

WHEN REPAIRING INFLU IN UNIONS, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. THE PARTS MAY BE CLEANED WITH CLOROTHENE, CARBON TETRA CHLORIDE, ALCOHOL OR ANY GOOD CLEANING SOLVENT.

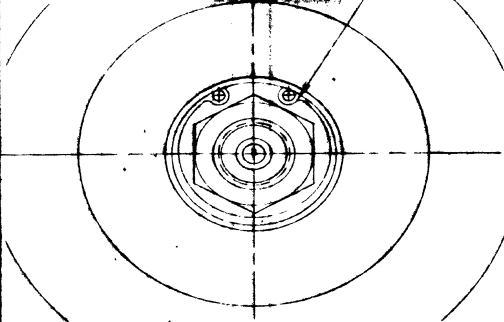
1005-185B REBUILDING KIT PARTS LIST

- (1) 1005-094 ROTOR
- (2) 1005-004 BALL BEARINGS
- (1) 1005-005 BEARING SPACER
- (1) 1005-007 SNAP RING

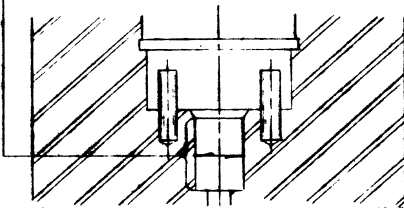
PRE-ASSEMBLED

- (1) 1005-008 O-RING
- (1) 1005-009 SEAL GUIDE
- (1) 1005-010 COIL SPRING
- (1) 1005-056 FLOATING SEAL
- (1) 1005-006 SNAP RING

1 REMOVE *1005-006 HOUSING SNAP RING

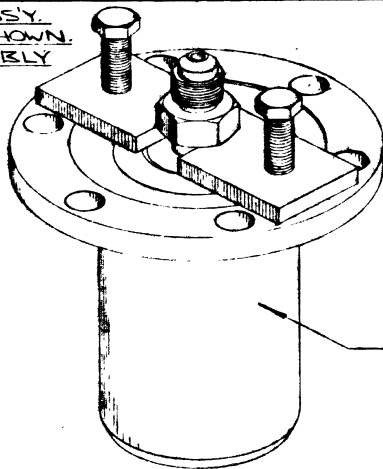


3 CHECK AREA OF BORE SHOWN FOR WEAR AND PITTING. THE BORE MUST BE SMOOTH (30-40 RMS FINISH) AND MAY BE ENLARGED TO .289 MAX. DIA. IF REQUIRED.



2 REMOVE ROTOR ASSY. WITH PULLER AS SHOWN. DISCARD ROTOR ASSEMBLY AND ALL LOOSE INTERNAL PARTS.

CLEAN ALL INTERNAL SURFACES.

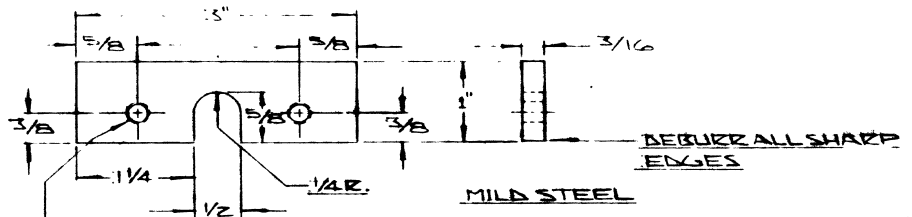


THIS SURFACE MUST BE PROTECTED FROM DAMAGE, SCRATCHES AND NICKS CAN CAUSE LEAKAGE PAST PISTON SEAL.

RECOMMENDED TOOLING

- TRIARC PLIERS NO 3
- (2) 1/4-28x1/2 HEX HEAD BOLTS
- ROTOR ASSEMBLY REMOVAL PLATE

TOOLING NOT INCLUDED WITH REBUILDING KIT.



*3 (213) DRILL THRU. TAP 1/4-28 UN.F. (R-H) THRU. 2 HOLES LOCATED AS SHOWN.

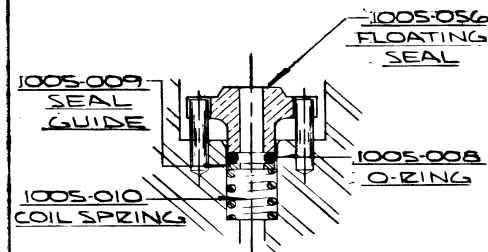
4 CLEAN ROTOR SEAL FACE AND *1005-056 BRONZE FLOATING SEAL FACE.

SEAL FACES MUST BE FREE OF ALL DIRT AND DUST.

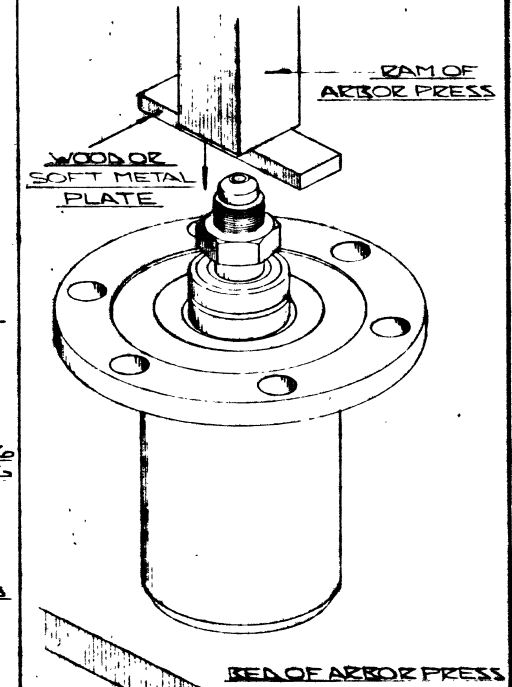
ASSEMBLE *1005-010 COIL SPRING, *1005-009 SEAL GUIDE, *1005-008 O-RING, AND *1005-056 FLOATING SEAL AS SHOWN BELOW.

OIL ENTIRE FLOATING SEAL FACE WITH CLEAN 20W MOTOR OIL.

IMPORTANT KEEP FLANGE UP RIGHT FOR STEPS 4 AND 5. FAILURE TO DO SO WILL DISENGAGE FLOATING SEAL FROM KEY PINS AND UNION WILL NOT ASSEMBLE PROPERLY.



5 PROTECT ROTOR END TAPER WITH A SMALL PIECE OF WOOD OR SOFT METAL PLATE. PRESS OR TAP LIGHTLY INTO BORE AS SHOWN. INSTALL HOUSING SNAP RING (REFER TO STEP NO. 1)



H	MATERIAL	SCALE
B		DRAWN G.A.
F		DATE 10-2-81
E		APP'D
C		
D		
B		
A		
LET	REVISION	ECO DATE SIGN

TOLERANCES - FRACTIONS & .010 DECIMALS AS SPECIFIED ANGLES & 1/2° ALL DIAMETERS TO BE CONCENTRIC WITH OD T.I.R. OR AS SPECIFIED REMOVE BURRS AND BREAK ALL SHARP CORNERS .010 OR AS SPECIFIED REMOVE SPRADE OR MACHINING OILS

DEUBLIN COMPANY
NORTHBROOK ILLINOIS U.S.A.

REBUILDING PROCEDURE FOR MODEL 1005-185

DA-47