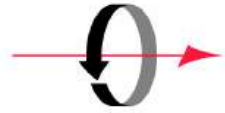


**Deublin Company
Waukegan, IL USA**



LTR	REVISION	ECO	DATE	SIGN
-	INITIAL RELEASE	N/A	10/11	ZK

Cleaning Instruction Union 925-400-000

E.I. 032-3006

SHT 1/9

Purpose:

This procedure will document the partial disassembly procedure for periodic cleaning and inspection by the end user.

Scope:

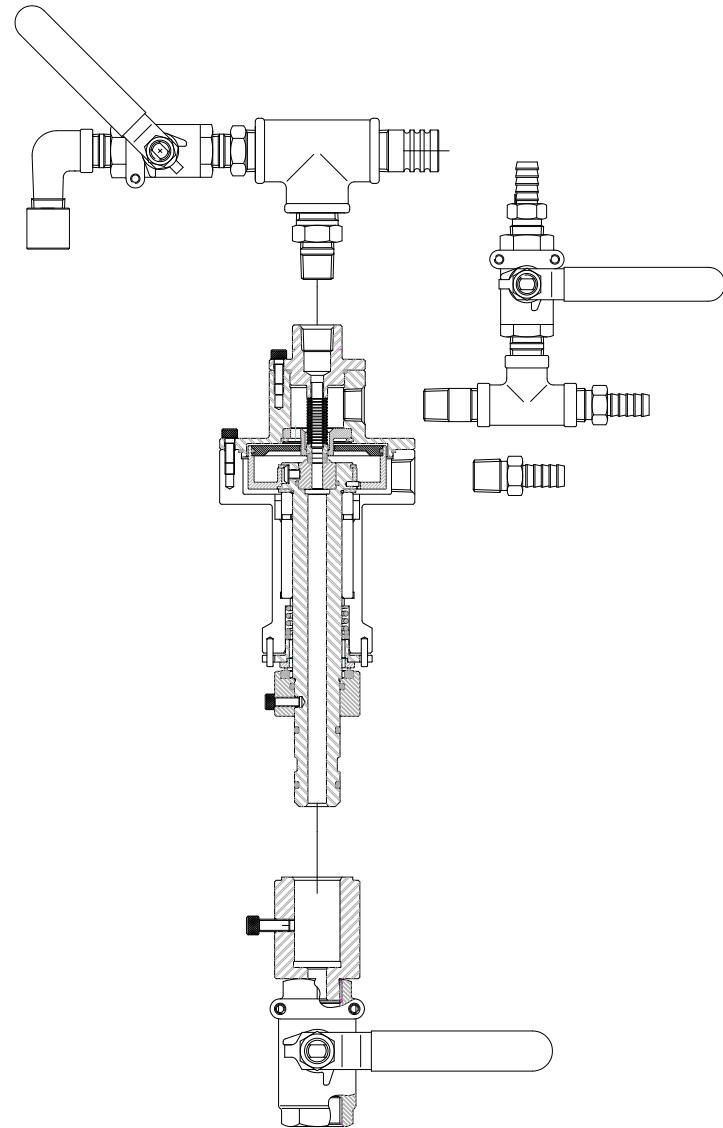
This procedure applies to all 925-400 unions.

Equipment Required:

- Adjustable and Pipe Wrenches
- 5/32", 3/16" Allen Wrenches
- Flat and Phillips Screwdrivers
- Sharp Pick for o-ring removal
- Internal Retaining Ring Pliers
- O-ring Grease
- Bucket of warm water with a little detergent and Ammonia
- Bottle Brushes of various sizes
- Non-Scratch Scrub Sponges and Dish Washing Pads
- Mineral Spirits and Acetone
- Cleaning Materials, Paper Towels

Rebuild Parts

- O-rings (replace if damaged)
- Felt Filter (replace every time)



