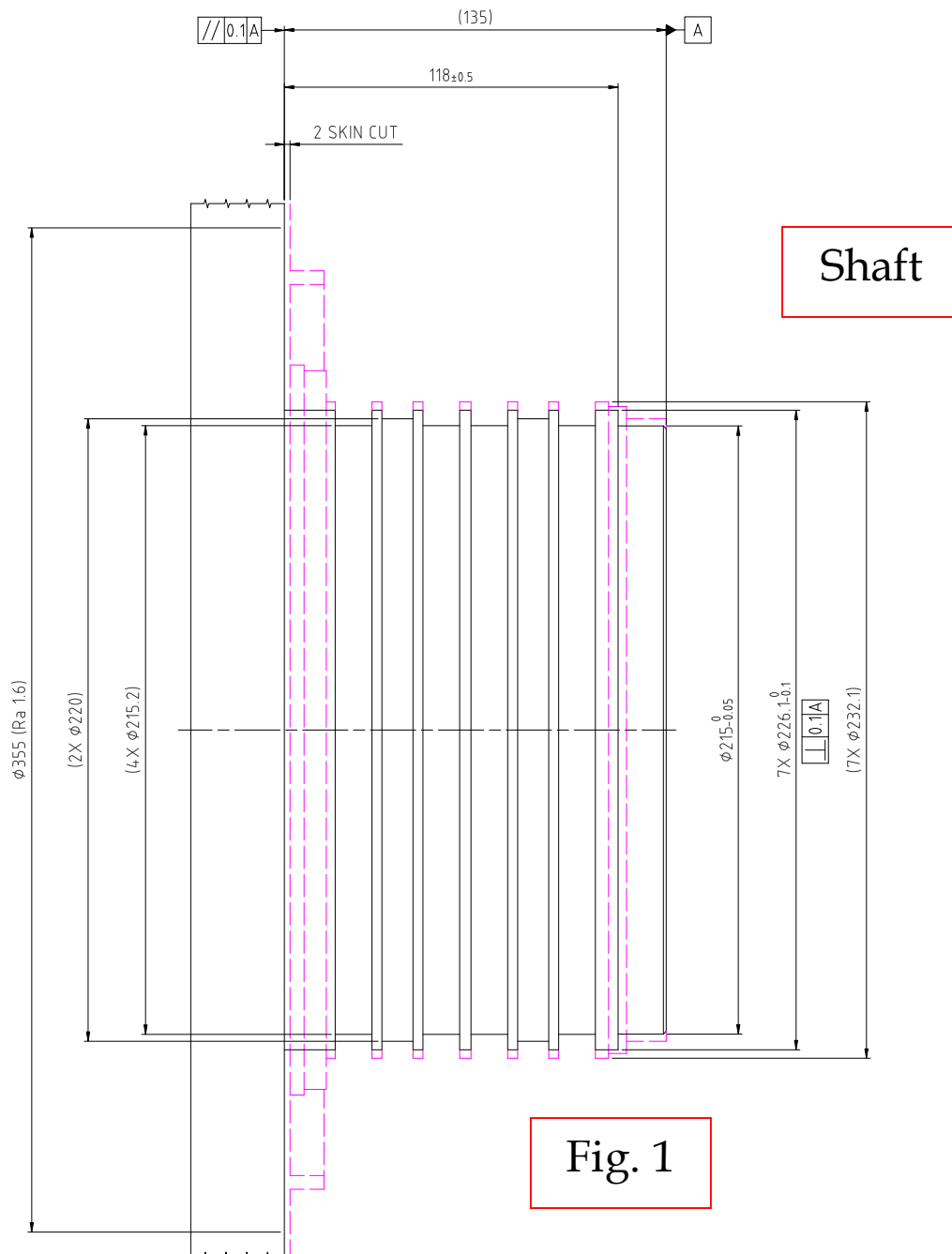


**Customer Preparation:**

- 1) Provide (2x) M6 x 310mm Lg. Threaded Rods, (2x) M6 Hex Nuts (2x) and (2x) M8 Flat Washers.
- 2) Shaft requires modifications illustrated in **Fig. #1**
- 3) Mounting Plate requires modifications illustrated in **Fig. #2**
- 4) Ensure Shaft and Mounting Plate are thoroughly cleaned following modifications.
- 5) Obtain copies of Deublin Drawing SP0320-Interface Customer (IC) (Pages 2).



