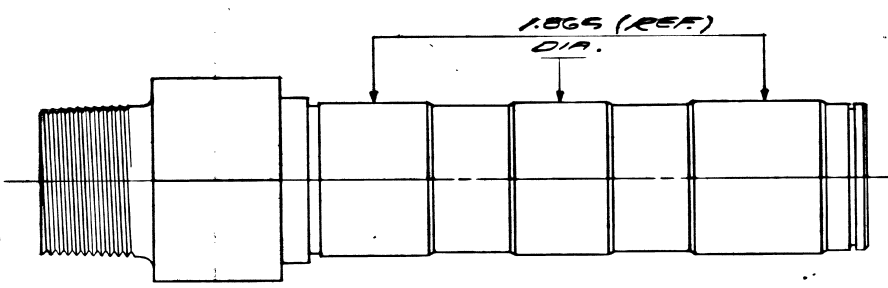
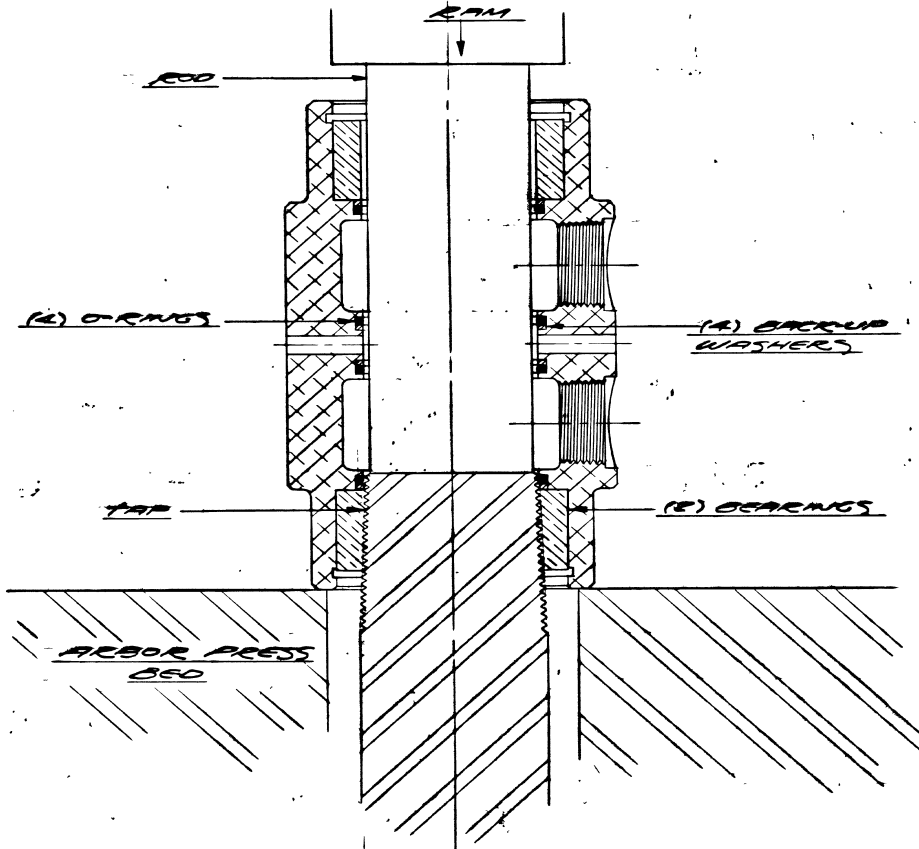
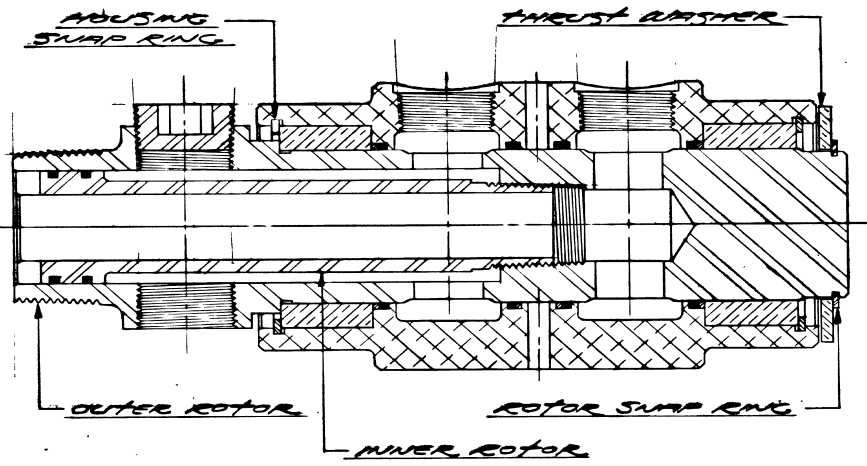


NOTE: PROCEED WITH STEPS 4 & 5 ONLY IF BEARINGS ARE SCORED AND REQUIRE REPLACEMENT

- ① REMOVE ROTOR SNAP RING (USE TWEARCL PLIERS #5)
- ② REMOVE THRUST WASHER AND ROTOR
- ③ REMOVE (E) HOUSING SNAP RINGS (USE TWEARCL PLIERS #5), IF BEARINGS REQUIRE REPLACEMENT.

