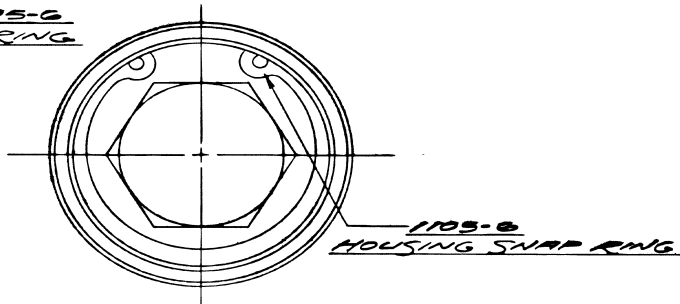
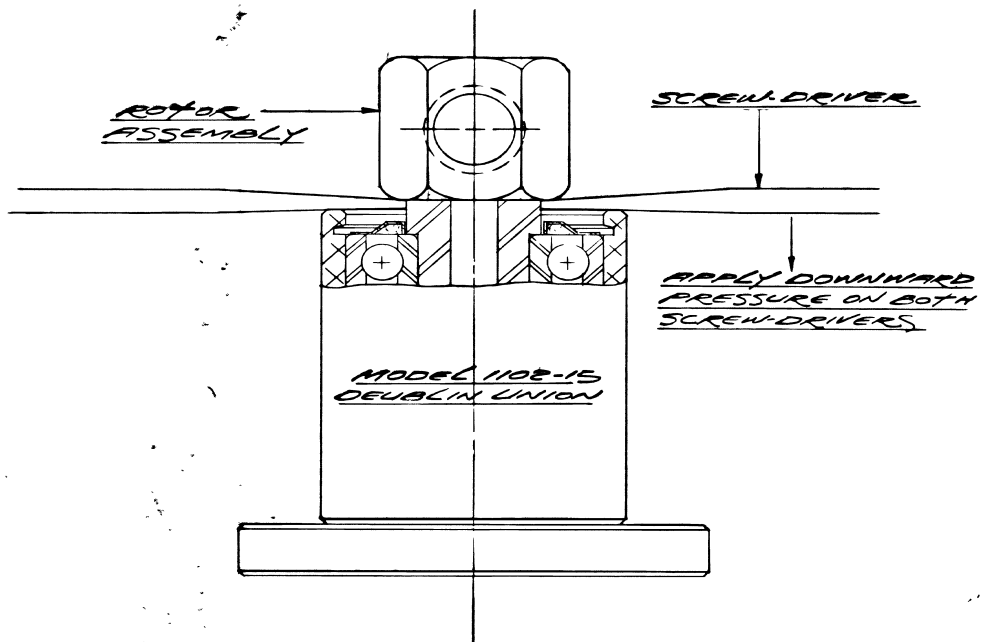


