VIEW FOR UNIONS WITHOUT

SIPHON ADJUSTMENT

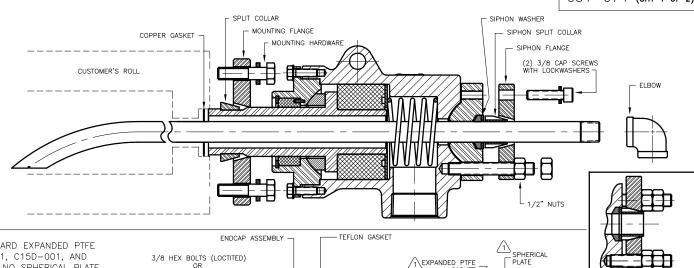
DISASSEMBLY

1. REMOVING UNION FROM ROLL:

REMOVE ELBOW. REMOVE CAP SCREWS, LOCKWASHERS, 1/2" NUTS, SIPHON FLANGE, SIPHON SPLIT COLLAR, AND SIPHON WASHER.

REMOVE MOUNTING FLANGE HARDWARE. BACK OFF MOUNTING FLANGE AND REMOVE SPLIT COLLAR.

SLIDE UNION AND GASKET OFF SIPHON PIPE: DISCARD COPPER GASKET.



REMOVE PACKING FROM SPHERICAL PLATE AND DISCARD. DISCARD EXPANDED PTFE GASKET. ON UNIONS WITHOUT SIPHON ADJUSTMENT (C15B-001, C15D-001, AND C15R-001), PACKING IS IN REAR OF HOUSING, AND THERE IS NO SPHERICAL PLATE OR EXPANDED PTFE GASKET.

DISASSEMBLE 3/8" OR 5/16" HEX BOLTS AND BELLEVILLE WASHERS; DISCARD WASHERS.

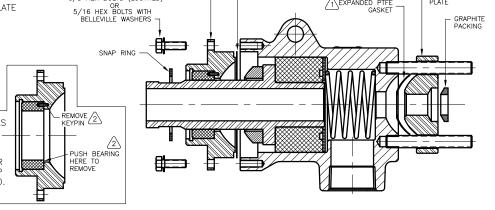
REMOVE SNAP RING AND DISCARD (FOR DUAL BEARING MODELS ONLY). PULL ENDCAP ASSEMBLY OFF OF UNION; REMOVE AND DISCARD TEFLON GASKET.

NOTES:

- 1 THESE ITEMS FOR UNIONS WITH SIPHON ADJUSTMENT ONLY.
- 2 THESE ITEMS FOR DUAL BEARING UNIONS ONLY.

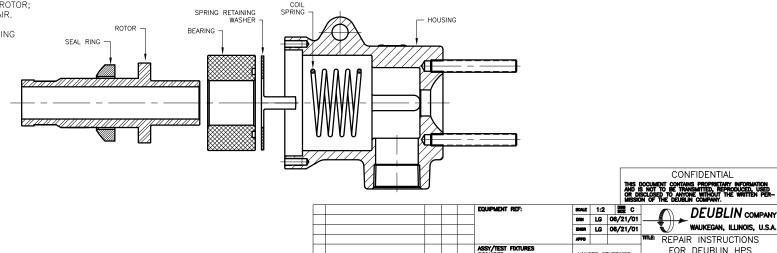
FOR REPAIR KITS ON DUAL BEARING MODELS ONLY:

DISASSEMBLE BEARING AND KEYPIN FROM ENDCAP AND DISCARD. NOT REQUIRED FOR REBUILD KITS; THEY INCLUDE NEW ENDCAP WITH BEARING AND KEYPIN PRE-ASSEMBLED.



REMOVE SEAL RING AND DISCARD. REMOVE ROTOR; DISCARD FOR REBUILD BUT RETAIN FOR REPAIR.

> REMOVE AND DISCARD CARBON BEARING, SPRING RETAINING WASHER, AND COIL SPRING.



ASSY/TEST FIXTURES REQUIRED: UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN [] ARE IN MILLIMETERS. NONE WAS DA-074 030109 09/14 RMika

ECO DATE SIGN

WAUKEGAN, ILLINOIS, U.S.A. FOR DEUBLIN HPS SERIES UNIONS

0.31 - 0.74 (SHT 1 OF 2)

CONFIDENTIAL

REPAIR INSTRUCTIONS

FOR DEUBLIN HPS

SERIES UNIONS

DEUBLIN COMPANY

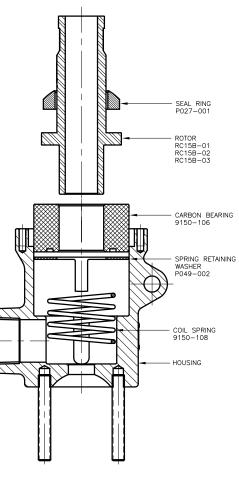
WAUKEGAN, ILLINOIS, U.S.A.

ASSEMBLY

ASSEMBLE COIL SPRING INTO BORE. ALIGN TABS ON SPRING RETAINING WASHER WITH GROOVES IN HOUSING AND PLACE ON TOP OF SPRING. PRESS DOWN A FEW TIMES TO VERIFY THAT WASHER CAN GLIDE TRAVEL FREELY WITH THE COMPRESSION OF THE SPRING.

