

ROTARY UNIONS

water | steam | air | hydraulic | hot oil | vacuum

General Industry Catalogue



Selection Chart for Deublin Rotary Unions

| Size | Series | Max. Operating Data | | | Description | Pages |
|----------------------------|---------------------|---------------------|---------|----------|--------------------------------|----------------|
| | | p bar | T °C | n rpm | | |
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Attention!

For applications exceeding given limits and/or unlisted rotor connections, contact Deublin for engineering assistance. Please indicate media, size, speed (RPM), pressure, temperature and requested connection. Please note our "Instructions of Hose Installation and Assembly of Deublin Rotary Unions" on page 49. – **Dimensions in mm.**

Subject to both technical and dimensional changes without prior notice.



Our Vision

We are the provider of choice for rotary solutions in mission critical applications

Our Mission

We listen to our customers and develop innovative solutions which are essential to their success

We foster a culture of curiosity and ownership where our people meet their full potential to exceed our customers' expectations

We strive for continuous improvement through problem solving activities as part of our Deublin Performance System to achieve operational excellence and provide reliable customer solutions

Our Ambition

We strengthen our global leadership in Rotary Unions and are a key player in Slip Rings

We expand our value proposition by integrating new technologies for the benefit of our customers

Wherever water, steam, oil, coolant lubricants or other media have to be conveyed into or through turning machine parts, like rollers, shafts or spindles, Rotary Unions are employed in a wide range of industrial fields.

Developed in 1945, and continually improved as a result of practical requirements, Deublin Rotary Unions are at the cutting edge of technology today.

Deublin Rotary Unions – the industry standard. Our customers can rely on our engineering expertise, R&D capabilities, manufacturing techniques and more than 77 years of knowledge and experience.

Our product range is continuously being developed and refined.

Direct contact with customers and a close collaboration with the original equipment manufacturers provide the basis for continuous improvement.

Quality encompasses our entire enterprise. At Deublin, reliable products at competitive prices and just-in-time deliveries are standards.

This, of course, requires an integrated total quality control system that is practiced in all areas of our organisation.

Quality is the result of teamwork!

Deublin has its Corporate Headquarter in Waukegan, Illinois, USA. For over 40 years the facilities in Germany and Italy, followed later by facilities in China and Brazil, have been producing for the Worldwide Market.

Besides sales channel partners in almost every country in Europe, we also have wholly owned subsidiaries in Austria, France, Japan, Poland, Singapore, Spain, South Korea and the United Kingdom.

Our customers can rely on our worldwide manufacturing and sales & service network.



Due to its Total Quality Management System Deublin Germany was awarded its initial Certification pursuant to DIN EN ISO 9001 in 1996 by the German Standard Institute. In October 2002 the re-certification followed accompanied by the initial Certification for its Environmental Management System pursuant to DIN EN ISO 14001. Certified as an Authorised Economic Operator (AEO) since March 2009, Deublin Germany has established that its supply chain is secure and customs-reliable. For its customers, it means faster flow of goods and materials. This is a significant advantage for Deublin's partners worldwide.

Deublin Ltd. are ISO 9001 and ISO 14001 certified.

Deublin sets new standards.



Reliability

Years of experience, continuous dialogues with customers and suppliers have enabled Deublin to offer reliable Rotary Unions at the cutting edge of technology. The right seal combination compatible with the media guarantees the maximum service life for every application.

A clean and efficient warehousing and handling of the union is just as much a prerequisite for our customers as the adherence to the Deublin specifications.

The market demands more products with a longer service life at more extreme parameters.

Besides new developments and the ongoing modification of existing products, it is above all better wear-resistant seal combinations that accommodate these market demands.

