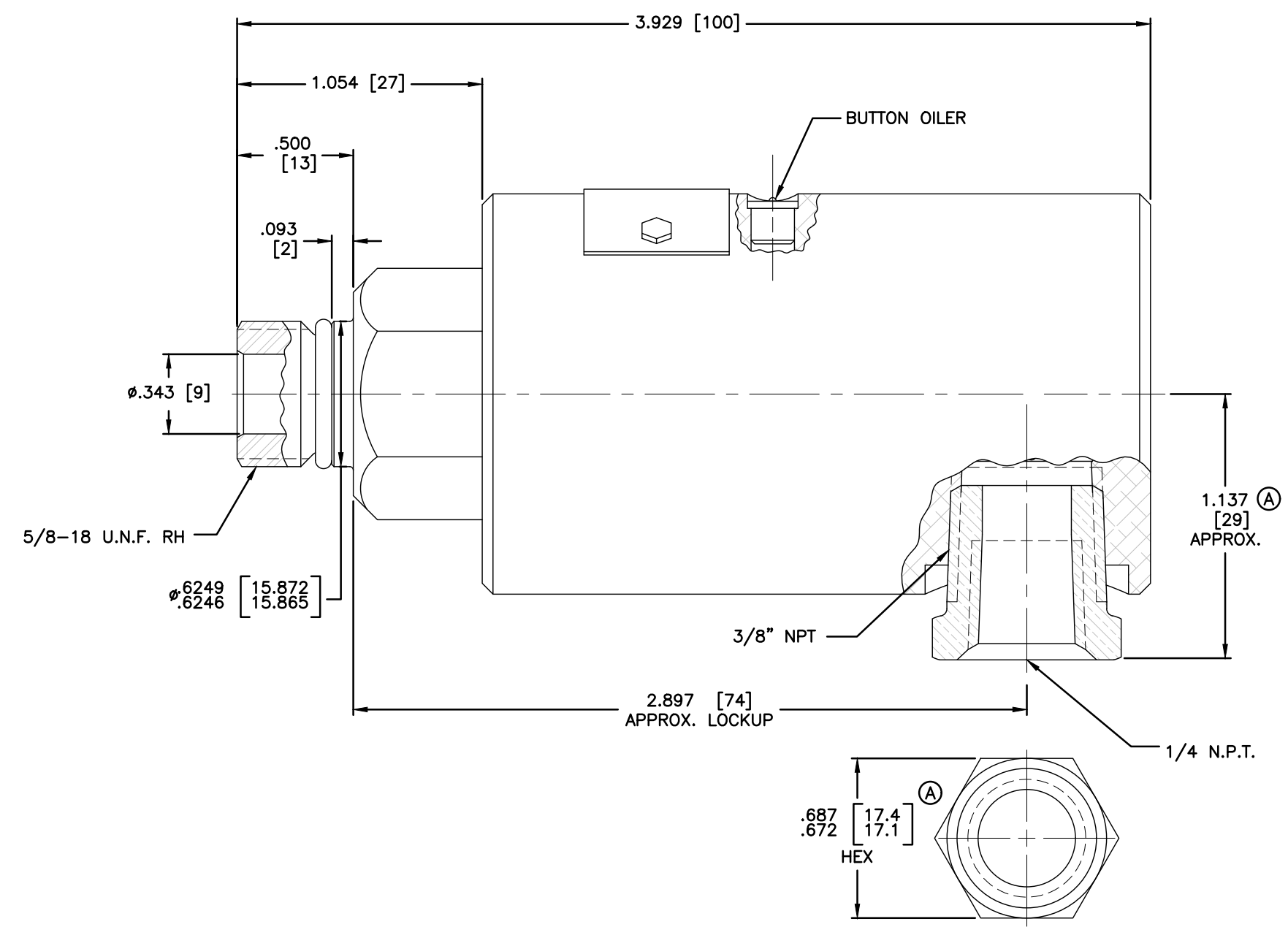
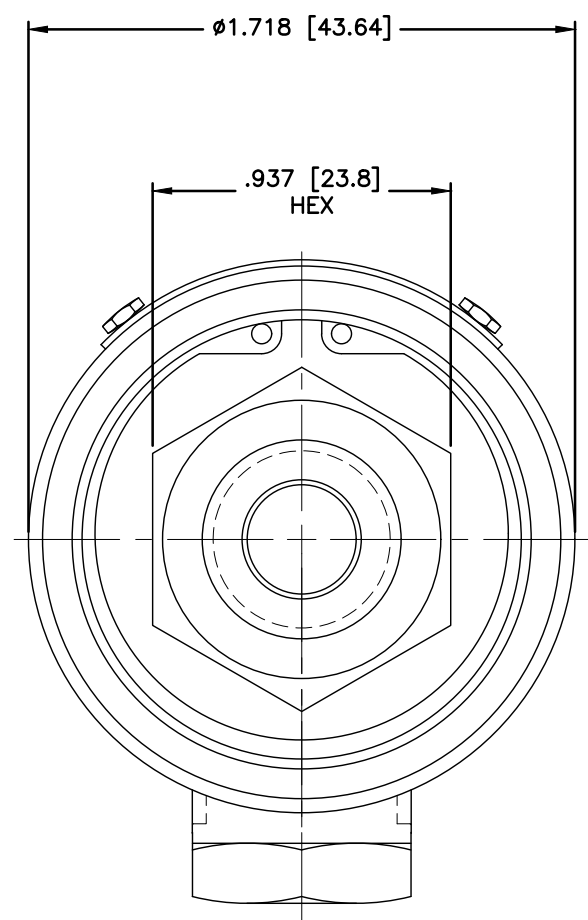


