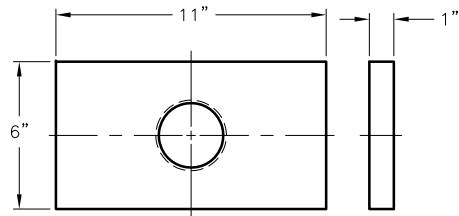
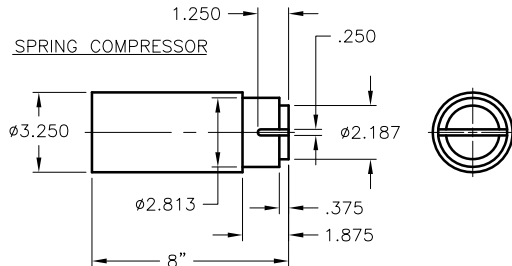


# TOOLING - BY CUSTOMER

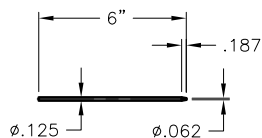
**ROTOR ASSEMBLY REMOVAL PLATE**



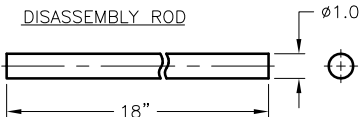
**SPRING COMPRESSOR**



**SPRING RETAINING PIN**

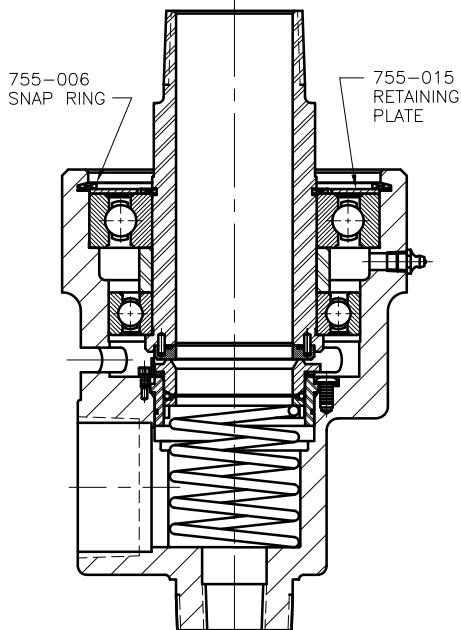


**DISASSEMBLY ROD**

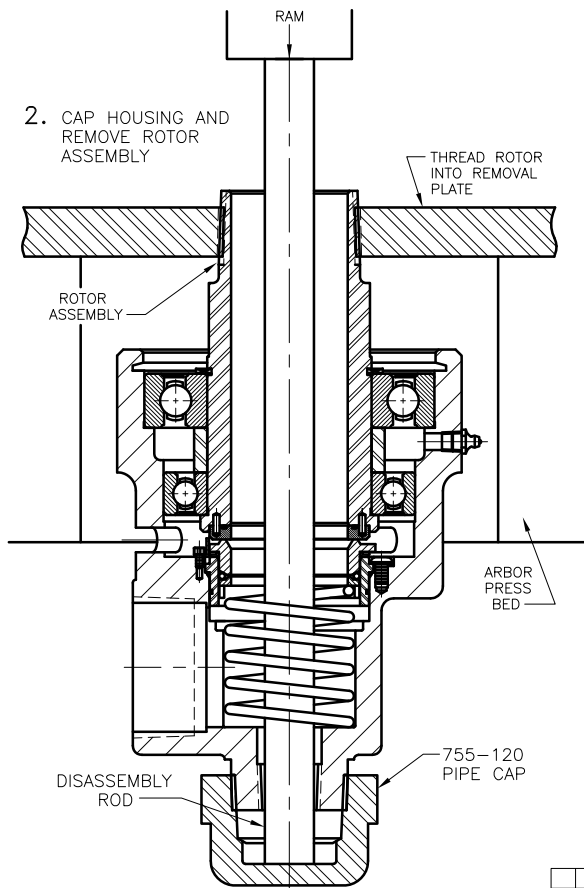


## DISASSEMBLY

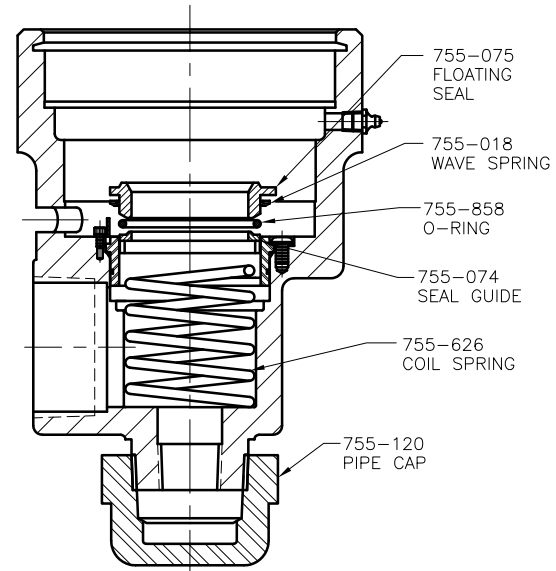
1. REMOVE HOUSING SNAP RING AND BEARING RETAINING PLATE