Service

For Deublin customer-orientated service means:

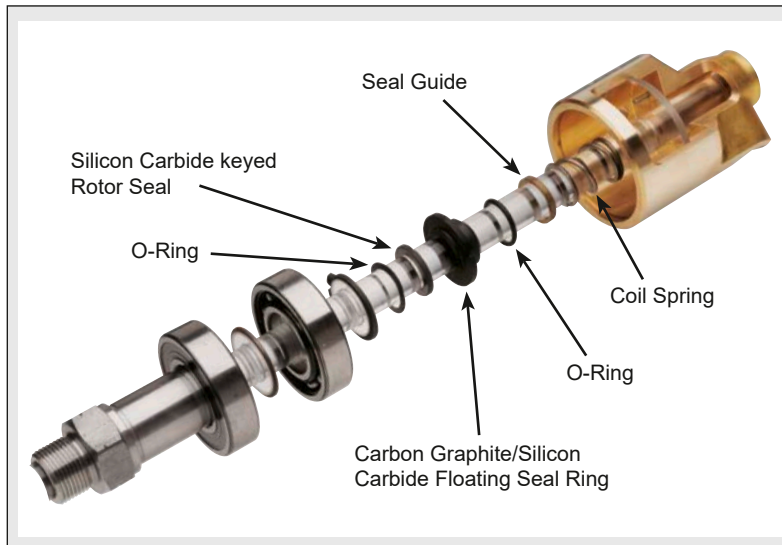
Trendsetting and newly engineered unions for special requirements, an all-encompassing technical consultation by union selection either from the Deublin facility or in the field by one of our representatives, short-term delivery of all selected components and, finally, fast troubleshooting of any and all problems.

Lengthy machine breakdowns are a thing of the past.

A broad assortment of unions is produced for stock and can be procured quickly. An automatic warehousing system enables all required components to be localized fast and effectively.

Lead times for special contractual products are only fractionally longer, for a modern and optimised production and assembly guarantee very short process times.

High-performance CAD systems allow efficient design of custom solutions based on the type of application and market potential.



Union Service

The 57 Series is designed for quick, easy replacement of both Floating Seal and the Rotor Seal.

The "57's" seal is seated in a keyed counter bore at the rotor's end. The worn seal simply lifts out and the new one drops right in. Since the entire rotor does not need to be replaced or relapped, the repair is fast, easy and on the spot. As you only replace the seals, the repair cost is very economical.

Deublin Performance System (DPS)[®]

The Deublin Performance System (DPS)[®] focuses production on customer's demand.

Through demand-oriented production, balancing of available resources and avoidance of non-value-adding activities the entire production process at Deublin is tailored to the customer's own requirements.

Today a wide range of models can be dispatched within only a few working days.



DEUBLIN

Rotary Unions 57 Series

General Purpose, DN 10 – 50

- Monoflow and duoflow design
- Self-supported Rotary Union
- Radial housing connection
- Balanced mechanical seal
- Keyed rotor seal
- Easy and quick replacement of sealing components (rotor seal, floating seal)
- 3 vent holes
- Forged brass housing
- Stainless steel rotor
- Seal combination – standard: Carbon Graphite/Silicon Carbide
- Lubrication guide page 45

For further information, please contact Deublin or your local representative.



