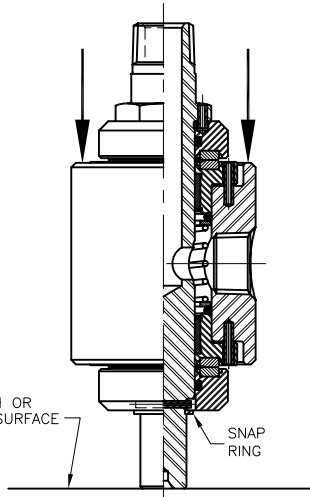
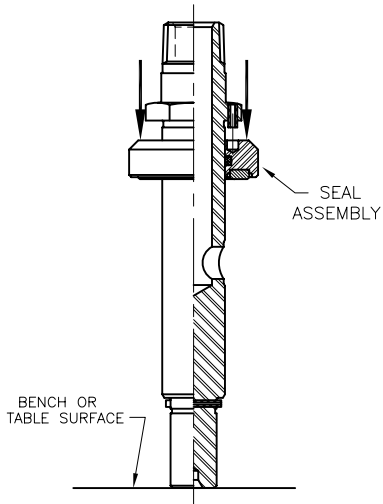


DISASSEMBLY

1. REMOVE SNAP RING; SET UNION ON END OF ROTOR AS SHOWN AND PUSH DOWN ON HOUSING TO REMOVE ROTOR AND ALL INTERNAL PARTS.



2. PUSH DOWN ON REMAINING SEAL ASSEMBLY TO REMOVE FROM ROTOR.



ASSEMBLY

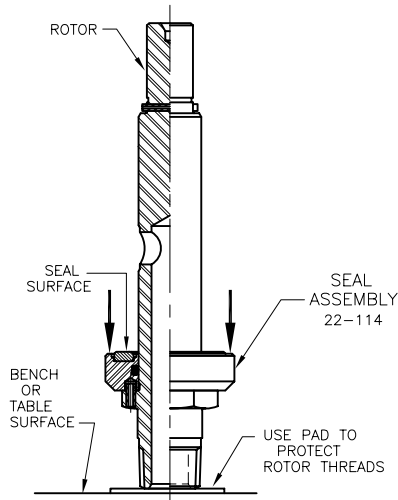
REBUILDING KIT PARTS LIST

DESCRIPTION	PART NO.	QTY
SEAL PLATE ASSY	22-114	1
O-RING	21-112	2
COIL SPRING	21-106	1
SEAL GUIDE	22-119	2
FLOATING SEAL ASSY	22-191	2
O-RING	6075-178	2
SEAL PLATE ASSY	22-178	1
SNAP RING	22-180	1

NOTE:

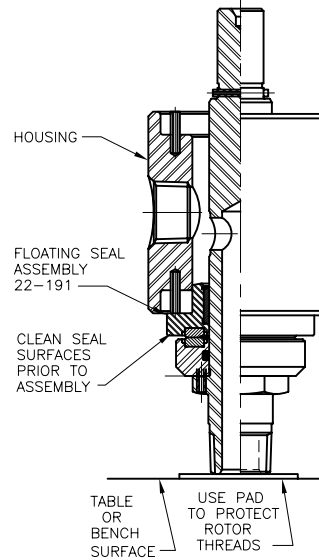
WHEN ASSEMBLING DEUBLIN UNIONS, CLEANLINESS IS AN IMPORTANT FACTOR. ALL PARTS MUST BE FREE OF DIRT AND CHIPS. THE PARTS MAY BE CLEANED WITH CARBON TETRACHLORIDE, DENATURATED ALCOHOL, OR ANY GOOD CLEANING SOLVENT.

1. ASSEMBLE SEAL ASSEMBLY, 22-114, ONTO ROTOR, TAKING CARE NOT TO MAR SEAL SURFACE.



NOTE: O-RINGS AND SEALS FACES TO BE CLEAN AND FREE OF LUBE OR GREASE.

2. CLEAN SEAL FACES. ASSEMBLE FLOATING SEAL ASSEMBLY, 22-191, AND HOUSING.

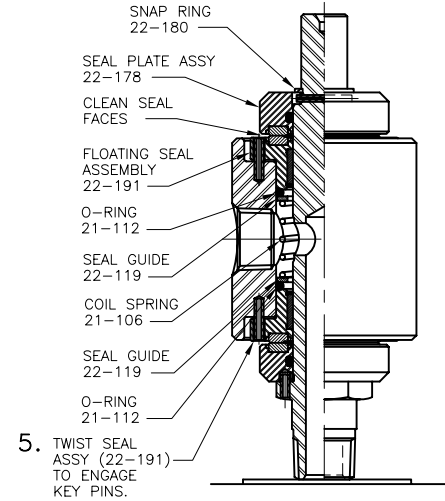
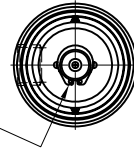


ASSEMBLY TIP:

DO NOT ALIGN SEAL ASSY (22-191) WITH KEY PINS IN HOUSING UNTIL AFTER THE REST OF ASSEMBLY IS COMPLETE.

3. ASSEMBLE REMAINING PARTS AS SHOWN. CLEAN SEAL FACES PRIOR TO ASSEMBLY. ALIGN SEAL ASSEMBLES TO ENGAGE ROTOR & HOUSING KEY PINS.

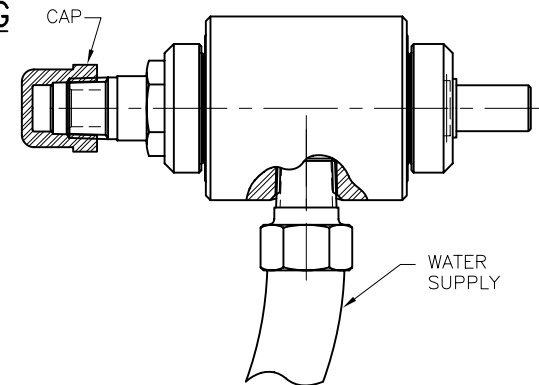
4. ASSEMBLE SNAP RING ALIGNED 90° FROM KEY PIN AS SHOWN, WITH SHARP SIDE OF SNAP RING I.D. FACING UP.



5. TWIST SEAL ASSY (22-191) TO ENGAGE KEY PINS.

RECOMMENDED TESTING

CAP ROTOR AS SHOWN AND TEST WITH 1000 PSI WATER @ 43 RPM. LEAK RATE IS 3 DROPS PER SECOND PER SIDE.



EQUIPMENT REF:				MARK VII ARVADA, CO		SCALE: NONE		DATE: 07/07/97		DRAWN: LG		ENGR:		APPD:		DEUBLIN COMPANY WAUKEGAN, ILLINOIS, U.S.A.	
ASSY/TEST FIXTURES REQUIRED:						UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN () ARE IN MILLIMETERS.		TITLE: REPAIR INSTRUCTIONS FOR DEUBLIN UNION MODEL 22-013-174		NO.		CAD DRAWING		DA-067			
A	REVISED & REDRAWN	07/97	BG	LET.	REVISION	ECD	DATE	SIGN									