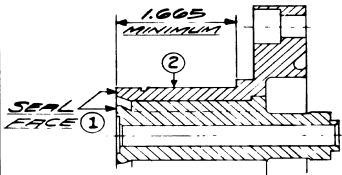


F				MATERIAL	SCALE 3/4"=1"	DEUBLIN COMPANY NORTHBROOK ILLINOIS MODEL 1500 UNION DISASSEMBLY PROCEDURE
E					DRAWN VSS	
D					DATE	
C					APP'D	
B					DATE	
A					ISSUED	
LET.	REVISION	DATE	SIGN	REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED REMOVE GREASE OR MACHINING OILS	TOLERANCES FRACTIONS ± .010 DECIMALS AS SPECIFIED	PART NO DA-11

When assembling the Model 1500 Deublin Union, cleanliness is an important factor. All parts must be free of dirt and chips. The parts may be cleaned with chloroethene, carbon tetra-chloride, alcohol or any good cleaning solvent.

Before assembly, the 1500-113 rotor seal face must be relapped or surface ground smooth to a 15 R.M.S. finish. If the dimension between the ball bearing stop and seal face is under 1.665 inch, the rotor must be replaced. Surface (1) must be square to (2) within .001 inch total indicator reading.



After grinding, the rotor seal face should be polished. This is done by placing a sheet of 4/0 polishing paper on a sheet of plate glass, and then placing the rotor (seal face down) on the polishing paper moving it in a figure eight several times.

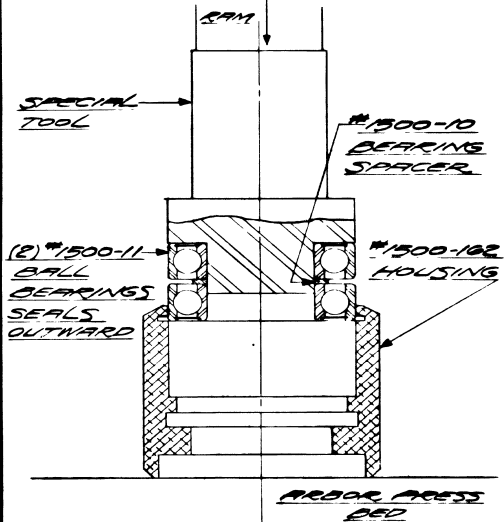
If possible, the polishing procedure should be replaced by machine lapping to 2 light bends flatness or better.

MODEL 1500 REPAIR KIT

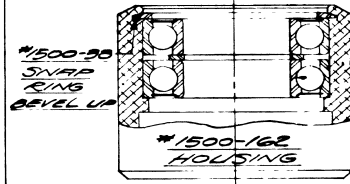
- (1) #1500-4 FLOATING SEAL
- (2) #1500-11 Ball Bearings
- (1) #1500-12 "O" Ring
- (1) #1500-16 Snap Ring
- (1) #1500-18 "O" Ring
- (1) #1500-19 Nose Gasket
- (1) #1500-34 Wave Spring
- (1) #1500-70 FLOATING SEAL
- (1) #1500-73 Coil Spring
- (2) #1105-14 Block "V" Seal

Pre-Assembled

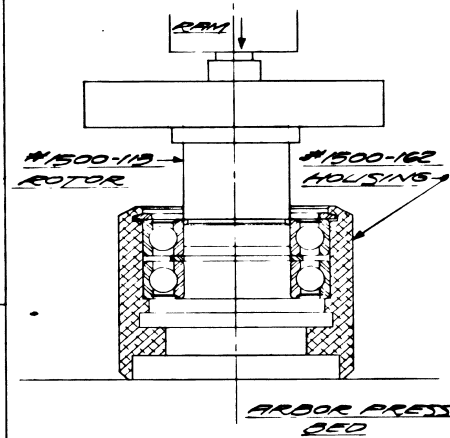
1 ASSEMBLE #1500-11 BALL BEARINGS AND #1500-10 BEARING SPACER.



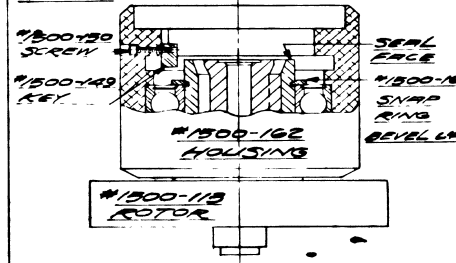
2 ASSEMBLE #1500-33 SNAP RING.



