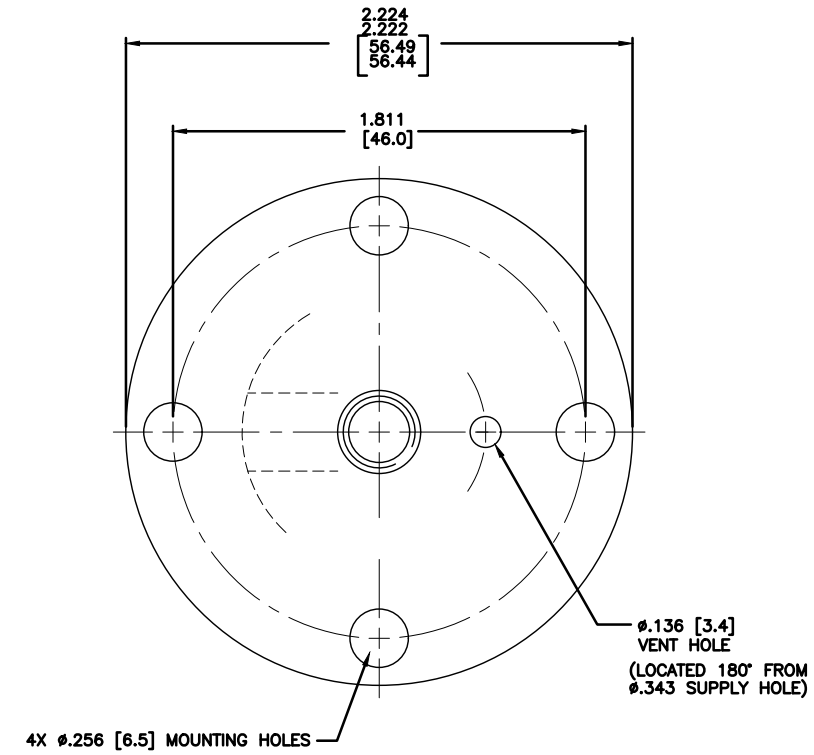
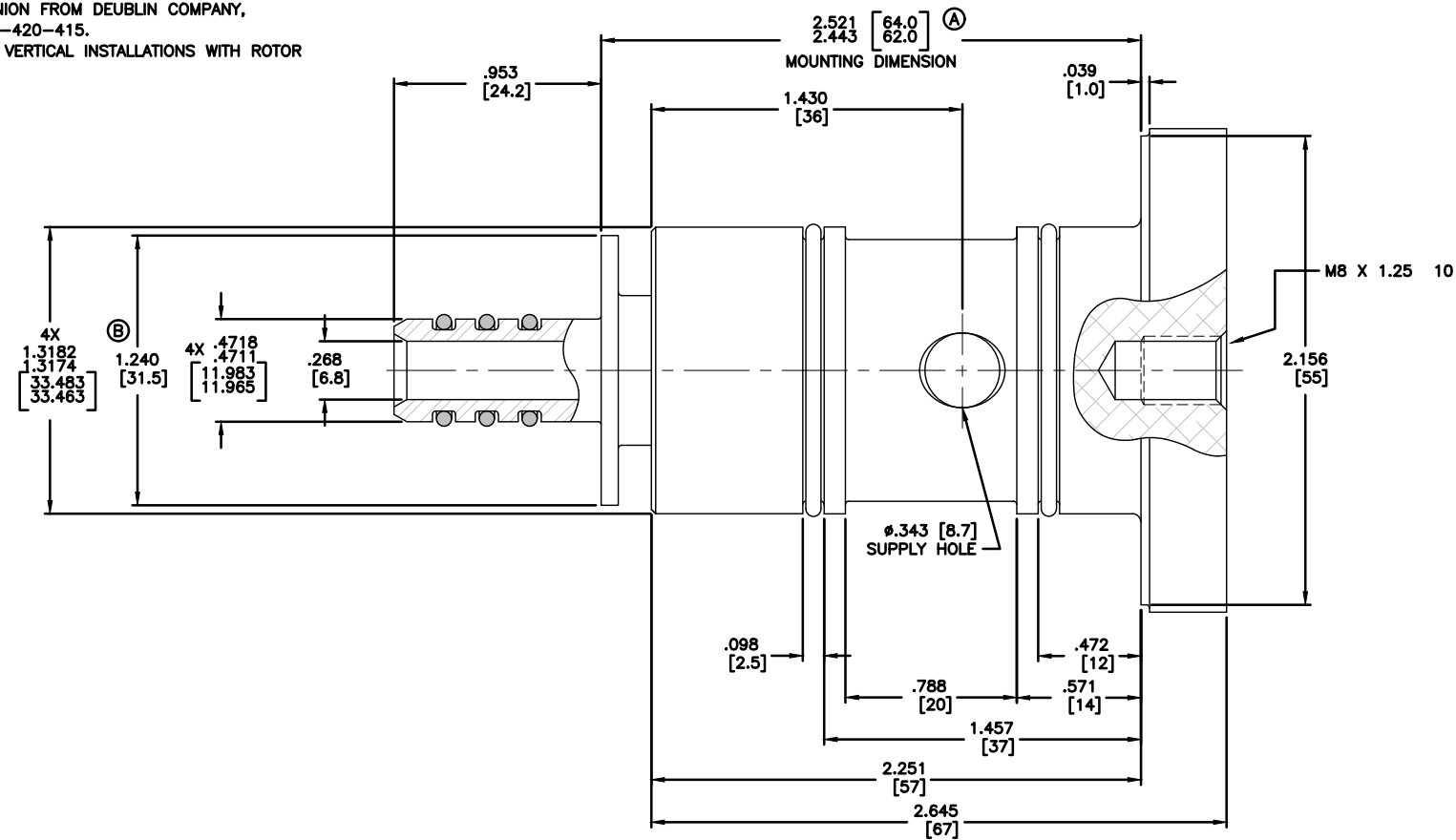
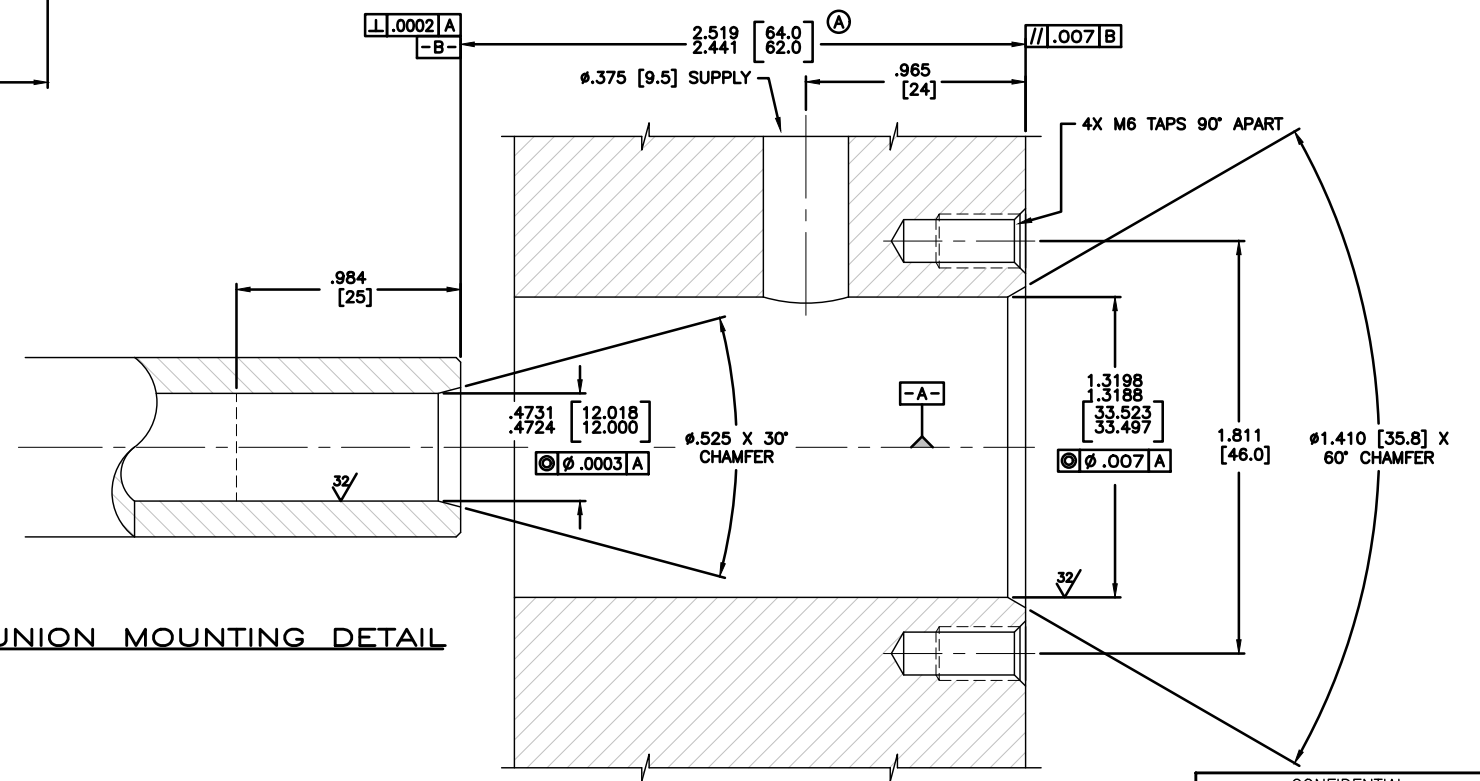


