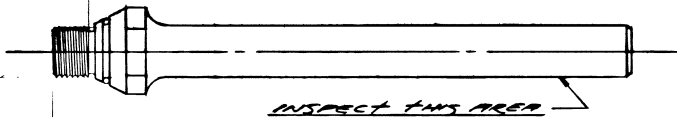


17-170

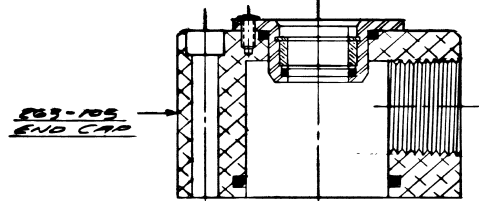
①

AFTER UNION IS REMOVED FROM SHAF, INSPECT #263-102 INNER ROTOR FOR WEAR AT THE O-RING & OILITE BEARING AREA. IF ROTOR IS DEEPLY GROOVED IT SHOULD BE REPLACED.



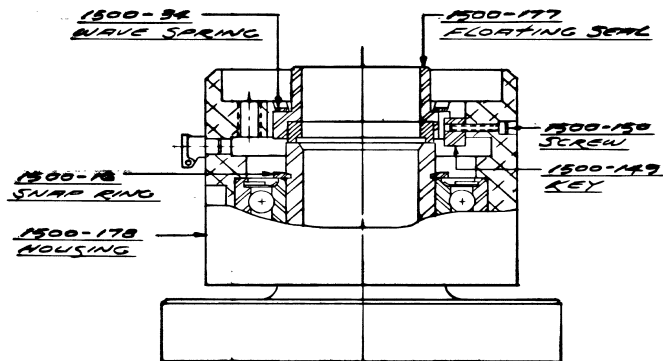
②

REMOVE #263-105 END CAP.



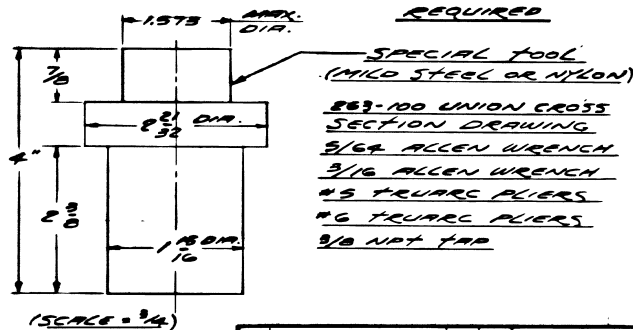
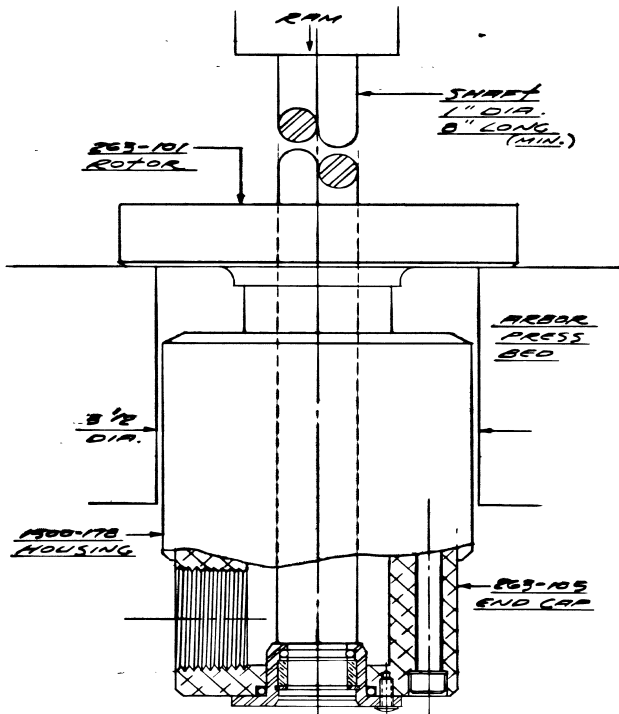
③

REMOVE #1500-177 FLOATING SEAL & 1500-34 WAVE SPRING FROM HOUSING. UNSCREW (2) #1500-150 SCREWS & REMOVE (2) 1500-149 KEYS. REMOVE #1500-12 SNAP RING.



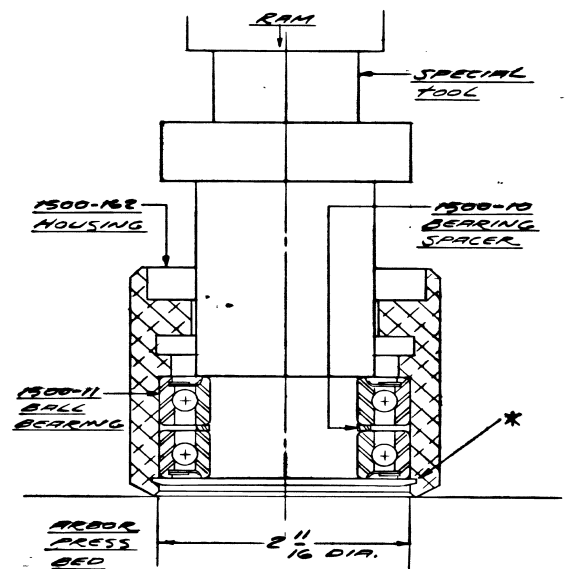
④

REPLACE #263-105 END CAP. POSITION IN ARBOR PRESS & REMOVE 263-101 ROTOR FROM BEARINGS AS SHOWN.



