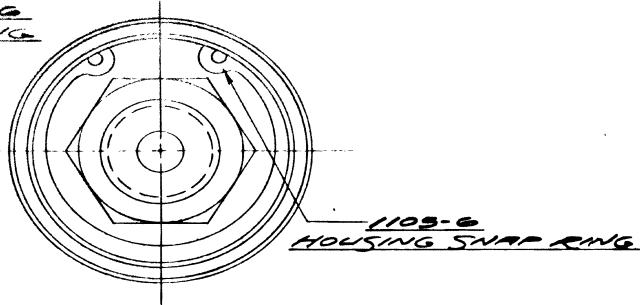
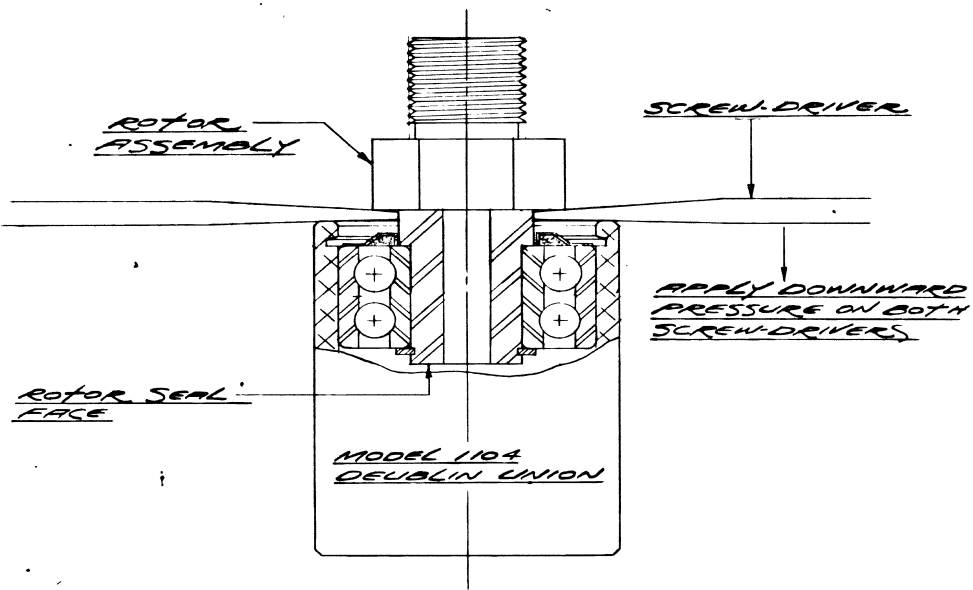


1
REMOVE #1103-G
 HOUSING SNAP RING



2
REMOVE ROTOR
 ASSEMBLY AS SHOWN

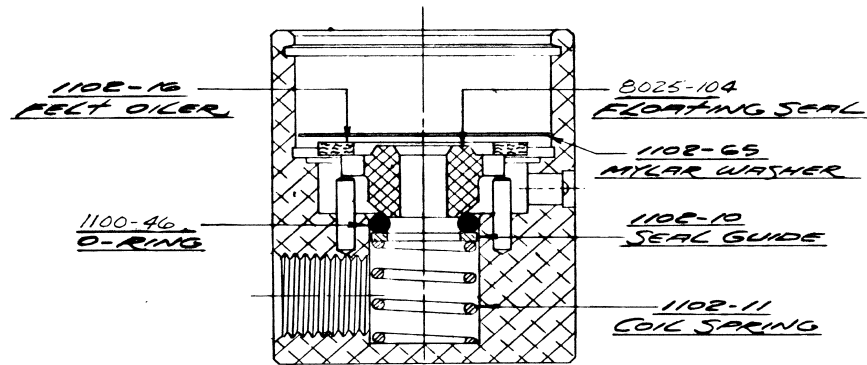


EXAMINE ROTOR SEAL FACE FOR SCORING. IF SEVERE SCORING IS EVIDENT THE ROTOR SHOULD BE REPLACED. IF LITTLE OR NO SCORING IS PRESENT, ROTOR CAN BE REUSED.