Operating Data

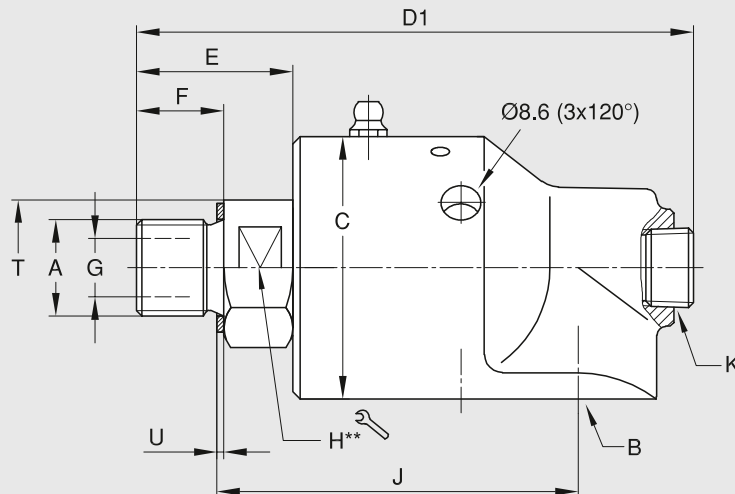
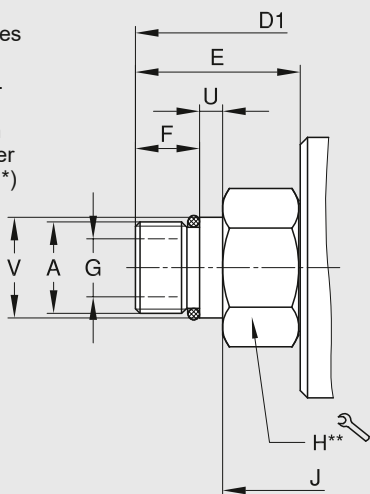
| | | | | |
|--|-------|---------|-----------|-------------------------|
| Max. Water Pressure | Model | 57-357 | 750 PSI | 50 bar |
| | | 527-657 | 300 PSI | 20 bar |
| Max. Sat. Steam Pressure (intern.) | Model | 57-657 | 15 PSI | 1 bar |
| | | | | |
| Max. Hot Oil Pressure | Model | 57-657 | 100 PSI | 6,6 bar |
| | | | | |
| Max. Speed, Rotor with Straight Threads: | Model | 57-257 | 3,500 rpm | 3.500 min ⁻¹ |
| | | 357 | 3,000 rpm | 3.000 min ⁻¹ |
| | | 527-557 | 2,500 rpm | 2.500 min ⁻¹ |
| | | 657 | 750 rpm | 750 min ⁻¹ |
| | | | | |
| NPT Threads: | Model | 57-557 | 1,500 rpm | 1.500 min ⁻¹ |
| | | 657 | 750 rpm | 750 min ⁻¹ |
| Max. Temperature | Model | 57-657 | 250 °F | 121 °C |

For higher temperature, please consult Deublin.

| Torque Ratings 57 Series | | |
|--------------------------|--------|------|
| DN | ft.lbs | Nm |
| 10 | 0.18 | 0.25 |
| 15 | 0.37 | 0.50 |
| 20 | 0.74 | 1.00 |
| 25 | 1.48 | 2.00 |
| 32 | 1.62 | 2.20 |
| 40 | 2.14 | 2.90 |
| 50 | 3.32 | 4.50 |

Monoflow unions are used when supply and return lines are connected to opposite sides of the cylinder or roll.

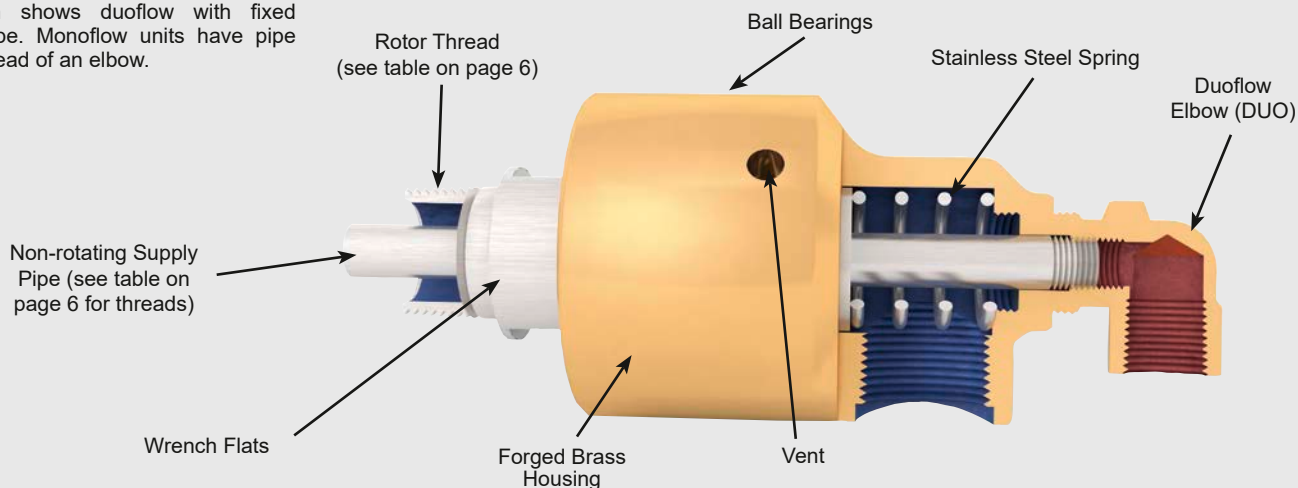
Note: Recessed O-Ring in rotor end in place of Copper gasket (see table on pg. 6 *)