1
REMOVE #1105-G
HOUSING SNAP RING

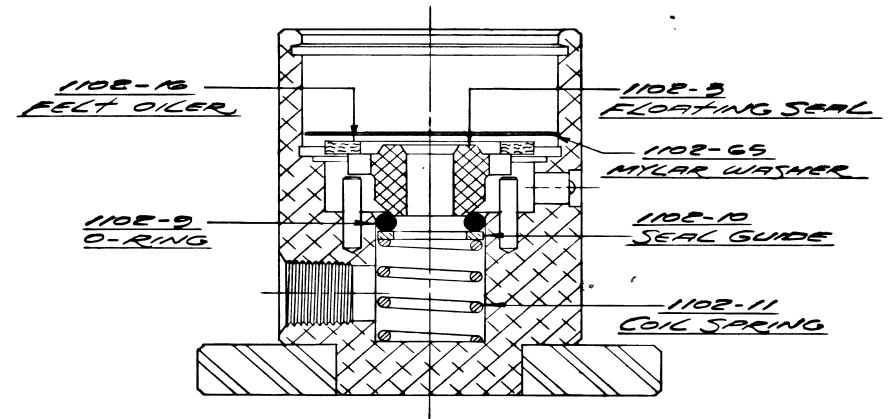


2
REMOVE ROTOR
ASSEMBLY AS SHOWN



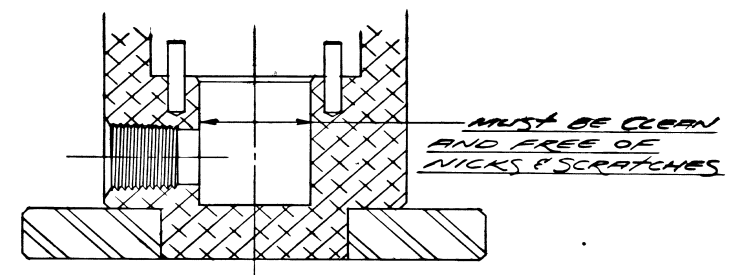
3

DA 30
A
REMOVE #1102-65 MYLAR WASHER,
#1102-16 FELT OILER,
1102-3 FLOATING SEAL, #1102-9
O-RING, 1102-10 SEAL GUIDE
AND #1102-11 COIL SPRING FROM
1102-14 HOUSING.



4

CHECK AREA OF BORE



G				MATERIAL	SCALE 2:1	DEUBLIN COMPANY
F				DRAWN		NORTHBROOK, ILLINOIS, U.S.A.
E				DATE		1102-15 UNION
D				APP'D		
C						
B						
A						
LET	REVISION	DATE	SIGN	ALL DIAMETERS TO BE CONCENTRIC WITHIN .005 T I R OR AS SPECIFIED REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED REMOVE GREASE OR MACHINING OILS		
				TOLERANCES	FRACTIONS ± .010	DECIMALS AS SPECIFIED
				ANGLES ± 1/2°	FILMED ☐ NO DA 30	

5

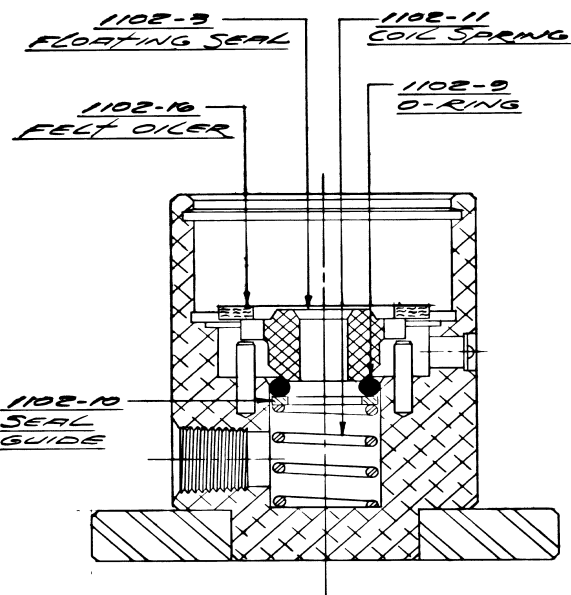
WHEN ASSEMBLING DEUBLIN UNIONS, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. THE PARTS MAY BE CLEANED WITH CLOROTHCENE, CARBON TETRACHLORIDE, ALCOHOL OR ANY GOOD CLEANING SOLVENT.

6

CLEAN ROTOR SEAL FACE AND #1102-3 FLOATING SEAL. SEAL FACES MUST BE FREE OF ALL DIRT AND DUST.

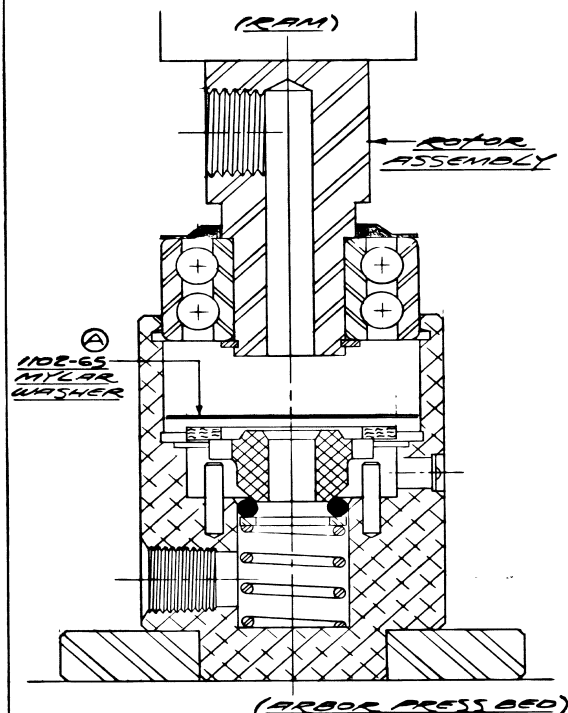
7

ASSEMBLE #1102-11 COIL SPRING, #1102-10 SEAL GUIDE, #1102-9 O-RING, #1102-3 FLOATING SEAL, #1102-16 FELT OILER.



