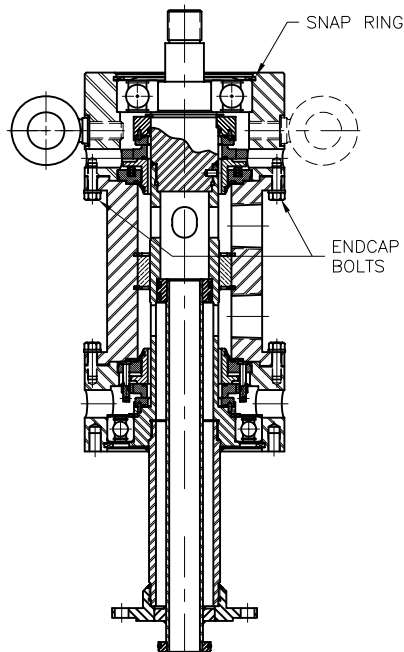
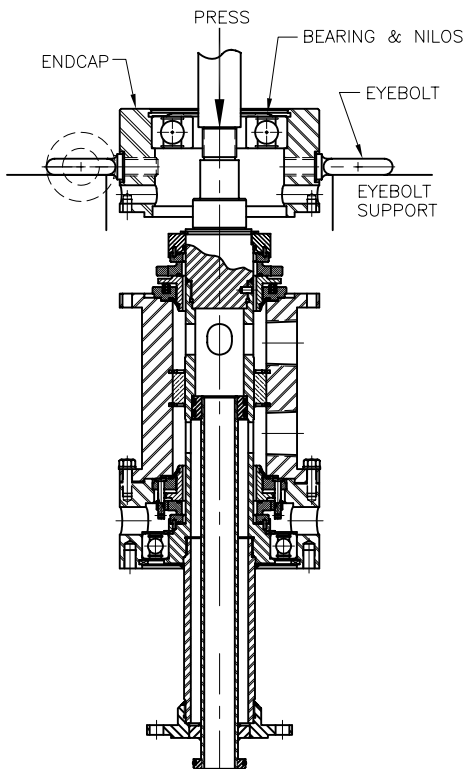


DISASSEMBLY

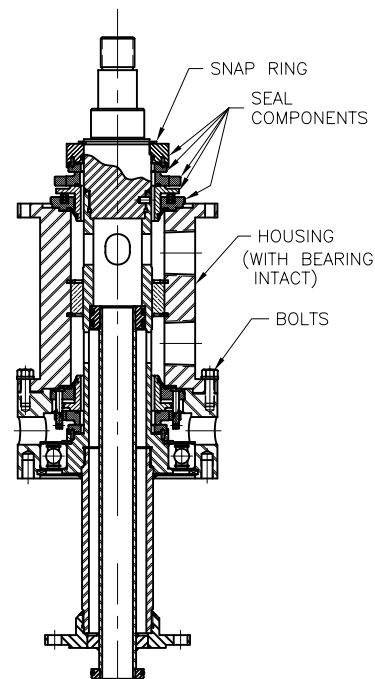
1. REMOVE INDICATED SNAP RING AND BOLTS.



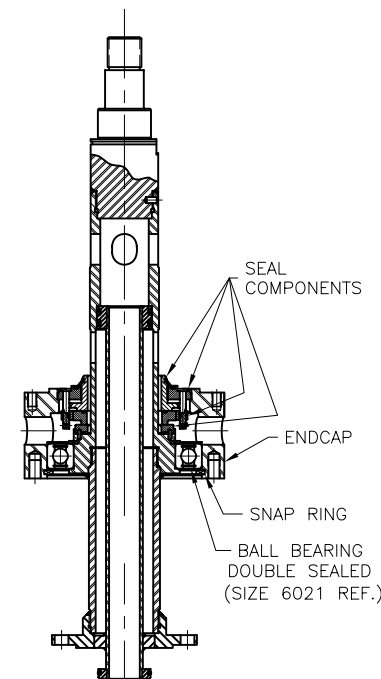
2. SUPPORT ENDCAP BY EYEBOLTS AND PRESS ROTOR AND REMAINING PARTS OUT OF ENDCAP.