Mounting  
Plate

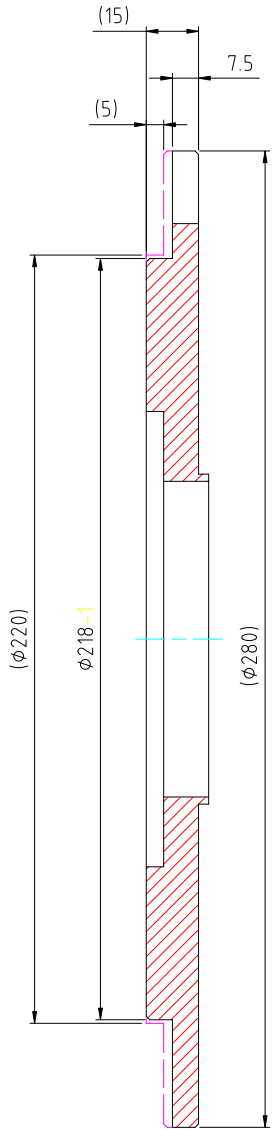
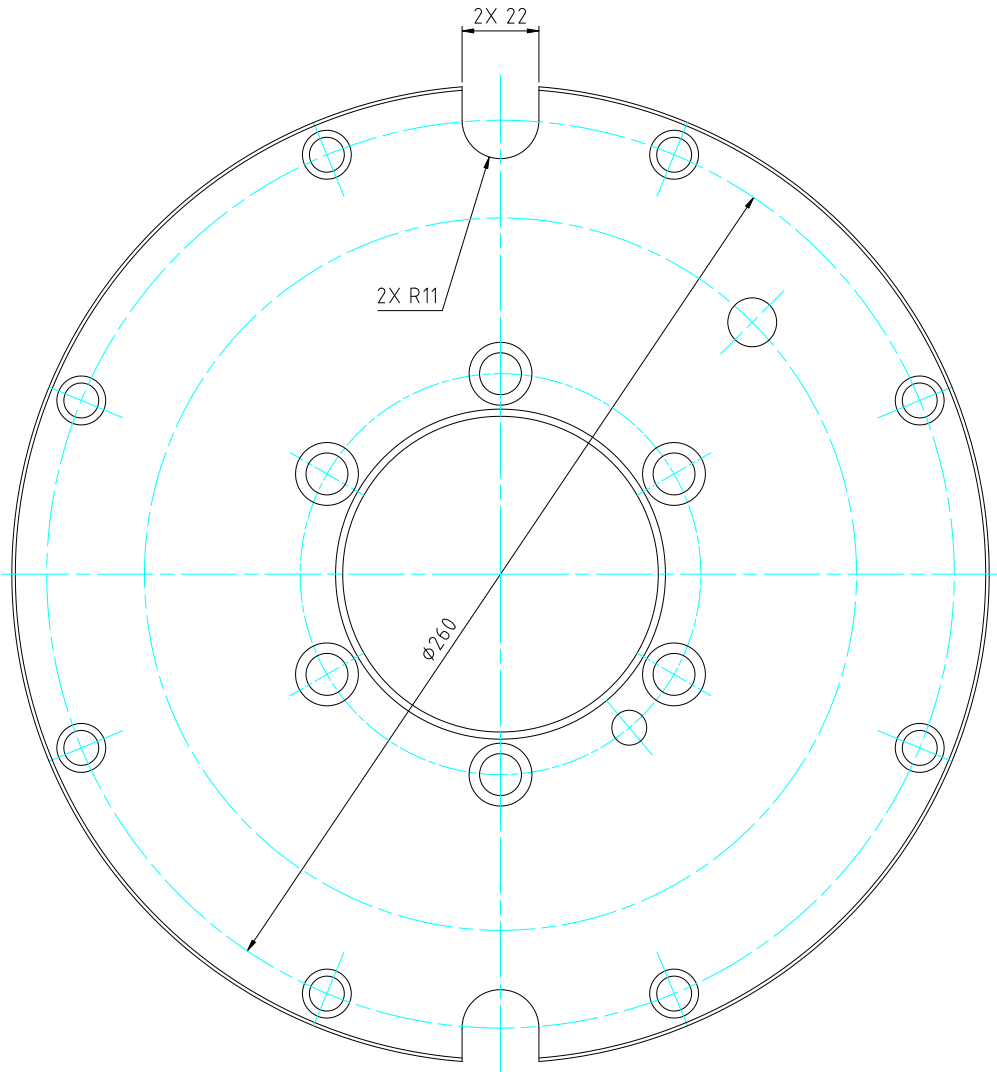
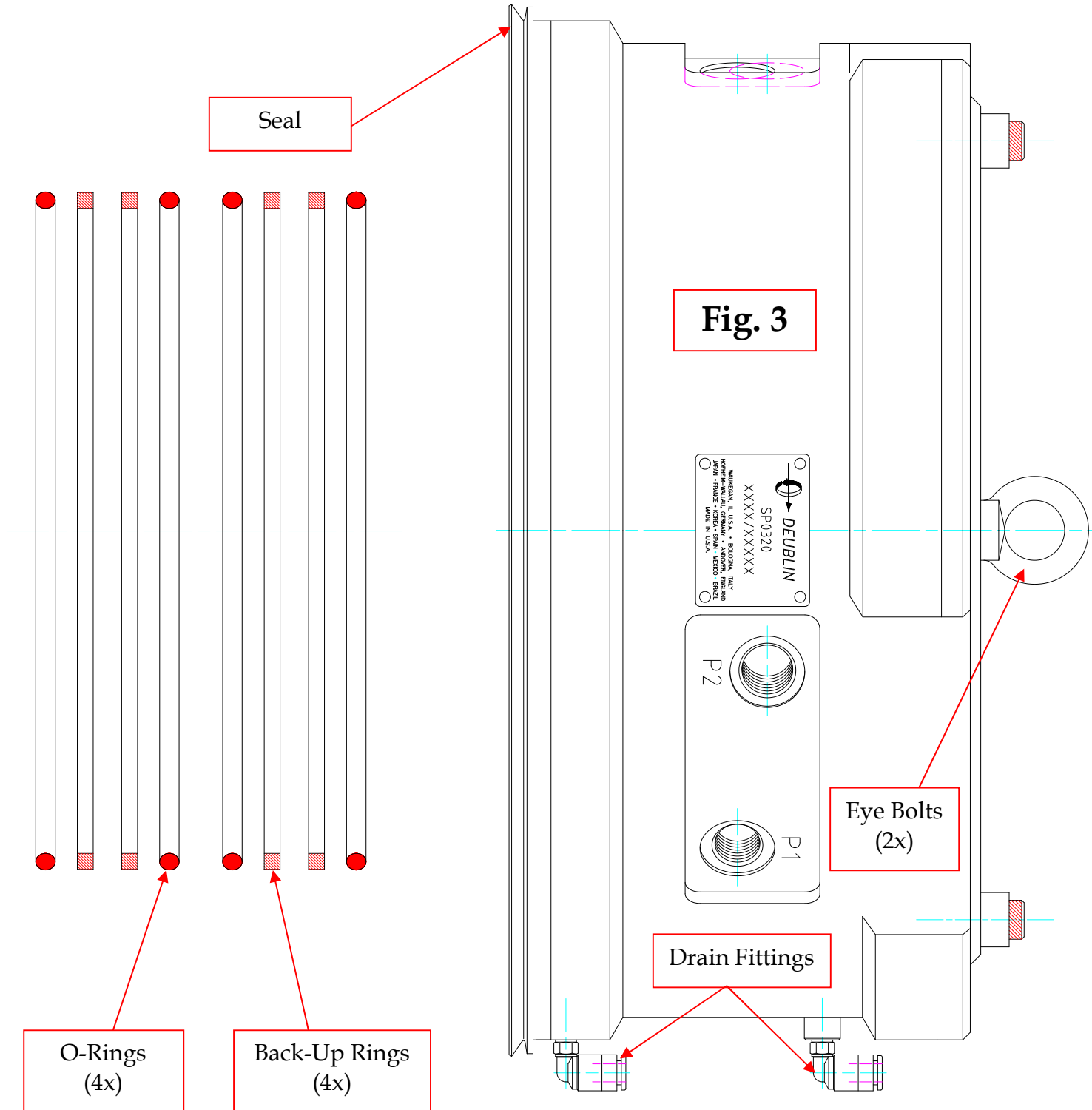


