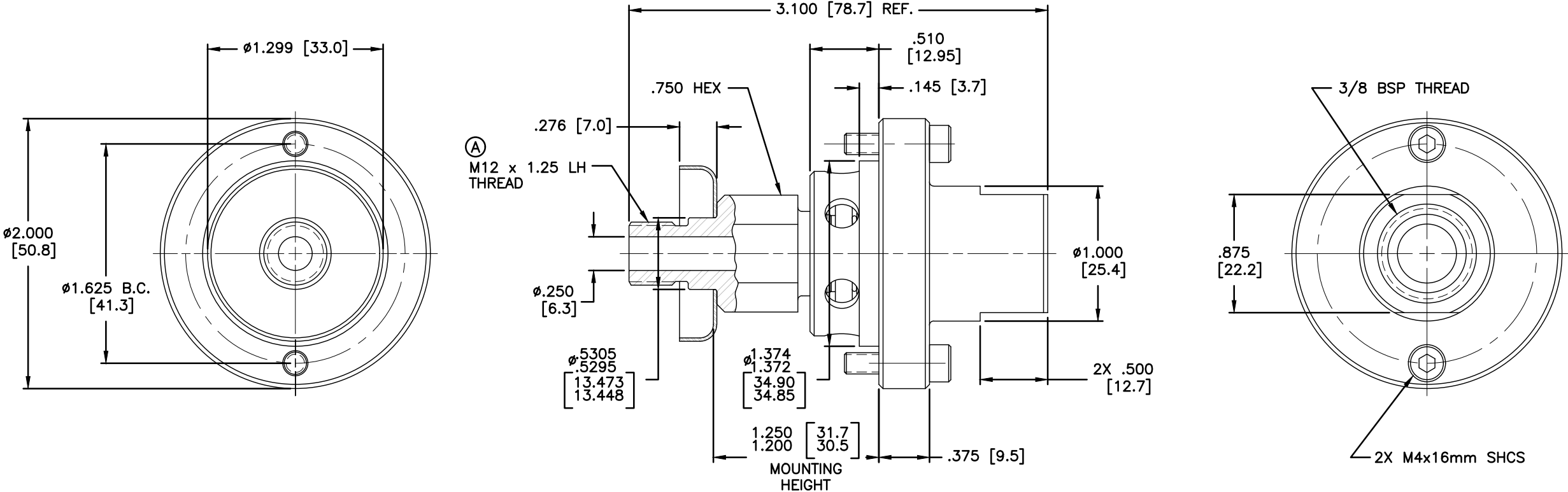


- NOTES:
- 1 - WHEN ORDERING THIS UNION FROM DEUBLIN COMPANY USE PART NUMBER 1117-404-406.
 - 2 - FOR EVERY 100 PSI OF COOLANT PRESSURE, XX LBS OF FORCE IS EXERTED ON THE UNION SIDE OF THE SPINDLE.
 - 3 - PROPER FILTRATION WILL IMPROVE SERVICE LIFE OF UNION.



OPERATING DATA:
COOLANT SERVICE
2000 PSI (138 bar) MAX. COOLANT PRESSURE
20,000 RPM (20K/min) MAX.SPEED
250°F (121°C) MAX. TEMPERATURE

				MATERIALS		SCALE	1.66:1	DWG	C
						DRN	RM	10/03/01	
						ENGR	ZK	10/03/01	
						APPD	ARS	10/03/01	
						UNLESS OTHERWISE SPECIFIED:			
						1. UNTOLERANCED DIMENSIONS ±.010			
						2. MACHINED DIAS CONCENTRIC WITHIN .005 T.I.R.			
						3. COUNTERSINK TAPPED HOLES TO FIRST THREAD			
						4. REMOVE BURRS AND SHARP CORNERS .010 MAX			
						5. ANGLE TOLERANCE ± 1/2°			
						6. ALL DIMENSIONS ARE FINISHED			
						7. DIP PARTS IN CORROSION PREVENTATIVE OIL			
A	WAS	M12 x 1.5	RH	4831	10/01	RM			
LET.	REVISION			ECO	DATE	SIGN			

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DEUBLIN COMPANY
WAUKEGAN, ILLINOIS, U.S.A.

TITLE: INTERFACE CONTROL,
DEUBLIN UNION
1117-404-406

FINAL ASSY: C.A.D. DRAWING
NO. 1117-404-406