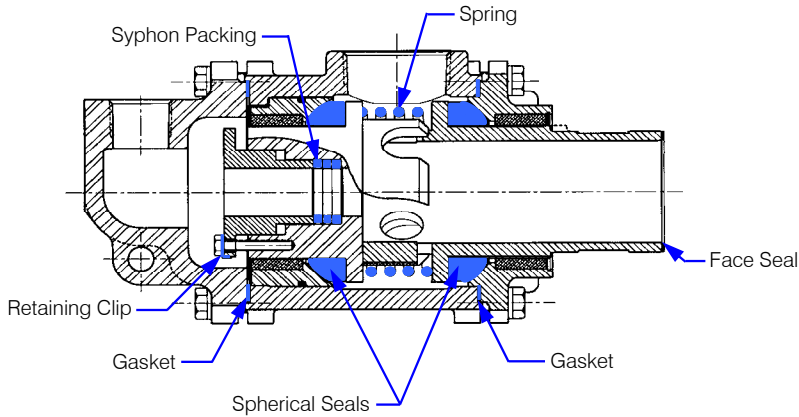
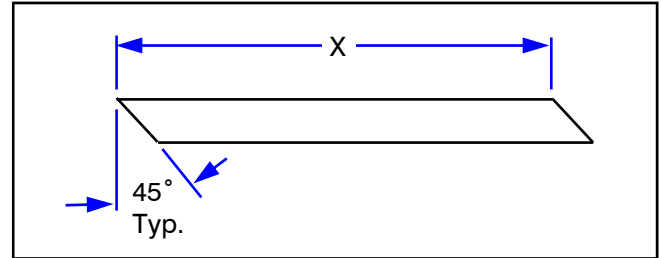


# DEUBLIN Type GR & GRX Repair Kit & Procedure



**Figure 3.** Syphon Packing Cutting Angle.



**Table 3.** Syphon Packing Cutting Lengths.

Pipe Size	3/4"	1"	1 1/4"	1 1/2"
X-Length	4.28"	5.00"	6.12"	6.75"

## REPAIR KIT

Repair kits for the Type GR & GRX rotary joint include : one face seal for quick release sleeve only; three syphon packings (see Table 3 for appropriate cutting lengths); two gaskets; three retaining clips; one spring; and two spherical seals.

### Repair Kit Part Numbers

Joint Size	GR	GRX
2"	10-64892-00	10-68451-00
2 1/2"	10-64893-00	10-69373-00
3"	N/A	10-68194-00

## REPAIR KIT INSTALLATION PROCEDURE

- CAUTION:** Relieve pressure from system and rotary joint before disconnecting hoses, removing rotary joint or disassembling joint.
- Disconnect hoses from inlet and outlet ports.
- Remove syphon cap and bend back retaining clip tab. Unscrew syphon plug cap screws to loosen syphon plug.
- Remove rotary joint from equipment.
- Remove front end cap.
- Remove sleeve and spring from the casing.
- Inspection and Parts Replacement:
  - End Cap Spherical Seal Seat—Inspect for wear and roughness. If it cannot be cleaned up smooth with light buffing, replace.
  - Spherical Seal—If seal is worn to the extent that it allows sleeve to come through end cap per maximum of the "X" Dimension, or if seal surfaces appear rough or chipped, replace.

- Sleeve—Inspect and be sure sealing face of shoulder is smooth and clean. Also, bearing areas must be smooth and not pitted.
  - Spring—Should be replaced when seal is replaced.
  - Syphon Packing—Refer to Table 3 for correct length and Figure 3 for proper cutting angle. Form Packing strip into a circle and place in joint.
- Be sure all sealing and mating surfaces are clean of all foreign particles.
  - Reassemble using new end cap gaskets. Draw up cap screws evenly so that sleeve does not become "cocked" in the casing.
  - Rotate the sleeve a few turns to lap sealing surfaces together.
  - In all cases, the rotary joint must be installed with flexible connections to allow it to float freely.



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### DEUBLIN USA

2050 Norman Drive, Waukegan, IL 60085-6747 USA  
 Phone: +1 847 689-8600 Fax: +1 847 689-8690  
 e-mail: [customerservice@deublin.com](mailto:customerservice@deublin.com)