Fig. 2

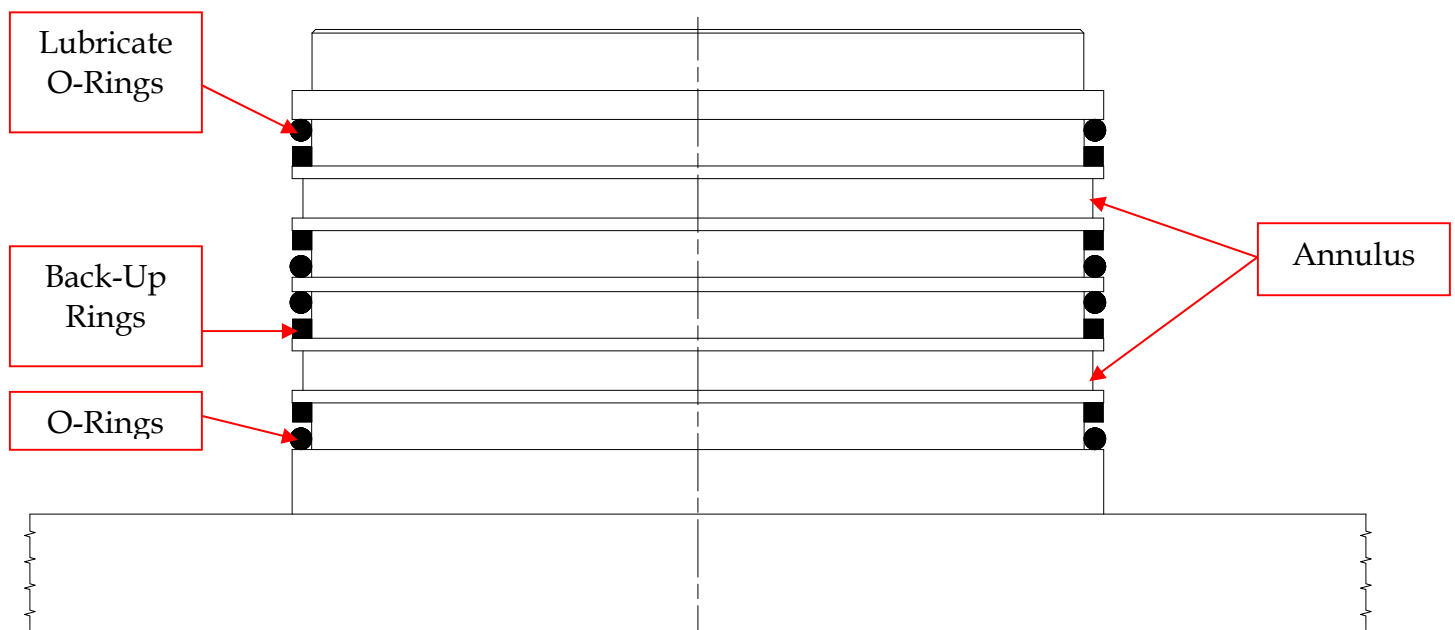
**SP0320 Preparation (See Fig. 3):**

- 1) Eye Bolts are provided to lift Union.
- 2) Drain Fittings are provided for possible connection to Drain Line.
- 3) Seal is provided to protect against intrusion of debris to the Union.
- 4) O-Rings are provided to seal Union to Shaft.
- 5) Back-Up Rings are provided to position O-Rings in Shaft grooves.