Pilot Type Rotor

** DN 10 – 20 = hexagon
 DN 25 – 50 = two wrench flats

Illustration shows duoflow with fixed supply pipe. Monoflow units have pipe plugs instead of an elbow.



DEUBLIN General Industry Catalogue

| DN | B | Ordering-No STD | A Rotor-Connections | C Ø | D1 | E | F | G Ø | H D | J | K NPT | T | U | V Ø |  |
|----|-----------|--------------------|------------------------|--------|-----|----|----|--------|--------|------|----------|------|-----|--------|--|
| 10 | 3/8 NPT | 57-000-001 | 3/8 NPT RH | 45 | 100 | 26 | 16 | 9.5 | 22 | 71 | 1/4 | - | - | - | 0.6 |
| | 3/8 NPT | 57-000-002 | 3/8 NPT LH | 45 | 100 | 26 | 16 | 9.5 | 22 | 71 | 1/4 | - | - | - | 0.6 |
| | 3/8 NPT | 57-000-003 | 5/8-18 UNF RH | 45 | 100 | 26 | 16 | 9.5 | 22 | 67 | 1/4 | - | 1.6 | - | 0.6 |
| | 3/8 NPT | 57-000-004 | 5/8-18 UNF LH | 45 | 100 | 26 | 16 | 9.5 | 22 | 67 | 1/4 | - | 1.6 | - | 0.6 |
| | 3/8 NPT | 57-000-094 | G 3/8 RH | 45 | 100 | 26 | 16 | 9.5 | 22 | 67 | 1/4 | - | 1.6 | - | 0.6 |
| | 3/8 NPT | 57-000-095 | G 3/8 LH | 45 | 100 | 26 | 16 | 9.5 | 22 | 67 | 1/4 | - | 1.6 | - | 0.6 |
| | G 3/8 | 57-130-094 | G 3/8 RH | 45 | 100 | 26 | 16 | 9.5 | 22 | 67 | 1/4 | - | 1.6 | - | 0.6 |
| | G 3/8 | 57-130-095 | G 3/8 LH | 45 | 100 | 26 | 16 | 9.5 | 22 | 67 | 1/4 | - | 1.6 | - | 0.6 |
| 15 | 1/2 NPT | 157-000-001 | 1/2 NPT RH | 57 | 122 | 38 | 22 | 12.7 | 30 | 89.5 | 3/8 | - | - | - | 1.2 |
| | 1/2 NPT | 157-000-002 | 1/2 NPT LH | 57 | 122 | 38 | 22 | 12.7 | 30 | 89.5 | 3/8 | - | - | - | 1.2 |
| | 1/2 NPT | 157-000-021 | 3/4-16 UNF RH | 57 | 119 | 34 | 19 | 12.7 | 30 | 79 | 3/8 | - | 1.6 | - | 1.2 |
| | 1/2 NPT | 157-000-022 | 3/4-16 UNF LH | 57 | 119 | 34 | 19 | 12.7 | 30 | 79 | 3/8 | - | 1.6 | - | 1.2 |
| | 1/2 NPT | 157-000-151 | G 1/2 RH | 57 | 119 | 35 | 19 | 12.7 | 30 | 79 | 3/8 | - | 1.6 | - | 1.2 |
| | 1/2 NPT | 157-000-152 | G 1/2 LH | 57 | 119 | 35 | 19 | 12.7 | 30 | 79 | 3/8 | - | 1.6 | - | 1.2 |
| | G 1/2 | 157-130-151 | G 1/2 RH | 57 | 119 | 35 | 19 | 12.7 | 30 | 79 | 3/8 | - | 1.6 | - | 1.2 |
| | G 1/2 | 157-130-152 | G 1/2 LH | 57 | 119 | 35 | 19 | 12.7 | 30 | 79 | 3/8 | - | 1.6 | - | 1.2 |
