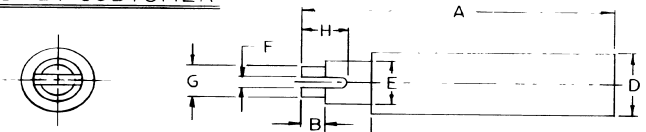


CONFIDENTIAL

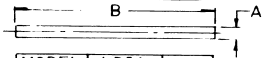
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TOOLING - BY CUSTOMER

SPRING COMPRESSOR



DISASSEMBLY ROD

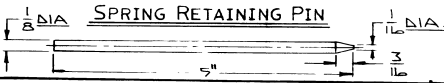


TRUARC PLIERS

MODEL	PLIERS NO.
057	3
157	5
257	5
357	5
527	5
557	5R

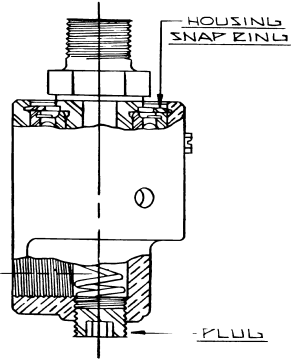
MODEL	A DIA.	B
057	5/16	5"
157	3/8	6"
257	1/2	7"
357	3/4	8"
527	1"	10"
557	1"	10"

MODEL	A	B	C	D	E	F	G	H
ⓐ 057	5"	3/8	1/2	3/4	.605	3/16	.475	1/2
ⓑ 157	6"	1/8	1/2	1"	.595	3/16	.465	1/2
Ⓒ 257	6"	1/8	1/2	1 1/4	.745	3/16	.490	1/2
Ⓓ 357	6"	3/16	7/8	1 3/4	.740	3/16	.480	1/2
Ⓔ 527	6"	3/16	1	2 1/4	.995	3/16	.740	1/2
Ⓕ 557	6"	3/16	1 1/8	2 1/8	1.435	1/4	.990	1/2
					1.430	1/4	.880	1/2
					1.570	1/4	1.210	1/2
					1.557	1/4	1.200	1/2
					1.867	1/4	1.420	1/2
					1.862	1/4	1.410	1/2



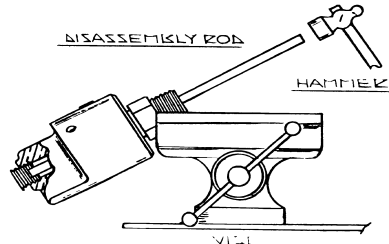
DISASSEMBLY

① REMOVE HOUSING SNAP RING AND PLUG HOUSING.

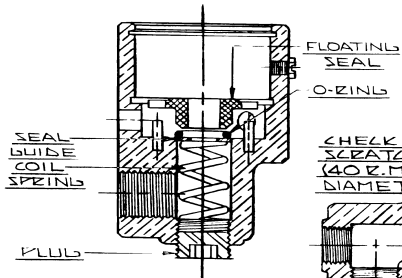


② RETAIN UNION BY CLAMPING ON ROTOR HEX WITH A VISE AND TAPPING DISASSEMBLY ROD WITH A HAMMER.

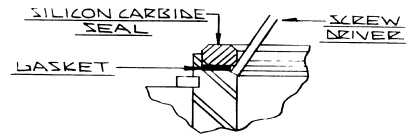
REMOVE ROTOR ASSEMBLY, AFTER REMOVING ROTOR ASSEMBLY CHECK BALL BEARINGS FOR WEAR OR DAMAGE, REPLACE IF REQUIRED.



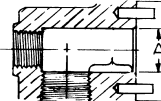
③ REMOVE FLOATING SEAL, O-RING, SEAL GUIDE, COIL SPRING AND PLUG.



④ REMOVE SILICON CARBIDE SEAL, BASKET AND DISCARD. CLEAN COUNTER BORE OF ROTOR.

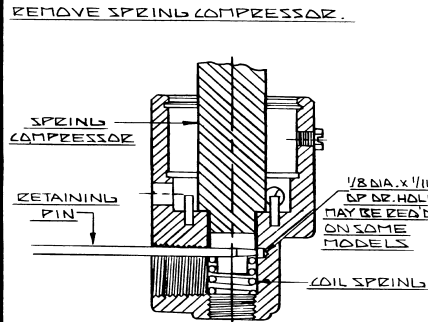


CHECK AREA OF BORE SHOWN FOR WEAR OR SCRATCHES. THE BORE MUST BE SMOOTH (40 R.M.S. MAX.) AND MAY BE ENLARGED TO THE DIAMETERS SHOWN IN CHART BELOW.