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SHT 2

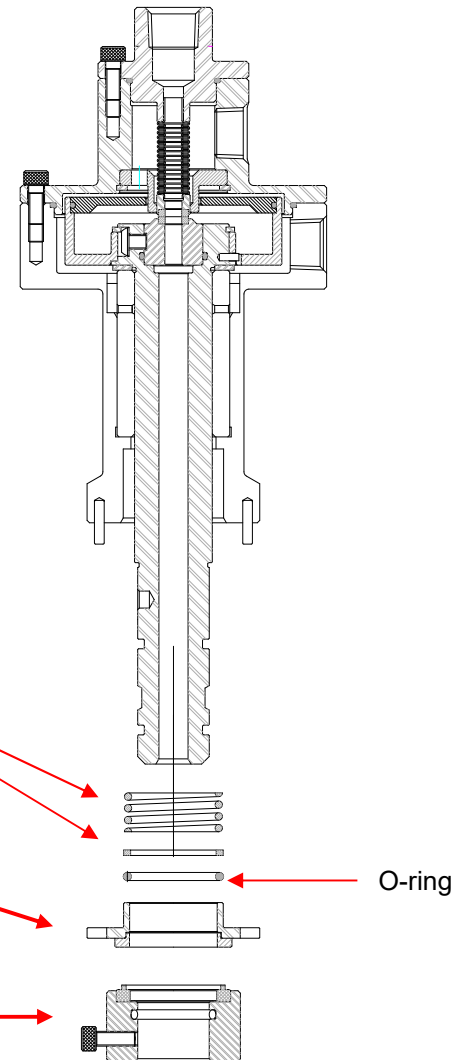
Instruction: Dis-Assemble Union's Water Seal

- 1. Clean all disassembled parts using dish washing tools and technique.**
- 2. Visually inspect parts for damage, clean seals with Mineral Spirits or Acetone if residual coagulum is present. Do not scratch seals!**
- 3. Lightly lubricate o-rings with grease.**
- 4. Before reassembly, put one drop of light oil on the face of the Floating Seal.**

Step 3: Remove O-ring, metal washer and spring.

Step 2: Remove Floating Seal by loosening 2 bolts holding the flange.

Step 1: Dis-assemble Water Seal by loosening the set screw.

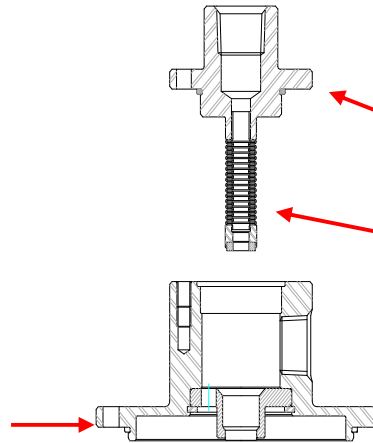


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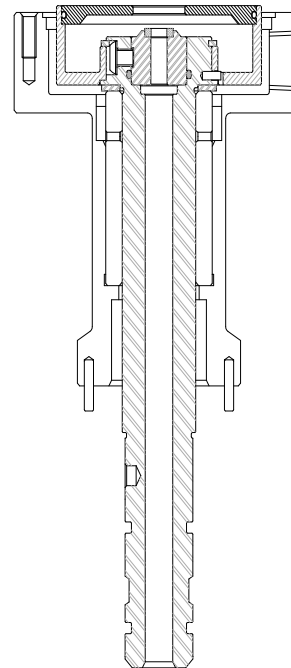
SHT 3

Instruction (cont.):
Dis-Assemble
Internal Seal's Chamber

Step 4: Open Internal Seal Assembly by removing cup screws holding Housing Cover.



Step 5: Carefully pull out rear Seal Assembly
Avoid bending or stretching metal bellow.



