

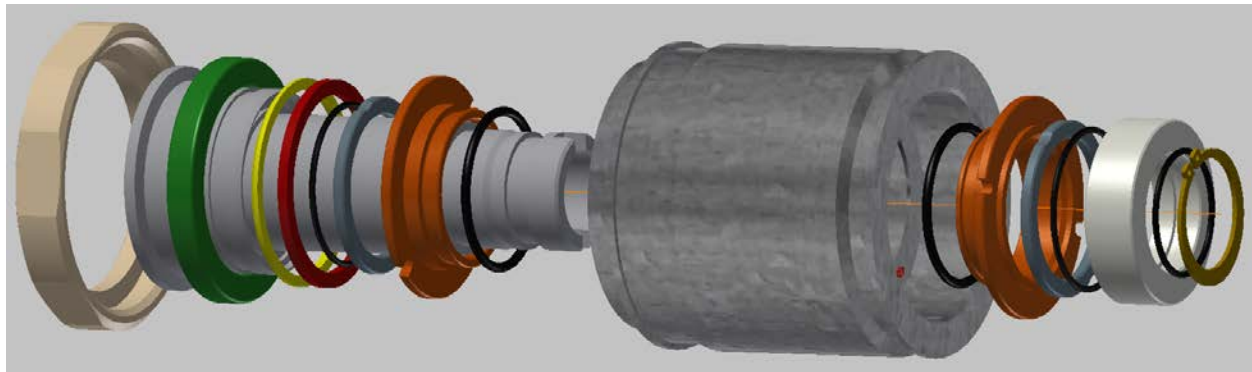
DEUBLIN®

Repair & Maintenance
Manual Instructions

ISSUE	MOD	ECO	DATE	SIGN
NONE	SEE ECO	041310	02/17	BN

032-3009

Repair Manual



20607-175

DEUBLIN Company

2050 Norman Drive

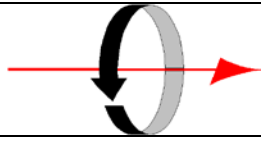
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Please read this instruction manual carefully and thoroughly before repairing the **DEUBLIN** Rotating Union. This instruction manual contains important information about proper repair procedure and maintenance.

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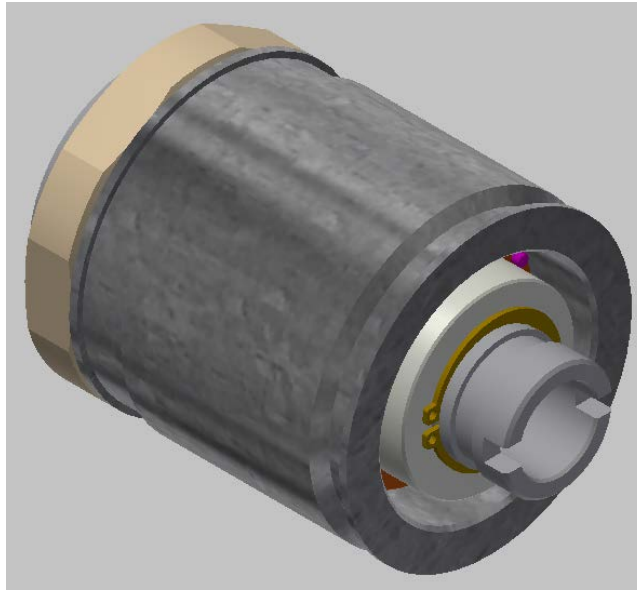


Figure 1: Fully assembled 20607-175 Union.

Repair Kit (20607-175B):

Part Number	Description	Quantity
20008-206	Floating Seal	2
20607-154	Spacer	1
20607-160	Ball Bearing	1
20607-161	Wave Spring	1
20607-166	O-ring	1
20607-167	O-ring	1
2425-106	Coil Spring	6
450-813	O-ring	2
557-008	Seal Plate	2
992-231	Snap Ring	1
P003206	O-ring	2

This kit contains the parts required to complete the following repair process. The part numbers are shown on each figure throughout the procedure.

