

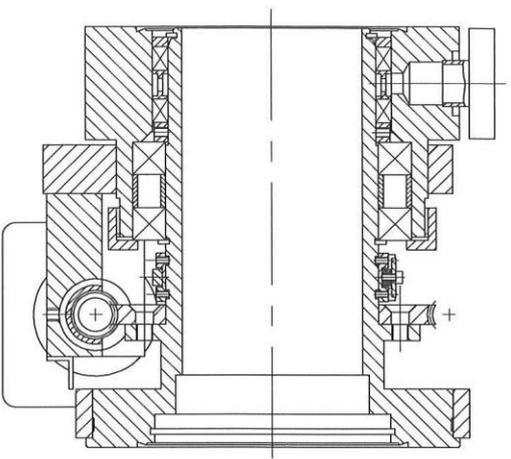


DPRF Assembly Information

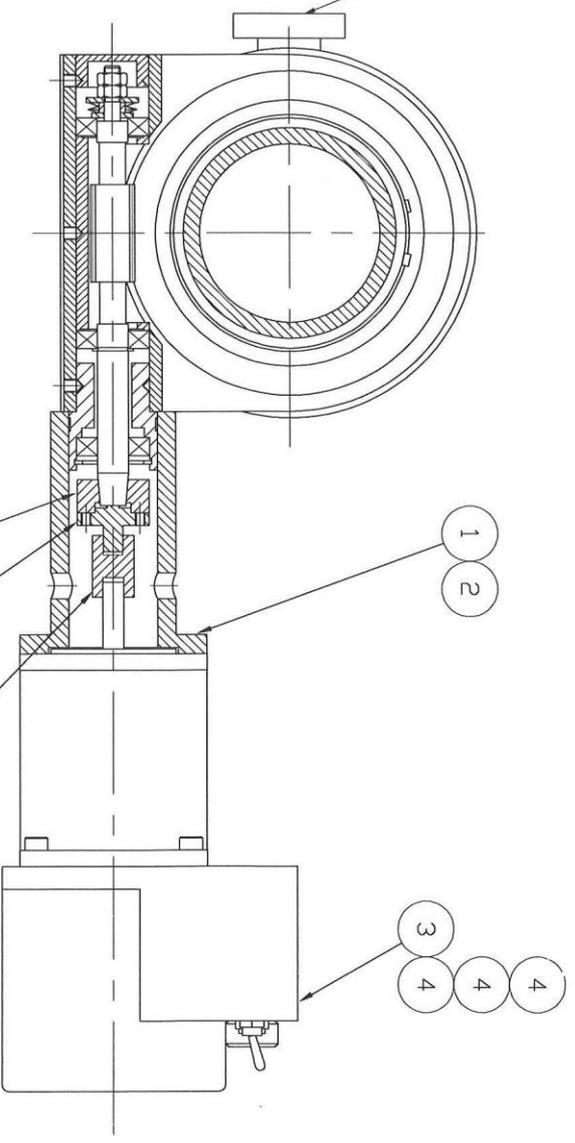
- 1) Remove the DPRF from the manipulator.
- 2) If fitted, remove the handwheel / motor assembly, this is held on to the body via cap head screws.
- 3) With the lower flange hand held, unscrews the clamp ring.
NOTE: the clamp ring may not fully undo, but hits the gear (If fitted). The DPRF has to be pulled apart slightly too fully undo the clamping ring fully.
- 4) With the lower flange hand held, turn and pull the top flange up, to draw out the seal assembly. Keep the pull as vertical as possible. This can be tight!
- 5) You will now have the inner assembly free of the outer assembly.
- 6) NOTE: Note the orientation of the “U” shaped seals, so you fit the new ones in the same orientation.
- 7) WITH GREAT CARE remove the spiral clip (11) that holds the seal assembly on to the inner tube.
- 8) WITH GREAT CARE remove the seals and spacers.
- 9) Check the sealing surface for damage, which would be very rare.
- 10) If any damage, polish in a lath using 1200 Grit Wet & Dry Paper.
Isopropanol is a better wetting agent than water.
- 11) Check the inner seal surface, this is more difficult to polish if required, and should be done by a skilled machinist.
- 12) FULLY clean with Isopropanol.
- 13) VERY IMPORTANT: FULLY WIPE OVER THE SEALS WITH ISOPROPANOL, to remove loose surface.
- 14) If your process allows this, use isopropanol as a lubricant when fitting seals.
VERY IMPORTANT: Make sure there is no dirt on the seal or seal face that will damage the sealing faces when the seals are refitted.
- 15) Assembly seal assembly as removed.
- 16) If your process allows this, use isopropanol as a lubricant when fitting the inner assembly into outer body
VERY IMPORTANT: Make sure there is no dirt on the seal or seal face that will damage the sealing faces when the seals are refitted.
- 17) When doing the locking ring up as the assembly closes down, pulling the inner assembly into the body, so take care not to trap your fingers as it closes down.
- 18) Rotate the DPRF in both directions and then test on a Leak Checker if possible WITH the interspaced pumped.
- 19) Fit handwheel / motor assembly if fitted.