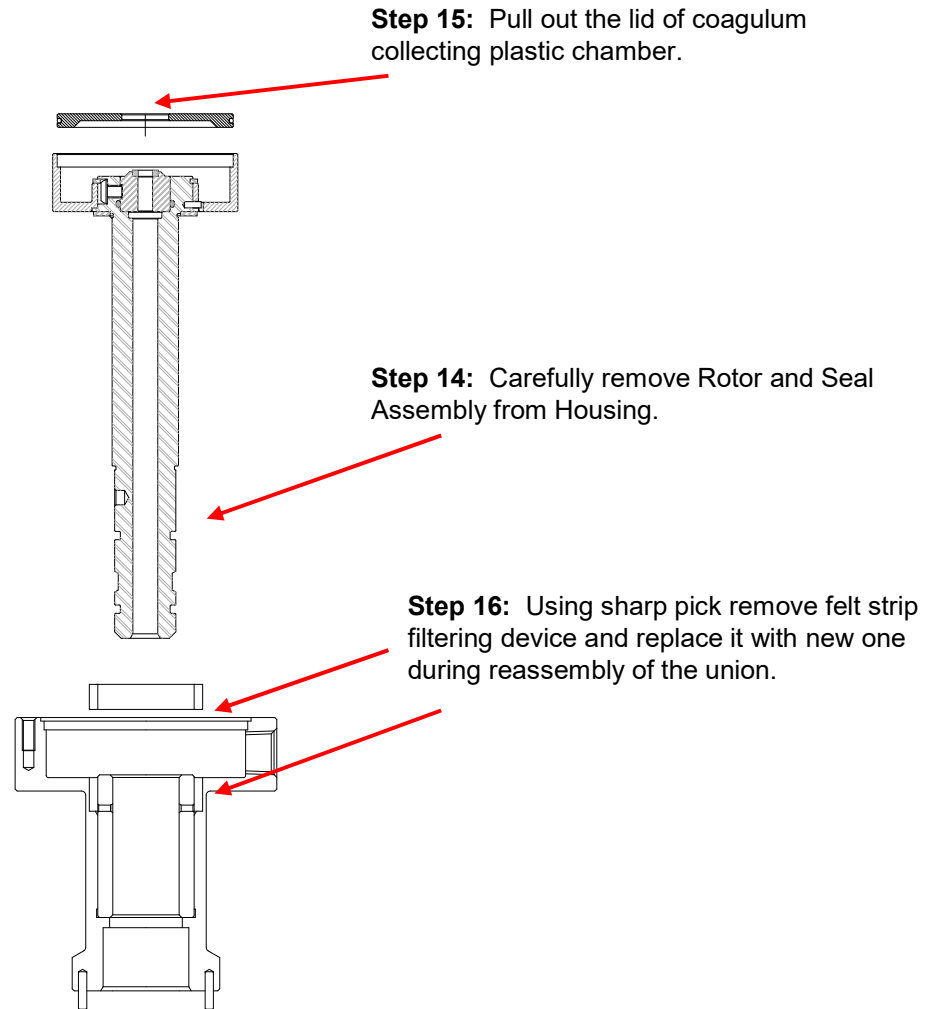
1. Clean all disassembled parts using dish washing tools and technique.
2. Visually inspect parts for damage, clean seal with Mineral Spirit or Acetone if residual coagulum is present. Do not scratch seals.
3. Lightly lubricate o-rings with grease.
4. Before reassembly, put one drop of light oil on the face of the Floating Seal.

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SHT 4

Instruction (cont.): Dis-Assemble Rotor

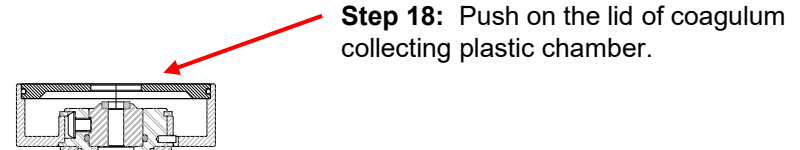
1. Clean all disassembled parts using dish washing tools and technique.
2. Visually inspect parts for damage, clean seal with Mineral Spirits or Acetone if residual coagulum is present. Do not scratch seals.
3. Lightly lubricate o-rings with grease.
4. Before reassembly put one drop of light oil on the face of the Rotor Seal.