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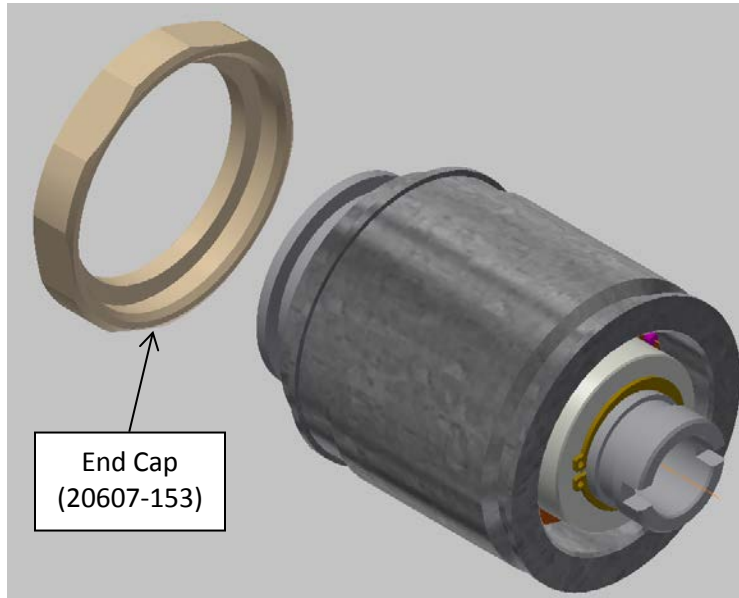
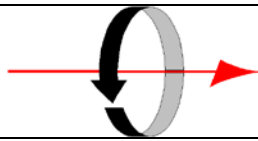


Figure 2: Removal of End Cap.

Step 1: Remove End Cap by unthreading or twisting it.

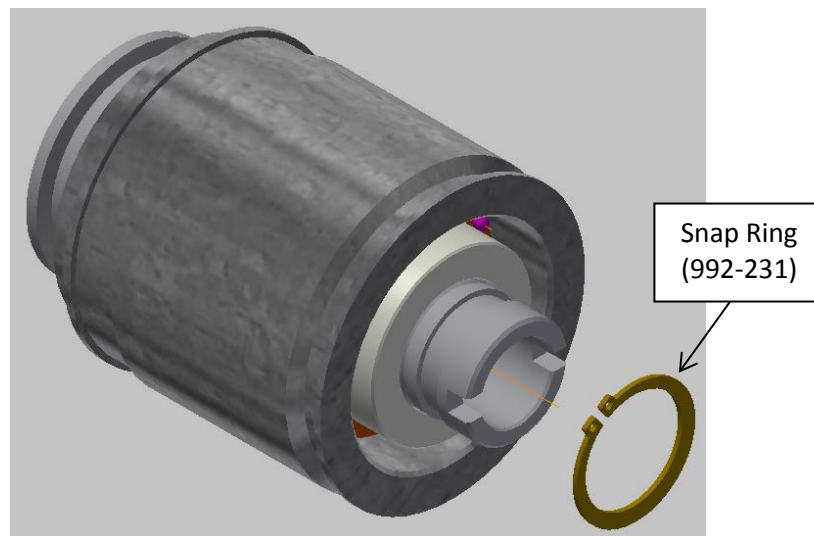


Figure 3: Snap Ring removal.

Step 2: Remove Snap Ring with snap ring pliers and discard.

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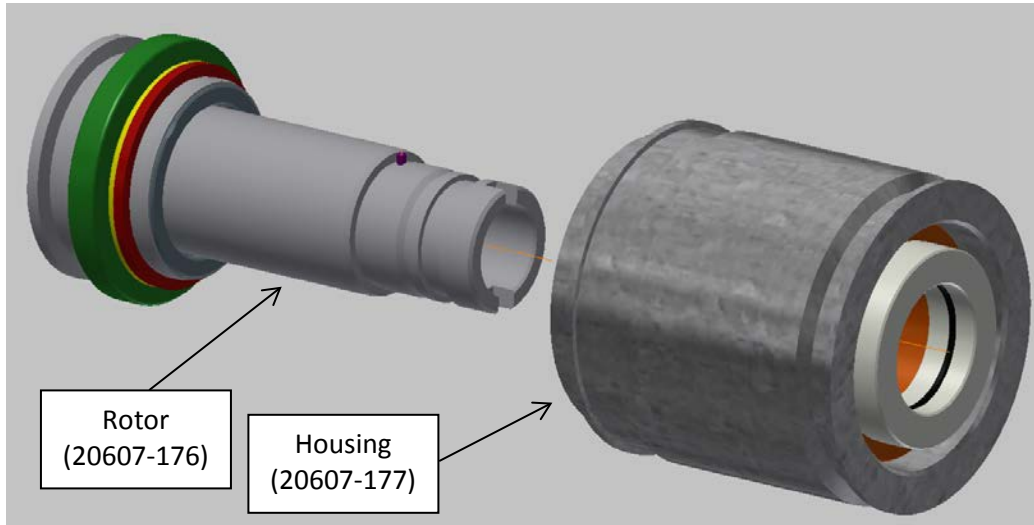
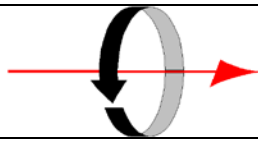


Figure 4: Separation of Rotor and Housing.