- ④ REMOVE (E) BEARINGS (USE 1/2 PIPE TAP)
- ⑤ THREAD TAP INTO ONE BEARING, WITH THE UNION ON THE ARBOR PRESS BED, INSERT A ROD AND PUSH TAP OUT. BEARING CAN BE FREED FROM TAP BY CRACKING IT WITH A HAMMER. REPEAT THIS OPERATION ON THE SECOND BEARING.

- ⑥ REMOVE (A) O-RINGS & BACK-UP WASHERS BY PIERCING WITH A SHARP POINTED TOOL

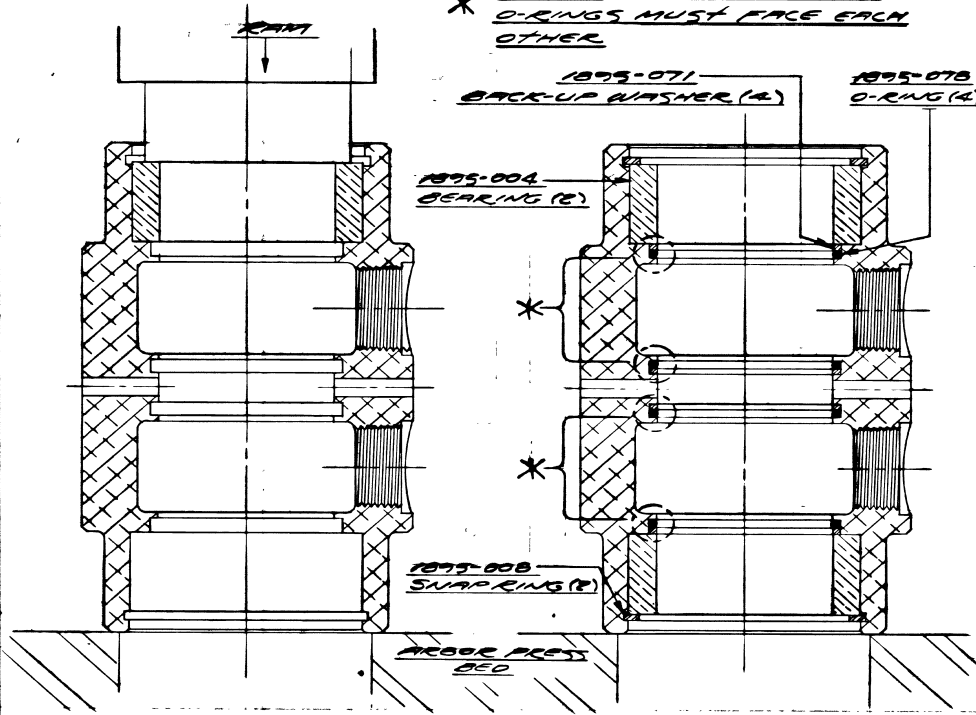


NOTE: INSPECT THE ROTOR FOR GROOVES OR EXCESSIVE WEAR. IF ROTOR IS IN POOR CONDITION OR GROOVES ARE DEEPER THAN GIVEN DIMENSIONS, A NEW (OUTER) ROTOR SHOULD BE PURCHASED BEFORE ASSEMBLING.

