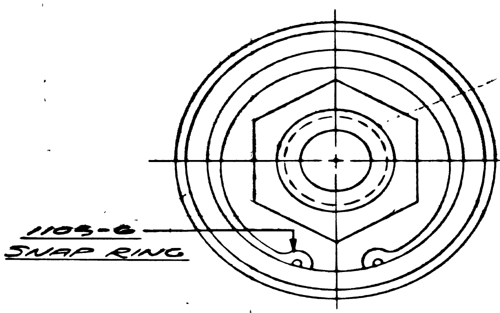
DA 44

① REMOVE HOUSING SNAP RING



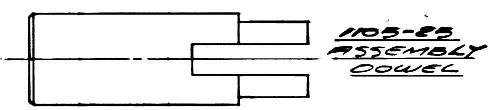
1105 REBUILD. KIT	
1105	ROTOR ASSEMBLY *
1105-5	FLOATING SEAL
1105-15	COIL SPRING
1105-24	SPRING ASSEMBLY PIN
1105-25	ASSEMBLY DOWEL
1105-38	O-RING

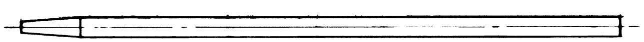
1106 REBUILD. KIT	
1106	ROTOR ASSEMBLY *
1105-107	FLOATING SEAL
1105-15	COIL SPRING
1106-6	SPRING ASSEMBLY TOOL
1105-25	ASSEMBLY DOWEL
1105-14	BLOCK 'V' SEAL

* ROTOR, PRE-ASSEMBLED

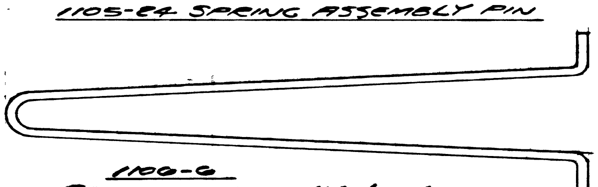
1105-7	BALL BEARING	(2)
1105-12	BEARING SPACER	(1)
1105-13	SNAP RING	(1)

TRUARC PLIERS # 113



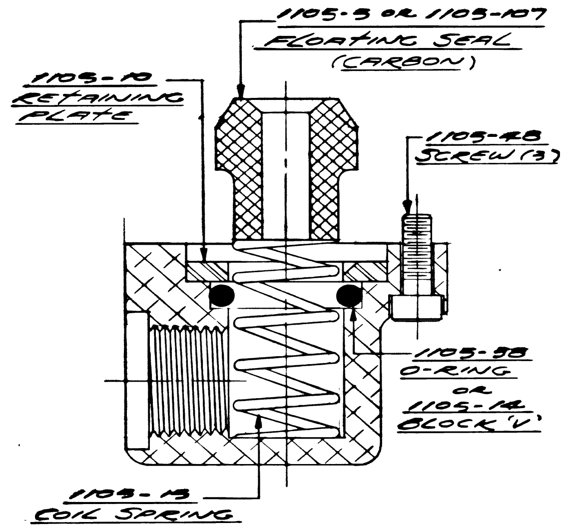


1105-24 SPRING ASSEMBLY PIN

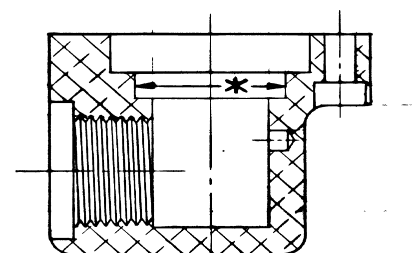


1106-6
SPRING ASSEMBLY TOOL

② UNSCREW END BELL FROM HOUSING – DISCARD SPRING, FLOATING SEAL, O-RING OR BLOCK 'V' SEAL. RETAIN (3) SCREWS AND RETAINING PLATE FOR RE-ASSEMBLY (SEE PAGE 2)