⑤

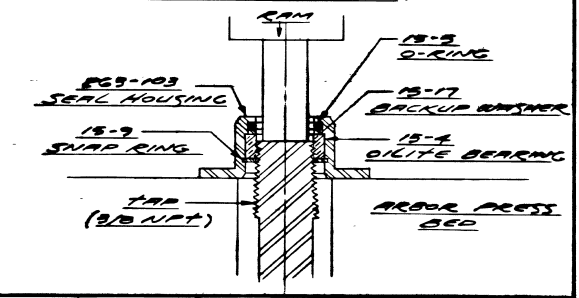
REMOVE END CAP. * REMOVE 1500-20 SNAP RING. REMOVE 1500-11 BEARINGS & 1500-10 FROM HOUSING AS SHOWN.



⑥

REMOVE #15-9 SNAP RING. REMOVE #15-4 OILITE BEARING.

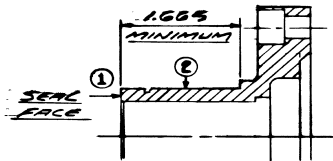
(AFTER UNSCREWING #263-103 HOUSING FROM END BELL, THREAD TAP INTO #15-9 OILITE BEARING. PLACE ON ARBOR PRESS & WITH A ROD PUSH TAP OUT. BEARING CAN BE FREED FROM TAP BY CRACKING IT WITH A HAMMER. REMOVE ALL INTERNAL PARTS & DISCARD.)



G				MATERIAL	SCALE FULL	DEUBLIN COMPANY	
F					DRAWN	NORTHBROOK, ILLINOIS, U.S.A.	
E					D/YE	DISASSEMBLY, MODEL #263-100	
D					APP D	TOLERANCES	
C						FILMED <input type="checkbox"/>	
B						FRACTIONS ± 0.10	
A						DECIMALS AS SPECIFIED	
LET	REVISION	DATE	SIGN			ANGLES ± 1/2°	
						NO. DA 41	

When assembling Model 263-100 Deublin Union, Cleanliness is an important factor. All parts must be free of dirt and chips. The parts must be cleaned with chloroethene, carbon tetra-chloride, alcohol or any good cleaning solvent.

Before assembly, the 263-101 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.



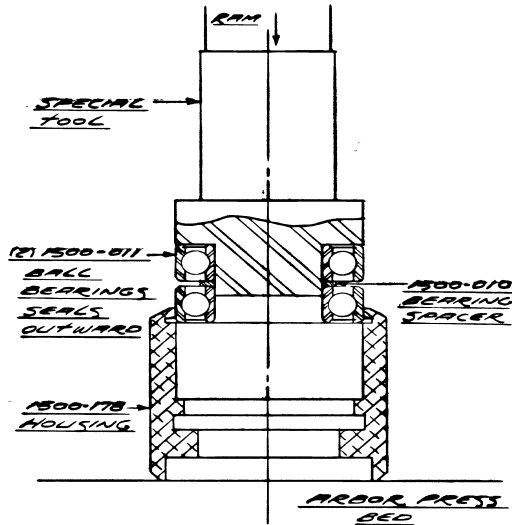
After grinding, the rotor seal face should be polished. This is done by placing a sheet of #/0 polishing paper on a sheet of plate glass, and then placing the rotor seal (face side down) on the polishing paper, moving it in a figure eight several times.

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

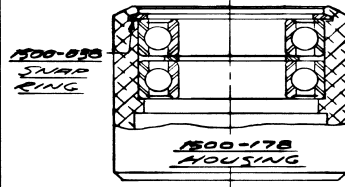
MODEL 263-100 REPAIR KIT

- (1) 15-004 Bearing
- (2) 15-005 O-ring
- (1) 15-009 Spirolox
- (1) 15-017 Backup washer
- (1) 263-104 Gasket
- (1) 1500-011 Ball Bearing
- (2) 1500-012 O-ring
- (1) 1500-016 Snap Ring
- (1) 1500-034 Wave Spring
- (1) 1500-177 Seal Assembly
- (1) 1595-009 O-Ring

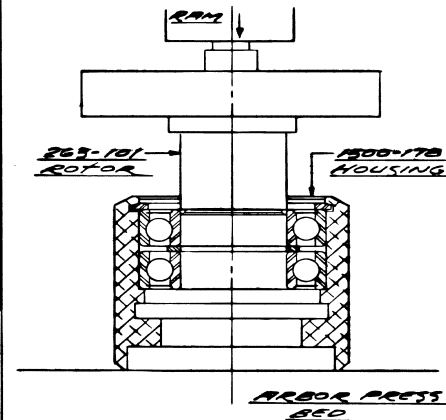
① ASSEMBLE #1500-011 BALL BEARINGS AND #1500-010 BEARING SPACER