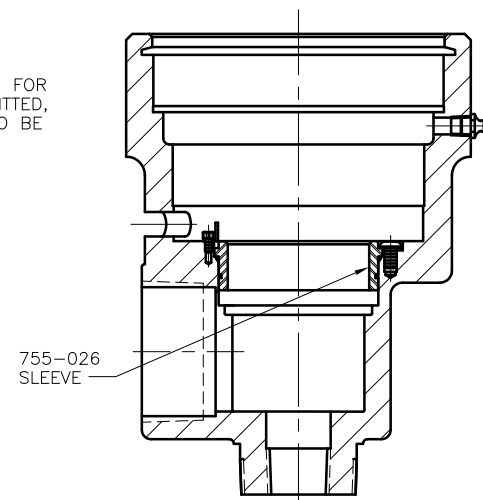
2. CAP HOUSING AND REMOVE ROTOR ASSEMBLY



3. REMOVE FLOATING SEAL, WAVE SPRING, O-RING, SEAL GUIDE, COIL SPRING, AND PIPE CAP.



4. CHECK SLEEVE I.D. FOR PITS. IF BADLY PITTED, PART WILL HAVE TO BE REPLACED.



EQUIPMENT REF:				SCALE	FULL	 DEUBLIN COMPANY WAUKEGAN, ILLINOIS, U.S.A.
				DRW	LG 08/18/07	
				ENGR	RMika 08/15/14	
				APPD		
ASSY/TEST FIXTURES REQUIRED:				UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN ( ) ARE IN MILLIMETERS.		TITLE: <b>755 SERIES REPAIR INSTRUCTIONS</b> NO. <b>031-043</b>
NO.	WAS DA-43	028324	08/14	RMika		
LET.	REVISION	ECO	DATE	SIGN		

# ASSEMBLY

PARTS MARKED WITH \* SUPPLIED WITH REPAIR KITS.

## REBUILDING KIT PARTS LIST

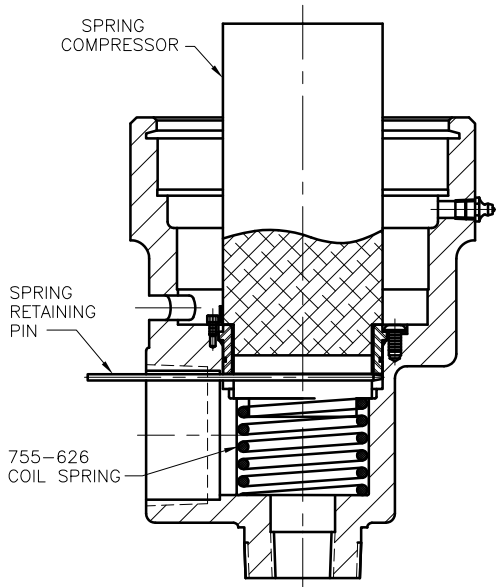
ROTOR ASSY (PRE-ASSEMBLED)

- \* 755-653 O-RING
- \* 755-296 SEAL
- 755-004 BALL BEARING
- 755-005 BALL BEARING
- 755-007 SNAP RING
- 755-008 BEARING SPACER
- 755-015 RETAINING PLATE
- \* 755-626 COIL SPRING
- \* 755-074 SEAL GUIDE
- \* 755-858 O-RING
- \* 755-018 WAVE SPRING
- \* 755-075 FLOATING SEAL
- 755-026 SLEEVE
- 755-022 O-RINGS

### NOTE:

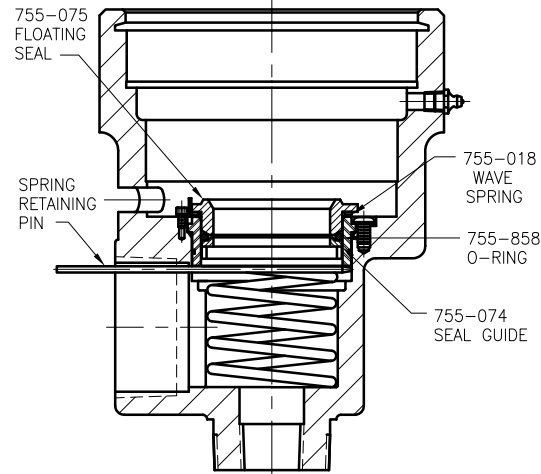
WHEN ASSEMBLING DEUBLIN UNIONS, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. THE PARTS MAY BE CLEANED WITH CARBON TETRA-CHLORIDE, DENATURED ALCOHOL, OR ANY GOOD CLEANING SOLVENT.

- GREASE BEARING BORE AND ASSEMBLE COIL SPRING. COMPRESS SPRING UNTIL RETAINING PIN CAN BE INSERTED THROUGH ENTRANCE PORT AS SHOWN; REMOVE SPRING COMPRESSOR.