9

ASSEMBLE ROTOR ASSEMBLY



8

OIL #1102-16 FELT OILER AND ENTIRE FACE OF #1102-3 FLOATING SEAL WITH LOW VISCOSITY OIL, AND INSTALL #1102-65 MYLAR WASHER ON TOP OF FELT OILER.

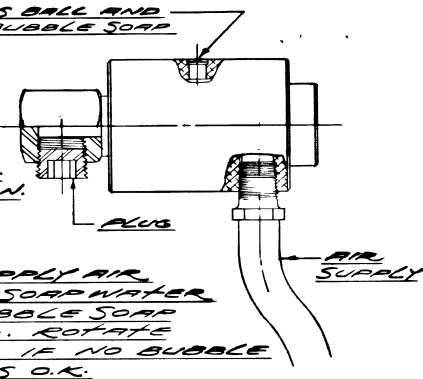
REBUILDING KIT PARTS LIST

- ROTOR, PRE-ASSEMBLED
- (1) 1102-6 BALL BEARING
 - (1) 1105-13 SNAP RING
 - (1) 055-43 DUST SHIELD
 - (1) 1102-11 COIL SPRING
 - (1) 1102-9 O-RING
 - (1) 1102-3 FLOATING SEAL
 - (1) 1102-10 SEAL GUIDE
 - (1) 1102-16 FELT OILER
 - (1) 1102-65 MYLAR WASHER (A)

TEST PROCEDURE

DEPRESS BALL AND
APPLY BUBBLE SOAP

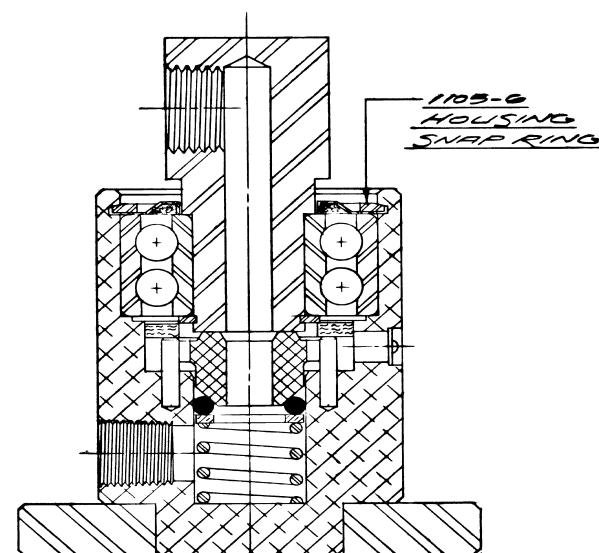
TEST UNION WITH
50 P.S.I. MINIMUM
AIR PRESSURE
BEFORE PERMAN-
ENT INSTALLATION.



PLUG ROTOR. APPLY AIR
PRESSURE. PUT SOAP/WATER
SOLUTION OR BUBBLE SOAP
OVER TEST HOLE. ROTATE
ROTOR BY HAND. IF NO BUBBLE
RAISES, UNION IS O.K.

10

ASSEMBLE #1105-6
HOUSING SNAP RING



G				MATERIAL	SCALE 2:1	DEUBLIN COMPANY
F					DRAWN	NORTHBROOK, ILLINOIS, U.S.A.
E					DATE	1102-15 UNION
D					APP'D	TOLERANCES
C						FRACTIONS ± .010
B						DECIMALS AS SPECIFIED
A						ANGLES ± 1/2°
LEY	REVISION	DATE	SIGN	ALL DIAMETERS TO BE CONCENTRIC WITHIN .005 T I R OR AS SPECIFIED REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED. REMOVE GREASE OR MACHINING OILS		

NO DA 30