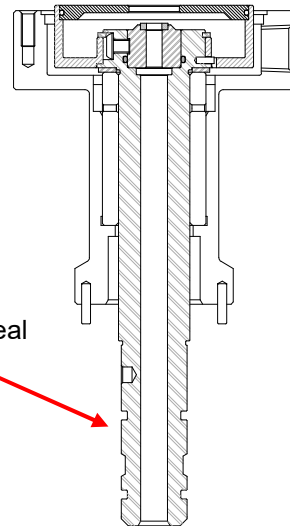
E.I. 032-3006

SHT 5

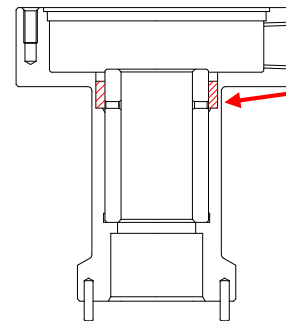
Instruction (cont.):
Re-Assemble Union
using reverse steps



Step 18: Push on the lid of coagulum collecting plastic chamber.



Step 19: Carefully install Rotor and Seal Assembly into the Housing.



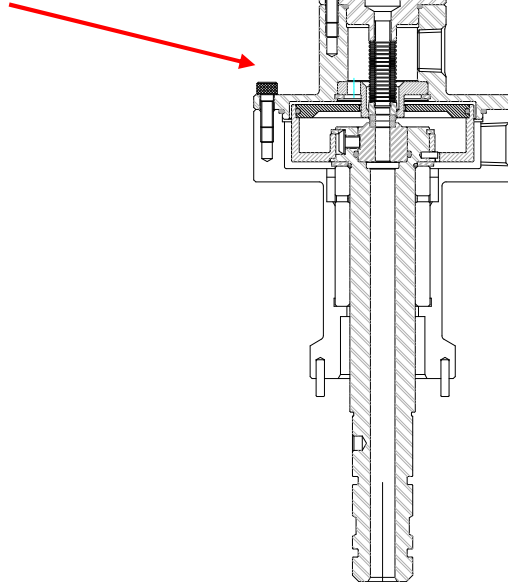
Step 17: Using sharp pick place new felt strip filtering device into the gap between housing and carbon bushing bearing. Make sure that the holes in the bushing are clean and clear of any compound coagulum.

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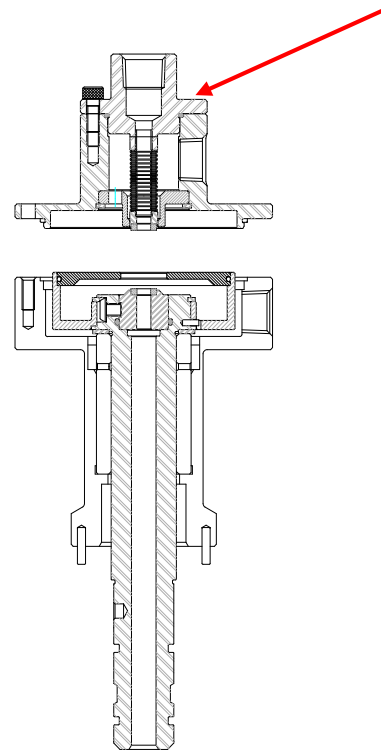
SHT 6

Instruction (cont.):
Re-Assemble Union
using reverse steps

Step 21: Reinstall Housing Cover Assembly on top of the Housing.

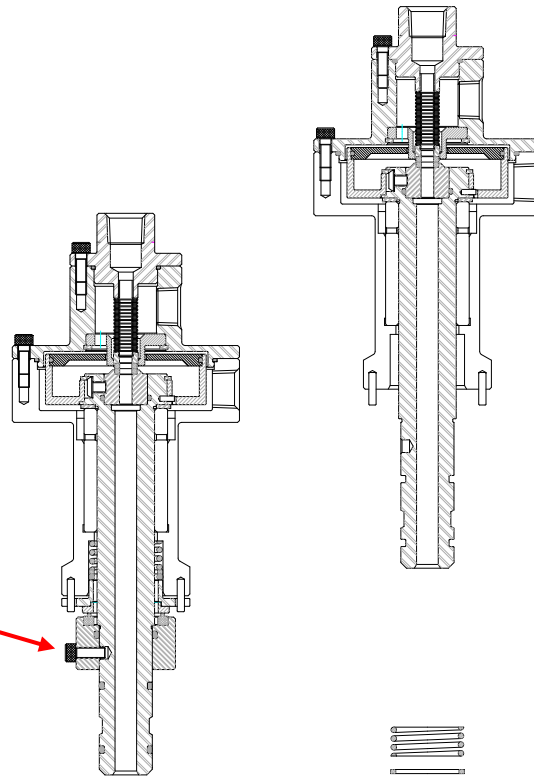


Step 20: Reinstall Seal Assembly into the Housing Cover.

