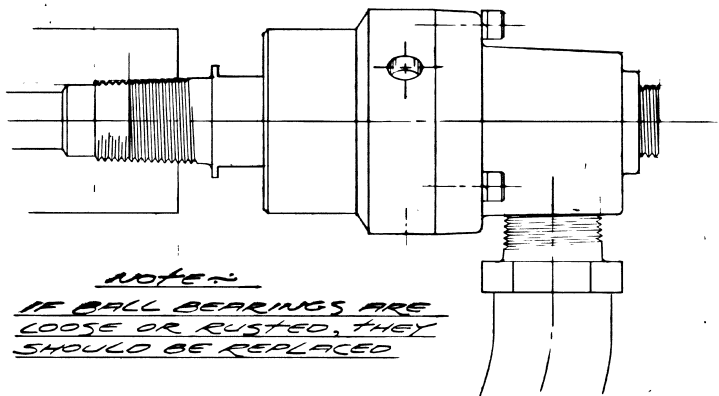
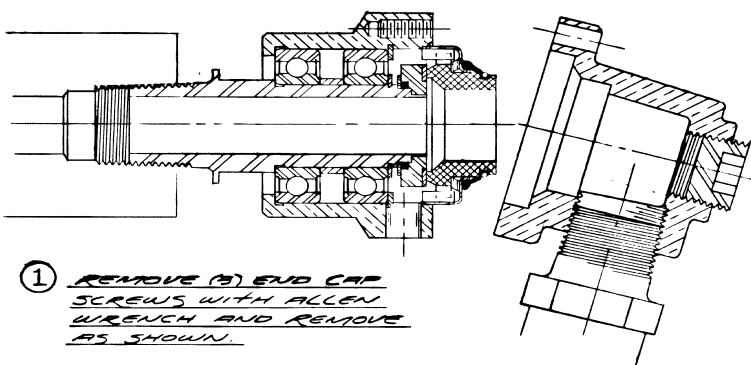


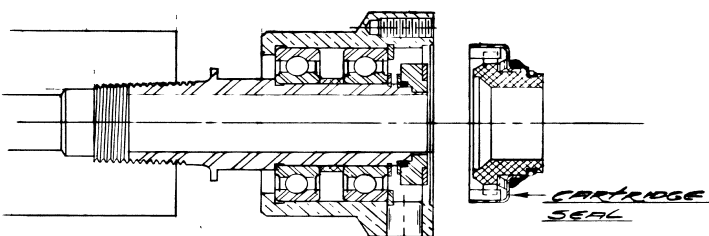
6000 SERIES UNIONS MAY BE REPAIRED WITHOUT REMOVAL FROM SHAFT OR DISCONNECTING HOSE, IF BALL BEARINGS ARE IN GOOD CONDITION.



NOTE:
IF BALL BEARINGS ARE LOOSE OR RUSTED, THEY SHOULD BE REPLACED.

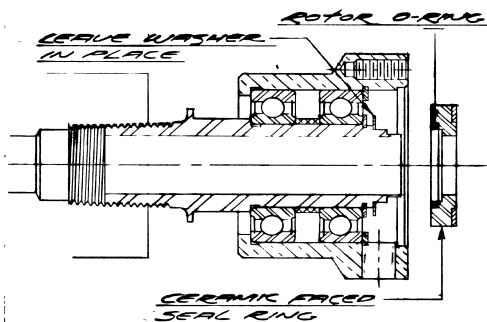


① REMOVE (B) END CAP SCREWS WITH ALLEN WRENCH AND REMOVE AS SHOWN.

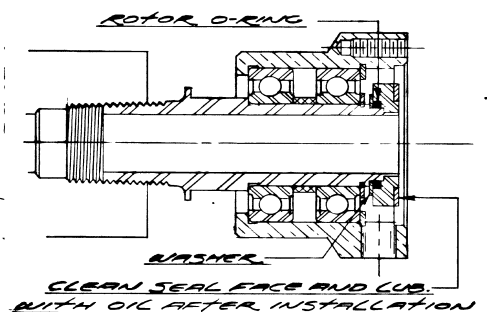


② REMOVE CARTRIDGE SEAL AND DISCARD.