Step 3: Vertically press Rotor down and out of Housing. Be cautious as some internal components will now be loose.

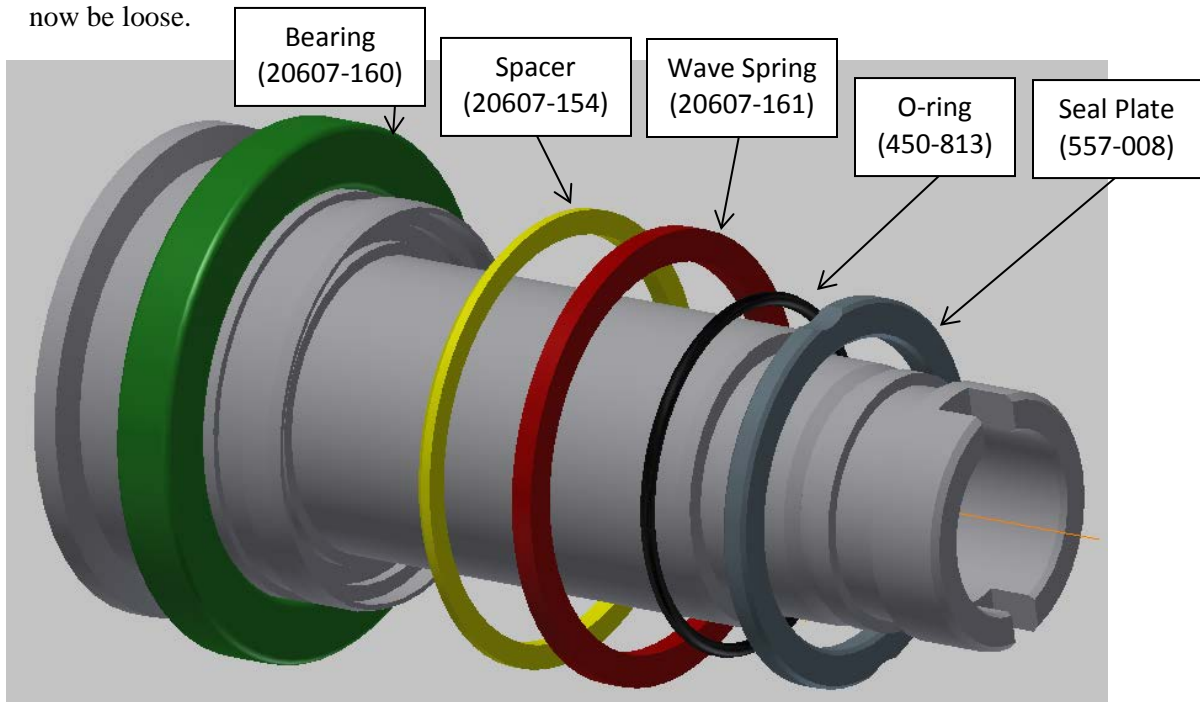


Figure 5: Seal and Spacer removal.

Step 4: Remove Wave Spring, Spacer, Seal Plate, and the O-ring behind the Seal Plate from Rotor. Discard and replace all.

Step 5: Use arbor press to press Bearing off Rotor. Discard and replace.

