

**DISASSEMBLY**

\*\*THESE INSTRUCTIONS CAN BE USED TO REPAIR EITHER 927-150-151/-152 OR 927-130-176/-177.

NOTE: UNION 927-150-151/-152 HAS THE FOLLOWING PARTS INCLUDED IN THE REPAIR KIT:

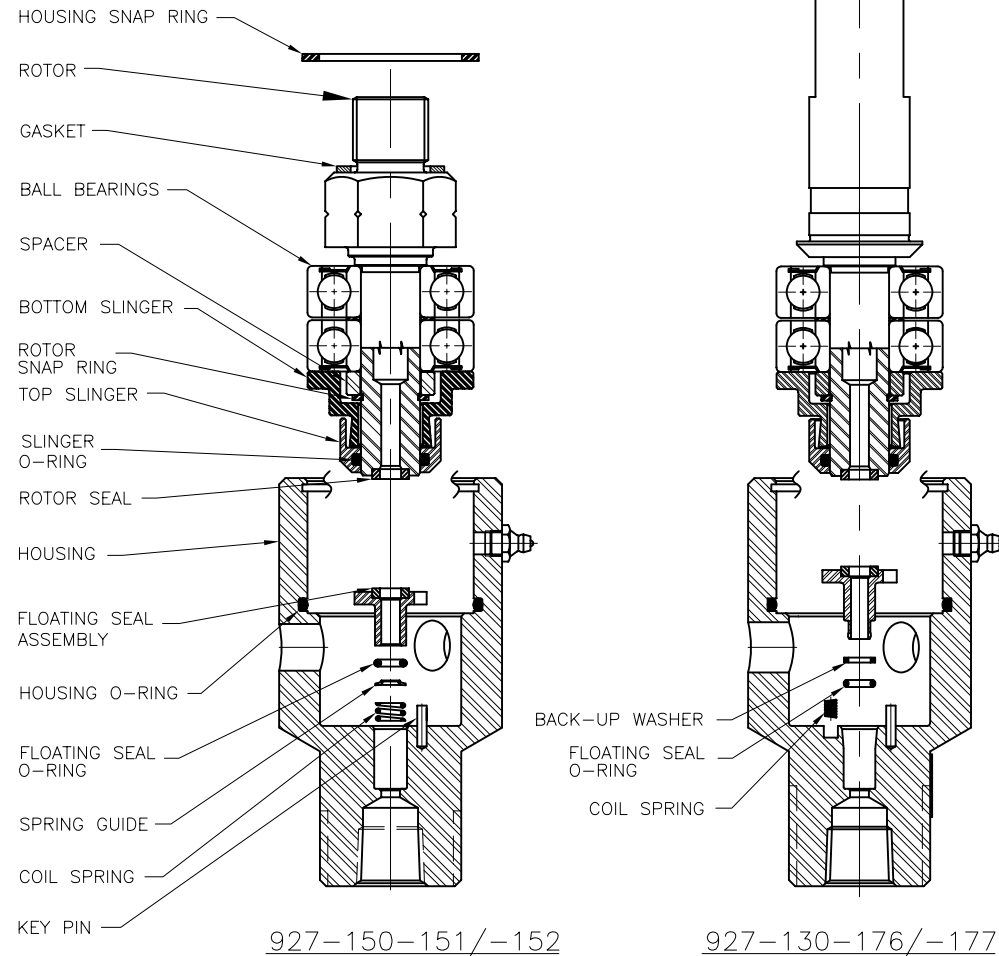
- BEARING SNAP RING
- SLINGER O-RING
- GASKET
- HOUSING O-RING
- FLOATING SEAL O-RING
- COIL SPRING
- SPRING GUIDE
- BALL BEARING (2)

UNION 927-130-176/-177 HAS THE FOLLOWING PARTS INCLUDED IN THE REPAIR KIT:

- BEARING SNAP RING
- SLINGER O-RING
- GASKET
- HOUSING O-RING
- FLOATING SEAL O-RING
- BACK-UP WASHER
- COIL SPRINGS (3)
- BALL BEARING (2)

1. REMOVE HOUSING SNAP RING ON END OF HOUSING AND REMOVE ROTOR ASSEMBLY INCLUDING BEARINGS, SPACER, SLINGERS, AND SLINGER O-RING.
2. REMOVE ROTOR ASSEMBLY INCLUDING BEARINGS, SPACER, SLINGERS, AND SLINGER O-RING
3. REMOVE FLOATING SEAL ASSEMBLY, SPRING GUIDE (OR BACK-UP WASHER, DEPENDING ON UNION MODEL), FLOATING SEAL O-RING, COIL SPRING(S), AND HOUSING O-RING.

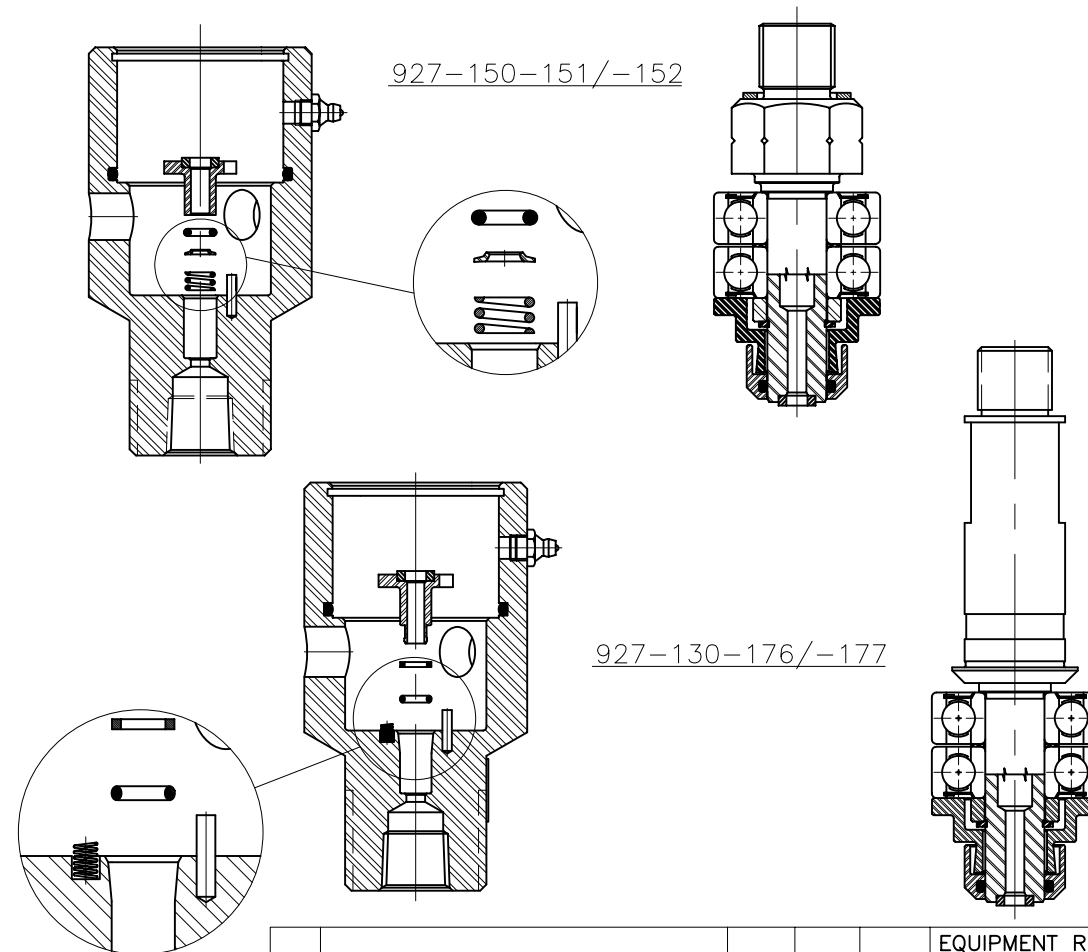
NOTE: ONLY PARTS THAT ARE DIFFERENT FROM THE 927-150-151/-152 ARE LABELED ON THE 927-130-176/-177 BELOW FOR CLARITY.