**Installation of SP0320:**

- 1) Install O-Rings and Back-Up Rings into appropriate Shaft grooves, see **Fig. 4.**
  - a) Do not install into Annulus see **Fig. 4.**
- 2) Lubricate O-Rings with Silicon Grease.
- 3) Install (2x), 180 degrees apart, M6 x 310mm Lg. Threaded Rods into Shaft, see **Fig. #5.**
- 4) Lift Union, by a Strap secured to Eye Bolts, see **Fig. #5.**
- 5) Position Union over Threaded Rods, see **Fig. #5.**
- 6) Align Threaded Rods with Holes in the Union, see **Fig. #5.**
- 7) Lower Union onto Shaft until resistance is felt.
- 8) Remove Strap from Eye Bolts.
- 9) Install Flat Washers onto Threaded Rods, see **Fig. #5.**
- 10) Install Hex Nuts onto Threaded Rods, see **Fig. #5.**
- 11) Tighten Hex Nuts to lower Union to final position onto the Shaft, see **Fig. #6.**
  - a) Tighten both Hex Nuts at the same time with equal and even torque.
    - i) This is required to prevent Union from binding onto the Platen Rotor.
  - b) Confirm final position has been achieved by checking that a 2mm axial clearance exists between the Union Housing and Shaft, see **Fig. #6.**
- 12) Remove Eye Bolts from Union, see **Fig. #5.**
- 13) Secure Union to Shaft with Screws (Supplied by Customer) , see **Fig. #6.**
- 14) Secure Customer Plate to Inner Shaft with Screws (Supplied by Customer), see **Fig. #6.**
  - a) During this process, Rotate Union Housing and align Union Anti-Rotation Pins with slots in the Mounting Plate, see **Fig. #6.**
- 15) Confirm final Mounting Plate Position has been achieved by checking that a 2mm axial clearance exists between the Union Housing and Mounting Plate, see **Fig. #7.**
- 16) Install Inlet and Outlet Fittings, see **Fig. #7.**
- 17) Ensure that Drain Fittings are orientated at or below the horizontal centerline to establish downward flow for leakage, see **Fig. #7.**
- 18) Union is ready for operation.