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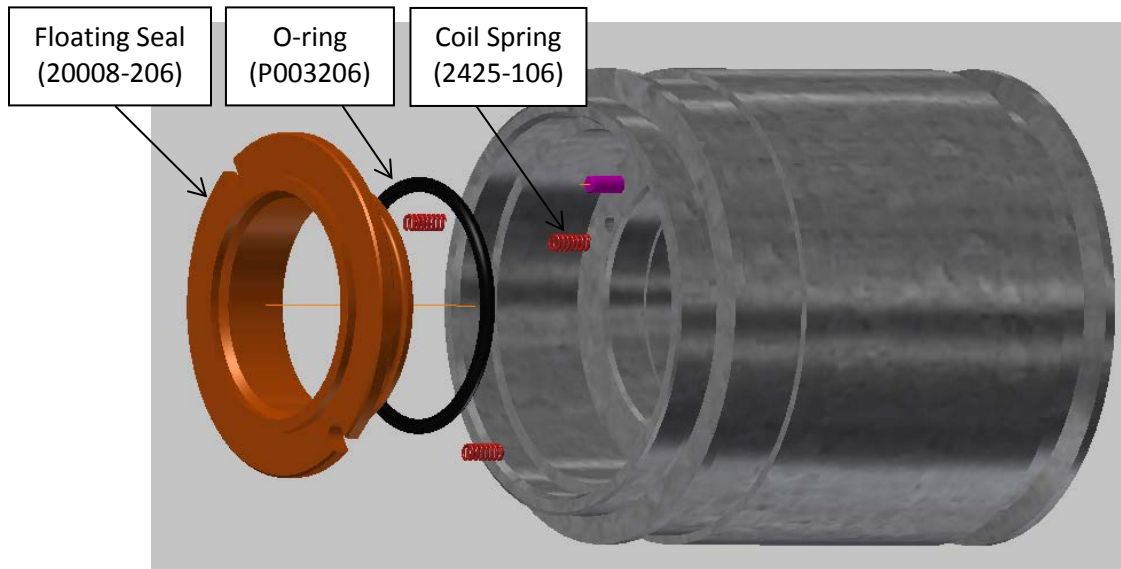
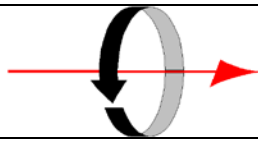


Figure 6: Floating Seal removal.

Step 6: Remove Floating Seal, O-ring, and Springs from End Cap side of Housing. Discard and replace.

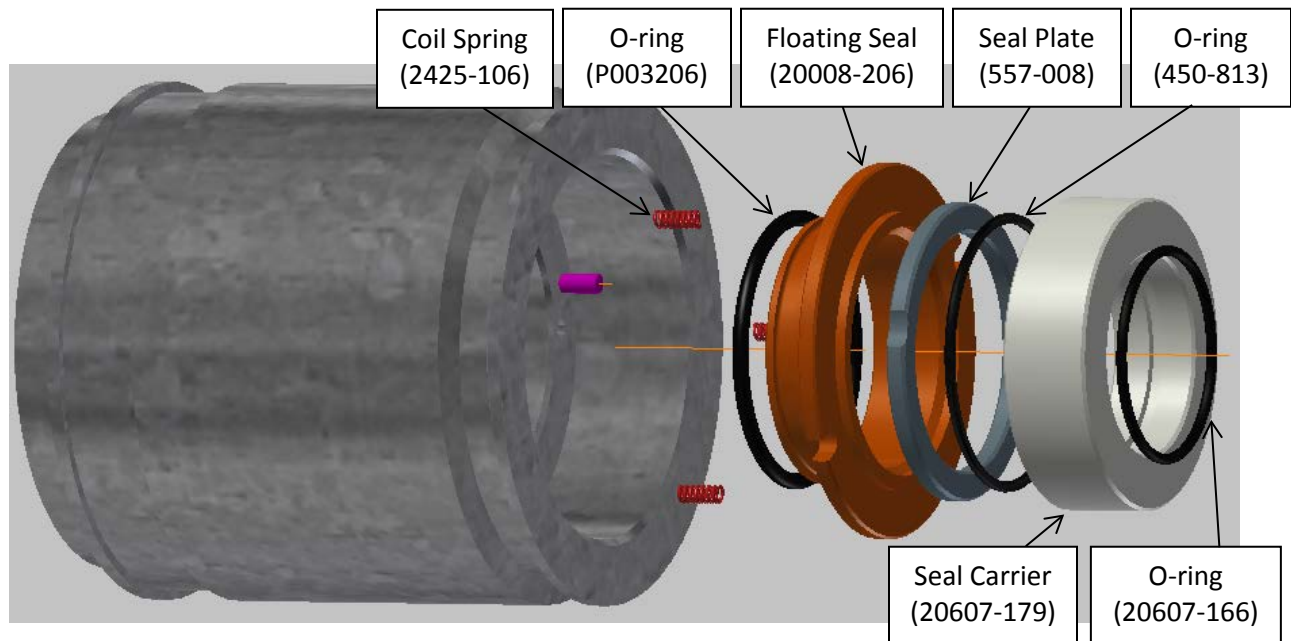


Figure 7: Floating Seal and Seal Carrier removal.