**ASSEMBLY**

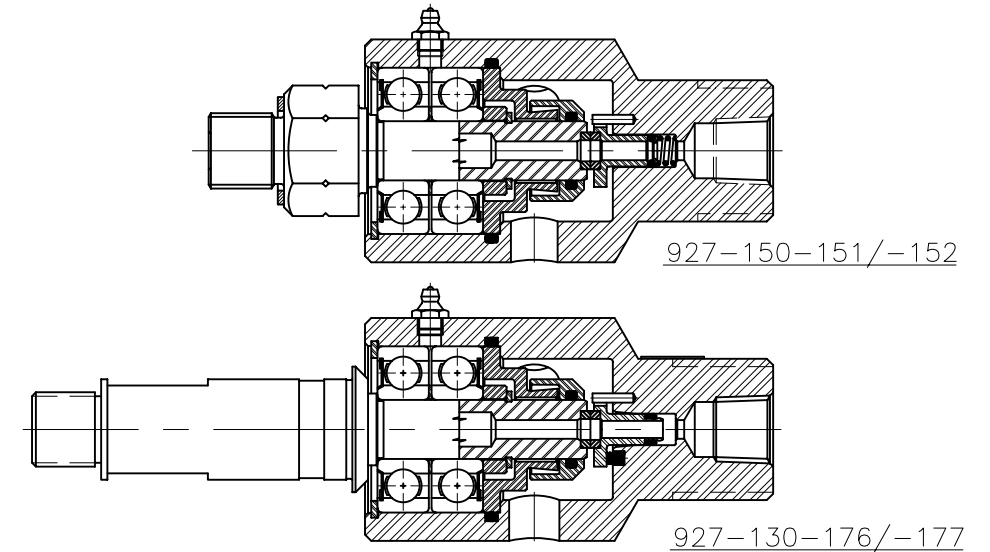
NOTE: WHEN ASSEMBLING DEUBLIN UNIONS CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. THE PARTS MAY BE CLEANED WITH CARBON TETRA-CHLORIDE, DENATURED ALCOHOL, OR ANY GOOD SOLVENT.

1. PLACE HOUSING ON END, PROTECTING THREADS. LUBRICATE NEW HOUSING O-RING WITH PARKER O-RING LUBE OR EQUIVALENT AND INSERT INTO HOUSING AS SHOWN.
- 2A. FOR 927-150-151/-152: CLEAN INTERIOR OF HOUSING, INCLUDING FLOATING SEAL BORE. INSERT NEW COIL SPRING INTO FLOATING SEAL BORE AND PLACE SPRING GUIDE ON TOP OF COIL SPRING. MAKE SURE FLAT SIDE OF SPRING GUIDE IS IN CONTACT WITH COIL SPRING. LUBRICATE NEW FLOATING SEAL O-RING WITH PARKER O-RING LUBE OR EQUIVALENT AND PLACE O-RING ONTO SPRING GUIDE.
- 2B. FOR 927-130-176/-177: CLEAN INTERIOR OF HOUSING, INCLUDING FLOATING SEAL BORE. INSERT NEW COIL SPRINGS INTO HOUSING. LUBRICATE NEW BACK-UP WASHER AND FLOATING SEAL O-RING WITH PARKER O-RING LUBE OR EQUIVALENT. PLACE BACK-UP WASHER ONTO SHAFT OF FLOATING SEAL THEN PLACE O-RING ON TOP OF BACK-UP WASHER.
3. CLEAN FLOATING SEAL FACE WITH ALCOHOL AND LINT FREE TISSUE OR SIMILAR, AND INSERT FLOATING SEAL ASSEMBLY INTO HOUSING BORE WITH KEY PIN IN SLOT OF FLOATING SEAL.
4. LUBRICATE SURFACE OF FLOATING SEAL WITH A FEW DROPS OF LIGHT VISCOSITY OIL.
5. CLEAN SEAL FACE OF ROTOR SEAL WITH ALCOHOL AND LINT FREE TISSUE OR SIMILAR.
6. INSERT ROTOR ASSEMBLY INCLUDING BEARINGS, SPACER, SLINGERS, AND SLINGER O-RING BEARING SNAP RING INTO GROOVE ON ROTOR SHAFT.
7. INSERT SNAP RING INTO HOUSING GROOVE.



