

NOTES:

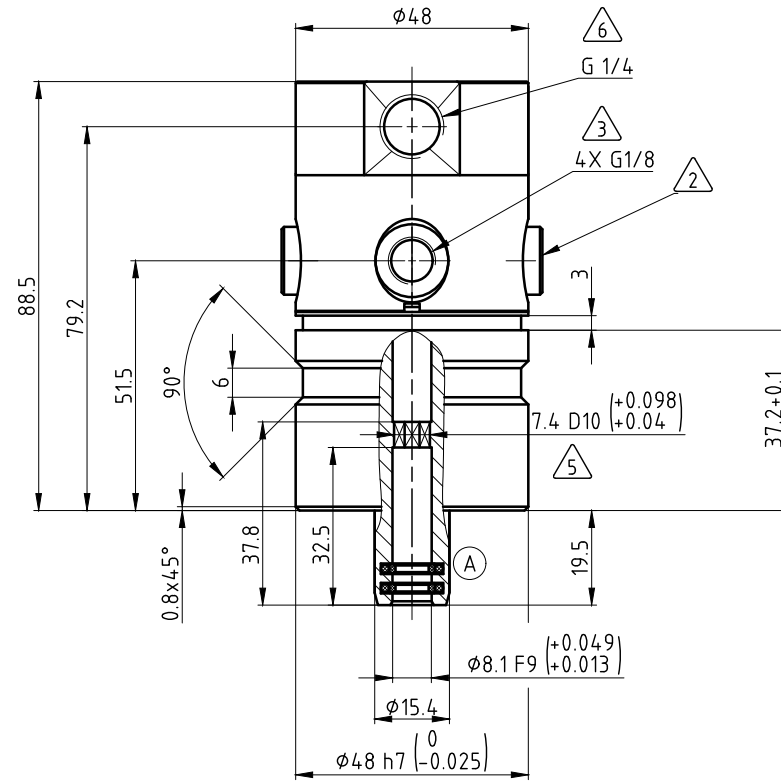
1 - CONTACT DEUBLIN OR VISIT WWW.DEUBLIN.COM FOR INSTRUCTION MANUAL: 040-553

- △ - 3X PIPE PLUG G1/8 SUPPLIED BY DEUBLIN
- △ - DRAIN PORT, 4X G1/8, 3X PLUGGED
- △ - MAXIMUM STROKE
- △ - OCTAGON
- △ - MEDIA PORT

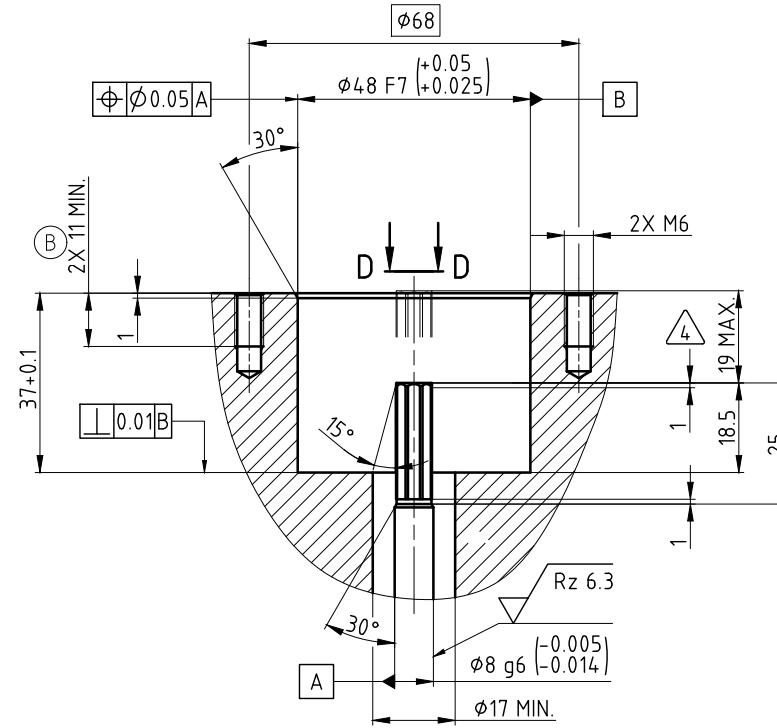
(B) △ - 2X CLAMP & 2X RIPP SCREW M6x12 SUPPLIED BY DEUBLIN.