Step 7: Remove Seal Carrier, which has 2 O-rings and 1 Seal Plate associated with it. Discard and replace all but Seal Carrier.

Step 8: Remove Floating Seal, O-ring, and Springs from Housing. Discard and replace all.

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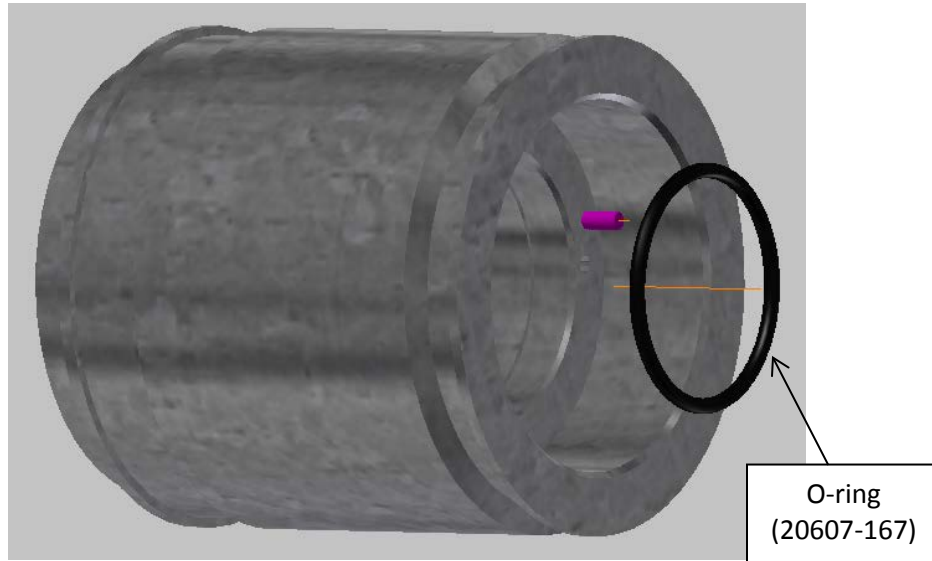
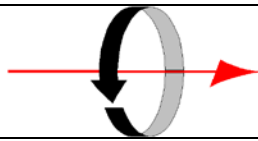


Figure 8: Final internal component removal.

Step 9: Remove and discard the O-ring in the center ID of the Housing.

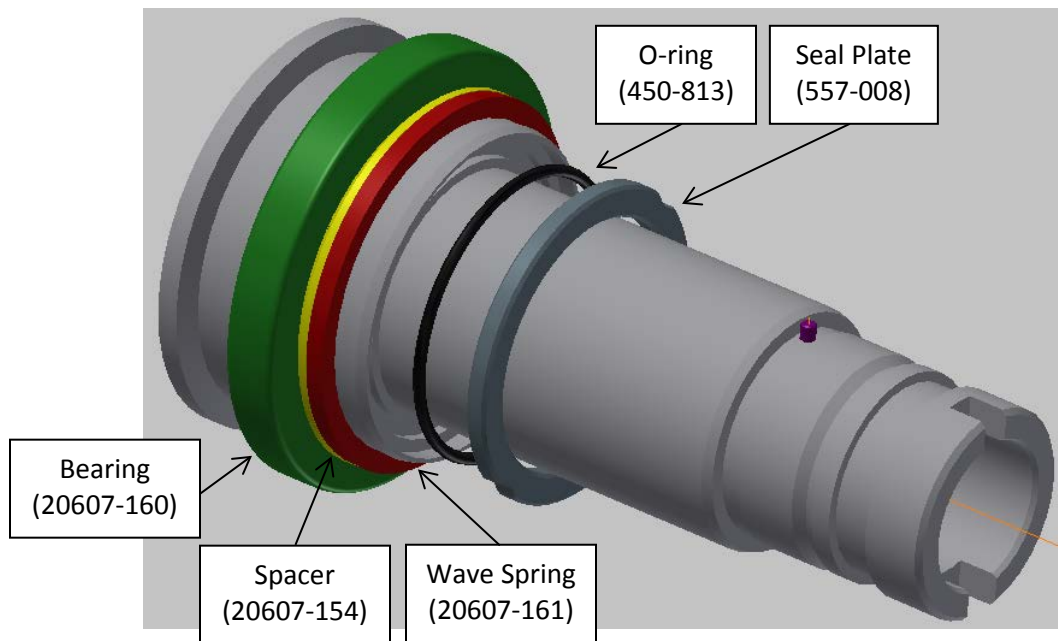


Figure 9: Bearing and Seal Plate assembly.