**Fig. 4**

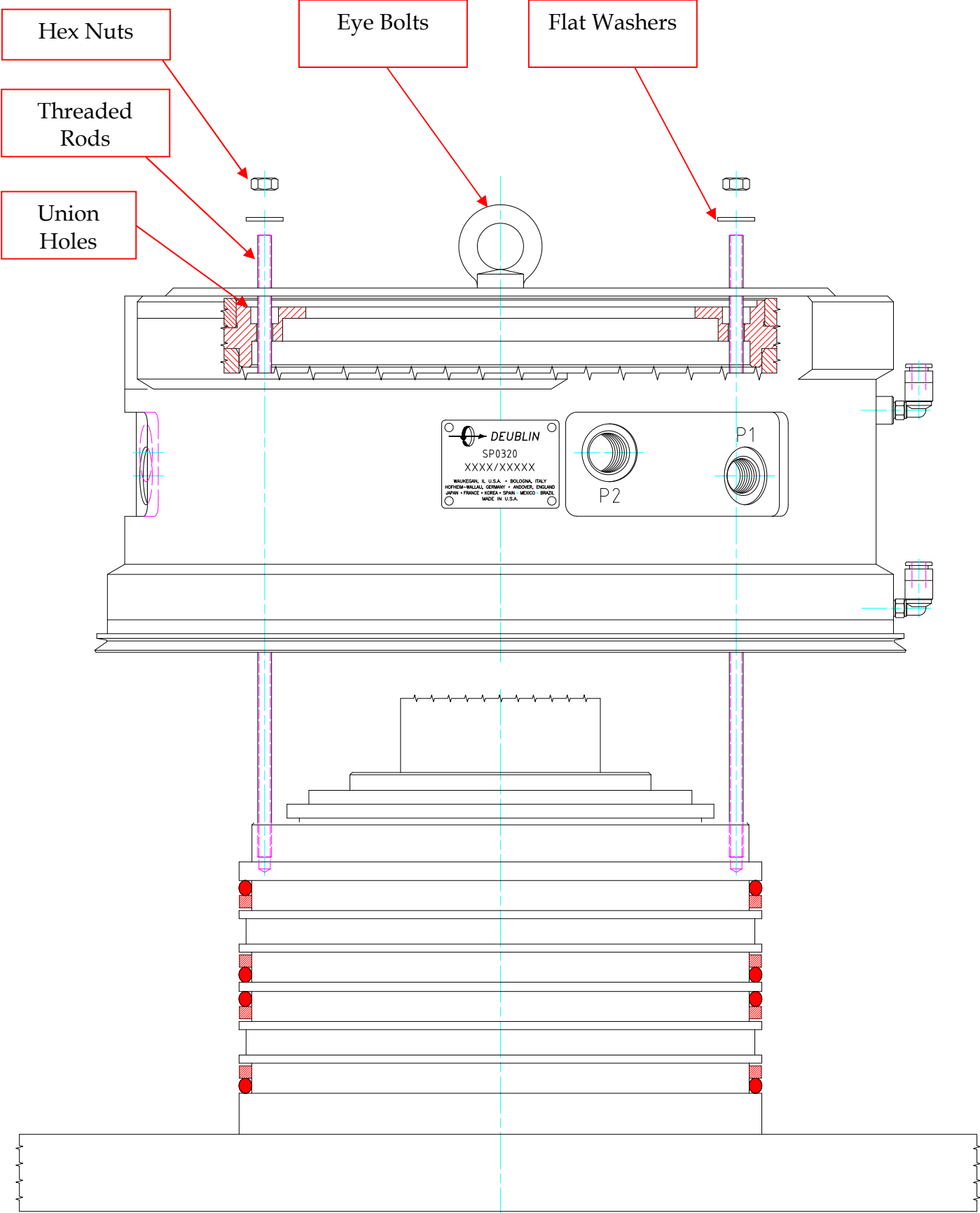