| 20 | 3/4 NPT | 257-000-020 | 3/4 NPT RH | 73 | 139 | 37 | 22 | 17.5 | 32 | 103 | 1/2 | 35 | - | - | 2.1 |
| | 3/4 NPT | 257-000-021 | 3/4 NPT LH | 73 | 139 | 37 | 22 | 17.5 | 32 | 103 | 1/2 | 35 | - | - | 2.1 |
| | 3/4 NPT | 257-000-135* | 1-14 UNS RH | 73 | 139 | 36 | 19 | 17.5 | 32 | 94 | 1/2 | 35 | - | - | 2.1 |
| | 3/4 NPT | 257-000-284 | G 3/4 RH | 73 | 136 | 34 | 19 | 17.5 | 36 | 95 | 1/2 | - | 1.6 | - | 2.1 |
| | 3/4 NPT | 257-000-285 | G 3/4 LH | 73 | 136 | 34 | 19 | 17.5 | 36 | 95 | 1/2 | - | 1.6 | - | 2.1 |
| | G 3/4 | 257-130-014 | M 35 x 1.5 RH | 73 | 140 | 38 | 15 | 17.5 | 41 | 102 | 1/2 | - | 1.6 | - | 2.2 |
| | G 3/4 | 257-130-048 | M 27 x 1.5 RH | 73 | 137 | 35 | 15 | 17.5 | 36 | 92 | 1/2 | - | 6 | 28g6 | 2.1 |
| | G 3/4 | 257-130-284 | G 3/4 RH | 73 | 136 | 34 | 19 | 17.5 | 36 | 95 | 1/2 | - | 1.6 | - | 2.1 |
| 25 | 1 NPT | 357-000-002 | 1 NPT RH | 83 | 173 | 49 | 29 | 25 | 36 | 117 | 3/4 | 45 | - | - | 3.1 |
| | 1 NPT | 357-000-003 | 1 NPT LH | 83 | 173 | 49 | 29 | 25 | 36 | 117 | 3/4 | 45 | - | - | 3.1 |
| | 1 NPT | 357-000-019 | 1 1/2-12 UNF RH | 83 | 173 | 49 | 29 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| | 1 NPT | 357-000-074 | 1 1/2-12 UNF LH | 83 | 173 | 46 | 29 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| | 1 NPT | 357-000-222 | G 1 RH | 83 | 163 | 42 | 22 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| | 1 NPT | 357-000-223 | G 1 LH | 83 | 163 | 42 | 22 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| | 1 NPT | 357-000-235 | M 35 x 1.5 RH | 83 | 157 | 36 | 15 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| | 1 NPT | 357-000-236 | M 35 x 1.5 LH | 83 | 157 | 36 | 15 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| | G 1 | 357-130-222 | G 1 RH | 83 | 163 | 42 | 22 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| | G 1 | 357-130-223 | G 1 LH | 83 | 163 | 42 | 22 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| | G1 | 357-130-235 | M 35 x 1.5 RH | 83 | 157 | 36 | 15 | 25 | 36 | 108 | 3/4 | 45 | 1.6 | - | 3.1 |
| 32 | 1 1/4 NPT | 527-000-001 | 1 1/4 NPT RH | 91 | 191 | 57 | 29 | 31.8 | 46 | 134 | 1 | 57 | - | - | 4.1 |
| | 1 1/4 NPT | 527-000-002 | 1 1/4 NPT LH | 91 | 191 | 57 | 29 | 31.8 | 46 | 134 | 1 | 57 | - | - | 4.1 |
