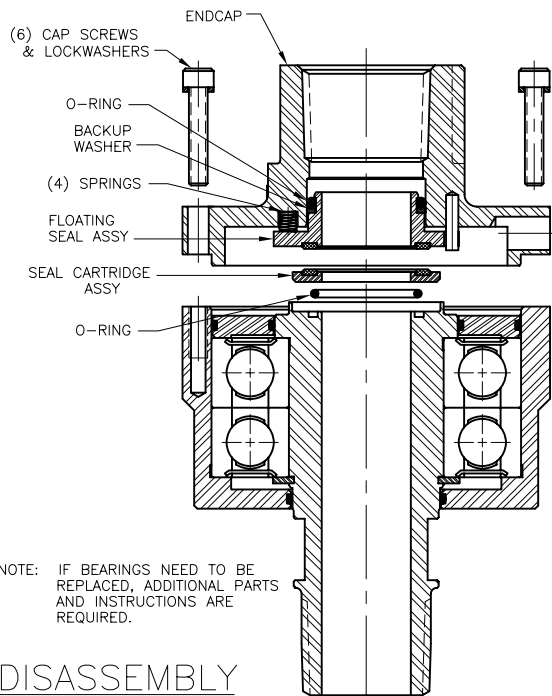
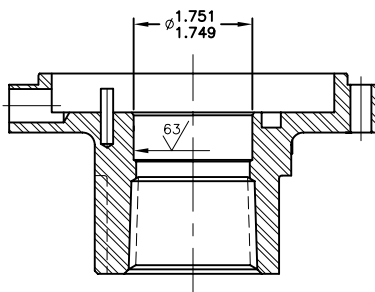


- REMOVE (6) CAP SCREWS AND REMOVE END CAP AS SHOWN. REMOVE FLOATING SEAL, SEAL CARTRIDGE ASSY, SPRINGS, BACKUP WASHER AND O-RINGS.

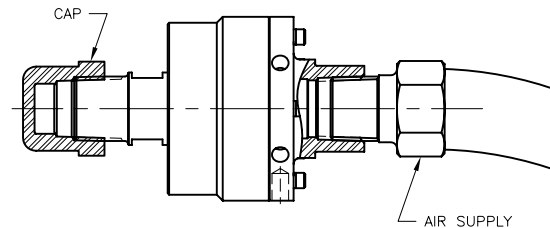


DISASSEMBLY

- 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.

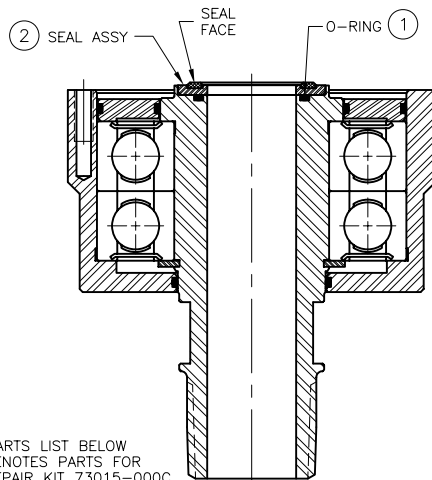
TESTING

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.

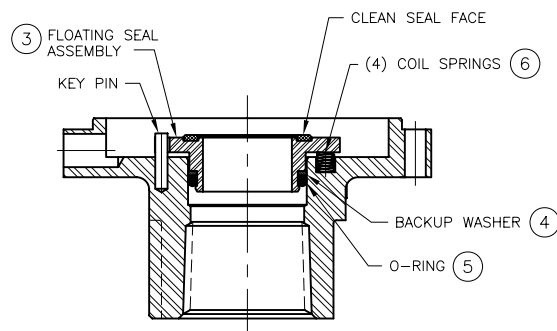
- ASSEMBLE ENDCAP TO HOUSING WITH CAP SCREWS AS SHOWN.

- 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.

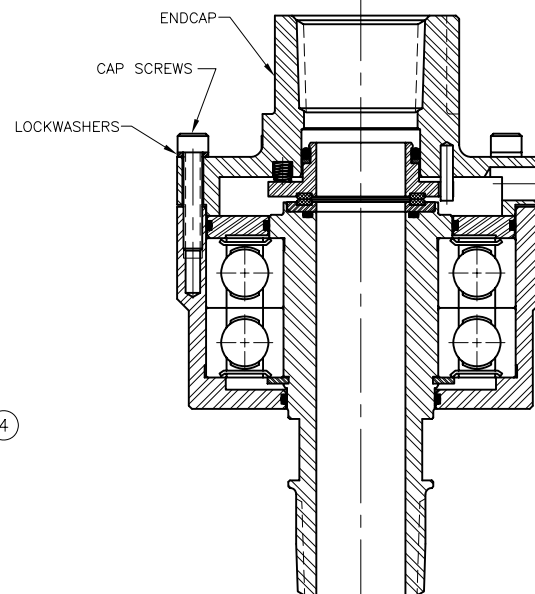


- ASSEMBLE NEW BACKUP WASHER AND O-RING ONTO FLOATING SEAL ASSY. PLACE (4) NEW SPRINGS INTO HOLES IN ENDCAP. ALIGN FLOATING SEAL WITH KEY PINS AND PUSH INTO BORE.

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



NOTE: PARTS LIST BELOW DENOTES PARTS FOR REPAIR KIT 73015-000C



NO	PART NUMBER	DESCRIPTION	QTY	MATERIAL
6	972-610	COIL SPRING ASSOCIATED #C0180-026-0310	4	STAINLESS STEEL
5	9711-408	O-RING #129	1	BUNA-N 80 DUROMETER
4	9711-406	BACK-UP WASHER	1	TEFLON
3	9711-405	FLOATING SEAL ASSY	1	S/S CARRIER, SIC SEAL
2	9711-411	SEAL ASSY	1	ST. STL CARRIER/SIC SEAL
1	525-023	O-RING #030	1	BUNA-N

LET.	REVISION	ECD	DATE	SIGN

EQUIPMENT REF:	
ASSY/TEST FIXTURES REQUIRED:	

SCALE	NONE
DRW	GA 09/15/00
ENGR	GA 09/15/00
APPD	DCR 09/15/00
UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN () ARE IN MILLIMETERS.	

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

TITLE: REPAIR INSTRUCTIONS FOR DEUBLIN UNION MODEL 73015-000

NO. **DA-73** CAD DRAWING