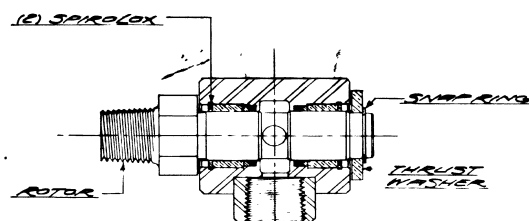
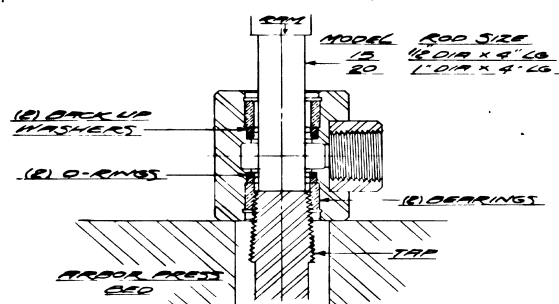


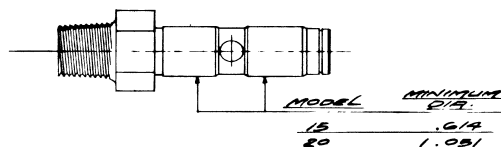
1. REMOVE ROTOR SNAP RING.
MODEL 15 USE TRIANG ALIER #E
MODEL 20 USE TRIANG ALIER #A
2. REMOVE THRUST WASHER, ROTOR
3. REMOVE (E) SPIROLOX RINGS (A SMALL SCREWDRIVER MAY BE USED TO HELP PULL THE SPIROLOX RING FROM THE GROOVE.)



4. REMOVE (E) BEARINGS
MODEL 15 USE 9/16 N.E.T. TAP
MODEL 20 USE 1/8-12 N.E. TAP
(THREAD TAP INTO ONE BEARING AT A TIME WITH THE UNION ON THE REAR. PRESS BEG. 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 (E) BACK UP WASHERS & (E) O-RINGS



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 ASSEMBLY.



NOTE 2:
ALL PARTS SHOULD BE CLEAN BEFORE ASSEMBLY.

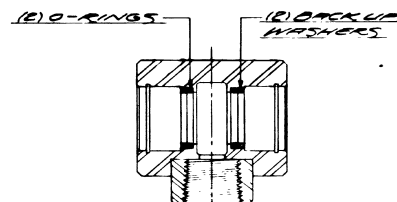
MODEL 15 REPAIR KIT

- (1) 15-10 SNAP RING
- (1) 15-9 SPIROLOX
- (1) 15-4 BEARING
- (1) 15-17 BACK UP WASHER
- (1) 15-5 O-RING

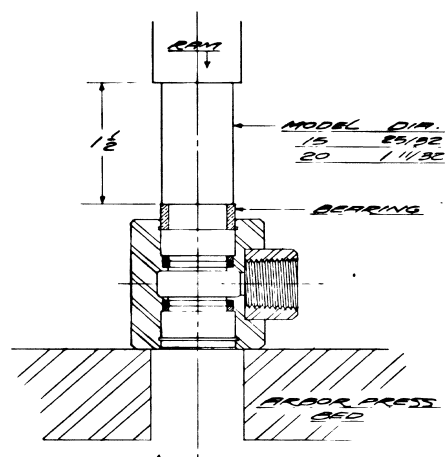
MODEL 20 REPAIR KIT

- (1) 20-7 SNAP RING
- (1) 20-10 SPIROLOX
- (1) 20-5 BEARING
- (1) 1925-9 BACK UP WASHER
- (1) 1925-9 O-RING

7. ASSEMBLE (E) O-RINGS & (E) BACK UP WASHERS
(APPLY A SMALL AMOUNT OF LIGHT GREASE TO THE O-RINGS)



8. ASSEMBLE (E) BEARINGS

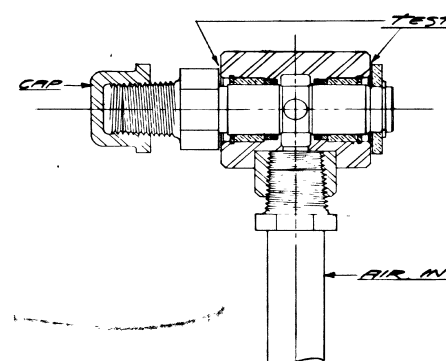


9. ASSEMBLE (E) SPIROLOX RINGS

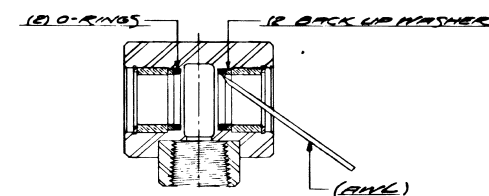
10. INSTALL ROTOR
(Wipe light grease on rotor.)
11. ASSEMBLE THRUST WASHER & SNAP RING

TESTING

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



FOR REPLACEMENT OF O-RINGS & BACK UP WASHERS ONLY FOLLOW STEPS #1, & #6. (REMOVE O-RINGS & BACK UP WASHERS BY PIERCING WITH A SHARP TOOL (AWL)). ASSEMBLE BACK UP WASHER INTO GROOVE, GREASE O-RING AND FOLD INTO GROOVE. FOLLOW STEPS #10 & #11.



F				MATERIAL	SCALE FULL	DEUBLIN COMPANY
E					DRAWN 1/5 S.	NORTHBROOK
D					DATE	ILLINOIS
C					APP'D	MODEL 15 & 20
B					DATE	REPAIR INSTRUCTIONS
A					ISSUED	TOLERANCES
LET.	REVISION	DATE	SIGN	REMOVE BURRS AND BREAK ALL SHARP CORNERS .010R OR AS SPECIFIED. REMOVE GREASE OR MACHINING OILS		FRACTIONS ± .010
						DECIMALS AS SPECIFIED
						PART NO DA-25