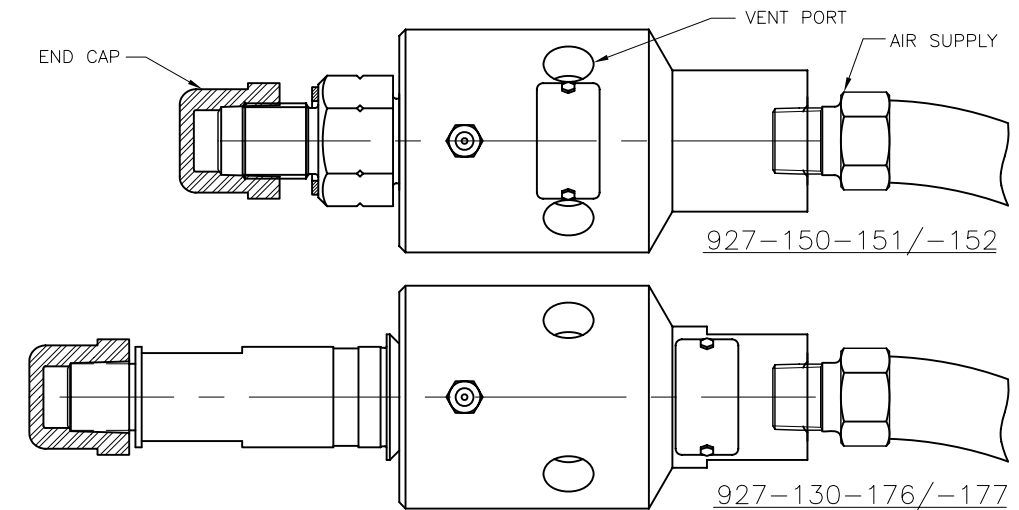
THE COMPLETED ASSEMBLY OF EACH UNION IS SHOWN BELOW:

DA-061



**TESTING**

1. CAP ROTOR CONNECT INLET TO AIR SUPPLY.
2. USING MASKING TAPE, COVER ALL BUT ONE VENT PORT.
3. APPLY AIR PRESSURE AT APPROX. 100 PSI FOR TWO MINUTES.
4. BRUSH SOAP WATER SOLUTION OVER VENT HOLE. IF NO BUBBLES ARISE FROM VENT HOLE, UNION IS NOT LEAKING. ROTOR CAN BE HAND-TURNED WHILE CHECKING FOR LEAKS.



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

TITLE: REPAIR INSTRUCTIONS  
927-150-151/152  
927-130-176/177

NO. C.A.D DRAWING

DA-061

LET.	REVISION	ECO	DATE	SIGN

EQUIPMENT REF:	SCALE	1:2	DWG SIZE	B
	DRN	JW	08/09/05	
	ENGR	JW	08/09/05	
	APPD	JW	08/09/05	
ASSY/TEST FIXTURES REQUIRED:	UNLESS SPECIFICALLY TOLERANCED, ALL DIMENSIONS ARE REFERENCE			
	DIMENSIONS IN [ ] ARE IN MILLIMETERS.			