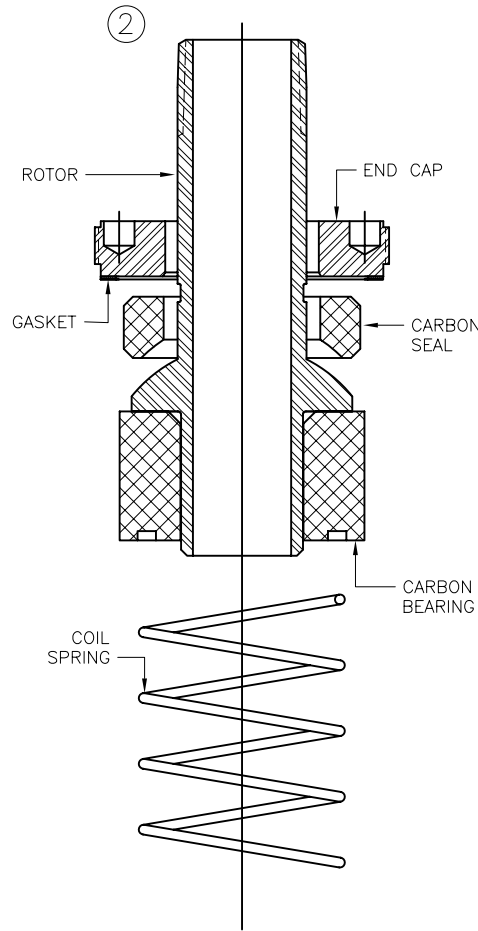
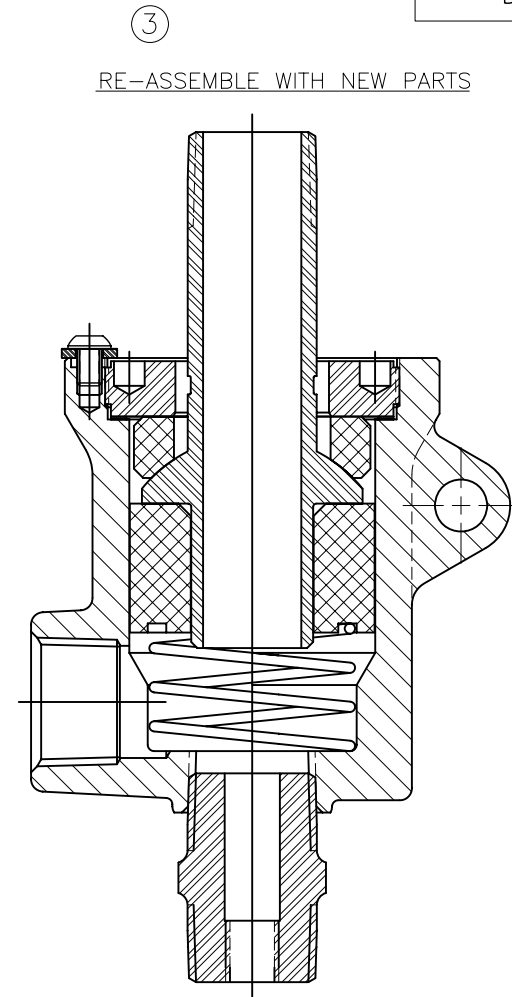


HOLDING HOUSING IN A VISE, REMOVE SCREW & LOCKWASHER (DO NOT DISCARD). UNSCREW END CAP WITH SPANNER WRENCH.



REMOVE AND DISCARD ALL COMPONENTS SHOWN ABOVE.



DROP NEW COIL SPRING INTO HOUSING, REPLACE CARBON BEARING, ROTOR, CARBON SEAL AND GASKET. SCREW END CAP WITH SPANNER WRENCH TO SPECIFIED TORQUE AND SECURE WITH SCREW AND WASHER.

RE-ASSEMBLE WITH NEW PARTS

SPANNER WRENCH SIZE

UNION MODEL	PIN CENTERS	DIA. OF PIN	END CAP TORQUE	SPANNER WRENCH NUMBER - WILLIAMS
9075	2 1/4	9/32	145 FT-LBS	#428
9100	2 1/2	9/32	175 FT-LBS	#430
9125	3	5/16	280 FT-LBS	#434
9150	3 1/2	5/16	375 FT-LBS	#438

DEUBLIN UNION P/N	REBUILDING KIT PART NUMBER
9075-001-ROTOR NO.	9075-001B-ROTOR NO.
9100-001-ROTOR NO.	9100-001B-ROTOR NO.
9125-001-ROTOR NO.	9125-001B-ROTOR NO.
9150-001-ROTOR NO.	9150-001B-ROTOR NO.

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EQUIPMENT REF:		SCALE: FULL SIZE C	<b>DEUBLIN COMPANY</b> WAUKEGAN, ILLINOIS, U.S.A.
ASSY/TEST FIXTURES REQUIRED:		DATE: 07/15/03	
REVISION		UNLESS SPECIFICALLY TOLERANCED, ALL DIMENSIONS ARE REFERENCE	TITLE: DISASSEMBLY & ASSEMBLY FOR SERIES 9000 UNIONS
LET.	ECO	DATE	SIGN
NO.		DA-039	