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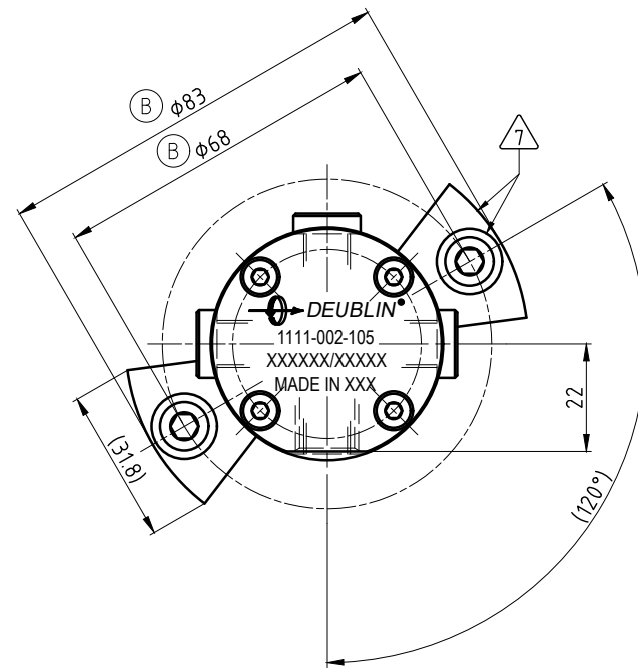
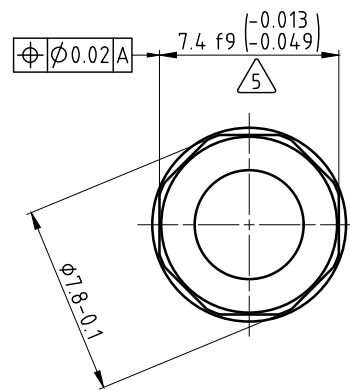
φ48	h7	+0.013	-0.005
φ48	F7	+0.025	+0.015
φ8.1	F9	+0.025	+0.015
φ8	g6	-0.005	-0.015
7.4	f9	+0.025	+0.015
7.4	D10	+0.025	+0.015
Dimen.	Fit		



CUSTOMER INTERFACE



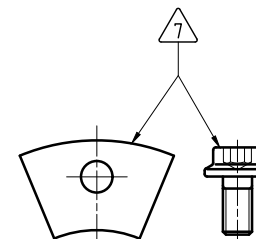
D-D (5:1)



OPERATING DATA

MEDIA		COOLANT (OIL IN WATER)	★ CUTTING OIL	MQL
(C) PRESSURE	MAXIMUM	140 bar	140 bar	10 bar
	MINIMUM	4 bar	4 bar	4 bar
FLOW RATE	MAXIMUM	(E) 30.8 L/min	(E) 30.8 L/min	18.8 L/sec
	MINIMUM	3 L/min	3 L/min	
TEMPERATURE	MAXIMUM	71 °C		
	MINIMUM	5 °C		
SPEED	MAXIMUM	24000 min <sup>-1</sup>		
AXIAL FORCE		5.02 N/bar		
DRY RUN		UNPRESSURIZED ONLY		

★ CUTTING OIL MAY BE USED WITH THIS ROTATING 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.



ISSUE	MODIFICATION	ECO	DATE	SIGN	DATE	NAME
E	WAS 24.3/min	053800	10/19	MKI	DRN.	12.02.2010 HS
D	WAS 044-552	0245866	14.08.13	HS	ENGR.	15.02.2010 CW
C	PRESSURE WAS 3 BAR	018504	06/12	CB	APPD.	
B	REVISED/NOTE ADDED	012884	02/11	FD		
A	ROTOR END REDESIGNED	010413	06/10	CW		

PROJECTION:	SCALE: 1:1	MATERIAL: INTERFACE CONTROL DRAWING
TITLE: DEUBLIN ROTATING UNION DEUBLIN Drehdurchführung		NO. 1111-002-105
UNLESS SPECIFICALLY TOLERANCED, ALL DIMENSIONS ARE CONSIDERED REFERENCE		SHEET A2