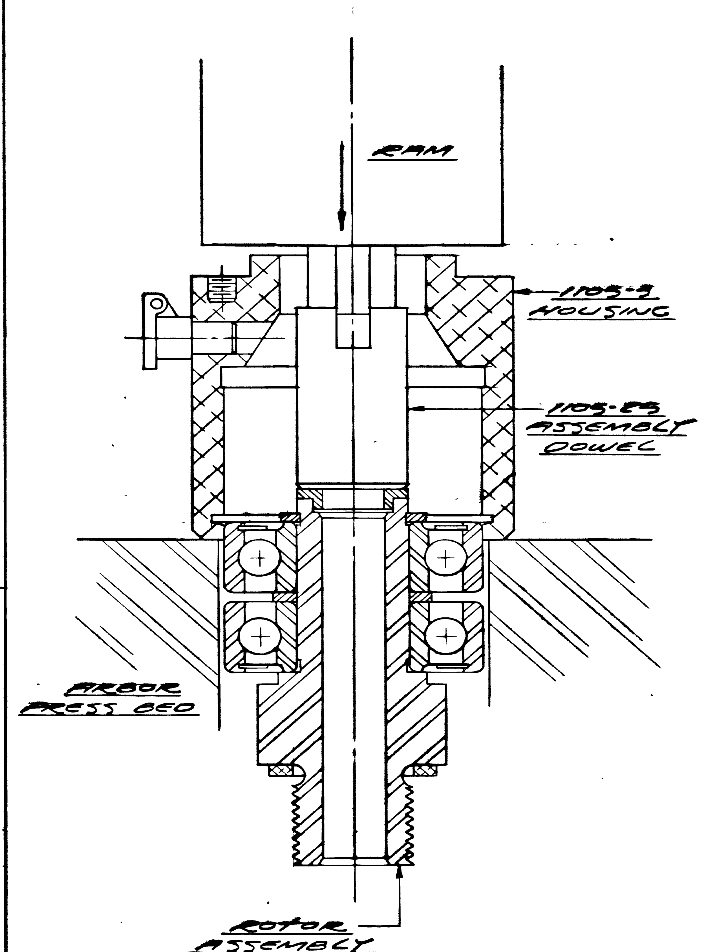


③ CHECK AREA OF BORE IN END BELL



* MUST BE CLEAN AND FREE OF NICKS & SCRATCHES

④. REMOVE ROTOR ASSEMBLY AS SHOWN



LET	REVISION	DATE	SIGN		
G				MATERIAL	SCALE 2:1
F					DRAWN
E					DATE
D					APP'D
C				ALL DIAMETERS TO BE CONCENTRIC WITHIN .005 T I R OR AS SPECIFIED	
B					
A				REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED REMOVE GREASE OR MACHINING OILS	

DEUBLIN COMPANY
NORTHBROOK, ILLINOIS, U S A

DISASSEMBLY PROCEDURE

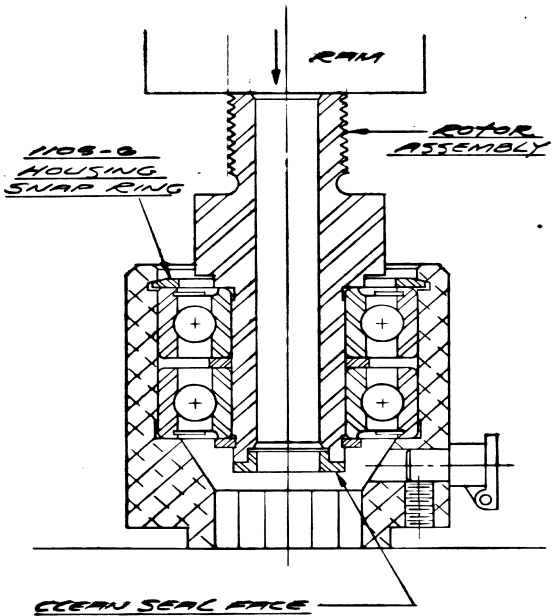
TOLERANCES
FRACTIONS ± .010
DECIMALS AS SPECIFIED
ANGLES ± 1/2°