ALSO INSPECT THE AMOUNT OF GREASE IN THE BALL BEARING, AND LUBRICATE IF REQUIRED.

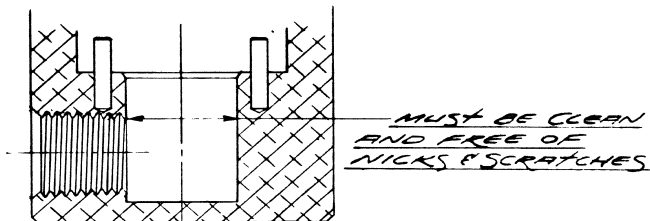
3

REMOVE #1102-65 MYLAR WASHER,
 #1102-10 FELT OILER,
 8025-104 FLOATING SEAL, #1100-46
 O-RING, 1102-10 SEAL GUIDE
 AND #1102-11 COIL SPRING FROM
 1104-103 HOUSING.



4

CHECK AREA OF BORE



(SHEET 1 OF 2)

G				MATERIAL	SCALE 2:1	DEUBLIN COMPANY NORTHBROOK ILLINOIS, U.S.A. 1104 UNION
F					DRAWN	
E					DATE	
D					APP'D	TOLERANCES
C						FRACTIONS ± 010
B						DECIMALS AS SPECIFIED
A						ANGLES ± 1/2°
LET	REVISION	DATE	SIGN.	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.		NO. DA 38

5

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 TETRACHLORIDE, ALCOHOL OR ANY GOOD CLEANING SOLVENT.

1104
REPAIR KIT
PARTS LIST

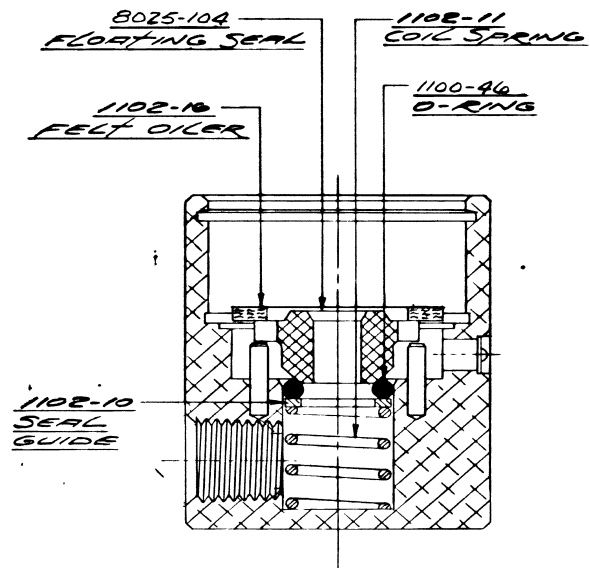
- (1) 1102-11 COIL SPRING
- (1) 1100-46 O-RING
- (1) 8025-109 FLOATING SEAL
- (1) 1102-10 SEAL GUIDE
- (1) 1102-16 FELT OILER
- (1) 1102-65 MYLAR WASHER

6

CLEAN ROTOR SEAL FACE AND #8025-109 FLOATING SEAL. SEAL FACES MUST BE FREE OF ALL DIRT AND DUST.

