PULL ENDCAP ASSEMBLY OFF. THERE ARE (4) 3/8" TAPPED HOLES IN BETWEEN BOLTS TO BE USED FOR JACKING SCREWS IF NECESSARY. REMOVE SNAP RING AND DISCARD. REMOVE AND DISCARD O-RING FROM END CAP.



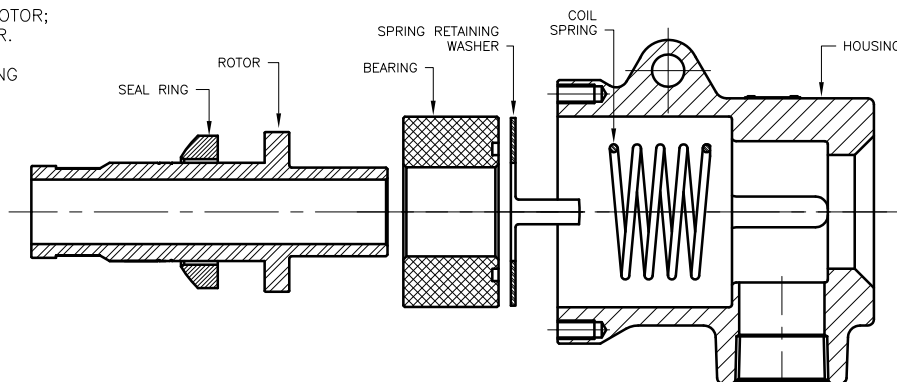
FOR REPAIR KITS ONLY:

DISASSEMBLE BEARING AND KEYPIN FROM ENDCAP AND DISCARD. NOT REQUIRED FOR REBUILD KITS; THEY INCLUDE NEW ENDCAP WITH BEARING AND KEYPIN PRE-ASSEMBLED.



3. REMOVE SEAL RING AND DISCARD. REMOVE ROTOR; DISCARD FOR REBUILD BUT RETAIN FOR REPAIR.

REMOVE AND DISCARD CARBON BEARING, SPRING RETAINING WASHER, AND COIL SPRING.



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TITLE: REPAIR INSTRUCTIONS FOR DEUBLIN HPS JOINT C15D-004-02-3A

NO. 031-075 (SHT 1 OF 2) CAD DRAWING

REV	DESCRIPTION	DATE	BY	CHKD
NONE	WAS DA-075	03/09/09	RMika	
LET.	REVISION	ECO	DATE	SIGN

EQUIPMENT REF:

ASSY/TEST FIXTURES REQUIRED:

SCALE 1:2

DATE 07/30/03

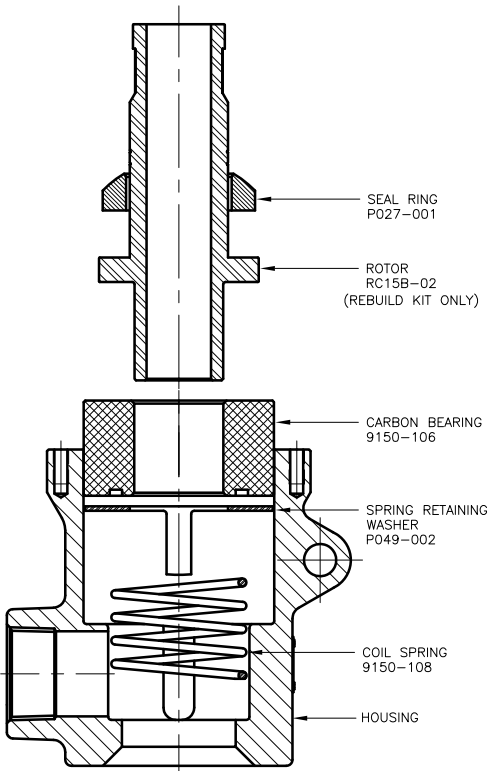
APPD 07/30/03

UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN [] ARE IN MILLIMETERS.