Seal Kits (2 seals in each kit):

- | | |
|---|---------|
| A) ZDPRF25 old style pumping port in body centre
The old seal may be white, the new version is grey. | ZXSMS01 |
| B) ZDPRF25 new style pumping port in lower flange | ZXSMS07 |
| C) ZDPRF55 all ages | ZXSMS03 |



TRUE PORT POSITION



8	HELIC COUPLING 8062-8-8M	1
7	SCREW PAN M4X6	4
6	LOCKING BOSS	1
5	DRIVING BOSS	1
4	DC MOTOR MAINS LEAD EU	1
4	DC MOTOR MAINS LEAD UK	1
4	DC MOTOR MAINS LEAD US	1
3	DC MOT 23F WITH 5:1 G/BOX	1
2	SCREW SET M4x10 FLAT PNT	4
1	MOTOR SUPPORT	1
ITEM	DESCRIPTION	QTY

ITEM	DESCRIPTION	QTY
1	MICROMETER BARREL	1
2	SPRING SCREW	1
3	MICROMETER BEARING HOUSING	1
4	SPACER	1
5	WASHER	1
6	WASHER	1
7	CAP	1
8	SMALL SPACER	1
9	LARGE SPACER	1
10	LOCKING RING	1
11	KEEP RING	1
12	SPACER	1
13	HOUSING MOUNTED ASST	1
14	BODY ASSY	1
15	TRIANGLE ENGAGING	1
16	SUPPORT BRACKET	1
17	MOM WHEEL	1
18	MOM SHAFT	1
19	SPACER	1
20	INDICATOR	1
21	INDEX RING	1
22	LOCKING RING WITH CHAMFER	1
23	BEARING HOUSING WITH DIRT RING	1
24	BEARING SPHERICALS	2
25	BEARING	3
26	CIRCLIP - INTERNAL SERIES 1300-Z2	1
27	EXT CIRCLIP - SHAF. 315-	1
28	RETENTION RING SMALLER ES-61	1
29	RETENTION RING SMALLER ES-61	1
30	ALU. ROTATING MANUFE.	2
31	WAL. FULL. ST STEEL .45	2
32	SCREEN CAP HEAD, M4 X 29 ST STEEL	6
33	SCREEN CAP HD M8 X 10 LG	8
34	M5 CSB SCREW, 10mm LONG	1
35	SCREEN PAN HD M3 X 5L	4
36	M4 SET SCREW 4 LONG	6
37	M4 SET SCREW 8 LONG	1
38	SEAL FOR 20PFR55 AR10103-333-1W0	2
39	WASHER, SCHENCK M8 X 0.8	1
40	WASHER WAY M8 ST/ST	1
41	WASHER WAY M8 ST/ST	1