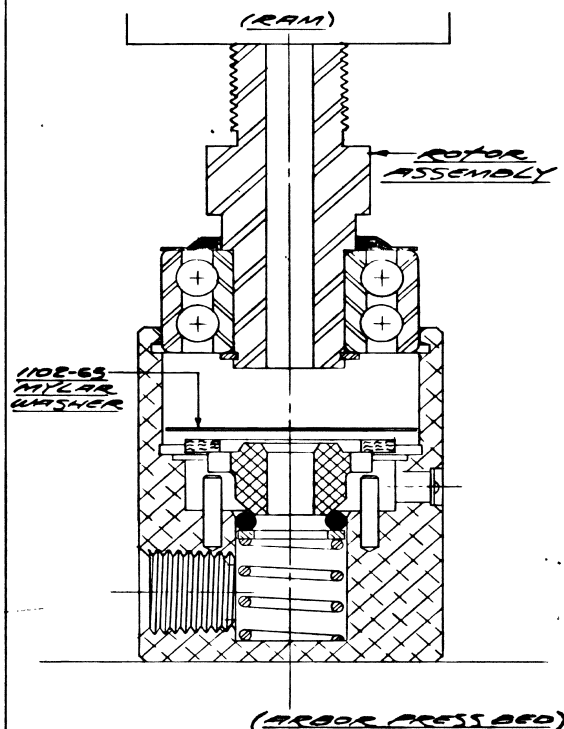
7

ASSEMBLE #1102-11 COIL SPRING, #1102-10 SEAL GUIDE, #1100-46 O-RING, #8025-109 FLOATING SEAL & #1102-16 FELT OILER



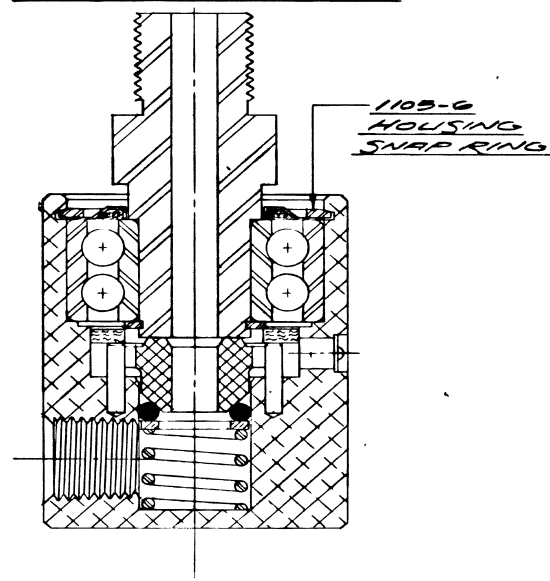
9

ASSEMBLE ROTOR ASSEMBLY



10

ASSEMBLE #1105-6 HOUSING SNAP RING



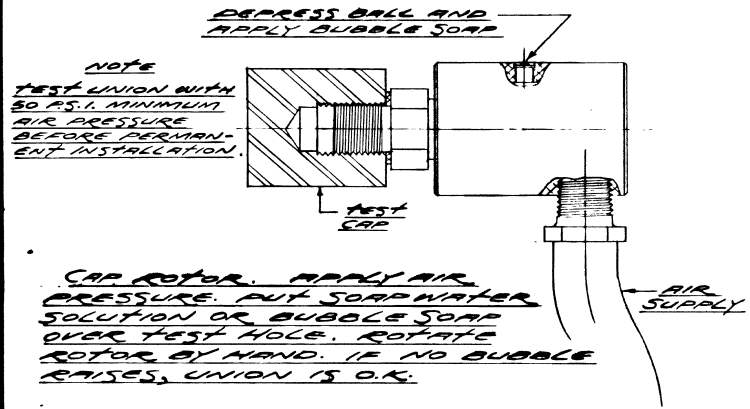
(SHEET 2 OF 2)

8

OIL #1102-16 FELT OILER AND ENTIRE FACE OF #8025-109 FLOATING SEAL WITH LOW VISCOSITY OIL, AND INSTALL #1102-65 MYLAR WASHER ON TOP OF FELT OILER.

TEST PROCEDURE

DA 38



G				MATERIAL	SCALE 2:1	DEUBLIN COMPANY NORTHBROOK, ILLINOIS, U.S.A. 1104 UNION TOLERANCES FRACTIONS ± 0.10 DECIMALS AS SPECIFIED ANGLES ± 1/2°
F				DRAWN	FILED	
E				DATE	NO	
D				APP'D	DA 38	
C				ALL DIAMETERS TO BE CONCENTRIC WITH DIM T 1 IN. OR AS SPECIFIED		
B				REMOVE BURRS AND BREAK ALL SHARP CORNERS. OIL OR AS SPECIFIED. REMOVE GUMBLE OR MACHINING OIL		
A				REVISION	DATE	
LET						