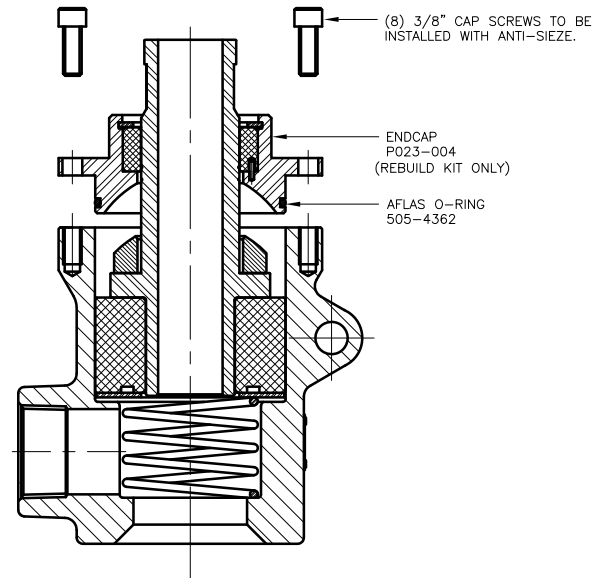
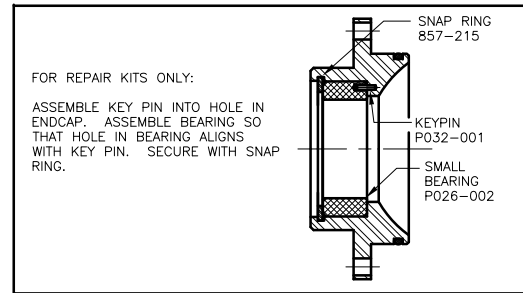
- ASSEMBLE COIL SPRING INTO BORE. ALIGN TABS ON SPRING RETAINING WASHER WITH GROOVES IN HOUSING AND PLACE ON TOP OF SPRING. PRESS DOWN A FEW TIMES TO VERIFY THAT WASHER CAN GLIDE FREELY WITH THE COMPRESSION OF THE SPRING.

ASSEMBLE BEARING WITH GROOVE SIDE DOWN INTO BORE. SLIDE ROTOR INTO BEARING.

ASSEMBLE SEAL WITH CONVEX SIDE UP AS SHOWN.