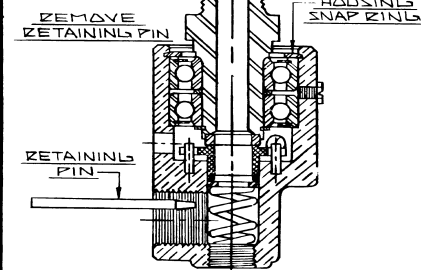


MODEL	A MAX.	MODEL	A MAX.
057	.629	527	1.574
157	.759	557	1.884
257	1.009	657	2.327
357	1.471		

① WITH SPRING COMPRESSOR, COMPRESS COIL SPRING INTO BORE UNTIL RETAINING PIN CAN BE INSERTED THROUGH ENTRANCE PORT AS SHOWN. REMOVE SPRING COMPRESSOR.



④ INSTALL HOUSING SNAP RING REMOVE RETAINING PIN.



IMPORTANT NOTE

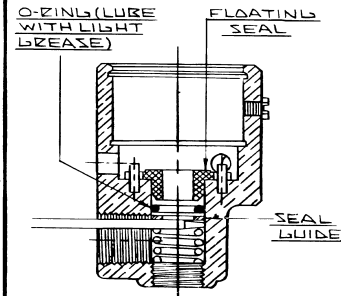
WHEN ASSEMBLING DEUBLIN UNIONS, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. PARTS MUST BE CLEANED WITH CLOROTHANE, CARBON TETRACHLORIDE, ALCOHOL OR ANY GOOD CLEANING SOLVENT.

REPAIR KIT PARTS LIST

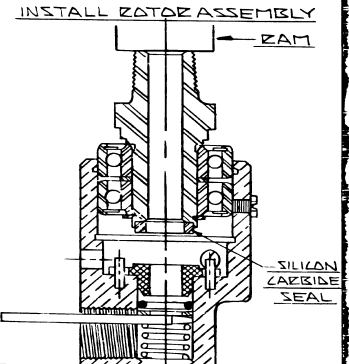
FLOATING SEAL, SILICON CARBIDE SEAL, BASKET, O-RING, SEAL GUIDE, COIL SPRING

② ASSEMBLE SEAL GUIDE, O-RING & FLOATING SEAL

NOTE: CLEAN FLOATING SEAL FACE AND LUBE WITH A LIGHT VISCOSITY OIL.

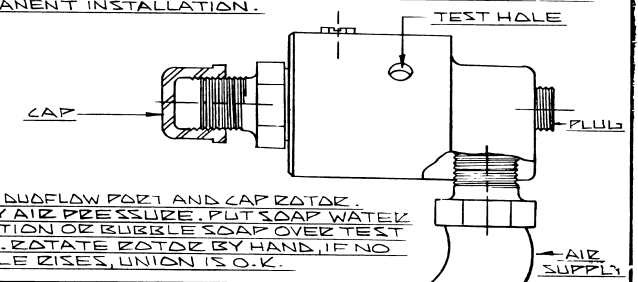


③ GREASE BEARING BORE OF HOUSING. INSTALL BASKET AND SILICON CARBIDE SEAL INTO NOTCHED FACE OF ROTOR (A SMALL AMOUNT OF GREASE ON THE SEAL & BASKET WILL HELP IN RETAINING PARTS ON ROTOR) CLEAN SILICON CARBIDE SEAL.



TESTING

TEST UNION WITH 50 P.S.I. MINIMUM AIR PRESSURE BEFORE PERMANENT INSTALLATION.



PLUG DOWNFLOW PORT AND CAP ROTOR. APPLY AIR PRESSURE. PUT SOAP WATER SOLUTION OR BUBBLE SOAP OVER TEST HOLE. ROTATE ROTOR BY HAND. IF NO BUBBLE RISES, UNION IS O.K.

NO.	REVISION	DATE	BY	CHKD.	APPROVED	MATERIAL	SCALE
1	WAS 1.457/1.452	8803/9/07	JK				DRAWN L.A.
2	WAS 2.227		TW				DATE 7/14/87
3	DIM CHANGES	1/81	AK				APP'D
4	ZEN DRAWN & REVISED		AK				

DEUBLIN COMPANY
NORTHBROOK, ILLINOIS U.S.A.
REPAIR INSTRUCTIONS FOR FIELD REPAIRABLE UNIONS

FILMED NO