NOTES:

1 - WHEN ORDERING FROM DEUBLIN USE PART NUMBER: 1115-179-345.



OPERATING DATA		
MEDIA	AIR	
MAX AIR PRESSURE	150 PSI	10 bar
MAX SPEED	3500 RPM	3500/min
MAX TEMPERATURE	250°F	121°C

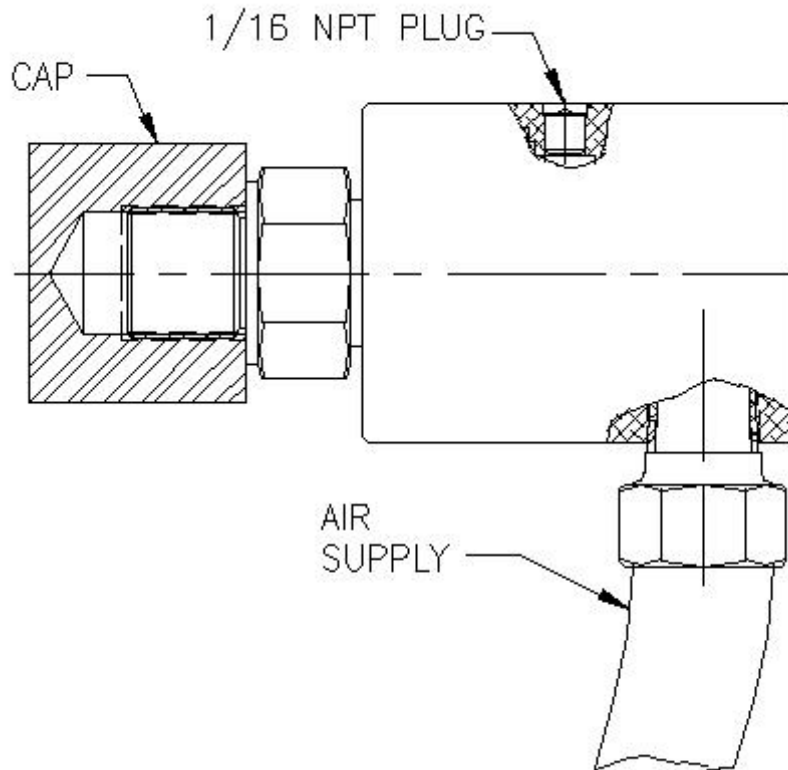
CONFIDENTIAL  
 THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION AND IS NOT TO BE TRANSMITTED, REPRODUCED, USED OR DISCLOSED TO ANYONE WITHOUT THE WRITTEN PERMISSION OF THE DEUBLIN COMPANY.

