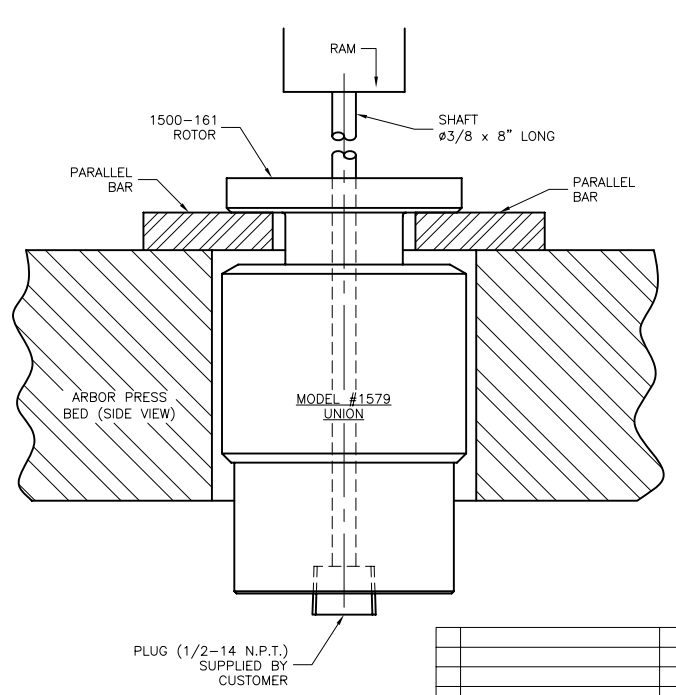


NOTE: CARE MUST BE TAKEN NOT TO NICK SEAL FACE IN REMOVING 1500-016 OR 1500-410 SNAP RING

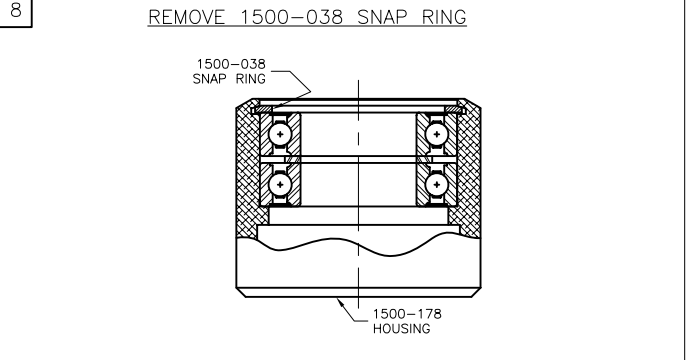
5 ASSEMBLE 1500-310 END BELL TO 1500-178 HOUSING, USING (4) 1500-039 SCREWS

6 PLUG 1500-310 END BELL AS SHOWN & REMOVE 1500-161 ROTOR FROM BEARINGS

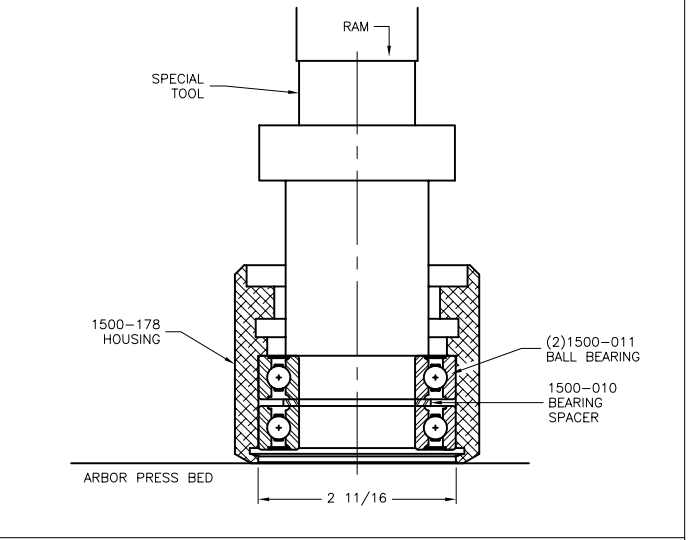


7 REMOVE 1500-310 END BELL

DA-16



9 REMOVE (2) 1500-011 BALL BEARINGS & 1500-010 BEARING SPACER



TOOLS REQUIRED

SPECIAL TOOL:
(MILD STEEL OR NYLON)

5/64" ALLEN WRENCH
3/32" ALLEN WRENCH
3/16" ALLEN WRENCH
#5 TRUARC PLIERS
#6 TRUARC PLIERS
(2) PARALLEL BARS (USED IN OPER. #6)

MATERIALS				SCALE	3/4=1" <small>ONE</small> C
LET.	REVISION	ECO	DATE	SIGN	DRW V.S.S.
F	REMOVED LEADER ARROW (PAGE 2 #3)		01/02	RM	
E	REDRAWN ON CAD. ADDED LOCTITE NOTE, AND SNAP RING 1500-410		1/99	MF	
			1/99	MF	