Step 10: Press new Bearing onto Rotor using an arbor press.

Step 11: Assemble new Spacer and new Wave Spring next to Bearing into the Rotor groove.

Step 12: Assemble new O-ring and new Seal Plate onto the rotor.

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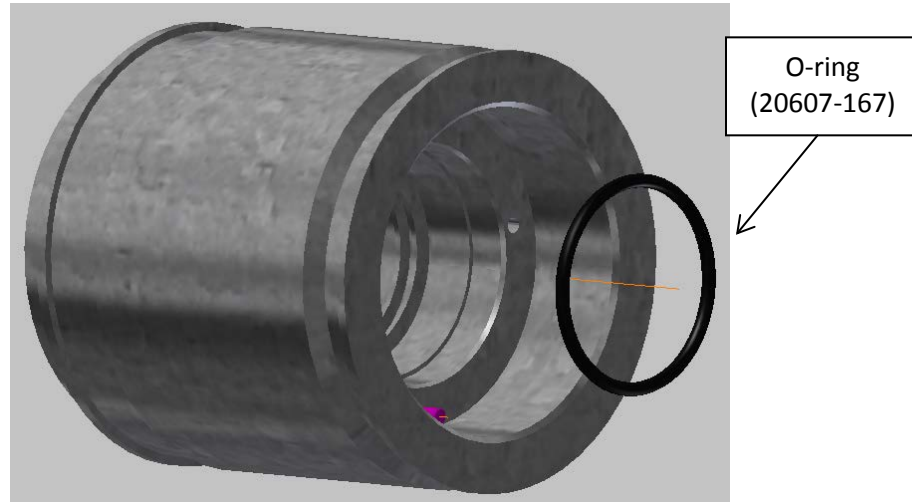
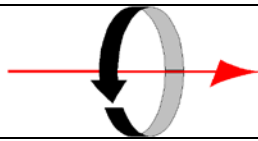


Figure 10: O-ring addition to Housing.

Step 13: Assemble new O-ring (lubricate with Molykote 55) into the ID center groove of Housing.

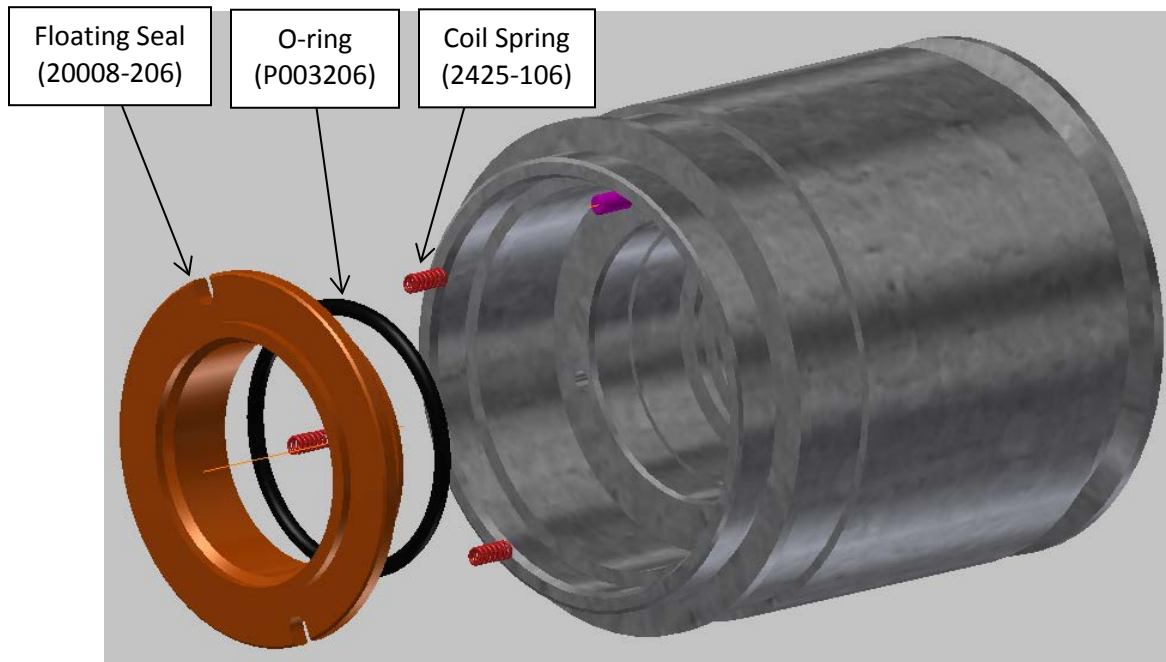


Figure 11: Floating Seal assembly into Housing.