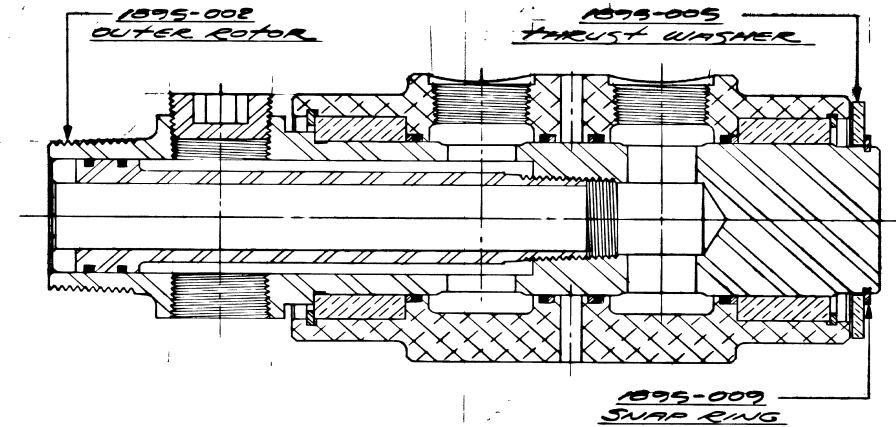
Q			MATERIAL	SCALE FULL	DEUBLIN COMPANY NORTHROOK, ILLINOIS, U.S.A.
F				DRAWN U.S.	
E				D/T/E	1895-100 REPAIR INSTRUCTIONS
D				APP B	
C					TOLERANCES FRACTIONS ± 010 DECIMALS AS SPECIFIED ANGLES ± 1/2°
B					
A					NO. DA 46
LET	REVISION	DATE SIGN	REMOVE BURRS AND BREAK ALL SHARP CORNERS 010 OR AS SPECIFIED REMOVE GREASE OR MACHINING OILS		

- ① CLEAN HOUSING AND WIPE BEARINGS
 LOAD (1) BEARING INTO HOUSING - TURN PART AND REPEAT OPERATION FOR 2ND BEARING. ASSEMBLE SNAP RINGS INTO HOUSING.
- ② INSERT (4) BACK-UP WASHERS AND (4) O-RINGS IN POSITION AS SHOWN

* NOTE: THE (2) SETS OF O-RINGS MUST FACE EACH OTHER

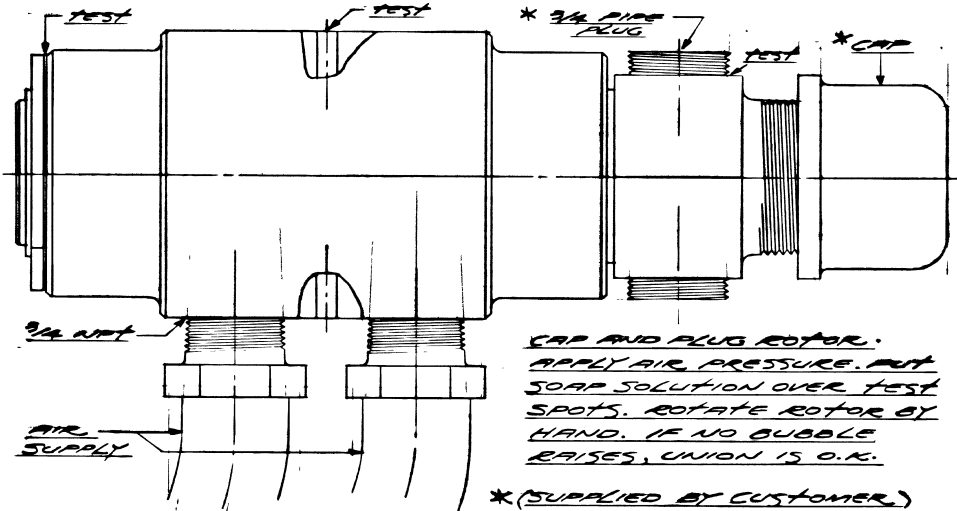


- ③ LIGHTLY GREASE ROTOR AND INSTALL INTO HOUSING
- ④ ASSEMBLE THRUST WASHER AND ROTOR SNAP RING



TESTING

TEST UNION WITH 50 P.S.I. MINIMUM AIR PRESSURE BEFORE PERMANENT INSTALLATION



NOTE: ALL PARTS MUST BE CLEAN BEFORE ASSEMBLY

REPAIR KIT PARTS LIST

- 1895-009 SNAP RING 1895-071 BACK-UP WASHER (4)
 1895-078 O-RING (4)

RE-BUILDING KIT PARTS LIST

- 1895-008 SNAP RING (2) 1895-009 SNAP RING
 1895-004 BEARING (2) 1895-071 BACK-UP WASHER (4)
 1895-005 THRUST WASHER 1895-078 O-RING (4)

G			MATERIAL	SCALE	FULL	DEUBLIN COMPANY NORTHBROOK, ILLINOIS, U.S.A. 1895-100 REPAIR INSTRUCTIONS
F				DRAWN	U.S.	
E				D/TE		
D				APP B		
C						
B			ALL DIAMETERS TO BE CONCENTRIC WITHIN .005 T I R OR AS SPECIFIED	TOLERANCES		FILMED <input type="checkbox"/>
A			REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED REMOVE GREASE OR MACHINING OILS	FRACTIONS ± .010 DECIMALS AS SPECIFIED ANGLES ± 1/8°		NO
LET	REVISION	DATE	SIGN			DA 46