UNLESS OTHERWISE SPECIFIED:
1. UNTOLERANCED DIMENSIONS ±.010
2. MACHINED DIAS CONCENTRIC WITHIN .005 T.I.R.
3. COUNTERSINK TAPPED HOLES TO FIRST THREAD
4. REMOVE BURRS AND SHARP CORNERS .010 MAX
5. ANGLE TOLERANCE ± 1/2°
6. ALL DIMENSIONS ARE FINISHED
7. DIP PARTS IN CORROSION PREVENTATIVE OIL

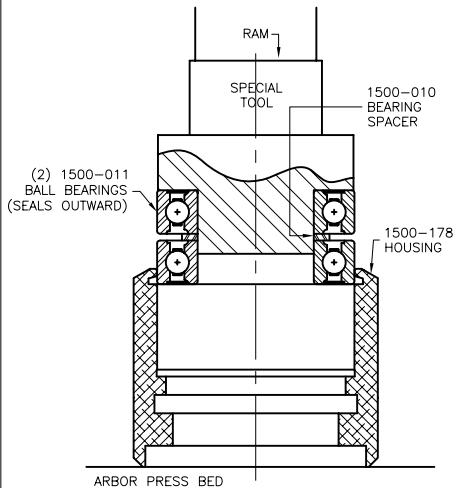
TITLE: MODEL 1579 UNION DISASSEMBLY PROCEDURE 1 OF 2
FINAL ASSY: C.A.D. DRAWING
NO. DA-16

DEUBLIN COMPANY
WAUKEGAN, ILLINOIS, U.S.A.

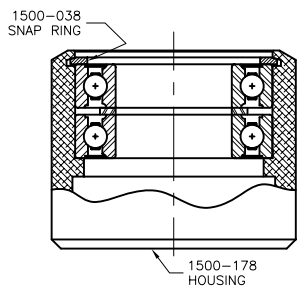
WHEN ASSEMBLING THE MODEL 1579 DEUBLIN UNION, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. THE PARTS MAY BE CLEANED WITH CHLOROTHENE, CARBON-TETRA-CHLORIDE, ALCOHOL, OR ANY GOOD CLEANING SOLVENT.

THE 1500-161 ROTOR MAY BE RE-USED IF THE CERAMIC SEAL FACE IS NOT SEVERELY WORN OR NICKED. A NEW ROTOR MAY BE PURCHASED FROM THE FACTORY IF REQUIRED.

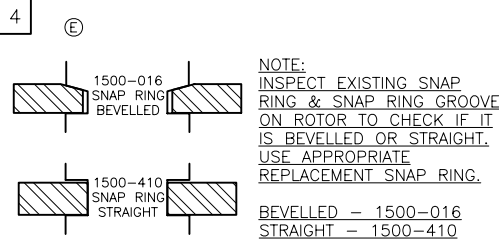
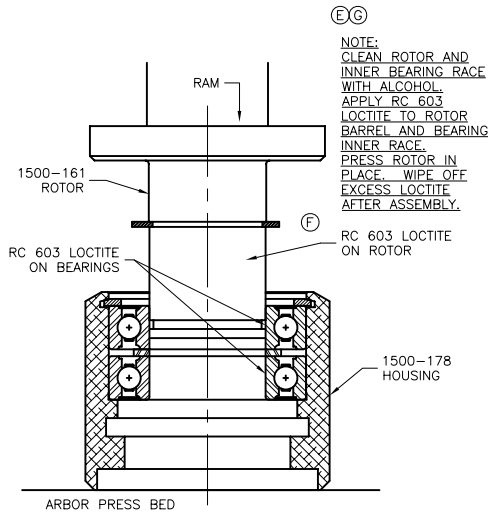
1 ASSEMBLE (2) 1500-011 BALL BEARINGS AND 1500-010 BEARING SPACER