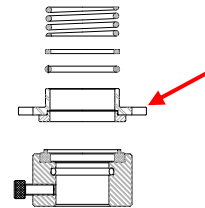


Instruction (cont.):
Re-Assemble Union
using reverse steps

Step 23: Install Water Seal on the Rotor and secure it with the Bolt. Make sure that after tightening the Bolt Head against the Seal, the Bolt is loosely engaged inside of the Rotor's counterbore allowing some looseness of the Seal on the Rotor.



Step 22: Reinstall Floating Seal Assembly starting with the Spring followed by the Washer, O-ring, Floating Seal and secure them with Bolts.

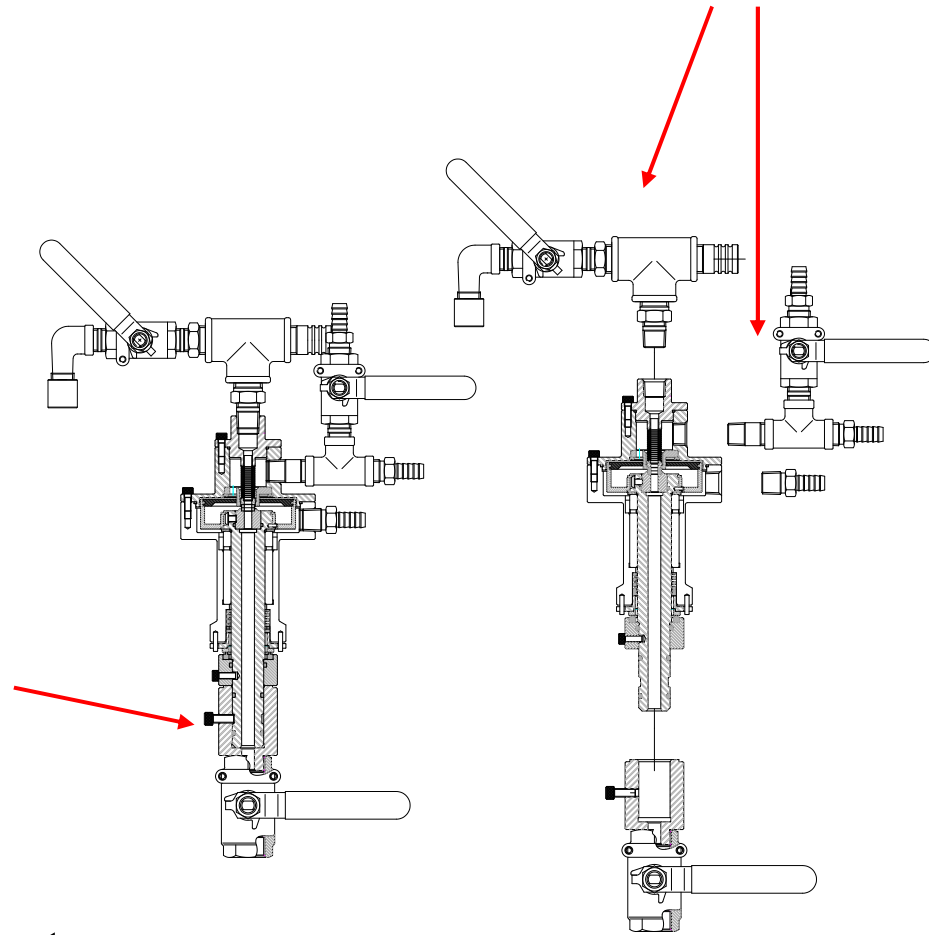


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SHT 8

Instruction (cont.):
Re-Assemble Union
using reverse steps

Step 24: Reinstall all Pipe Fittings.



Step 25: Reinstall the Union on the Machine and secure it with the Set Screw.

**Refill and purge the system
carefully following instruction**

E.I. 032-3006

SHT 9