FILMED ☐

NO DA 44

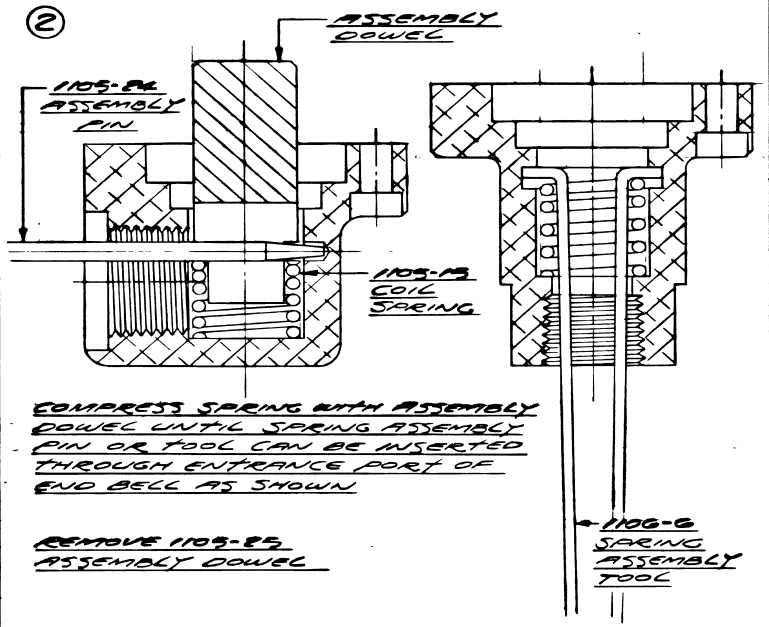
DA 44

① PRESS NEW ROTOR ASSEMBLY INTO HOUSING AND ASSEMBLE SNAP RING



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

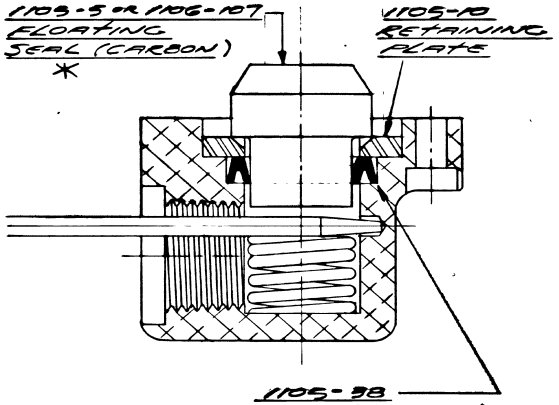
② ASSEMBLY DOWEL



COMPRESS SPRING WITH ASSEMBLY DOWEL UNTIL SPRING ASSEMBLY PIN OR TOOL CAN BE INSERTED THROUGH ENTRANCE PORT OF END BELL AS SHOWN

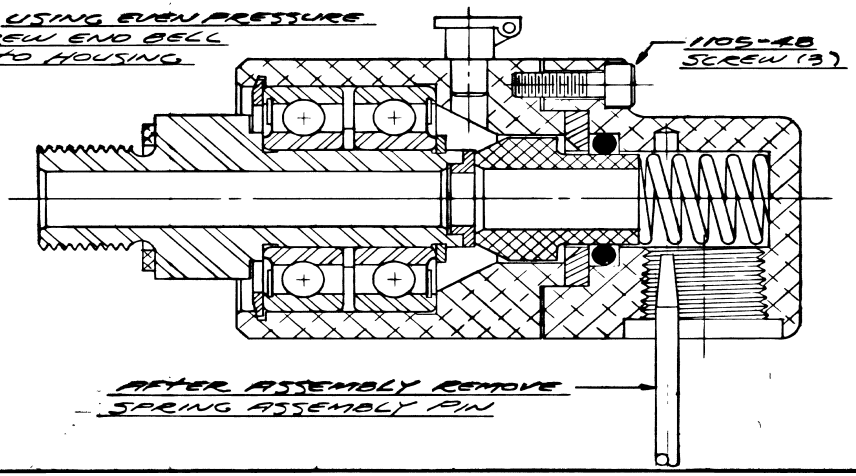
REMOVE 1105-B5 ASSEMBLY DOWEL

③ INSERT O-RING OR BLOCK 'V' SEAL, RETAINING PLATE AND FLOATING SEAL INTO END BELL. BLOCK 'V' LIPS MUST FACE SPRING. ASSEMBLE STEEL RETAINING PLATE WITH BEVEL TOWARDS FLOATING SEAL, AS SHOWN



*NOTE: SEAL FACE MUST BE CLEAN, FREE OF ALL DIRT AND DUST. CUB. ENTIRE SEAL FACE WITH LIGHT VISCOSITY OIL

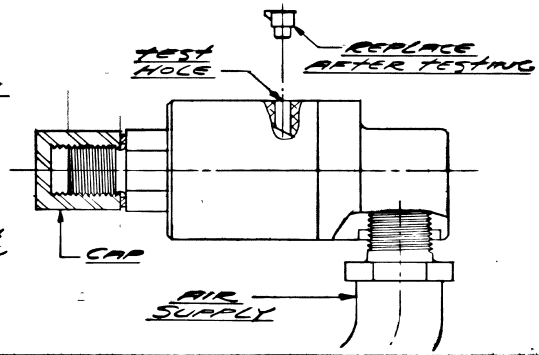
④ USING EVEN PRESSURE SCREW END BELL ONTO HOUSING



TESTING

TEST UNIONS WITH 50 PSI MINIMUM AIR PRESSURE BEFORE PERMANENT INSTALLATION

CAP ROTOR. APPLY AIR PRESSURE. PUT SOAP WATER SOLUTION OR BUBBLE SOAP OVER TEST HOLE. ROTATE ROTOR BY HAND. IF NO BUBBLE RAISES, UNION IS O.K.



LET	REVISION	DATE	SIGN
G			
F			
E			
D			
C			
B			
A			

MATERIAL — SCALE 2:1 — DRAWN — DATE — APP'D

ALL DIAMETERS TO BE CONCENTRIC WITHIN .005 T I R OR AS SPECIFIED

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

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

ASSEMBLY PROCEDURE

TOLERANCES
FRACTIONS ± .010
DECIMALS AS SPECIFIED
ANGLES ± 1/2°

FILMED ☐

NO DA 44