TOOLING — BY CUSTOMER

DISASSEMBLY

1. Remove housing snap ring and plug housing.
2. Remove rotor assembly.
3. Remove floating seal. (1) 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.

ASSEMBLY

REBUILDING KIT PARTS LIST

- Rotor (pre-assembled) - Teflon seal wedge or O-ring
- Ball bearings - Bearing spacer
- Rotor snap ring - Seal guide
- Floating seal - 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, denatured alcohol, or any good cleaning solvent.

2. Assemble seal guide, Teflon wedge or O-ring) and floating seal.
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 on bubble soap over test hole. Rotate union by hand. If no bubble rises, union is O.K.