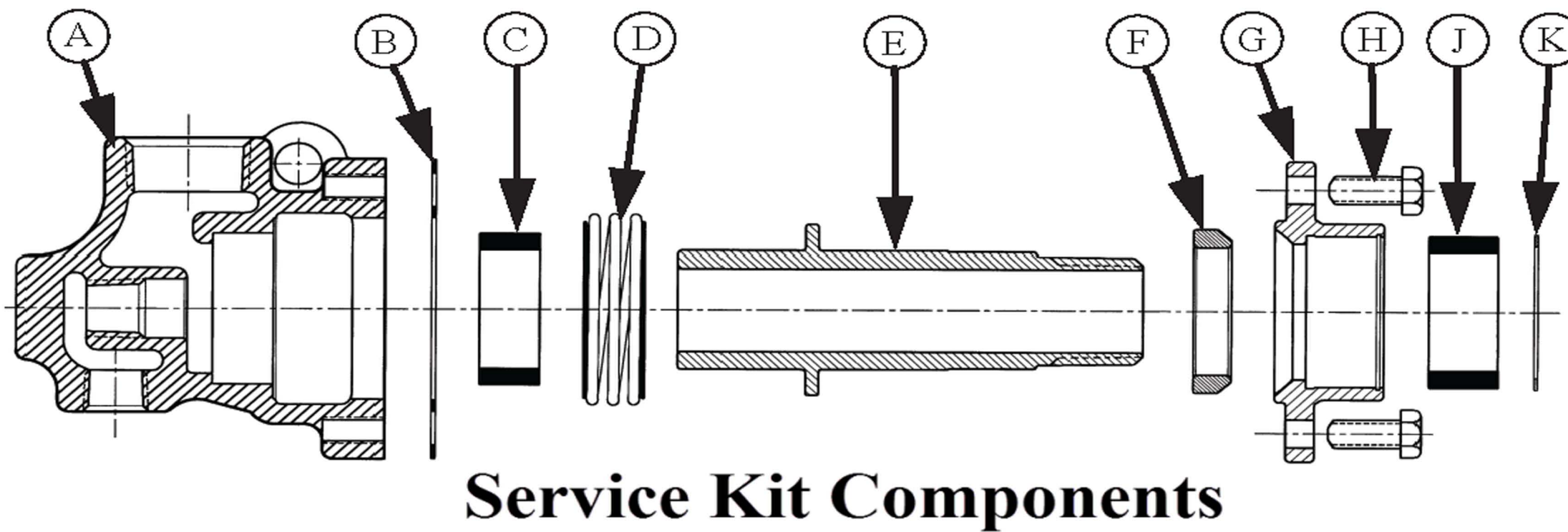


DEUBLIN Type "C" & "G"

Rotary Joint Repair Kits & Repair Procedure

DOCUMENT: 031-537



Cast Iron Housing	A	Spherical Carbon Seal	*F
Grafoil Gasket	*B	Ferrous / Bronze End Cap	**G
Carbon Bearing	**C	Cap Screw	H
Stn. Stl. Spring & Spring Guides	*D	Carbon Bearing	**J
Ferrous/Bronze Rotor	**E	Stn. Stl. Retaining Ring	K

- * Items In Service Kits
- **Additional Items In Service Kit Plus (Contact Deublin Company For Part Numbers)

Repair Procedure

Please refer to illustration above.

- 1 - Remove joint from equipment.
- 2 - Remove cap screws - Part H.
- 3 - Remove Rotor (E), End Cap (G), Spherical Carbon Seal (F) and Spring and Spring Guides (D) From Casing (A).
- 4 - Inspection and Parts Replacement Procedure.
 - Part G—End Cap should be inspected for wear and roughness.
 - Part F—Spherical Carbon Seal—If carbon seal is worn to the extent that it allows Rotor to come through end cap per maximum of dimension "X" or if seal surfaces appear rough or chipped, replace.
 - Part E—Inspect Rotor to be sure sealing face of shoulder is smooth and clean. Also, bearing areas must be smooth and not pitted. (If it cannot be cleaned up smooth with light buffing, replace).
 - Part D—Spring and Spring Guides should be replaced when seal is replaced.
 - Parts C & J—Carbon Bearings—If bearings in housing and end cap are worn with resulting sloppy fit on the sleeve, they should be replaced. These bearings may be purchased as part of either the end cap or housing assemblies.
 - Parts A & G—or the Bearings—Part C & J can be purchased separately and are easily shrunk in by first heating evenly the end cap or housing in an oven, and then dropping the carbon bearings into place. (Do not try to heat with a torch: this will warp the housing).
- 5 - Be sure all the sealing and mating surfaces are clean of all foreign particles.
- 6 - Reassembly using a new gasket—Part B. Draw up cap screws evenly so that housing does not become "cocked" in housing.
- 7 - Rotate Rotor a few turns to lap sealing surfaces together.
- 8 - In all cases—joint must be installed with flexible connection to allow it to float freely.
- 9 - Tie rods (if used for holding joints) must not restrict "free floating" action.

Type "C" Service Kit

Type	Joint Size	Part Number
"C"	1/2"	BC-54KIT-08
	3/4"	BC-54KIT-12
	1"	BC-54KIT-16
	1-1/4"	BC-54KIT-20
	1-1/2"	BC-54KIT-24
	2"	BC-54KIT-32
	2-1/2"	BC-54KIT-40
	3"	BC-54KIT-48

Type "G" Service Kit

Type	Joint Size	Part Number
"G"	1-1/4"	10-64571-00
	1-1/2"	10-64572-00
	2"	10-64573-00



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