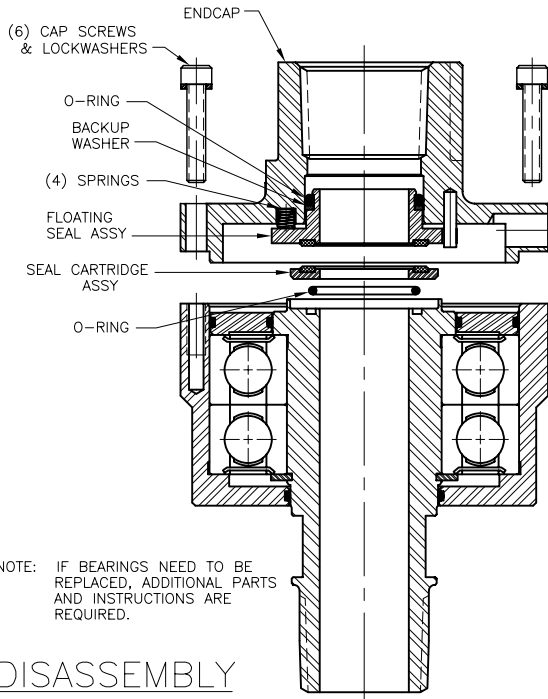
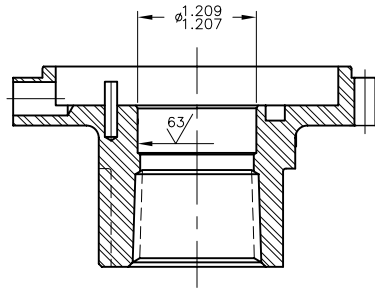


1. REMOVE (6) CAP SCREWS AND REMOVE END CAP AS SHOWN. REMOVE FLOATING SEAL, SEAL CARTRIDGE ASSY, SPRINGS, BACKUP WASHER AND O-RINGS.

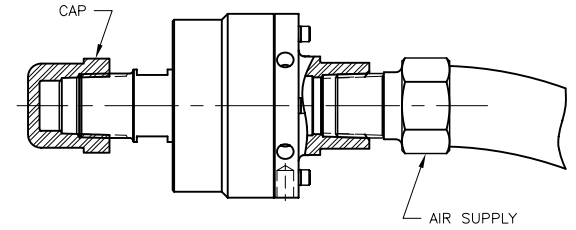


DISASSEMBLY

2. INSPECT ENDCAP BORE FOR WEAR OR PITTING. BORE SHOULD BE SMOOTH AND TO SIZE SHOWN.



CAP ROTOR AND PUT MASKING TAPE OVER ALL BUT ONE VENT HOLE. APPLY AIR PRESSURE. BRUSH SOAP WATER SOLUTION OR BUBBLE SOAP TO VENT HOLE. ROTATE UNION BY HAND; IF NO BUBBLE RISES, UNION IS O.K.



TEST UNION WITH 100 PSI AIR PRESSURE BEFORE PERMANENT INSTALLATION.

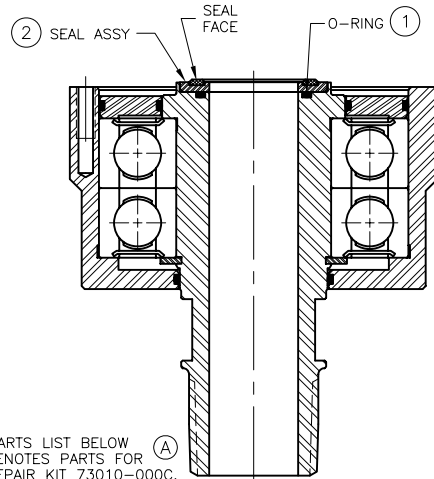
TESTING

ASSEMBLY

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 TETRA-CHLORIDE, DENATURATED ALCOHOL, OR ANY GOOD CLEANING SOLVENT.

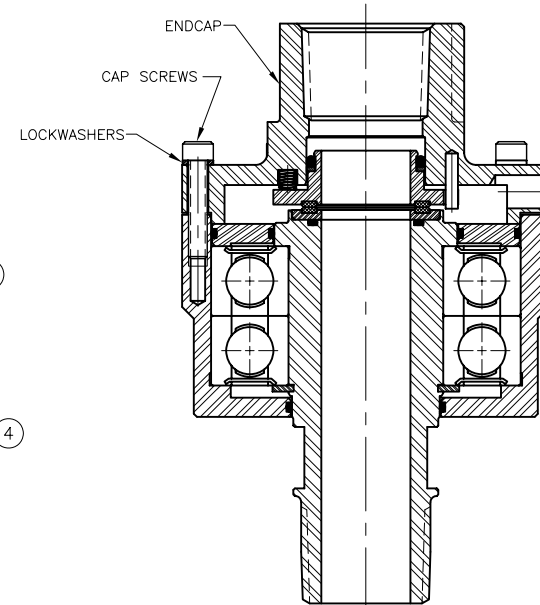
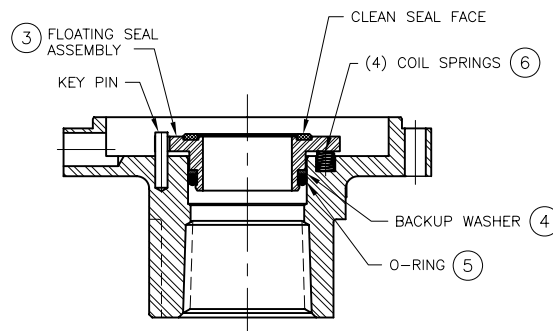
3. ASSEMBLE ENDCAP TO HOUSING WITH CAP SCREWS AS SHOWN.

1. PLACE ROTOR ON END, PROTECTING THREADS. ASSEMBLE O-RING AND SEAL ASSY AS SHOWN. CLEAN SEAL FACE AND LUBRICATE WITH A FEW DROPS OF LIGHT VISCOSITY OIL.



2. ASSEMBLE NEW BACKUP WASHER AND O-RING ONTO FLOATING SEAL ASSY. PLACE (4) NEW SPRINGS INTO HOLES IN ENDCAP. ALIGN FLOATING SEAL WITH KEY PINS AND PUSH INTO BORE.

CLEAN SEAL FACE AND LUBRICATE WITH A FEW DROPS OF LIGHT VISCOSITY OIL.



NOTE: PARTS LIST BELOW (A) DENOTES PARTS FOR REPAIR KIT 73010-000C.

NO	PART NUMBER	DESCRIPTION	QTY	MATERIAL	LET.	REVISION	ECO	DATE	SIGN	EQUIPMENT REF:	SCALE	FULL	DRW	LG	05/06/98	ENGR	LG	05/06/98	APPD	TITLE:	REPAIR INSTRUCTIONS FOR DEUBLIN UNION (A) MODEL 73010-000-101	NO.	CAED DRAWING
6	972-610	COIL SPRING ASSOCIATED #C0180-026-0310	4	STAINLESS STEEL																			
5	500-015	O-RING 120	1	BUNA-N 80 DUROMETER																			
4	972-608	BACK-UP WASHER	1	TEFLON																			
3	972-606	FLOATING SEAL ASSY	1	S/S CARRIER, SIC SEAL																			
2	972-604	SEAL ASSY	1	ST. STL CARRIER/SIC SEAL																			
1	1300-016	O-RING 022	1	BUNA-N																			
										A	WAS 972-600C AND 972-600		02/03	RM									
										UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN () ARE IN MILLIMETERS.													