# DISASSEMBLY/ASSEMBLY INSTRUCTIONS
## MODEL 857

**031-056**
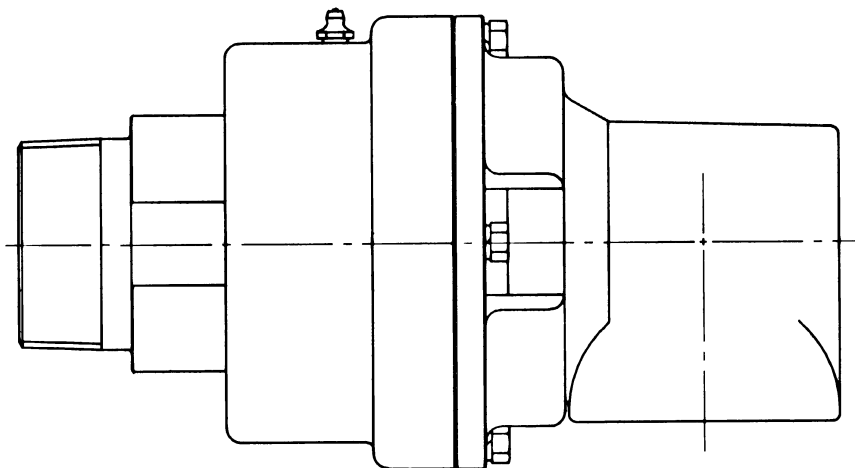


**REPAIR KIT PARTS LIST:**
FLOATING SEAL
SEAL PLATE
SEAL GUIDE
WAVE SPRING
O-RING (2)
SLINGER
SHOULDER SCREW (2)

IMPORTANT NOTE:
WHEN ASSEMBLING DEUBLIN UNIONS, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. PARTS MAY BE CLEANED WITH CHLOROTHANE, CARBON TETRACHLORIDE, ALCOHOL OR ANY GOOD CLEANING SOLVENT.
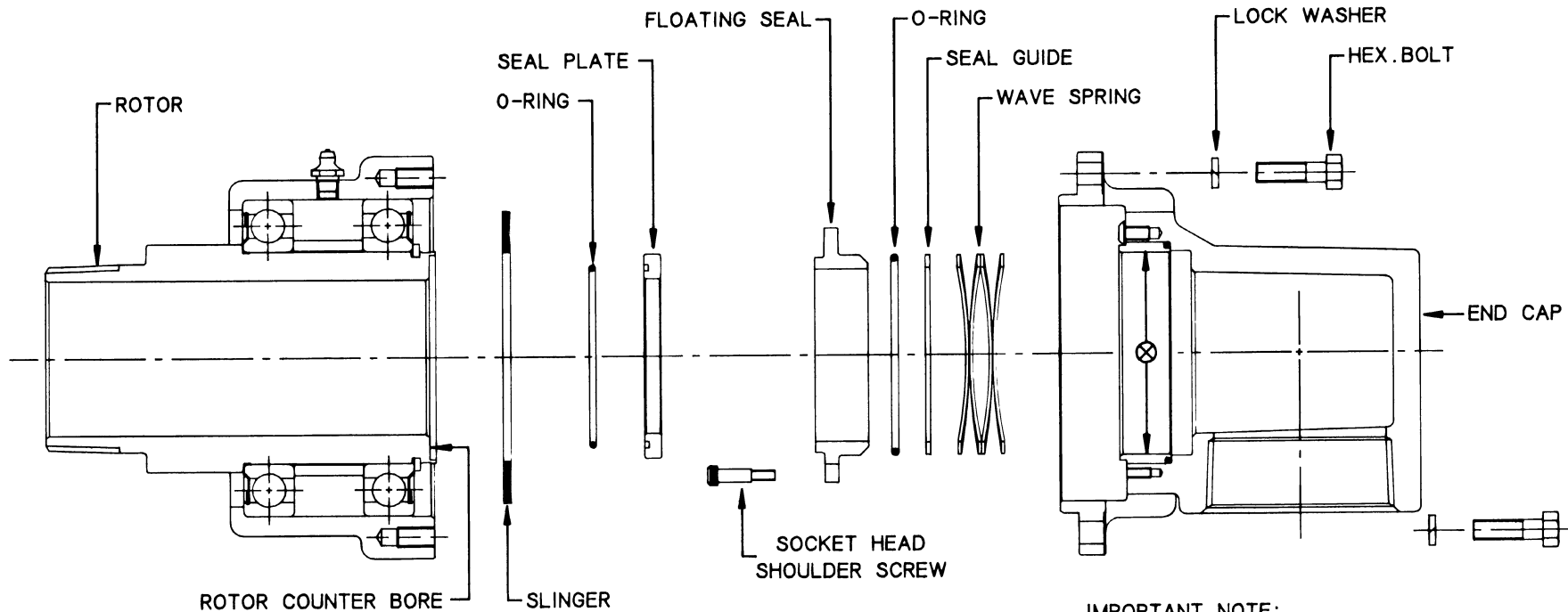
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| E | | | | | SCALE NONE | | |
| D | | | | | DRAWN GA 6/15/90 | | |
| C | | | | | ENGR GA 6/15/90 | | |
| B | | | | | APP D GA 6/15/90 | | |
| A | WAS DA-56 | 028324 | 8/14 | RM | UNTOLERANCED DIMENSIONS ± 010 DECIMALS AS SPECIFIED DIMENSIONS IN ( ) ARE IN MILLIMETERS | | |