② ASSEMBLE #1500-034 SNAP RING (BEVEL SIDE UP)

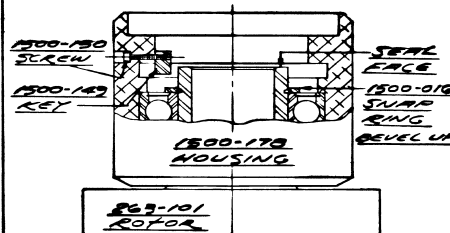


③ ASSEMBLE #263-101 ROTOR
NOTE - ROTOR WILL SLIP IN UP TO THE SNAP RING GROOVE & MUST PRESS IN FROM THERE



④ ASSEMBLE #1500-016 SNAP RING

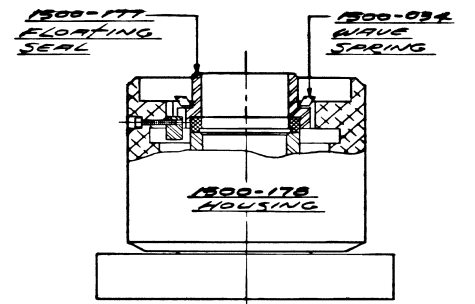
(THIS IS A DIFFICULT OPERATION AND CARE MUST BE TAKEN NOT TO NICK THE SEAL FACE DURING INSTALLATION.) ASSEMBLE 1500-180 KEYS WITH LONG SECTION DOWN.



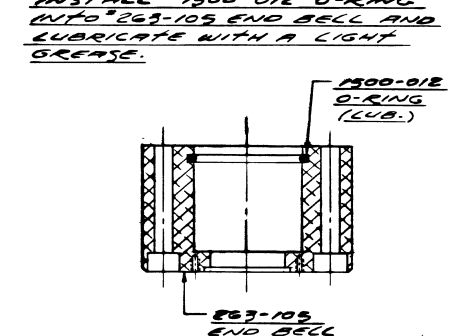
⑤ CLEAN SEAL FACES

SEAL FACE OF #263-101 ROTOR AND OF #1500-177 FLOATING SEAL MUST BE FREE OF ALL DIRT AND OIL.
OIL ENTIRE #263-101 ROTOR SEAL FACE (LIGHT VISCOSITY OIL)

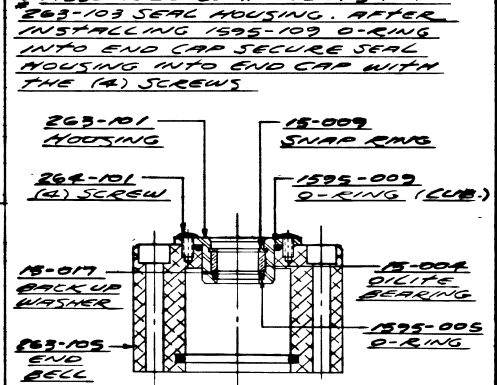
⑥ INSTALL #1500-177 FLOATING SEAL AND 1500-034 WAVE SPRING



⑦ INSTALL #1500-012 O-RING INTO #263-105 END BELL AND LUBRICATE WITH A LIGHT GREASE.

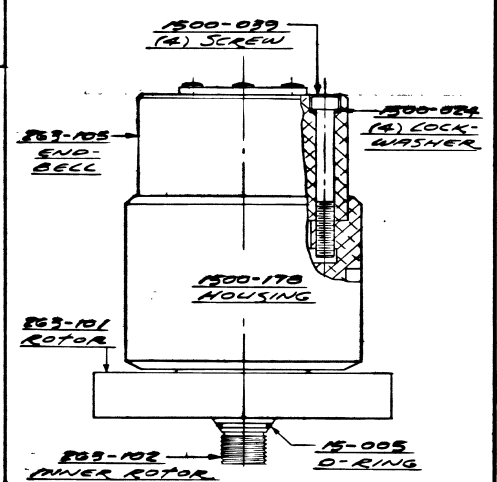


⑧ ASSEMBLE COMPONENTS INTO #263-103 SEAL HOUSING. AFTER INSTALLING 1595-109 O-RING INTO END CAP SECURE SEAL HOUSING INTO END CAP WITH THE (4) SCREWS



⑨ ASSEMBLE #263-105 END CAP INTO HOUSING. (HOLD DOWN WHILE TIGHTENING SCREWS) - INSTALL #15-009 O-RING INTO #263-103 ROTOR.

INSTALL #263-104 GASKET INTO CUSTOMER SHAFT PREPARE UNION



Q		MATERIAL	SCALE 3/4" = 1"	DEUBLIN COMPANY NORTHBROOK, ILLINOIS, U.S.A. ASSEMBLY, MODEL #263-100
F			DRAWN U.S.S.	
E			DATE	
D			APP. B	
C				TOLERANCES FRACTIONS ± 0.10
B				DECIMALS AS SPECIFIED
A				ANGLES ± 1/2°
REV	REVISION	DATE	SIGN	NO. DA-41