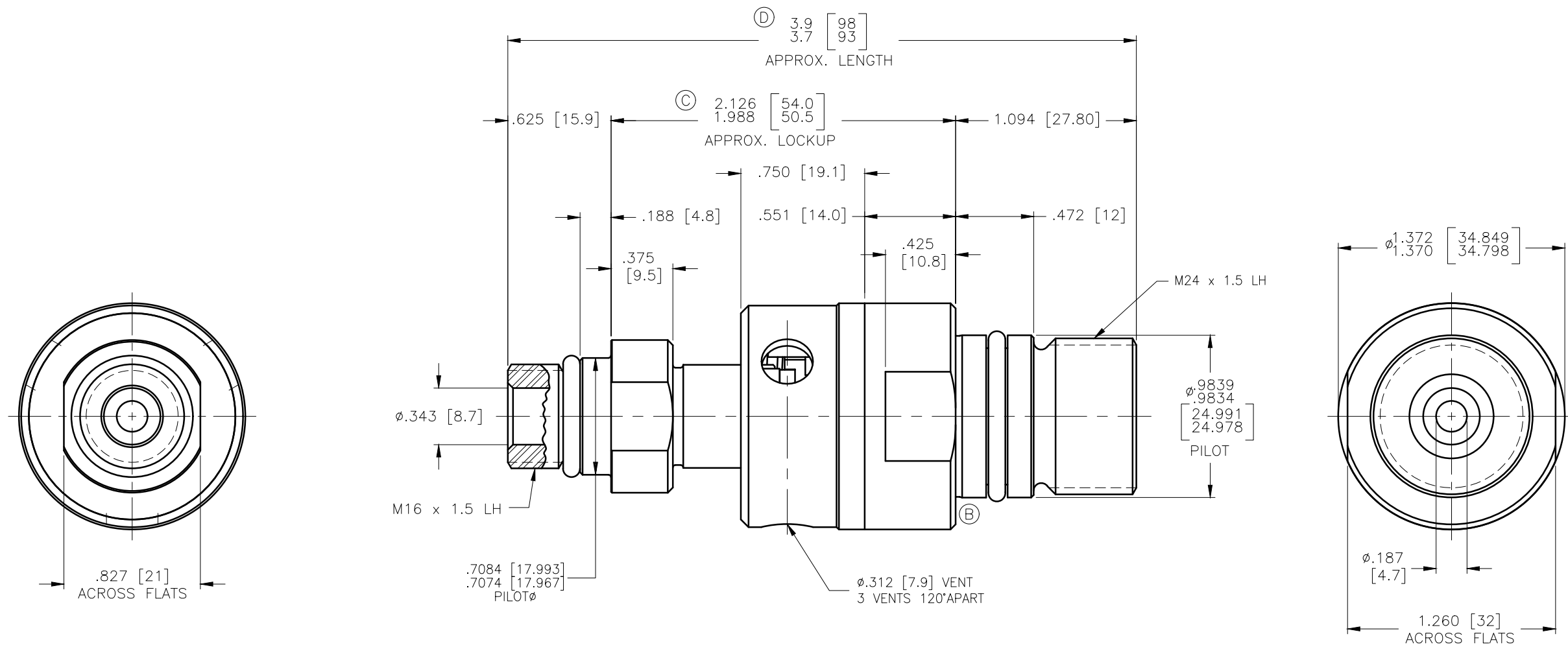


NOTES:

1 - WHEN ORDERING FROM DEUBLIN USE PART NUMBER: 1129-205-201.



**OPERATING DATA:**

DEUBLIN "POP-OFF" COOLANT UNION  
WATERBASED COOLANTS

(C) 2030 PSI (140 Kg/cm<sup>2</sup>) MAX.PRESSURE  
 30,000 RPM (30,000/min) MAX.SPEED  
 (A) 6.4 GPM (24.3 L/min) MAX.FLOW CAPACITY

NOTE:  
WILL ACCEPT THE THERMAL EXPANSION OF  
THE SPINDLE UP TO .027 (.7mm)


WARNING:  
FOR EVERY 101.5 PSI (7bar) OF COOLANT PRESSURE  
APPROX.20 POUNDS (9.1Kg) OF FORCE IS  
EXERTED ON THE UNION SIDE OF THE SPINDLE.

SEAL CLOSING REQUIRES A MINIMUM OF 15 P.S.I.  
(1 bar) AND 1.5 G.P.M. (6 L/min) FLOW RATE

**PATENT PENDING**

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				EQUIPMENT REF:		SCALE	2:1	DWG SIZE	C
						DRN	LG	09/05/03	
						ENGR			
						APPD	ARS	09/05/03	
D	WAS 3.806 [97]; ADDED RANGE	000620	01/08	LG	ASSY/TEST FIXTURES REQUIRED:	UNLESS OTHERWISE SPECIFIED TOLERANCES ±.010. DIMENSIONS IN [ ] ARE IN MILLIMETERS.			
C	WAS 53; REV. OP DATA	000556	01/08	LG					
B	REVISED GEOMETRY OF END CAP	8711	11/07	NR					
A	6.3 GPM [24 L/MIN] WAS 4 GPM [15 L/MIN]	6216	05/05	LG					
LET.	REVISION	ECO	DATE	SIGN					


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

TITLE: INTERFACE CONTROL  
DRAWING FOR DEUBLIN  
UNION 1129-205-201

NO. 1129-205-201-IC  
C.A.D. DRAWING