

LTR	REVISION	ECO	DATE	SIGN
NONE	Original	19985	8/12	GM

**Deublin Company
Waukegan, IL USA**



**Engineering Instruction
031-085**

**Disassembly Procedure
7100-1012/1014 Series Unions**

Description: Disassembly 7100-1012/1014 Series Unions

Engineering Instruction Number: 031-085

Revision: NONE

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Description: Disassembly 7100-1012/1014 Series Unions	
Engineering Instruction Number: 031-085	Revision: NONE

1. Purpose:

1.1. To provide pictorial instructions from Disassembly of the 7100-1012 and 7100-1014 union.

2. Scope:

2.1. Covers both 7100-1012 and 7100-1014 Unions

3. Input:

3.1. Work Packet

3.2. Assembled Union

4. Records:

4.1. N/A

5. Tools, Supplies and Fixtures:

5.1. Tools

5.1.1. Flat Head Screw Driver

5.1.2. Slide Hammer Pliers

5.1.3. Snap Ring Pliers

5.1.4. Arbor press

5.1.5. Bearing Separator

5.1.6. Arbor Press

5.1.7. Hex Wrench

5.2. Supplies

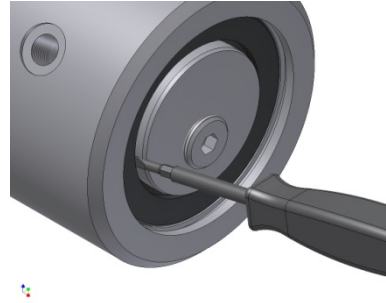
5.2.1. Oil

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6. Quality Check Summary



QC:0010

Quality Check #	Page	Description	Method	Frequency
0010	5	Make sure not to scratch rotor on sealing surface.	Visual	100%

Quality checked by _____ Clock # _____ Date ___/___/___ MO Number: _____

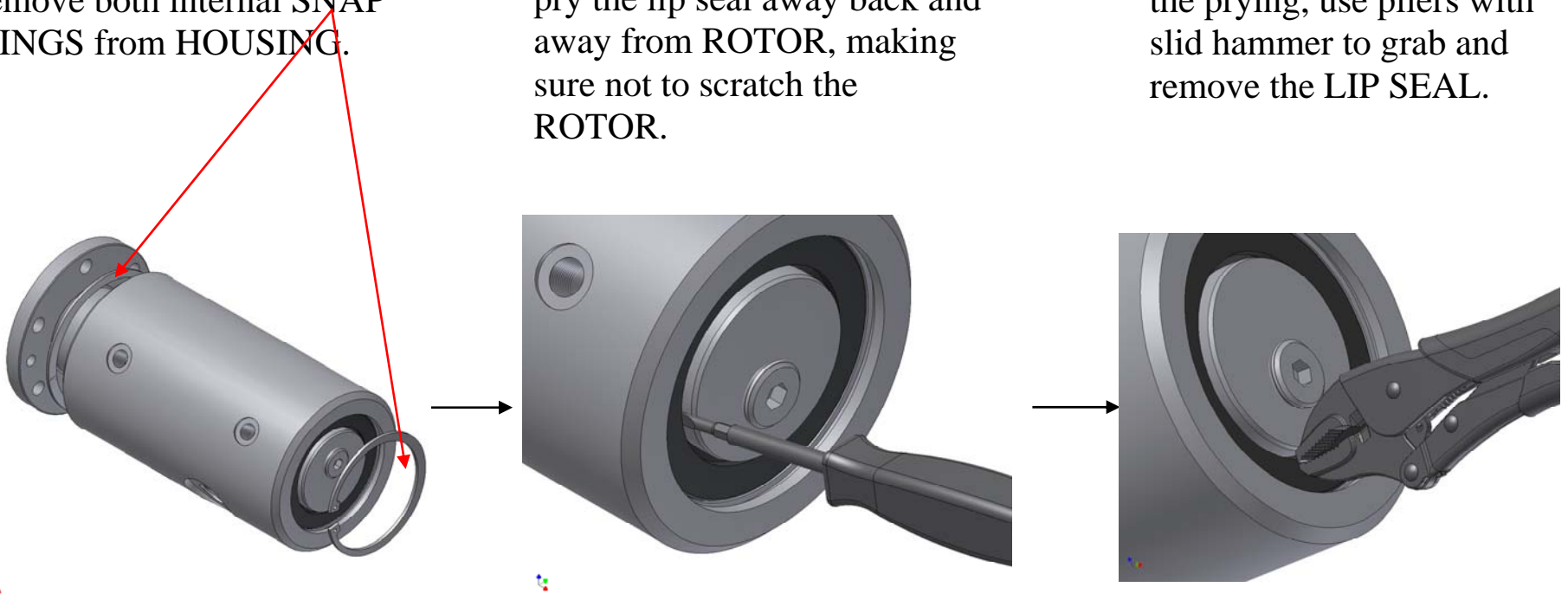
7. Procedure

7.1. Dissassembly

Using Snap Ring pliers, remove both internal SNAP RINGS from HOUSING.

Using a flat head screw driver, pry the lip seal away back and away from ROTOR, making sure not to scratch the ROTOR.

With the lip created from the prying, use pliers with slid hammer to grab and remove the LIP SEAL.



Quality Check: 0010

Description: Make sure not to scratch rotor on sealing surface.

Method: Visual

Frequency: 100%

Tools

Snap Ring Pliers

Tools

Flat Head Screw Driver

Tools

Slide Hammer Pliers

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Using Snap Ring pliers,
remove external SNAP RING
from ROTOR groove.

Using Arbor Press,
press ROTOR out of
HOUSING.

Using Snap Ring pliers,
remove external SNAP RING
from ROTOR
groove.



Tools

Snap Ring Pliers

Tools

Arbor Press

Tools

Snap Ring Pliers

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Using Arbor press and bearing separator, remove LIP SEAL and BEARING from the ROTOR.



Tools

Arbor press
Bearing Separator

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