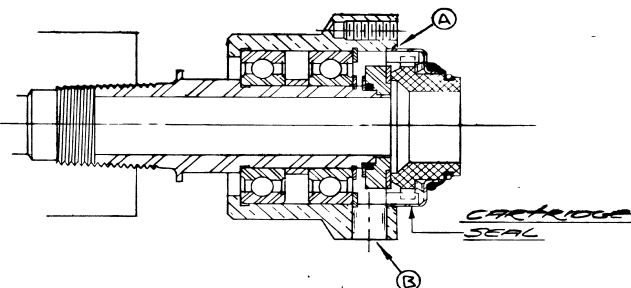
③ REMOVE CERAMIC FACED SEAL RING AND ROTOR O-RING AND DISCARD.



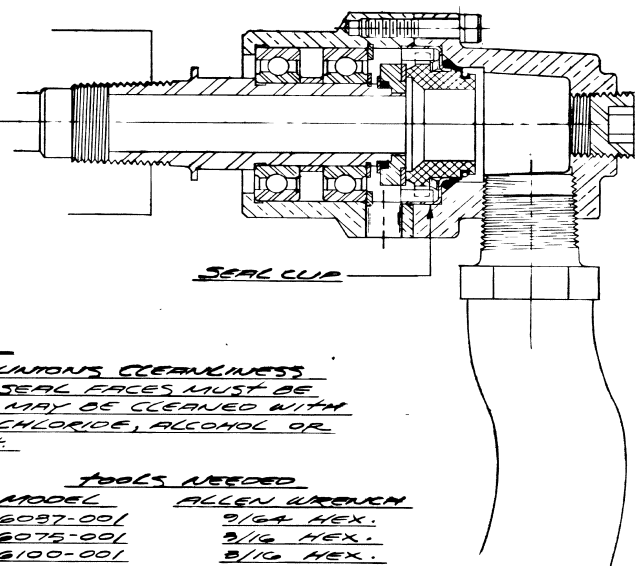
④ PLACE NEW O-RING ONTO ROTOR AND LUB O-RING WITH GREASE. INSTALL NEW CERAMIC FACED SEAL RING ON ROTOR, MAKING CERTAIN IT IS SEATED FIRMLY ON THE ROTOR.



⑤ CLEAN CARBON-GRAPHITE SEAL FACE AND INSTALL THE NEW CARTRIDGE SEAL INTO THE HOUSING.



⑥ RE-ASSEMBLE END CAP. TIGHTEN SCREWS DOWN EVENLY DUE TO ACCUMULATION OF TOLERANCES, A SLIGHT GAP MAY EXIST BETWEEN HOUSING AND END CAP. THIS WILL NOT AFFECT THE PERFORMANCE OF THE UNION.



NOTE:
WHEN ASSEMBLING DEUBLIN UNIONS CLEANLINESS IS AN IMPORTANT FACTOR. SEAL FACES MUST BE FREE OF DIRT AND CHIPS AND MAY BE CLEANED WITH CCLOTHENE, CARBON TETRA-CHLORIDE, ALCOHOL OR ANY GOOD CLEANING SOLVENT.

REPAIR KIT PARTS LIST

- (1) CERAMIC MATING SEAL RING
- (1) ROTOR O-RING
- (1) CARTRIDGE SEAL
- (3) SCREWS
- (3) LOCKWASHERS

TOOLS NEEDED

- | MODEL | ALLEN WRENCH |
|----------|--------------|
| 6037-001 | 3/64 HEX. |
| 6075-001 | 3/16 HEX. |
| 6100-001 | 5/16 HEX. |

G			MATERIAL	SCALE	DEUBLIN COMPANY	
F				DRAWN <i>US</i>	NORTHBROOK, ILLINOIS, U S A	
E				DATE <i>5-22-82</i>	<i>6000 UNION'S REPAIR INST.</i>	
D				APP'D		
C	LOCKWASHER ADDED	<i>54</i>	ALL DIAMETERS TO BE CONCENTRIC WITHIN .003 T I R OR AS SPECIFIED	TOLERANCES		FILMED ☐
B	WAS TAPPED VENTS	<i>15</i>		FRACTIONS ± .010		
A	HSA O-RING REMOVED	<i>83 LB</i>		DECIMALS AS SPECIFIED		
LET	REVISION	DATE SIGN	REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED. REMOVE GREASE OR MACHINING OILS	ANGLES ± 1/2°		NO <i>DA 32</i>