



Figure 1

Item #	Qty	Description	Service Kit
1	1	O-RING	Included
2	1	BACKUP WASHER	Included
3	1	O-RING	Included
4	4	SPRING, COIL	Included
5	1	HOUSING	-
6	2	SCREW, SHOULDER	Included
7	1	O-RING	Included
8	1	BACKUP WASHER	Included
9	1	FLOATING SEAL ASSEMBLY	-
10	1	O-RING	Included
11	1	BACKUP WASHER	Included
12	1	SEAL ASSEMBLY	-

Table 1: Union's Components

Table 2: Tool & Supplies List

DISASSEMBLY

Item #	Qty	Description	Service Kit
TS1	1	5/64" ALLEN WRENCH	--
TS3	1	ISOPROPYL ALCOHOL	--
TS4	--	LINT-FREE WIPE	--
TS5	--	LUBRICATION OIL (MOBIL 1 RECOMMENDED)	--
TS6	--	LOCTITE 242 ADHESIVE	--
TS7	--	TORQUE WRENCH with 5/64" hex bit and capable of 3.5 +/- 0.7 in-lb	--
TS8	--	PETROLEUM-BASED GREASE (PARKER O-RING GREASE RECOMMENDED)	--

Step 1

Remove and discard **o-rings (1, 3)** and **backup washer (2)** from the outer surface of the **housing (5)**. Discard **seal assembly, o-ring, and backup washer (10, 11)**. Save seal assembly (12).

Step 2

Press the **floating seal assembly (9)** against the **housing (5)**. Remove & discard **shoulder screws (6)** with Allen wrench (TS1), noting the screws are held into the housing with loctite 242. The seal face of the **floating seal assembly** should be protected impact may cause the seal to shatter.

Step 3

Remove the **floating seal assembly (9)** from the **housing (5)**. Discard the, **o-ring, backup washer, and coil springs (7, 8, 4)**. Save floating seal assembly (9).

Step 4

Clean **housing (5)** with isopropyl alcohol and lint-free wipe (TS3, TS4). Note: the **housing's** smaller inner diameter surface must be free of damage and debris so as to allow an elastomer to seal. If damaged or heavily scratched (See Figure 2), do not proceed with assembly; Contact Deublin Co for a new union.



Figure 2: Housing inner diameter showing no useable damage

ASSEMBLY**Step 1**

Lubricate **o-ring (7)** with petroleum-based grease (TS8). Install the **o-ring and backup washer (7,8)** onto **floating seal assembly (9)**.

ATTENTION: the **backup washer** MUST be installed on the **floating seal assembly** in the same location related to the **o-ring** as shown in Figure 1.

Step 2

Lubricate **o-ring (10)** with petroleum-based grease (TS8). Install the **o-ring and backup washer (10,11)** into **seal assembly (12)**.

ATTENTION: the **backup washer** MUST be installed in the **seal assembly** in the same location related to the **o-ring** as shown in Figure 1.

Step 3

Insert the **coil springs (4)** into the holes in the **housing (5)**. Insert the **floating seal assembly (9)** into the **housing (5)**.

Step 4

Apply a drop of Loctite 242 adhesive (TS6) to the threads of the **shoulder screws (6)**. Press down on the **floating seal assembly (9)**.

ATTENTION: take care when pressing down or releasing the **floating seal assembly** after installing the **shoulder screws**. The seal face of the **floating seal assembly** must not be used to hold down the **assembly** at this step due to possible damage.

Insert the **shoulder screws (6)** in the threaded holes of the **housing (5)** with the 5/64" Allen wrench. Torque the **shoulder screws** to 3.5 +/- 0.7 in-lb using the torque wrench (TS7).

Step 5

Lubricate **o-rings (1,3)** with petroleum-based grease (TS8). Install the **o-rings and backup washer (1,2,3)** onto **housing (5)**.

ATTENTION: the **backup washer** MUST be installed on the **housing** in the same location related to the **o-ring** as shown in Figure 1. The **o-ring (3)** must be contacting the shoulder of the **housing**.



Service Instruction

Model/Series: 20001-530
Number: 031-088
Revision: C

Step 6

Clean the mechanical seal faces of the **floating seal assembly (9)** and the **seal assembly (12)** with isopropyl alcohol and lint-free wipe (TS3 & TS4) to remove any grease and/or debris on the seal faces.

TESTING

The union can not be tested in the field before installation in the customer's application.