3 ASSEMBLE #1500-113 ROTOR. NOTE - ROTOR WILL SLIP IN UP TO THE SNAP RING GROOVE & MUST PRESS IN FROM THERE.

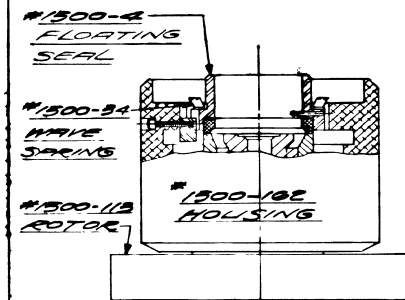


4 ASSEMBLE #1500-16 SNAP RING. (THIS IS A DIFFICULT OPERATION AND CARE MUST BE TAKEN NOT TO NICK THE SEAL FACE DURING INSTALLATION.) ASSEMBLE #1500-149 KEYS WITH LONG SECTION DOWN.

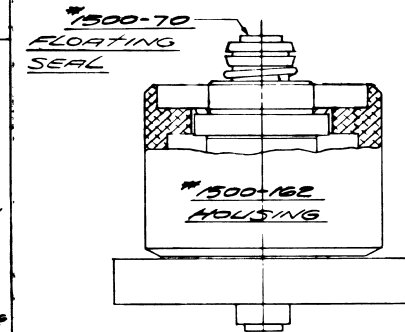


5 CLEAN SEAL FACES (SEAL FACES MUST BE FREE OF ALL DIRT AND DUST) #1500-113 ROTOR #1500-4 FLOATING SEAL #1500-70 FLOATING SEAL OIL ENTIRE #1500-113 ROTOR SEAL FACES (LIGHT VISCOSITY OIL)

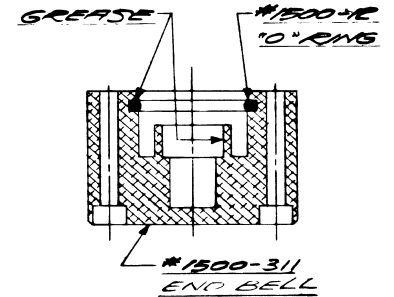
6 INSTALL #1500-4 FLOATING SEAL, #1500-34 WAVE SPRING



7 INSTALL #1500-70 FLOATING SEAL

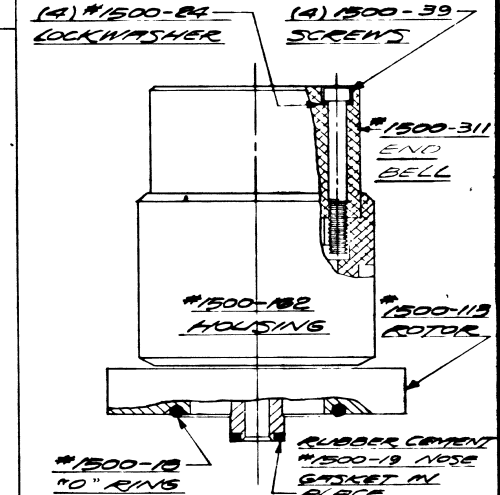


8 INSTALL #1500-12 "O" RING INTO #1500-311 END BELL, AND LUBRICATE WITH A LIGHT GREASE.



9 ASSEMBLE #1500-311 END BELL (HOLD DOWN WHILE TIGHTENING SCREWS). POSITION ENTRANCE PORTS AS ILLUSTRATED IN #1500 CROSS SECTION DRAWINGS.

INSTALL #1500-18 "O" RING IN ROTOR FLANGE & CEMENT #1500-19 NOSE GASKET IN PLACE.



		MATERIAL	SCALE 3/4" = 1"
F			DRAWN U.S.S.
E			DATE
D			APP'D
C			DATE
B			ISSUED
A			
REV.	REVISION	DATE SIGN	

DEUBLIN COMPANY NORTHBROOK ILLINOIS	
MODEL 1500 UNION	
ASSEMBLY PROCEDURE	
TOLERANCES FRACTIONS ± .010 DECIMALS AS SPECIFIED	PART NO DA-11