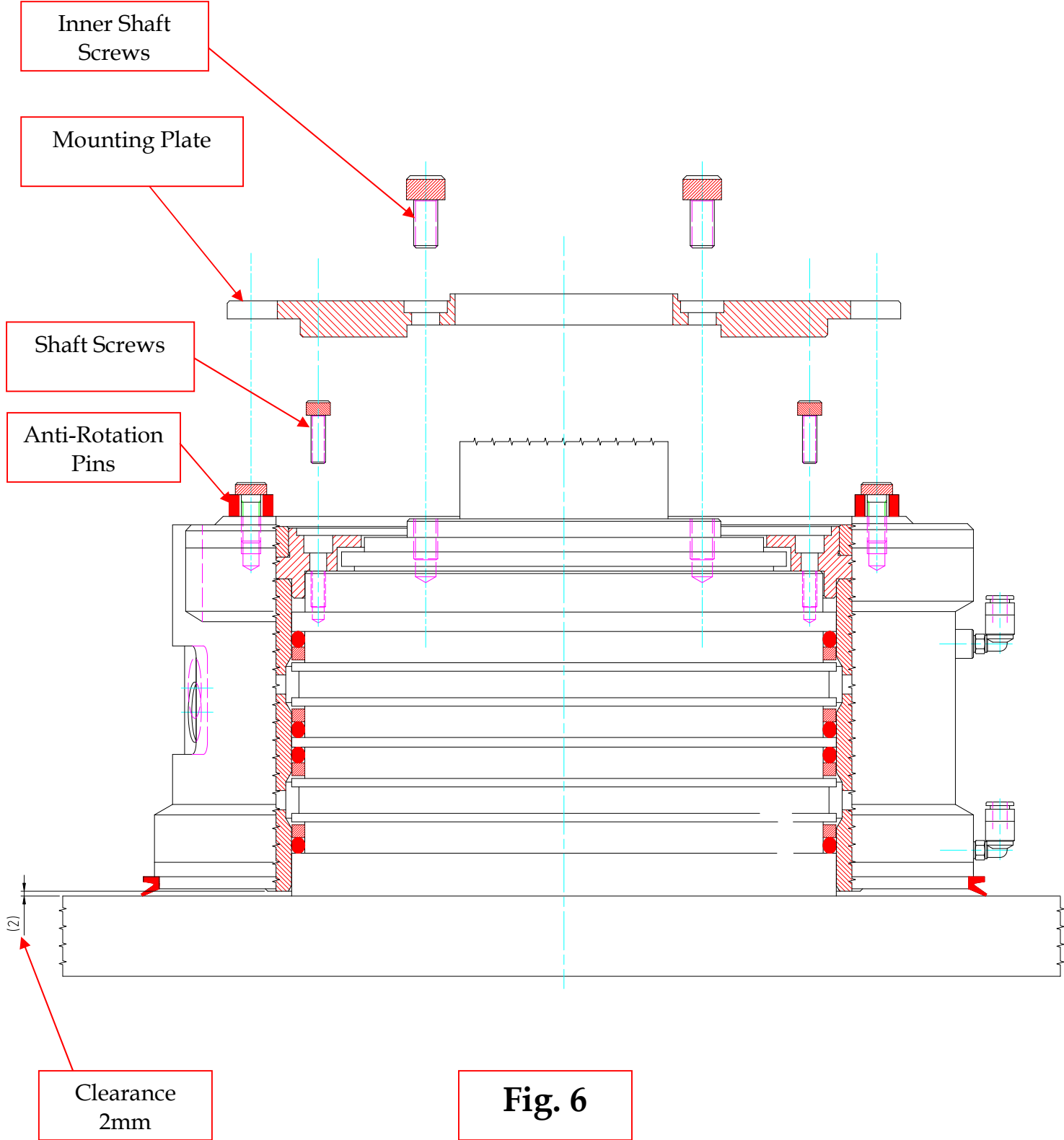
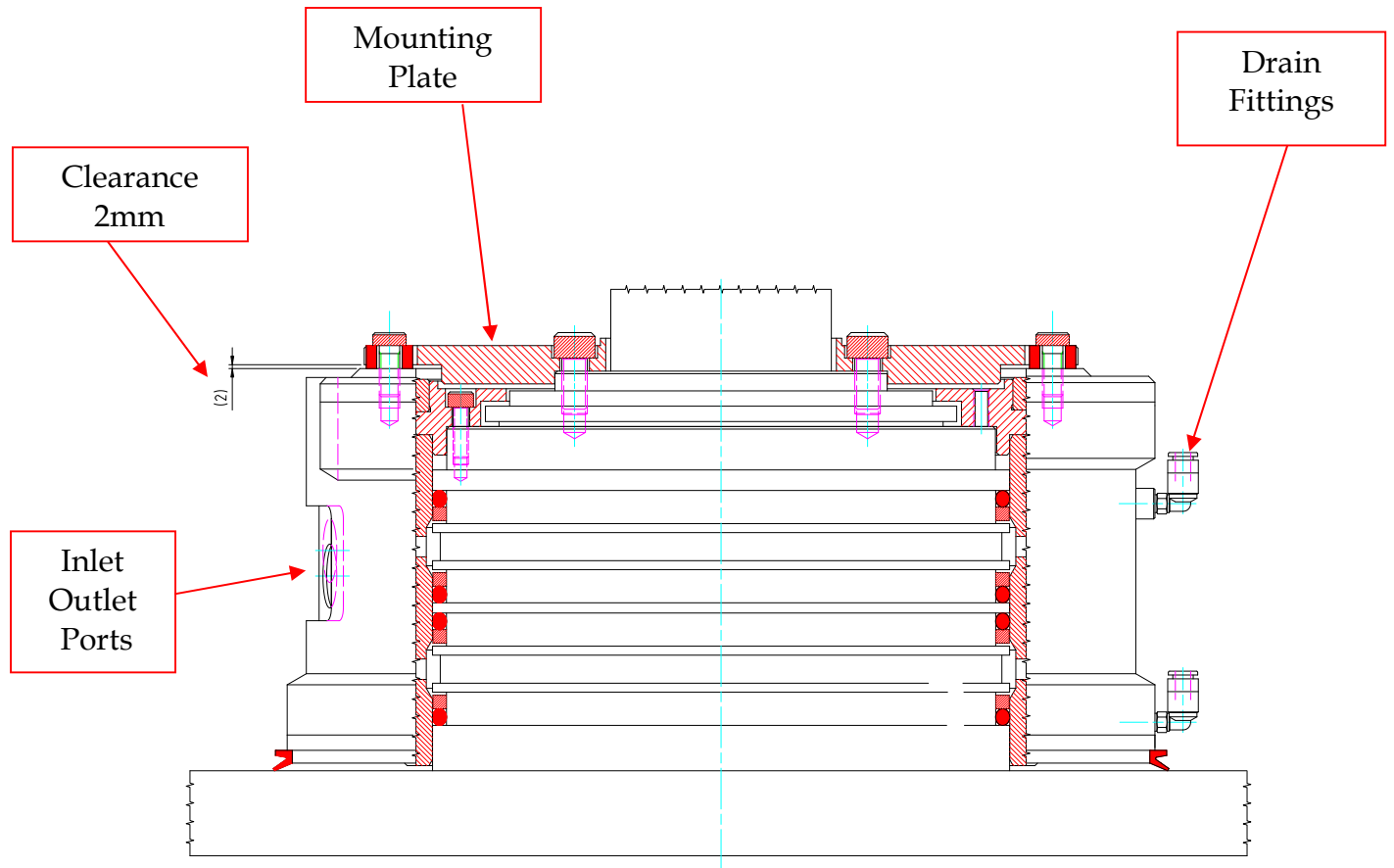