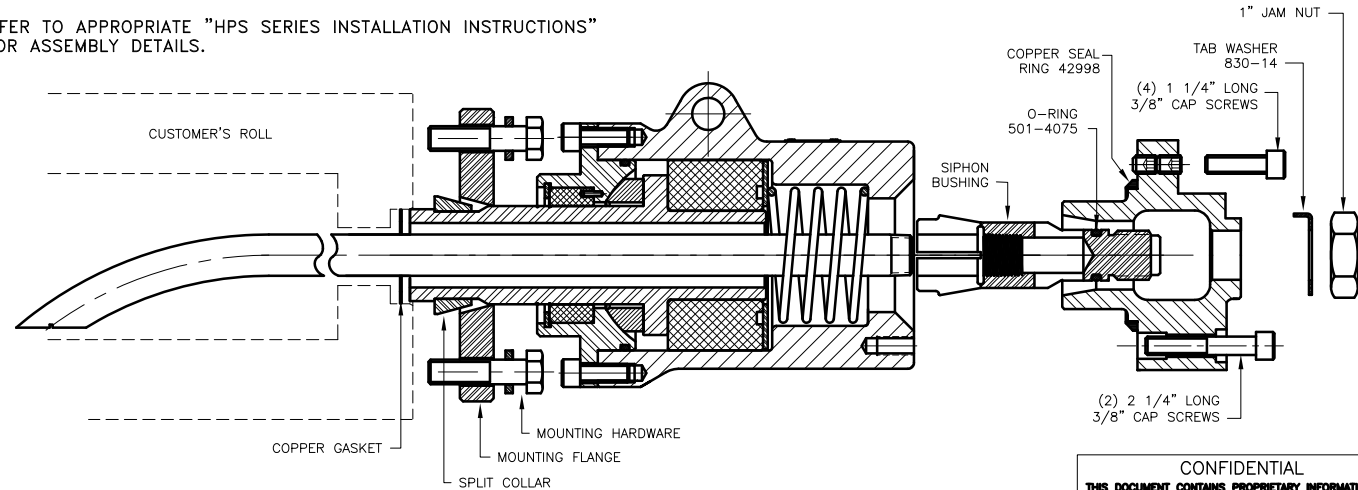


- FOR REPAIR KITS ONLY: ASSEMBLE KEY PIN, BEARING AND SNAP RING INTO ENDCAP AS SHOWN IN DETAIL BELOW.
 - CLEAN BORE IN HOUSING AND GROOVE OF ENDCAP WHERE O-RING WILL SIT WITH A LINT-FREE WIPE AND ALCOHOL. VERIFY SURFACES ARE CLEAN AND FREE OF LINT.
 - PLACE NEW O-RING INTO GROOVE IN ENDCAP.
 - ASSEMBLE ENDCAP INTO HOUSING BEING CAREFUL NOT TO DAMAGE O-RING. ALIGN CLEARANCE HOLES IN ENDCAP WITH TAPPED HOLES IN HOUSING.
 - ASSEMBLE (8) 3/8" SOCKET HEAD CAP SCREWS WITH ANTI-SIEZE COMPOUND. TIGHTEN IN A CROSS PATTERN SUCCESSION AND TORQUE TO 25 FT-LBS.



- AFTER ENDCAP IS ASSEMBLED, PLACE COPPER GASKET IN JOURNAL PILOT, AND ASSEMBLE SIPHON PIPE INTO ROLL. MOUNT JOINT ROTOR TO ROLL WITH SPLIT COLLAR AND FLANGE. CHECK GAP BETWEEN FLANGE AND ROLL TO VERIFY THAT IT IS CONSISTENT ALL THE WAY AROUND (GASKET MUST BE COMPRESSED EVENLY). ASSEMBLE REMAINING ITEMS AT REAR OF JOINT.

NOTE: REFER TO APPROPRIATE "HPS SERIES INSTALLATION INSTRUCTIONS" FOR ASSEMBLY DETAILS.



QTY	ITEM	DESCRIPTION	PARTS CONTAINED IN MODELS:	
			C15D-004C (REPAIR KIT)	C15D-004B02 (REBUILD KIT)
1	P034-020	COPPER GASKET	X	X
1	RC15B-02	ROTOR, DUAL BEARING		X
1	P032-001	KEY PIN	X	X
1	857-215	SNAP RING	X	X
1	P026-002	CARBON BEARING	X	X
1	P023-004	ENDCAP		X
1	505-4362	O-RING (FOR ENDCAP)	X	X
1	P027-001	SEAL	X	X
1	9150-106	CARBON BEARING	X	X
1	P049-002	SPRING RETAINING WASHER	X	X
1	9150-108	COIL SPRING	X	X
1	42998	COPPER SEAL RING	X	X
1	501-4075	O-RING (SIPHON BUSHING)	X	X
1	830-14	TAB WASHER	X	X

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TITLE: REPAIR INSTRUCTIONS FOR DEUBLIN HPS UNION C15D-004-02-3A

NO. 031-075 (SHT 2 OF 2)

EQUIPMENT REF:		SCALE 1:2	REV C
ASSY/TEST FIXTURES REQUIRED:		DRW LG 07/30/03	ENR LG 07/30/03
NONE WAS DA-075		UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN [] ARE IN MILLIMETERS.	
LET.	REVISION	ECO	DATE SIGN
			030109 09/14 RMika