| | 1 1/4 NPT | 527-000-026 | 1 3/4-12 UN RH | 91 | 191 | 57 | 29 | 31.8 | 46 | 119 | 1 | 58 | 1.6 | - | 4.1 |
| | 1 1/4 NPT | 527-000-027 | 1 3/4-12 UN LH | 91 | 191 | 57 | 29 | 31.8 | 46 | 119 | 1 | 58 | 1.6 | - | 4.1 |
| | 1 1/4 NPT | 527-000-054 | G 1 1/4 RH | 91 | 189 | 54 | 28 | 31.8 | 46 | 119 | 1 | 58 | 1.6 | - | 4.1 |
| | 1 1/4 NPT | 527-000-055 | G 1 1/4 LH | 91 | 189 | 54 | 28 | 31.8 | 46 | 119 | 1 | 58 | 1.6 | - | 4.1 |
| | G 1 1/4 | 527-130-054 | G 1 1/4 RH | 91 | 189 | 54 | 28 | 31.8 | 46 | 119 | 1 | 58 | 1.6 | - | 4.1 |
| | G 1 1/4 | 527-130-055 | G 1 1/4 LH | 91 | 189 | 54 | 28 | 31.8 | 46 | 119 | 1 | 58 | 1.6 | - | 4.1 |
| 40 | 1 1/2 NPT | 557-000-001 | 1 1/2 NPT RH | 108 | 218 | 62 | 30 | 38 | 54 | 152 | 1 1/4 | 63.5 | - | - | 6.7 |
| | 1 1/2 NPT | 557-000-002 | 1 1/2 NPT LH | 108 | 218 | 62 | 30 | 38 | 54 | 152 | 1 1/4 | 63.5 | - | - | 6.7 |
| | 1 1/2 NPT | 557-000-395 | 2-12 UN RH | 108 | 228 | 72 | 29 | 38 | 54 | 149 | 1 1/4 | 65 | 1.6 | - | 6.7 |
| | 1 1/2 NPT | 557-000-396 | 2-12 UN LH | 108 | 228 | 72 | 29 | 38 | 54 | 149 | 1 1/4 | 65 | 1.6 | - | 6.7 |
| | 1 1/2 NPT | 557-000-198 | G 1 1/2 RH | 108 | 228 | 72 | 29 | 38 | 55 | 149 | 1 1/4 | 65 | 1.6 | - | 6.7 |
| | 1 1/2 NPT | 557-000-199 | G 1 1/2 LH | 108 | 228 | 72 | 29 | 38 | 55 | 149 | 1 1/4 | 65 | 1.6 | - | 6.7 |
| | G 1 1/2 | 557-130-198 | G 1 1/2 RH | 108 | 228 | 72 | 29 | 38 | 55 | 149 | 1 1/4 | 65 | 1.6 | - | 6.7 |
| | G 1 1/2 | 557-130-199 | G 1 1/2 LH | 108 | 228 | 72 | 29 | 38 | 55 | 149 | 1 1/4 | 65 | 1.6 | - | 6.7 |
| 50 | 2 NPT | 657-000-116 | 2 NPT RH | 118 | 257 | 74 | 38 | 47.6 | 60 | 185 | 1 1/4 | 70 | - | - | 7.6 |
| | 2 NPT | 657-000-117 | 2 NPT LH | 118 | 257 | 74 | 38 | 47.6 | 60 | 185 | 1 1/4 | 70 | - | - | 7.6 |
| | 2 NPT | 657-000-124 | G 2 RH | 118 | 248 | 65 | 29 | 47.6 | 60 | 165 | 1 1/4 | 70 | 1.6 | - | 7.6 |
| | 2 NPT | 657-000-125 | G 2 LH | 118 | 248 | 65 | 29 | 47.6 | 60 | 165 | 1 1/4 | 70 | 1.6 | - | 7.6 |
| | G 2 | 657-130-124 | G 2 RH | 118 | 248 | 65 | 29 | 47.6 | 60 | 165 | 1 1/4 | 70 | 1.6 | - | 7.6 |
| | G 2 | 657-130-125 | G 2 LH | 118 | 248 | 65 | 29 | 47.6 | 60 | 165 | 1 1/4 | 70 | 1.6 | - | 7.6 |

