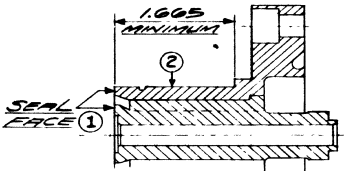


F				MATERIAL	SCALE 3/4" = 1"	<b>DEUBLIN COMPANY</b> NORTHBROOK ILLINOIS <b>MODEL 1500-225 UNION</b> <b>DISASSEMBLY PROCEDURE</b>
E					DRAWN 155.	
D					DATE	
C					APP'D	
B					DATE	
A				REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED. REMOVE GREASE OR MACHINING OILS.	ISSUED	TOLERANCES FRACTIONS ± .010 DECIMALS AS SPECIFIED
LET	REVISION	DATE	SIGN			PART NO. <b>DA-34</b>

When assembling the Model 1500-225 Deublin Union, cleanliness is an important factor. All parts must be free of dirt and chips. The parts may be cleaned with chloroethene, carbon tetra-chloride, alcohol or any good cleaning solvent.

Before assembly, the 1500-113 rotor seal face must be relapped or surface ground smooth to a 15 R.M.S. finish. If the dimension between the ball bearing stop and seal face is under 1.665 inch, the rotor must be replaced. Surface (1) must be square to (2) within .001 inch total indicator reading.



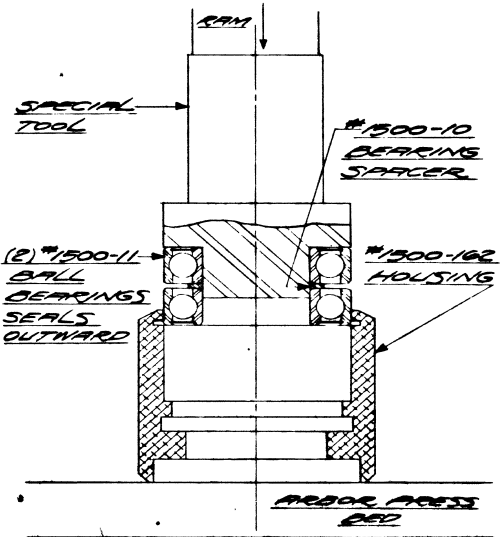
After grinding, the rotor seal face should be polished. This is done by placing a sheet of 4/0 polishing paper on a sheet of plate glass, and then placing the rotor (seal face down) on the polishing paper moving it in a figure eight several times.

If possible, the polishing procedure should be replaced by machine lapping to 2 light bands flatness or better.

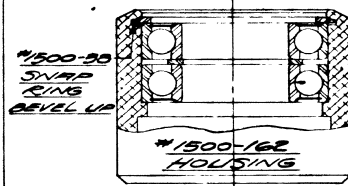
**MODEL 1500 REPAIR KIT**

- (1) #1500-220 FLOATING SEAL
- (2) #1500-11 Ball Bearings
- (1) #1500-12 "O" Ring
- (1) #1500-16 Snap Ring
- (1) #1500-18 "O" Ring
- (1) #1500-19 Nose Gasket
- (1) #1500-34 Wave Spring
- (1) #1500-221 FLOATING SEAL
- Pre-Assembled (1) #1500-73 Coil Spring
- (2) #1105-14 Block "V" Seal

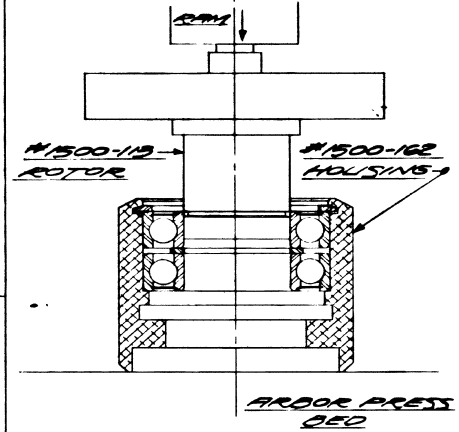
**1 ASSEMBLE #1500-11 BALL BEARINGS AND #1500-10 BEARING SPACER**