EQUIPMENT REF:				SCALE	2.5:1	DWG SIZE	C
ASSY/TEST FIXTURES REQUIRED:				DRN	RM	10/06/03	
UNLESS OTHERWISE SPECIFIED TOLERANCES $\pm .010$ . DIMENSIONS IN [ ] ARE IN MILLIMETERS.				ENGR	ARS	10/06/03	
A ADDED VIEW OF HEX ADAPTER AND DIMENSIONS				APPD	ARS	10/06/03	
LET.	REVISION	ECO	DATE	SIGN	DEUBLIN COMPANY WAUKEGAN, ILLINOIS, U.S.A. TITLE: INTERFACE CONTROL DRAWING FOR DEUBLIN UNION 1115-179-345 NO. 1115-179-345-IC C.A.D. DRAWING		

LTR	REVISION	ECO	DATE	SIGN
None	Initial Released		11/08	TW



## Customer Test Instruction: 040-100



### Testing

#### Step 1

Cap rotor.

#### Step 2

Remove 1/16 NPT pipe plug from union.

#### Step 3

Pressurize union with 50 PSI minimum air pressure.

#### Step 4

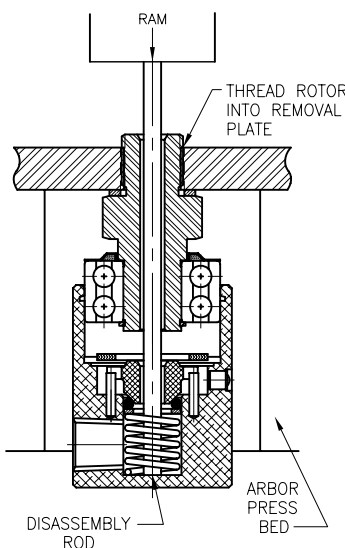
Apply soap solution over 1/16 NPT hole and wait 15 seconds. If no air bubbles form & pop at test hole, then the plug is ready to be permanently installed. Apply pipe sealant before re-install pipe plug.

**DISASSEMBLY**

1. REMOVE HOUSING SNAP RING

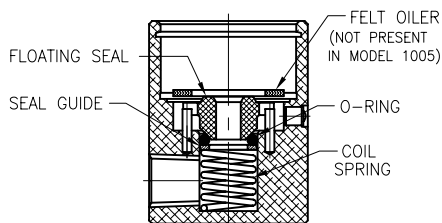


2. REMOVE ROTOR ASSEMBLY AS SHOWN



**PREFERRED METHOD OF ROTOR REMOVAL**

3. REMOVE FELT OILER, FLOATING SEAL, O-RING, SEAL GUIDE AND COIL SPRING FROM HOUSING.



**TOOLING**

**TRUARC PLIERS**

MODEL	PLIERS NO.
1005	L-0100
1102	0300
1115	0300
1205	0500

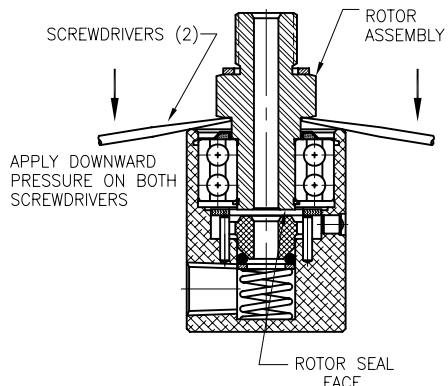
**DISASSEMBLY ROD**

MODEL	ø"A"	"B"
1005	3/32	4"
1102	3/16	4"
1115	5/16	6"
1205	3/8	6"

**ROTOR ASSEMBLY REMOVAL PLATE**

MODEL	"A"	"B"
1005	3"	3/8"
1102	3"	3/8"
1115	4"	1/2"
1205	4"	1/2"

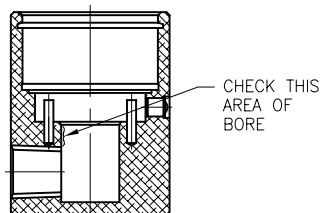
(LENGTH TO SPAN FORK IN BASE OF ARBOR PRESS)  
"A" MIN.  
DRILL & TAP TO FIT ROTOR THREAD  
"B"



**ALTERNATE METHOD**

EXAMINE ROTOR SEAL FACE FOR SCORING. IF SEVERE SCORING IS EVIDENT THE ROTOR SHOULD BE REPLACED. IF LITTLE OR NO SCORING IS PRESENT, ROTOR CAN BE REUSED. INSPECT THE AMOUNT OF GREASE IN THE BALL BEARING(S); RELUBRICATE IF REQUIRED.