3. REMOVE ROTOR SNAP RING AND SEAL COMPONENTS AS SHOWN.
NEXT REMOVE HOUSING BOLTS AND HOUSING (WITH BRONZE BEARING INTACT) AS SHOWN.



4. REMOVE REMAINING SEAL COMPONENTS. IF BALL BEARING REPLACEMENT IS REQUIRED, REMOVE SNAP RING AND PRESS ROTOR WITH BEARING OUT OF ENDCAP.



				EQUIPMENT REF:		SCALE	1:2	DATE	07/18/97	 DEUBLIN COMPANY WAUKEGAN, ILLINOIS, U.S.A.
				FORD GLASS TECHNICAL		DRW	LG	07/18/97		
						ENGR	LG	07/18/97		
				ASSY/TEST FIXTURES REQUIRED:		APPD				TITLE:
						UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN () ARE IN MILLIMETERS.				REPAIR INSTRUCTIONS FOR DEUBLIN UNION MODEL 936-300
LET.	REVISION	ECD	DATE	SIGN					NO.	DA-068 (SHT 1 OF 2) C.A.D. DRAWING

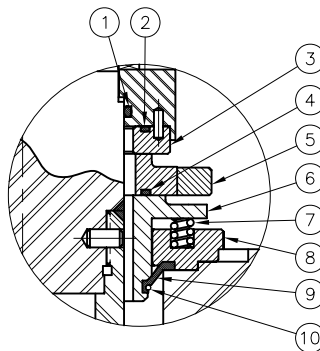
REPAIR KIT PARTS LIST

KIT #936-300C

NOTE:

SEAL COMPONENTS COME PRE-ASSEMBLED IN (2) CARTRIDGE ASSEMBLIES, MADE UP OF ITEMS INDICATED (ITEMS 11 AND 12 NOT SHOWN IN THIS VIEW)

ITEM	PART NO.	DESCRIPTION	QTY
1	676-208	O-RING	1
2	857-109	O-RING	2
3	6300-154	SEAL FACE	2
4	6300-127	O-RING	2
5	6300-112	SEAL RING ASSY	2
6	6300-108	FLOATING SEAL	2
7	6300-131	COIL SPRING	12
8	6300-109	RETAINING PLATE	2
9	6300-114	DIAPHRAGM	2
10	6300-115	GARTER SPRING	2
11	6250-108	KEY PIN	4
12	250-081	KEY PIN	4