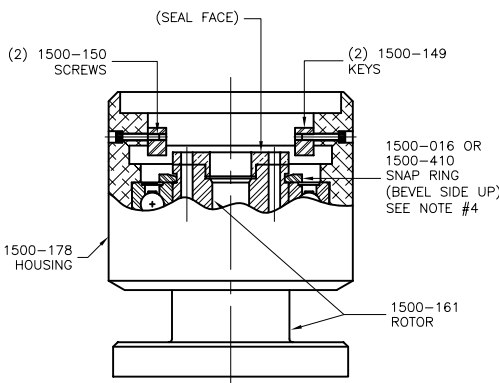
2 ASSEMBLE 1500-038 SNAP RING



3 ASSEMBLE 1500-161 ROTOR
NOTE: ROTOR WILL SLIP IN UP TO THE FIRST SNAP RING GROOVE & MUST PRESS IN FROM THERE



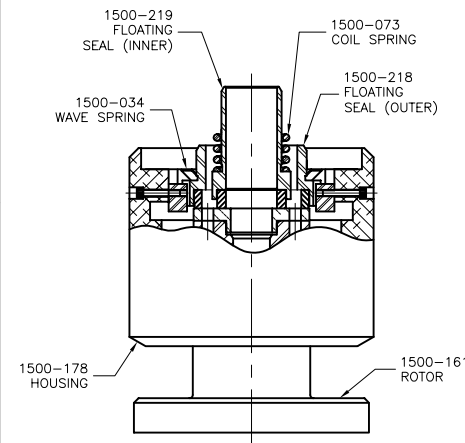
5 ASSEMBLE 1500-016 1500-410 SNAP RING, (THIS IS A DIFFICULT OPERATION AND CARE MUST BE TAKEN NOT TO NICK THE SEAL FACE DURING INSTALLATION). ASSEMBLE (2) 1500-149 KEYS WITH LONG SECTION DOWN.



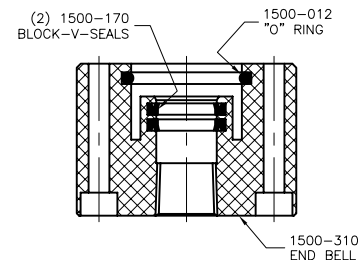
6 CLEAN SEAL FACES (SEAL FACES MUST BE FREE OF ALL DIRT AND DUST)
1500-161 ROTOR
1500-219 FLOATING SEAL (INNER)
1500-218 FLOATING SEAL (OUTER)

OIL ENTIRE 1500-161 ROTOR SEAL FACES (LIGHT VISCOSITY OIL)

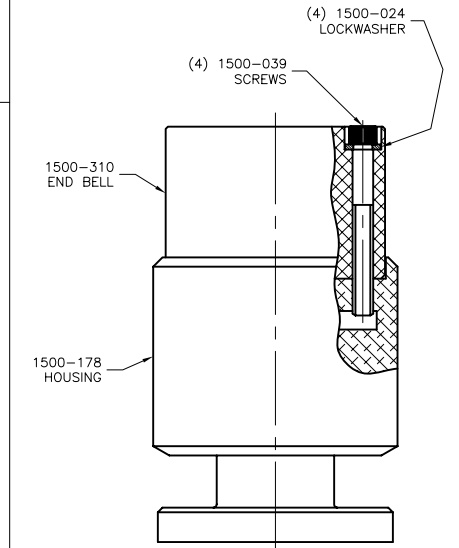
7 INSTALL 1500-218 FLOATING SEAL (OUTER), 1500-219 FLOATING SEAL (INNER), 1500-073 COIL SPRING & 1500-034 WAVE SPRING



8 INSTALL 1500-418 QUAD RING & (2) 1500-170 BLOCK-V-SEALS AS SHOWN



9 DA-16
ASSEMBLE 1500-310 END BELL (HOLD DOWN WHILE TIGHTENING SCREWS). POSITION ENTRANCE PORT AS DESIRED



10 TEST UNION WITH AIR PRESSURE BEFORE PERMANENT INSTALLATION

MODEL 1579 REPAIR KIT

- (1) 1500-410 QUAD RING
- (1) 1500-016 SNAP RING
- (1) 1500-034 WAVE SPRING
- (1) 1500-073 COIL SPRING
- (1) 1500-103 GASKET
- (2) 1500-170 BLOCK-V-SEAL
- (1) 1500-218 FLOATING SEAL
- (1) 1500-219 FLOATING SEAL
- (2) 1500-011 BALL BEARING

MATERIALS				SCALE	3/4-1"	DRW	V.S.S.	ENGR	APPD	DATE	C
G	ADDED ROTOR CLEANING TO INSTRUCTIONS	04/02	RM								
F	REMOVED LEADER ARROW (PAGE 2 #3)	01/02	RM								
E	REDRAWN ON CAD. ADDED LOCTITE	1/99	MF								
LET.	REVISION	ECO	DATE	SIGN	UNLESS OTHERWISE SPECIFIED:						
					1. UNTOLERANCED DIMENSIONS ±.010						
					2. MACHINED DIAS CONCENTRIC WITHIN .005 T.I.R.						
					3. COUNTERSINK TAPPED HOLES TO FIRST THREAD						
					4. REMOVE BURRS AND SHARP CORNERS .010 MAX						
					5. ANGLE TOLERANCE ± 1/2°						
					6. ALL DIMENSIONS ARE FINISHED						
					7. DIP PARTS IN CORROSION PREVENTATIVE OIL						

DEUBLIN COMPANY
WAUKEGAN, ILLINOIS, U.S.A.

TITLE: MODEL 1579 UNION
ASSEMBLY PROCEDURE
2 OF 2

FINAL ASSY: C.A.D. DRAWING
NO. DA-16