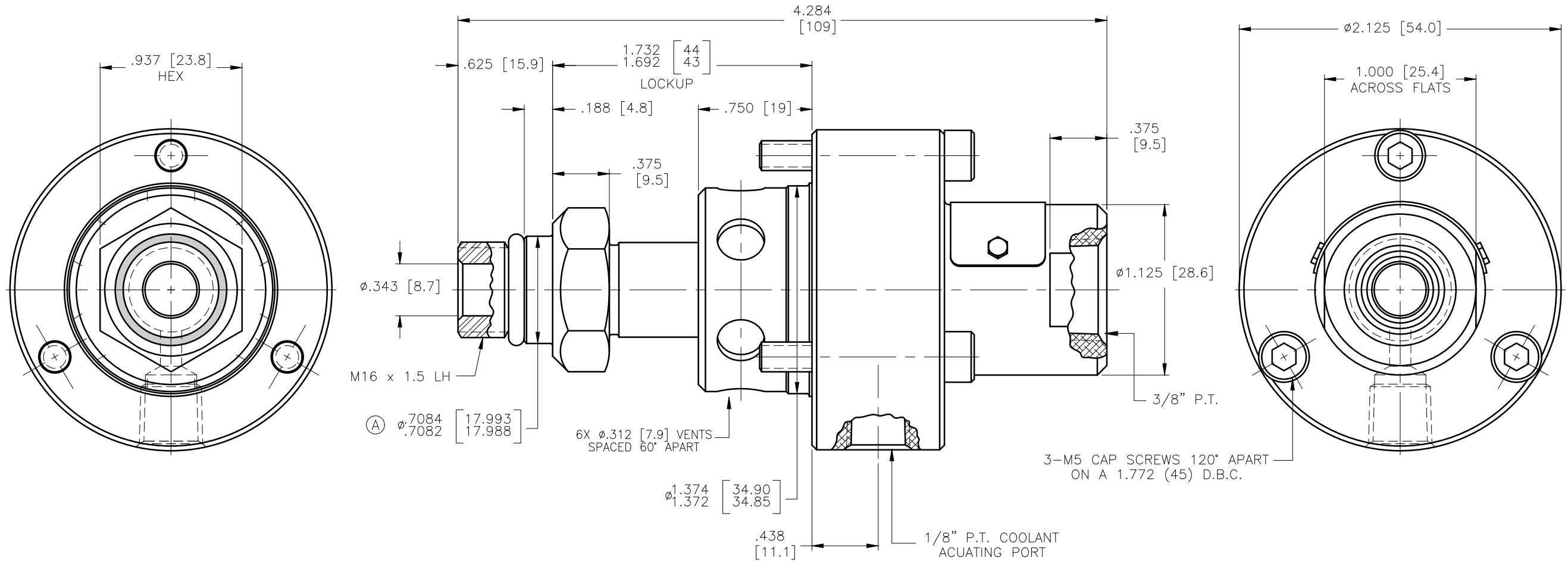


NOTES:

1 - WHEN ORDERING FROM DEUBLIN USE PART NUMBER: 1139-041-301.



OPERATING DATA:

DEUBLIN "POP-OFF" COOLANT UNION
 WATERBASED COOLANTS
 2030 PSI (140 BAR) MAX. PRESSURE
 30,000 RPM (30,000/min) MAX. SPEED
 7.4 GPM (28 L/min) MAX.FLOW CAPACITY

NOTE:
 WILL ACCEPT THE THERMAL EXPANSION OF
 THE SPINDLE UP TO .118 (3mm)

WARNING:
 FOR EVERY 100 PSI (7bar) OF COOLANT PRESSURE
 APPROX.20 POUNDS (10kg) OF FORCE IS
 EXERTED ON THE UNION SIDE OF THE SPINDLE.
 SEAL CLOSING REQUIRES A MINIMUM OF 15 P.S.I.
 AND 1.5 G.P.M. FLOW RATE

PATENTED USA, #5,669,636, AND OTHER FOREIGN COUNTRIES.

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| | | | | | | | |
|---|---|------|-------|---|-----|-------------|---|
| EQUIPMENT REF: | | | | SCALE | 2:1 | DWG SIZE | C |
| ASSY/TEST FIXTURES REQUIRED: | | | | DRN | RM | 08/27/03 | |
| UNLESS SPECIFICALLY TOLERANCED, ALL DIMENSIONS ARE REFERENCE | | | | ENGR | ARS | 08/27/03 | |
| DIMENSIONS IN [] ARE IN MILLIMETERS. | | | | APPD | ARS | 08/27/03 | |
| NO. 1139-041-301-IC | | | | TITLE: INTERFACE CONTROL DRAWING FOR DEUBLIN UNION 1139-041-301 | | | |
| C.A.D DRAWING | | | | | | | |
| A | REVISED OP. DATA AND DIM. WAS 0.7084/.7074 (017.993/17.967) | 8282 | 05/07 | NR | | | |
| LET. | REVISION | ECO | DATE | SIGN | | | |