Step 14: Assemble 3 new Springs into the spring holes in the Housing on the End Cap side.

Step 15: Assemble new O-ring (lubricate with Molykote 55) around new Floating Seal and press the Floating Seal into the Housing (Be careful that pins align with slots in the Floating Seal). This will compress the springs.

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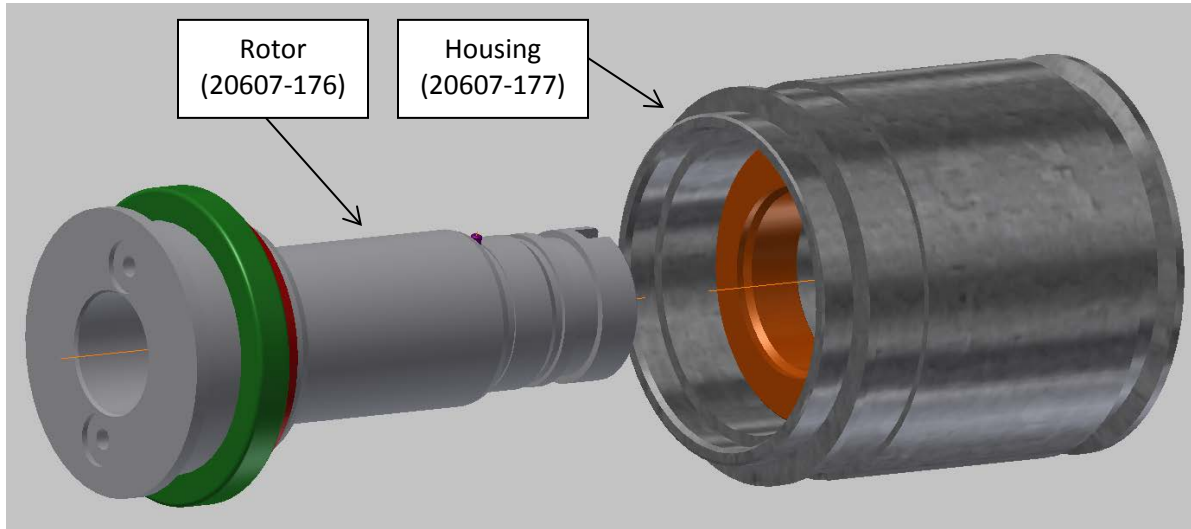
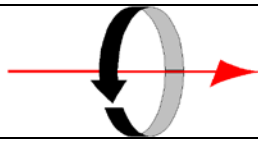


Figure 12: Rotor Housing assembly

Step 16: Stand Housing up with the new Floating Seal on top and press the Rotor assembly down into it.