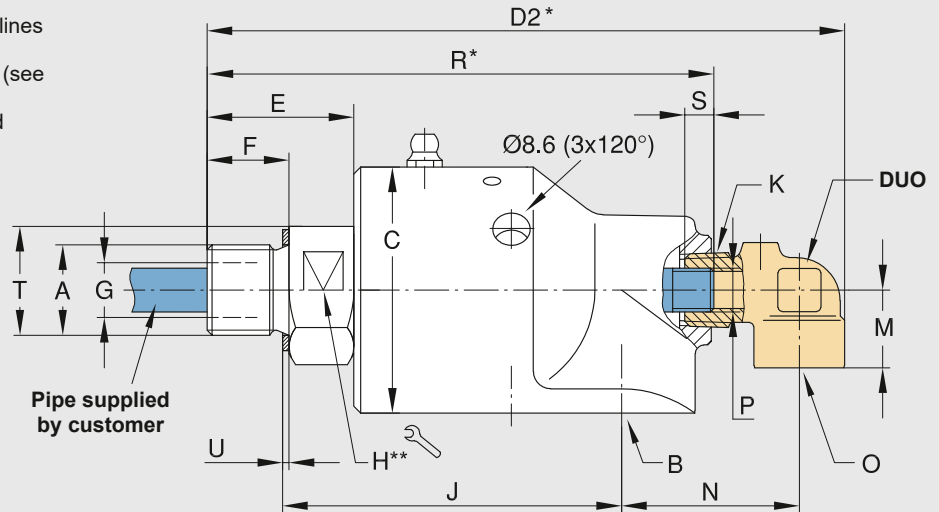
57 Series – Elbows DN 10 – 50 for Fixed, Threaded Supply Pipe