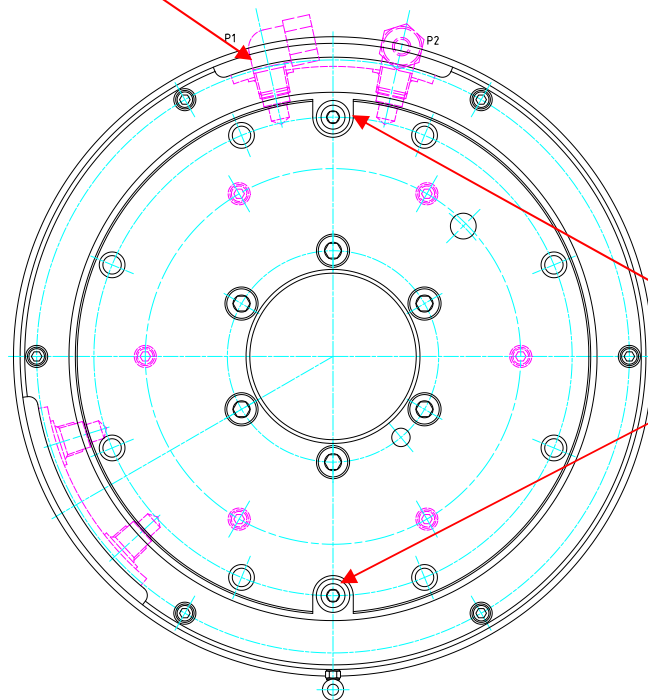
Fig. 5





Inlet / Outlet Port Fittings

**Fig. 7**



Anti-Rotation Pins / Slots