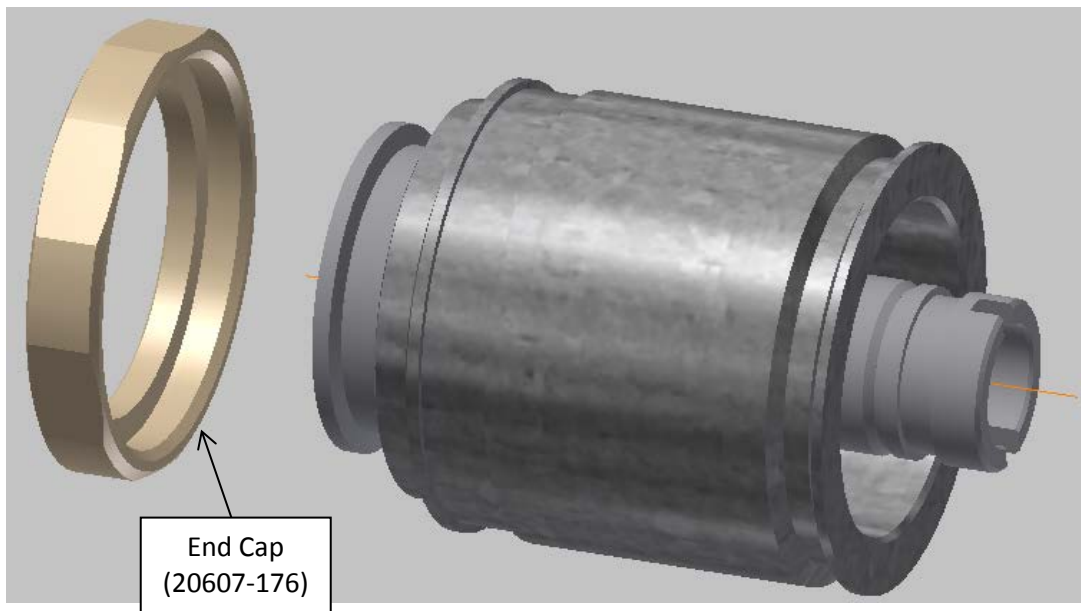


Figure 13: End Cap assembly.

Step 17: Thread End Cap onto Housing. This seals the Rotor and Housing together.

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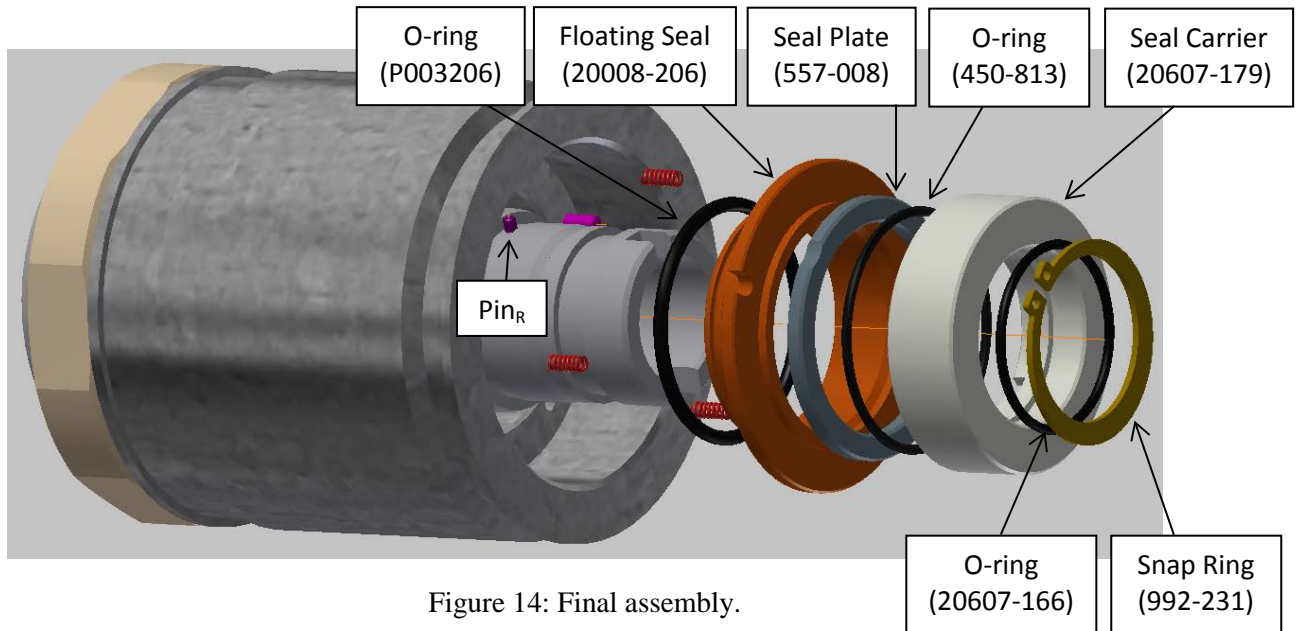
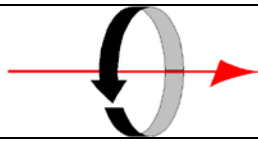


Figure 14: Final assembly.

Step 18: Stand union up on End Cap side and place 3 new springs into the spring holes in the Housing.

Step 19: Put new O-ring (lubricate with Molykote 55) around new Floating Seal and press into the Housing (Be careful that pins align with slots in Floating Seal). This will compress the springs.

Step 20: Assemble 2 new O-rings into their respective grooves in the Seal Carrier along with new Seal Plate (lubricate 20607-166 ID O-ring with Molykote 55).

Step 21: Press Seal Carrier around rotor so the Seal Plate contacts the Floating Seal. Be careful to align Pin_R in Rotor with slot in the Seal Carrier.

Step 22: Use snap ring pliers to put Snap Ring in Rotor groove.

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