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# DISASSEMBLY

REMOVE (4) HEX.BOLTS AND LOCK WASHERS AND
RETAIN FOR RE-ASSEMBLY.
REMOVE END CAP AND SET ASIDE.
REMOVE SEAL PLATE AND O-RING FROM FACE OF
ROTOR AND DISCARD.
REMOVE SLINGER AND DISCARD
CLEAN COUNTER BORE OF ROTOR
REMOVE (2) SOCKET HEAD SHOULDER SCREWS FROM
END CAP AND DISCARD.
REMOVE FLOATING SEAL, O-RING, SEAL GUIDE, WAVE
SPRING AND DISCARD

IMPORTANT NOTE:
CHECK BORE MARKED $\otimes$ FOR WEAR OR SCRATCHES.
THE BORE MUST BE SMOOTH. (40 R.M.S.MAX.)
IF REWORK IS REQUIRED, USE EMORY PAPER TO
CLEAN THIS BORE.

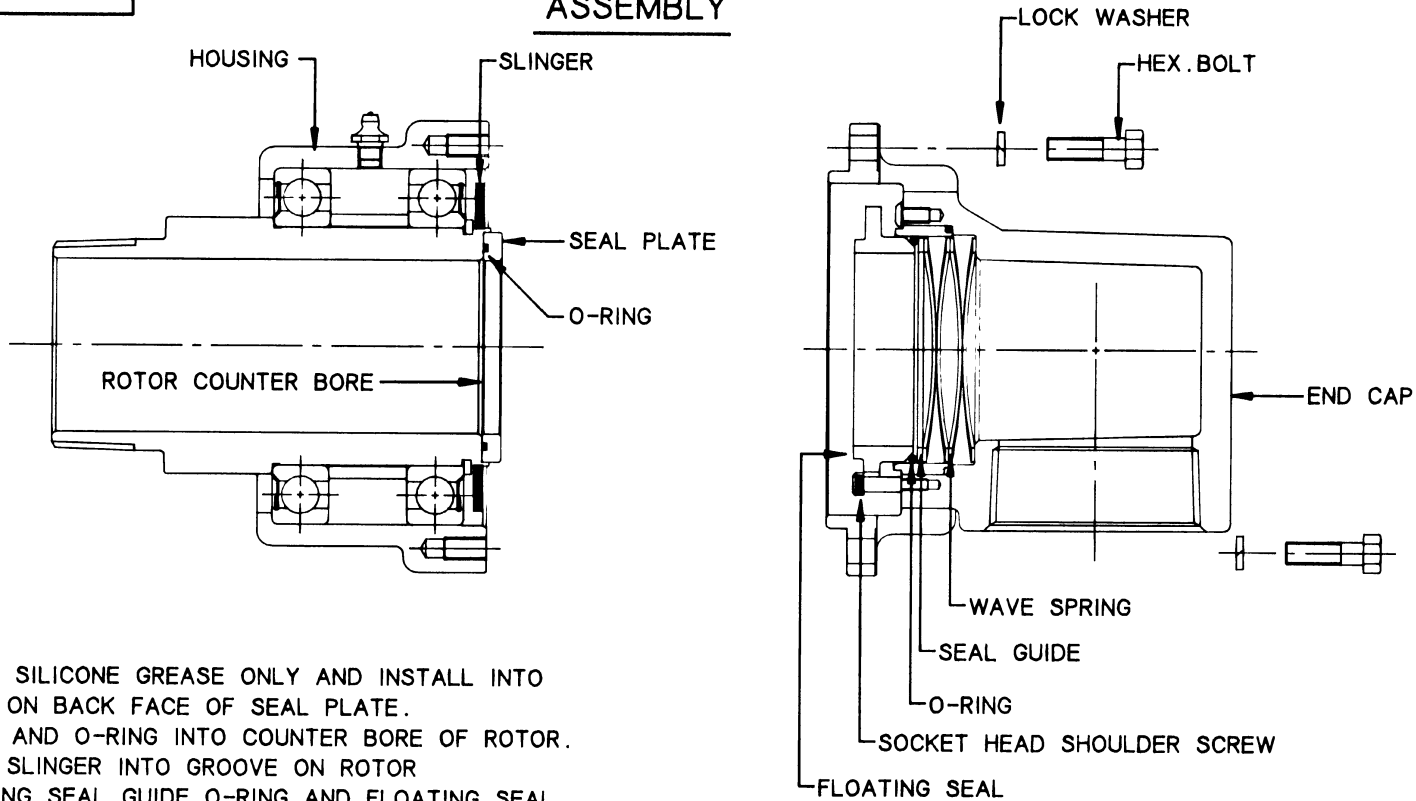| LET | REVISION | ECO | DATE | SIGN | | |
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## ASSEMBLY