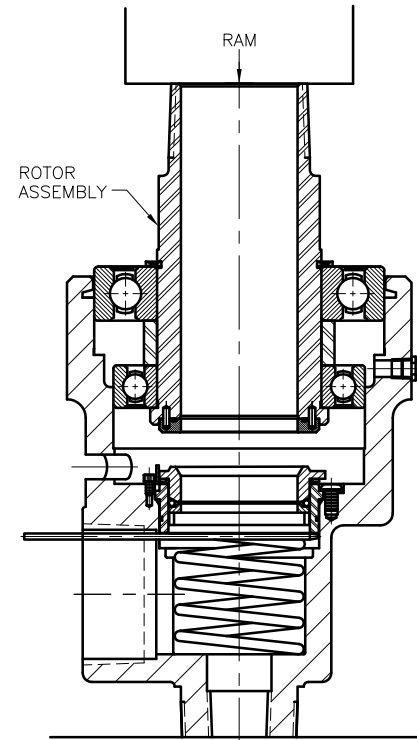


- CLEAN ROTOR CERAMIC SEAL FACE AND FLOATING SEAL FACE (SEAL FACES MUST BE FREE OF ALL DIRT AND DUST). OIL 755-075 FLOATING SEAL FACE WITH 20 WT. S.A.E. MOTOR OIL.

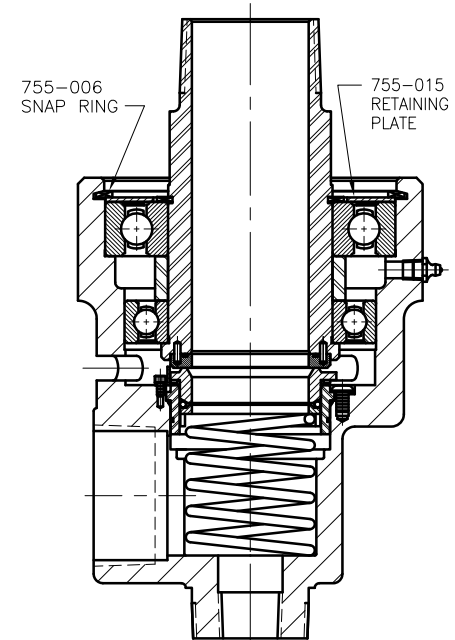
- ASSEMBLE SEAL GUIDE, O-RING, WAVE SPRING, AND FLOATING SEAL AS SHOWN



## 4. ASSEMBLE ROTOR ASSEMBLY



- ASSEMBLE BEARING RETAINING PLATE AND SNAP RING.



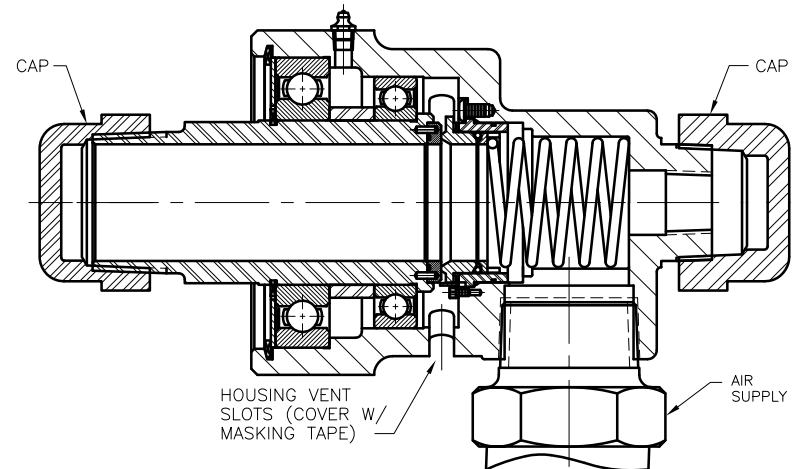
031-043

(SHT 2 OF 2)

## TESTING PROCEDURE

TEST UNION WITH 50 PSI MINIMUM AIR PRESSURE BEFORE PERMANENT INSTALLATION.

CAP ROTOR AND REAR ENTRANCE PORT. COVER HOUSING VENT SLOTS COMPLETELY WITH MASKING TAPE, THEN POKE A SMALL HOLE IN THE TAPE OVER ONE VENT SLOT. PUT SOAP WATER SOLUTION OR BUBBLE SOAP OVER HOLE IN TAPE. ROTATE UNION BY HAND. IF NO BUBBLE RISES, UNION IS O.K.



(SHT 2 OF 2)

EQUIPMENT REF:				SCALE	FULL	 <b>DEUBLIN COMPANY</b> WAUKEGAN, ILLINOIS, U.S.A.
				DRW	LG 08/18/97	
				ENGR	RMika 08/15/14	
				APPD		
ASSY/TEST FIXTURES REQUIRED:				UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN ( ) ARE IN MILLIMETERS.		<b>755 SERIES REPAIR INSTRUCTIONS</b> NO. <b>031-043</b>
ONE	WAS DA-43	028324	08/14	RMika		
LET.	REVISION	ECO	DATE	SIGN		CAD DRAWING