ASSEMBLE BEARING WITH GROOVE SIDE DOWN INTO BORE. SLIDE ROTOR INTO BEARING. NOTE: FOR ROD SUPPORTED MODELS, ROTOR DOES NOT ENGAGE INTO BEARING; VISUALLY

ASSEMBLE SEAL WITH CONVEX SIDE UP AS SHOWN.



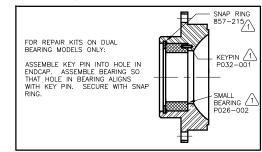
FOR DUAL BEARING UNIONS ONLY; ASSEMBLE BEARING INTO ENDCAP AS SHOWN IN

CLEAN COUNTERBORE IN HOUSING AND EDGE OF ENDCAP WHERE TEFLON GASKET WILL SIT WITH A LINT-FREE WIPE AND ALCOHOL. VERIFY SURFACES ARE CLEAN AND FREE OF LINT.

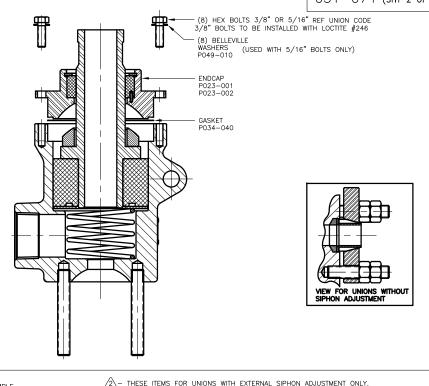
PLACE TEFLON GASKET INSIDE COUNTERBORE OF HOUSING.

ASSEMBLE ENDCAP INTO HOUSING BEING CAREFUL NOT TO PULL GASKET OFF CENTER. ALIGN HOLES IN ENDCAP AND HOUSING.

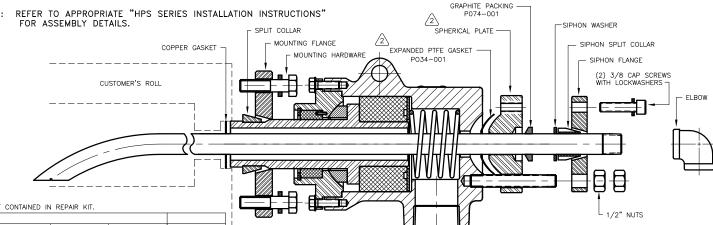
ASSEMBLE (8) BELLEVILLE WASHERS OR LOCTITE #246 AND (8) HEX BOLTS. TIGHTEN IN A CROSS PATTERN SUCCESSION, AND TORQUE TO 25 FT-LBS. NOTE: FOR ROD SUPPORTED UNIONS, ASSEMBLE FRONT ROD SUPPORT BRACKET FIRST (SEE INSTALLATION INSTRUCTIONS).



1 - THESE ITEMS FOR DUAL BEARING UNIONS (C15D-XXX) ONLY.



AFTER ENDCAP IS ASSEMBLED. PLACE COPPER GASKET IN JOURNAL PILOT. AND ASSEMBLE SIPHON PIPE INTO ROLL. MOUNT UNION ROTOR TO ROLL WITH SPLIT COLLAR AND FLANGE. ASSEMBLE REMAINING ITEMS AT REAR OF UNION.



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REVISION

"R" INDICATES REBUILD KIT ONLY; NOT CONTAINED IN REPAIR KIT.

OTY	ITEM	DESCRIPTION	PARTS CONTAINED IN MODELS:						
UI T	IIEM	DESCRIPTION	C15B-001-01-3F	C15D-001-02-3F	C15D-002-02-3A	C15D-003-02-3A	C15R-001-03-3F	C15R-002-03-3A	C15R-003-03-3A
1	P034-020	COPPER GASKET	X	X	X	X	X	X	X
1	RC15B-01	ROTOR, SINGLE BEARING	R						
1	RC15B-02	ROTOR, DUAL BEARING		R	R	R			
1	RC15B-03	ROTOR, ROD SUPPORTED					R	R	R
1	857-215	SNAP RING		X	X	X			
1	P026-002	CARBON BEARING		X	X	X		X	X
8	02-027	3/8" X 1" GRADE 8 HEX				X			X
	02-015	5/16" X 1" GRADE 8 HEX		X	X		X	X	
8	P049-010	BELLEVILLE WASHER	X	X	X		X	X	
1	P023-001	ENDCAP	R	R				R	R
1	P023-002	ENDCAP, DUAL BEARING			R	R	R		
1	P032-001	KEY PIN		X	X	X			
1	P027-001	SEAL	X	X	X	X	X	X	X
1	P034-040	TEFLON GASKET	Х	X	X	X	X	X	X
1	9150-106	CARBON BEARING	X	X	X	X	X	X	X
1	P049-002	SPRING RETAINING WASHER	X	X	X	X	X	X	X
1	9150-108	COIL SPRING	Х	X	X	X	X	X	X
1	P034-001	EXPANDED TEFLON GASKET	The state of the s		X	X		X	X
1	P074-001	GRAPHITE PACKING	X	X	X	X	X	X	X

EQUIPMENT REF: SONLE 1:2 SEE C DRM LG 06/21/01 EMBR LG 06/21/01 APPO ASSY/TEST FIXTURES REQUIRED: UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN [] ARE IN MILLIMETERS. NONE WAS DA-074 030109 09/14 RMika 0.31 - 0.74 (SHT 2 OF 2)

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