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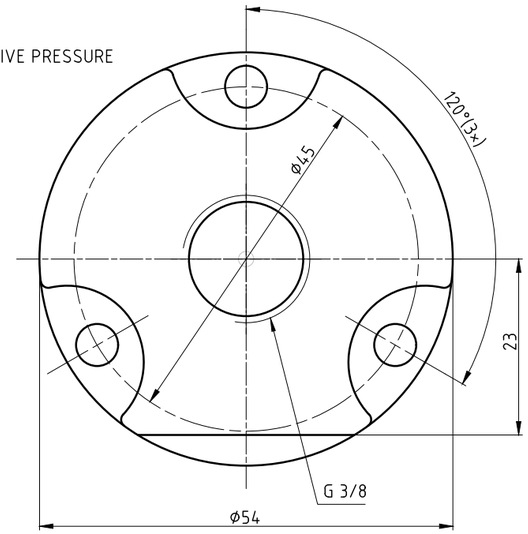
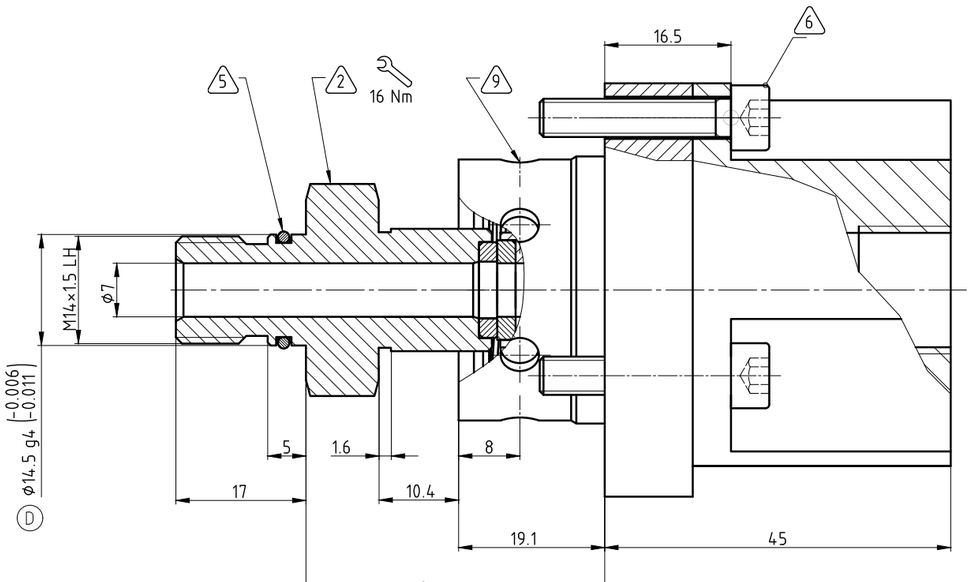
ϕ14.5	g4	-0.006 / -0.011	14.494 / 14.489
ϕ14.5	H4	+0.005 / 0.000	14.505 / 14.500
Dimen.	Fit		

NOTES:

1. UNION MOUNTING DISTANCE.
2. HEXAGON 24
3. USE INSTRUCTION MANUAL 040-558
4. SPINDLE BEARING ARRANGEMENT.
5. O-RING ϕ11.5x1.5
6. 3X SCREW DIN 912-M5×25 SUPPLIED BY THE CUSTOMER
7. SEAL CLOSING REQUIRES A MINIMUM PRESSURE OF 1 bar OR 1.6 l/min FLOW RATE!
8. OBSERVE THE AXIAL FORCE, RESULTING FROM THE ACTIVE PRESSURE LOADED AREA AND THE MEDIA SUPPLY PRESSURE !
9. 6X ϕ5 DRAIN HOLE (6×60°)





CUSTOMER's INTERFACE

★ CUTTING OIL MAY BE USED WITH THIS BEARINGLESS UNION.
HOWEVER; STEADY DRIPPING IS POSSIBLE IN SOME CONDITIONS, DEPENDING ON MANY FACTORS INCLUDING OIL VISCOSITY. WITH PROPER DRAINAGE THAT IS REQUIRED
ALSO FOR POP-OFF-OPERATION, THIS NORMAL BEHAVIOR SHOULD NOT HARM THE SPINDLE.

OPERATING DATA

MEDIA		COOLANT (OIL IN WATER)	★CUTTING OIL	MQL	AIR
PRESSURE	MAXIMUM	150 bar	150 bar	10 bar	10 bar
	MINIMUM	1 bar	1 bar	2 bar	2 bar
FLOW RATE	MAXIMUM	50 L/min	50 L/min	1133 L/min	1133 L/min
	MINIMUM	6 L/min	6 L/min	6 L/min	6 L/min
TEMPERATURE	MAXIMUM	71 °C	71 °C	71 °C	71 °C
	MINIMUM	5 °C	5 °C	5 °C	5 °C
SPEED	MAXIMUM	30000 min^{-1}	30000 min^{-1}	30000 min^{-1}	STATIONARY
8 AXIAL FORCE		9 N/bar	9 N/bar	9 N/bar	9 N/bar
DRY RUN		UNPRESSURIZED ONLY	UNPRESSURIZED ONLY	-	-

DEUBLIN® Engineered for Performance

PROJECTION:

						DATE	NAME
E	UPDATE IMS	007727	21.10.09	HS	DRN.	14.01.03	Schmid
D	UPDATED PILOT TOLERANCE	001540	10/09	JK	ENGR.	14.03.03	Ch.Wolf
c	Serienfreigabe	060400	1.03.06	Wolf	APPD.		
b	Toleranzen geä.	--	03.03.03	HS			
a	O-Ring geändert	--	24.02.03	HS			
ISSUE	MODIFICATION	ECO	DATE	SIGN			

UNLESS SPECIFICALLY TOLERANCED, ALL DIMENSIONS ARE CONSIDERED REFERENCE

SCALE: 2:1
MATERIAL: INTERFACE CONTROL DRAWING
TITLE: DEUBLIN ROTATING UNION
DEUBLIN Dichtungssatz
NO. 1129-927-929
SHEET A2