4. CHECK INDICATED AREA OF BORE; AREA TO CROSS HOLE MUST BE CLEAN AND FREE OF NICKS & SCRATCHES



**ASSEMBLY**

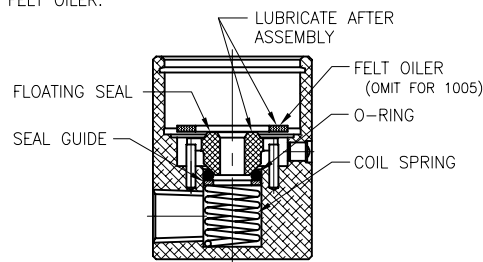
**REBUILDING KIT PARTS LIST**

- ROTOR (PRE-ASSEMBLED)
- FELT OILER (OMIT FOR MODEL 1005)
- DUEPLEX BALL BEARING WITH NILOS SHIELD (FOR MODEL 1102 ONLY)
- FLOATING SEAL
- O-RING
- SEAL GUIDE
- COIL SPRING
- (2) BALL BEARINGS WITH BEARING SPACER
- ROTOR SNAP RING
- ROTOR GASKET (IF REQ'D)

**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, DENATURED ALCOHOL, OR ANY GOOD CLEANING SOLVENT.

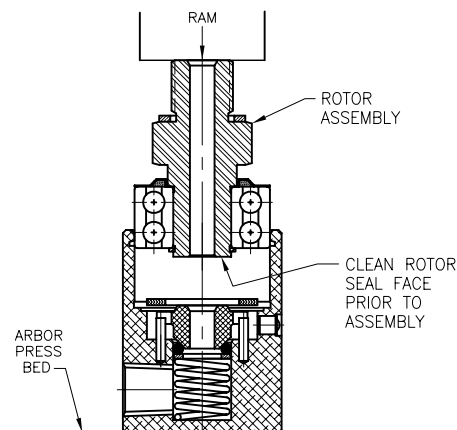
1. ASSEMBLE COIL SPRING, SEAL GUIDE, O-RING. CLEAN FACE OF FLOATING SEAL AND ASSEMBLE. ASSEMBLE FELT OILER.



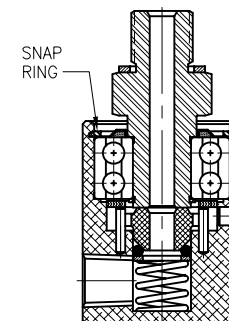
**NOTE:**

FOR MODELS 1115 & 1205, COIL SPRING MUST BE COMPRESSED DURING ASSEMBLY USING A SPRING COMPRESSION TOOL AND RETAINING PIN.

2. LUBRICATE FELT OILER AND ENTIRE FACE OF FLOATING SEAL WITH LOW VISCOSITY OIL.
3. CLEAN ROTOR SEAL FACE AND ASSEMBLE ROTOR ASSEMBLY AS SHOWN.



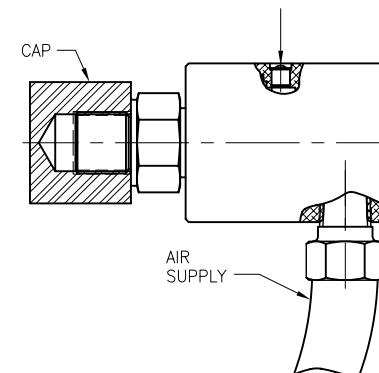
4. ASSEMBLE HOUSING SNAP RING.



**TEST PROCEDURE**

TEST UNION WITH 50 PSI MINIMUM AIR PRESSURE BEFORE PERMANENT INSTALLATION.

DEPRESS BALL AND APPLY BUBBLE SOAP (FOR MODEL 1005, THERE IS NO OILER - APPLY SOAP TO TEST HOLE)



CAP ROTOR AS SHOWN. APPLY AIR PRESSURE. PUT SOAP WATER SOLUTION OR BUBBLE SOAP OVER TEST HOLE. ROTATE ROTOR BY HAND. IF NO BUBBLE RAISES, UNION IS O.K.

EQUIPMENT REF:		SCALE FULL	<p>DEUBLIN COMPANY WAUKEGAN, ILLINOIS, U.S.A.</p>
		DRW LG 05/28/97	
		ENGR	
		APPD	
ASSY/TEST FIXTURES REQUIRED:		UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN ( ) ARE IN MILLIMETERS.	
LET.	REVISION	ECO	DATE SIGN