HOUSING — ┌SLINGER
LOCK WASHER
┌HEX.BOLT

—SEAL PLATE

—O-RING

ROTOR COUNTER BORE —

END CAP

—WAVE SPRING

—SEAL GUIDE

—O-RING

—SOCKET HEAD SHOULDER SCREW

—FLOATING SEAL

LUBE O-RING WITH SILICONE GREASE ONLY AND INSTALL INTO
GROOVE ON BACK FACE OF SEAL PLATE.
INSTALL SEAL PLATE AND O-RING INTO COUNTER BORE OF ROTOR.
INSTALL SLINGER INTO GROOVE ON ROTOR
INSTALL WAVE SPRING, SEAL GUIDE, O-RING, AND FLOATING SEAL
INTO END CAP (LUBE O-RING WITH SILICONE GREASE ONLY)
INSTALL (2) SOCKET HEAD SHOULDER SCREWS INTO END CAP
THRU SLOTS ON THE FLOATING SEAL AND TIGHTEN
EVENLY UNTIL BOTTOMING.
CLEAN FACES OF BOTH THE SEAL PLATE AND THE FLOATING SEAL
AND LUBE BOTH WITH A LIGHT VISCOSITY OIL.
PLACE END CAP GENTLY ONTO HOUSING AND TIGHTEN DOWN
HEX.BOLTS AND LOCK WASHERS EVENLY.
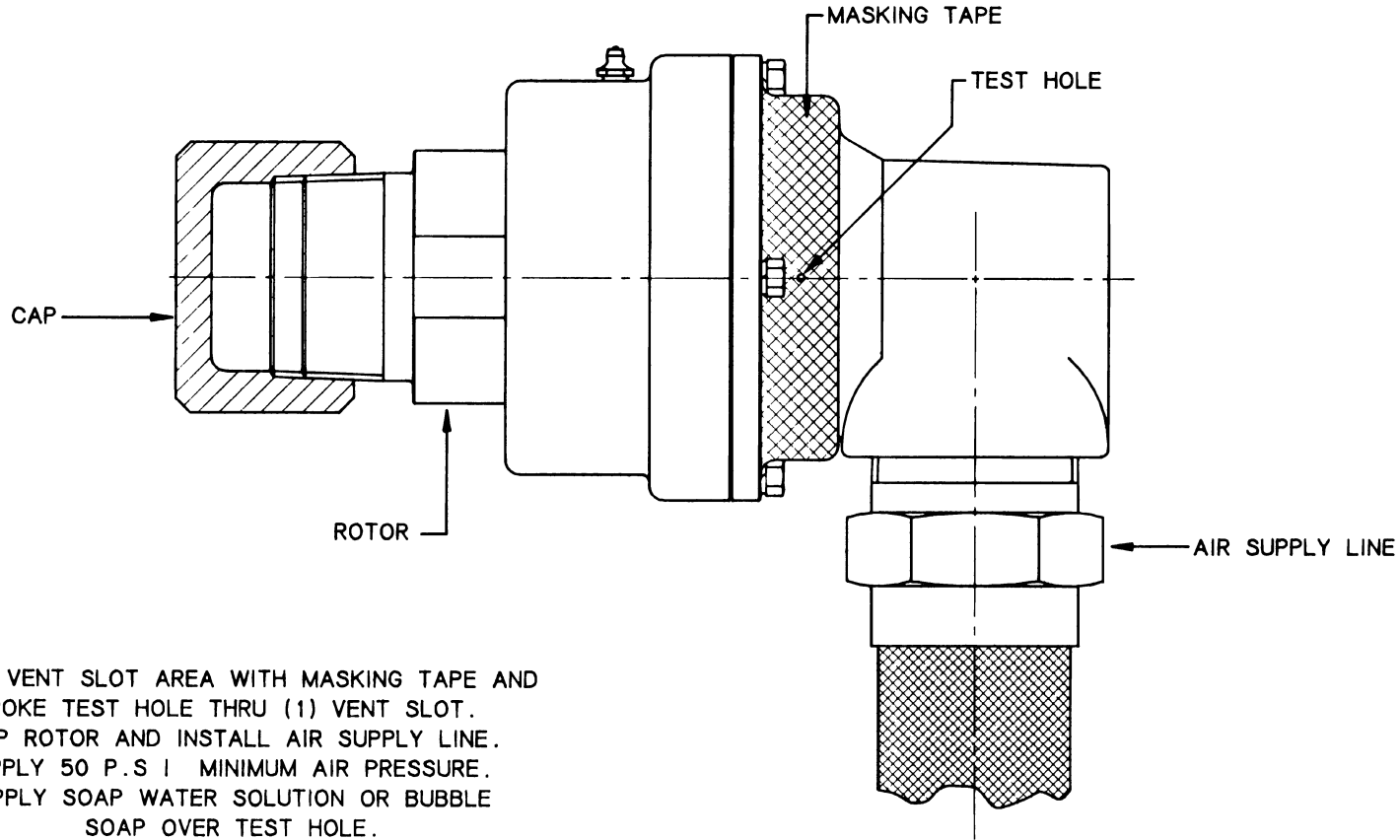(NOTE: TORQUE HEX.BOLTS TO 20-30 FT.LBS.)

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| E | | | | | SCALE  NONE | |
| D | | | | | DRAWN  GA 6/15/90 | |
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| B | | | | | APP D  GA 6/15/90 | NO |
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MASKING TAPE

TEST HOLE

CAP

ROTOR

AIR SUPPLY LINE

MASK VENT SLOT AREA WITH MASKING TAPE AND
POKE TEST HOLE THRU (1) VENT SLOT.
CAP ROTOR AND INSTALL AIR SUPPLY LINE.
APPLY 50 P.S I  MINIMUM AIR PRESSURE.
APPLY SOAP WATER SOLUTION OR BUBBLE
SOAP OVER TEST HOLE.
ROTATE ROTOR BY HAND. IF NO BUBBLE RISES,
UNION IS O.K.

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EQUIPMENT REF

SCALE   NONE
DRAWN  GA 6/15/90
ENGR   GA 6/15/90
APP D   GA 6/15/90
UNTOLERANCED DIMENSIONS ± 010
DECIMALS AS SPECIFIED
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