NOTES:

- 1 - FOR EVERY 100 PSI OF COOLANT PRESSURE, 20 POUNDS OF FORCE IS EXERTED ON THE UNION SIDE OF THE SPINDLE.
- 2 - PROPER FILTRATION WILL IMPROVE SERVICE LIFE OF UNION.
- 3 - WHEN ORDERING THIS UNION FROM DEUBLIN COMPANY, USE PART NUMBER 1117-420-415.
- 4 - NOT RECOMMENDED FOR VERTICAL INSTALLATIONS WITH ROTOR FACING DOWN.



OPERATING DATA:
 COOLANT SERVICE
 2000 PSI [138bar] MAX. PRESSURE
 20,000 RPM [20,000/min] MAX. SPEED
 250°F [121°C] MAX. TEMPERATURE
 8.3 GPM [30L/min] MAX. FLOW
 RECOMMENDED FILTRATION 25 MICRONS



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EQUIPMENT REF:			DATE: 2.5:1 [D]	
REV: []			DATE: 10/24/01	
ASSY/TEST FEATURES REQUIRED:				
UNTOLERANCED DIMENSIONS ±.010 DECIMALS AS SPECIFIED. DIMENSIONS IN [] ARE IN MILLIMETERS.				
B	FLANGE DIA WAS 0.925 (23.5mm)	5086	07/02	RM
A	ADDED TOLERANCE TO MOUNTING DIM	01/02	LG	
LET:	REVISION	EOO	DATE	DSH

DEUBLIN COMPANY
 WAUKEGAN, ILLINOIS, U.S.A.
 INTERFACE CONTROL
 DRAWING, DEUBLIN UNION
 1117-420-415
 1117-420-415-IC