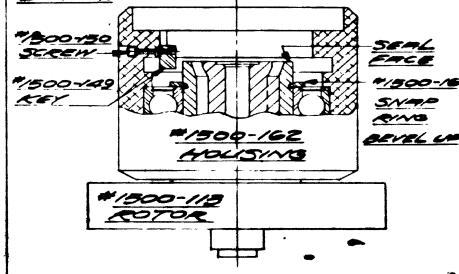
**2 ASSEMBLE #1500-38 SNAP RING**



**3 ASSEMBLE #1500-113 ROTOR**  
NOTE: ROTOR WILL SLIP IN UP TO THE SNAP RING GROOVE & MUST PRESS IN FROM THERE



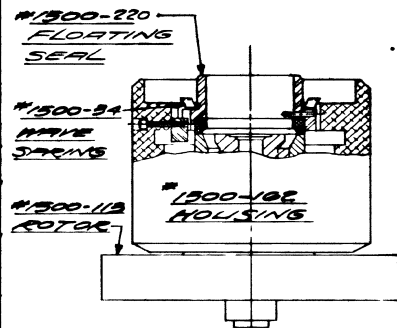
**4 ASSEMBLE #1500-18 SNAP RING**  
(THIS IS A DIFFICULT OPERATION AND CARE MUST BE TAKEN NOT TO NICK THE SEAL FACE DURING INSTALLATION) ASSEMBLE #1500-149 KEYS WITH LONG SECTION DOWN.



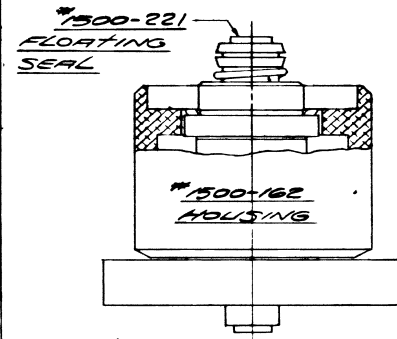
**5 CLEAN SEAL FACES**  
(SEAL FACES MUST BE FREE OF ALL DIRT AND DUST)

- #1500-113 ROTOR
- #1500-220 FLOATING SEAL
- #1500-221 FLOATING SEAL
- OIL ENTIRE #1500-113 ROTOR SEAL FACES (LIGHT VISCOSITY OIL)

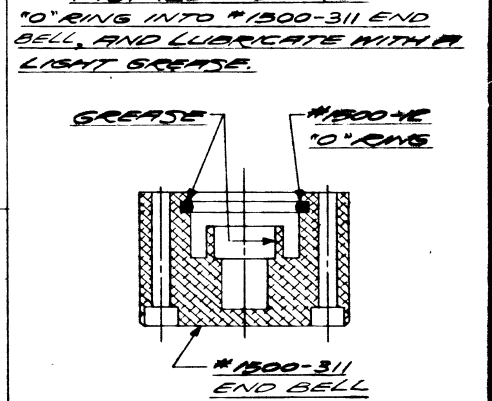
**6 INSTALL #1500-220 FLOATING SEAL, #1500-34 WAVE SPRING**



**7 INSTALL #1500-221 FLOATING SEAL**

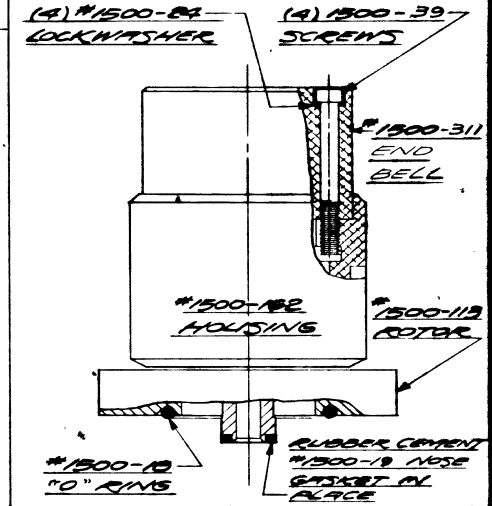


**8 INSTALL #1500-12 "O" RING INTO #1500-311 END BELL, AND LUBRICATE WITH A LIGHT GREASE.**



**9 ASSEMBLE #1500-311 END BELL (HOLD DOWN WHILE TIGHTENING SCREWS), POSITION ENTRANCE PORTS AS ILLUSTRATED IN #1500 CROSS SECTION DRAWINGS.**

INSTALL #1500-18 "O" RING IN ROTOR FLANGE (CEMENT #1500-19 NOSE GASKET IN PLACE).



F				MATERIAL	SCALE 3/4" = 1"	DEUBLIN COMPANY	
E					DRAWN K.S.S.	NORTHBROOK, ILLINOIS	
D					DATE	MODEL 1500-225 UNION	
C					APP'D	ASSEMBLY PROCEDURE	
B					DATE	TOLERANCES	
A					ISSUED	FRACTIONS ± .010	
LET.	REVISION	DATE	SIGN.	REMOVE BURRS AND BREAK ALL SHARP CORNERS. OIL OR AS SPECIFIED. REMOVE GREASE OR MACHINING OIL.		DECIMALS AS SPECIFIED	
						PART NO. DA-34	