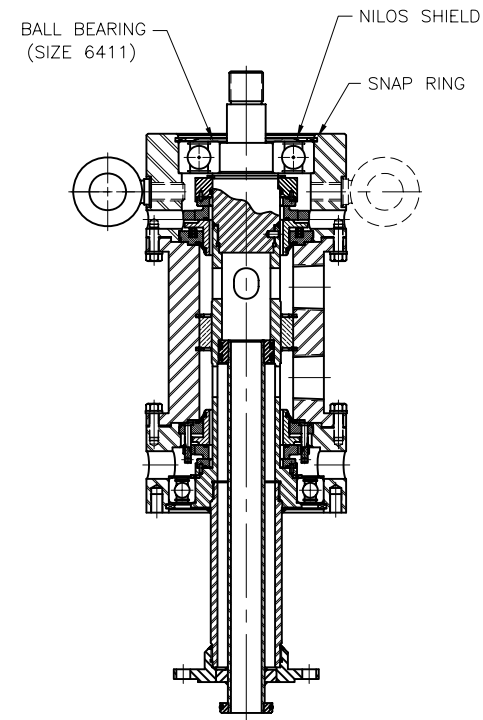
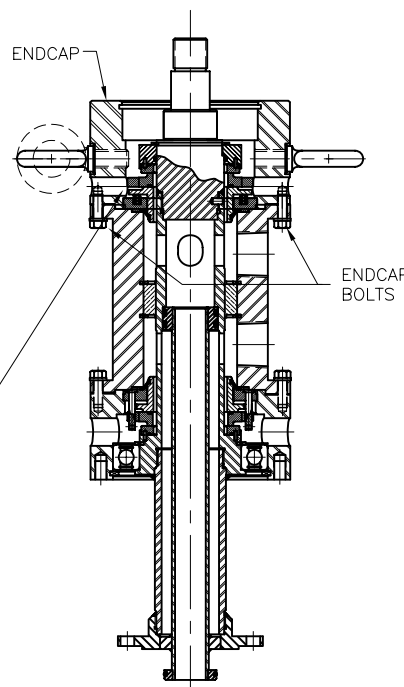
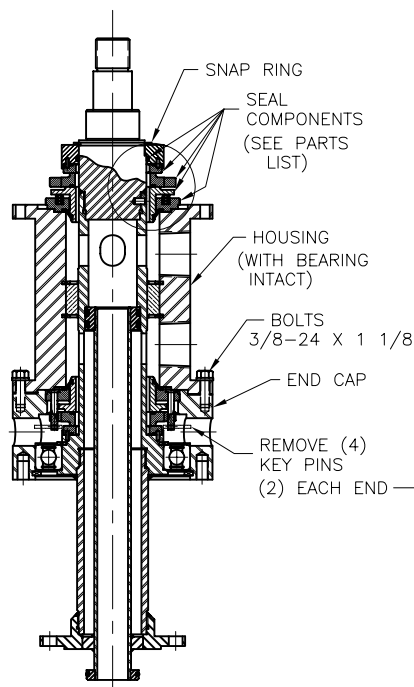
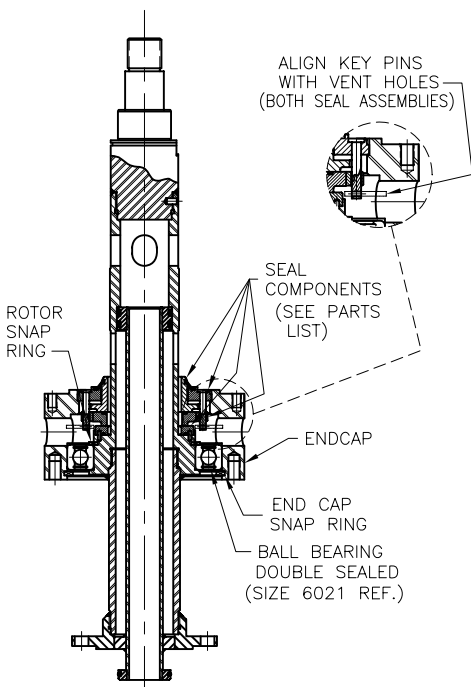
ASSEMBLY

1. IF BEARING IS BEING REPLACED, PRESS BEARING ONTO ROTOR AND ASSEMBLE ROTOR SNAP RING. ASSEMBLE END CAP AND END CAP SNAP RING. ASSEMBLE SEAL COMPONENTS AS SHOWN SO THAT KEY PINS ALIGN WITH VENT HOLES (TO BE REMOVED AFTER ASSEMBLY).

2. BOLT HOUSING ONTO END CAP AS SHOWN AND ASSEMBLE NEW SEAL COMPONENTS AND SNAP RING.

3. BOLT ENDCAP TO HOUSING AS SHOWN.

4. PRESS IN BALL BEARING. ASSEMBLE NILOS SHIELD AND SNAP RING AS SHOWN



LET.	REVISION	ECD	DATE	SIGN

EQUIPMENT REF:
FORD GLASS
TECHNICAL

ASSY/TEST FIXTURES
REQUIRED:

SCALE 1:2
DIN LG 07/18/97
ENGR LG 07/18/97
APPD

UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN () ARE IN MILLIMETERS.

DEUBLIN COMPANY
WAUKEGAN, ILLINOIS, U.S.A.

TITLE: REPAIR INSTRUCTIONS FOR DEUBLIN UNION MODEL 936-300

NO. DA-068 (SHT 2 OF 2)

CAD DRAWING