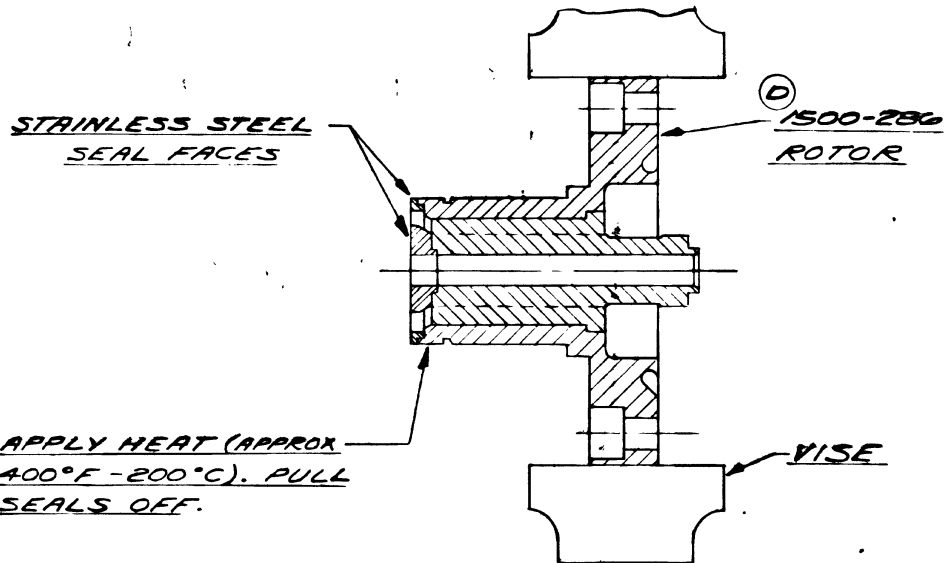


DISASSEMBLE NO. 1500-280 UNION PER DA-12 PROCEDURES 1 THRU 9

REMOVE STAINLESS STEEL SEAL FACES



THOROUGHLY REMOVE ALL ADHESIVE FROM ROTOR AFTER SEALS HAVE BEEN REMOVED.

ROTOR REBUILDING KIT #1500-245

- 1 #1500-283 BRONZE SEAL
- 1 #1500-284 BRONZE SEAL
- 1 #1500-243 SCOTCHWELD WASHER
- 1 #1500-244 SCOTCHWELD WASHER

LET.	REVISION	DATE	SIGN
F			
E			
D	WAS #3-265-6	11-69	K.S.
C	WAS #3-265-5	11-69	K.S.
B	WAS #3-265-4	11-69	V.S.
A	WAS #SK-3-265	11-69	V.S.

MATERIAL
REMOVE BURRS AND BREAK ALL SHARP CORNERS 010R OR AS SPECIFIED REMOVE GREASE OR MACHINING OILS.

SCALE
DRAWN JF
DATE 6-1-67
APP D
DATE
ISSUED

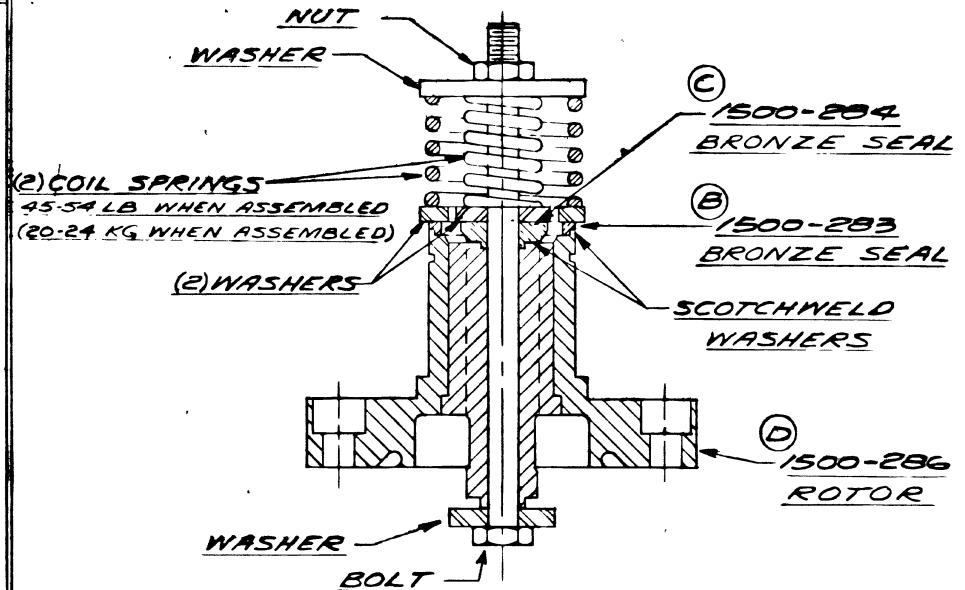
**DEUBLIN COMPANY**  
NORTHBROOK, ILLINOIS, U. S. A.

**ROTOR REBUILDING**  
PROCEDURE FOR #1500-280

TOLERANCES FRACTIONS ± 010 DECIMALS AS SPECIFIED	PART NO. <b>DA-14</b>
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ASSEMBLE BRONZE SEAL FACES

DA-14  
FOR MODEL #1500-280



DEGREASE ROTOR AND BRONZE SEALS IN A CLEAN SOLVENT. REMOVE PROTECTIVE PAPER FROM SCOTCHWELD WASHERS AND ASSEMBLE THEM WITH THE BRONZE SEALS TO THE ROTOR WITH CLEAN HANDS.

ASSEMBLE SPRINGS, WASHERS, ETC.

BAKE IN 375°F OVEN FOR 50 MINUTES.

COOL IN AIR BEFORE DISMANTLING ASSEMBLY.

REFER TO DA-12 ASSEMBLY PRINT FOR RE-SURFACING SEAL FACES AND ASSEMBLING UNION.