Duoflow unions are used when supply and return lines are connected to one side of the cylinder or roll; non-supported pipe lengths no longer than 4 x D1 (see page 5 and 6); max. speed 1,000 RPM; for higher speeds divided supply pipes must be used.

For Rotary Unions with pilot rotor, additional basic models and weight refer to page 6.

* Values are based on the NPT RH models. Refer to difference in E values on page 6 for length on other models or IC drawings on Deublin's website.

** DN 10 – 20 = hexagon
DN 25 – 50 = two wrench flats



Elbows 57 Series

| DN | O | fixed, threaded | | | | rotating | | | | divided | + self-centering | L | P1 Ø H9 | Q | S | D ₂ | M | N |
|----|---------|---------------------|-----------|-----|------|---------------------|-----------|-----|----|---------------------|---------------------|-----|------------|----|-----|----------------|----|----|
| | | Ordering No. DUO | P Pipe | R | S | Ordering No. DUO | P Ød11 | R | S | Ordering No. DUO | Ordering No. DUO | | | | | | | |
| 10 | G ¼ | 55-121 | M 6 | 98 | 8 | 55-807 | 5.8 | 98 | 20 | 55-843 | - | 171 | 6 | 5 | 60 | 124 | 18 | 33 |
| | ¼ NPT | 55-120 | M 6 | 98 | 8 | 55-446 | 5.8 | 98 | 20 | 55-030 | - | 171 | 6 | 5 | 55 | 124 | 18 | 33 |
| | ¼ NPT | - | - | - | - | - | - | - | - | 55-445 | - | 171 | 6 | 5 | 60 | 124 | 18 | 33 |
| 15 | G ⅜ | 155-581 | G ⅜ | 118 | 8 | 155-709 | 9.8 | 116 | 30 | 150-232 | 155-981 | 201 | 10 | 8 | 60 | 147 | 18 | 40 |
| | ⅜ NPT | 155-012 | ⅜ NPT | 120 | 5.5 | 155-061 | 9.8 | 120 | 30 | - | - | - | - | - | 147 | 18 | 40 | |
| | ⅜ NPT | 155-199 | G ⅜ | 117 | 8 | 155-471 | 9.8 | 117 | 30 | 155-470 | 155-797 | 201 | 10 | 8 | 60 | 147 | 18 | 40 |
| 20 | G ½ | 251-351 | G ¼ | 134 | 12 | 251-352 | 12.8 | 112 | 32 | 251-551 | 251-371 | 208 | 13 | 11 | 60 | 170 | 26 | 46 |
| | ½ NPT | 250-043 | ¼ NPT | 134 | 7.9 | 250-075 | 12.8 | 138 | 32 | - | - | - | - | - | 170 | 26 | 46 | |
| | ½ NPT | 250-044 | ⅜ NPT | 134 | 5.5 | 250-681 | 12.8 | 135 | 32 | 250-026 | - | 208 | 12.5 | 11 | 60 | 170 | 26 | 46 |
| | ½ NPT | 250-367 | G ⅜ | 134 | 5.5 | - | - | - | - | 250-680 | 250-994 | 208 | 13 | 11 | 60 | 170 | 26 | 46 |
| | ½ NPT | 250-368 | G ¼ | 135 | 12 | - | - | - | - | - | - | - | - | - | 170 | 26 | 46 | |
| 25 | G ½ | 350-912 | G ⅜ | 160 | 12 | 350-772 | 15.8 | 153 | 35 | 350-990 | 351-173 | 272 | 16 | 14 | 60 | 204 | 28 | 59 |
| | ½ NPT | 350-083 | ⅜ NPT | 166 | 20.9 | 350-163 | 15.8 | 166 | 32 | 350-366 | 350-974 | 272 | 16 | 14 | 60 | 204 | 28 | 59 |
| | ½ NPT | 350-084 | ¼ NPT | 169 | 20.6 | 350-347 | 15.8 | 160 | 35 | - | - | - | - | - | 204 | 28 | 59 | |
| | ½ NPT | 350-255 | G ⅜ | 160 | 12 | - | - | - | - | - | - | - | - | - | 204 | 28 | 59 | |
| 32 | G ¾ | 525-594 | G ½ | 189 | 14 | 525-480 | 21.8 | 185 | 40 | 525-931 | 525-926 | 285 | 22 | 20 | 60 | 237 | 35 | 72 |
| | ¾ NPT | 525-007 | ½ NPT | 189 | 10.8 | 525-104 | 19.02 | 187 | 38 | 525-236 | 525-592 | 285 | 22 | 20 | 60 | 237 | 35 | 72 |
| | ¾ NPT | 525-079 | G ½ | 185 | 14 | 525-237 | 21.8 | 185 | 40 | - | - | - | - | - | 237 | 35 | 72 | |
| 40 | G ¾ | 451-171 | G ¾ | 220 | 16 | 451-173 | 25.8 | 213 | 44 | 451-274 | 451-175 | 319 | 26 | 24 | 60 | 262 | 38 | 76 |
| | ¾ NPT | 450-013 | ¾ NPT | 220 | 11.3 | 450-144 | 25.8 | 220 | 44 | 450-263 | - | 319 | 26 | 24 | 60 | 262 | 38 | 76 |
| | ¾ NPT | 450-036 | ½ NPT | 230 | 10.8 | 450-468 | 25.8 | 220 | 44 | 450-467 | 451-162 | 319 | 26 | 24 | 60 | 262 | 38 | 76 |
| | ¾ NPT | 450-221 | G ¾ | 220 | 16 | - | - | - | - | - | - | - | - | - | 262 | 38 | 76 | |
| 50 | ¾ NPT | 450-013 | ¾ NPT | 260 | 11.3 | - | - | - | - | - | - | - | - | - | 298 | 38 | 78 | |
| | G 1 ¼ | 450-534 | G 1 | 261 | 26 | 450-612 | 32.1 | 240 | 52 | 655-174 | 655-707 | 382 | 34 | 31 | 60 | 316 | 45 | 96 |
| | 1 NPT | 450-183 | 1 NPT | 265 | 34.2 | - | - | - | - | - | - | - | - | - | 316 | 45 | 96 | |
| | 1 ¼ NPT | 451-242 | G 1 | 255 | 19.5 | 450-625 | 31.8 | 240 | 52 | 655-966 | 655-968 | 382 | 34 | 31 | 60 | 316 | 45 | 96 |

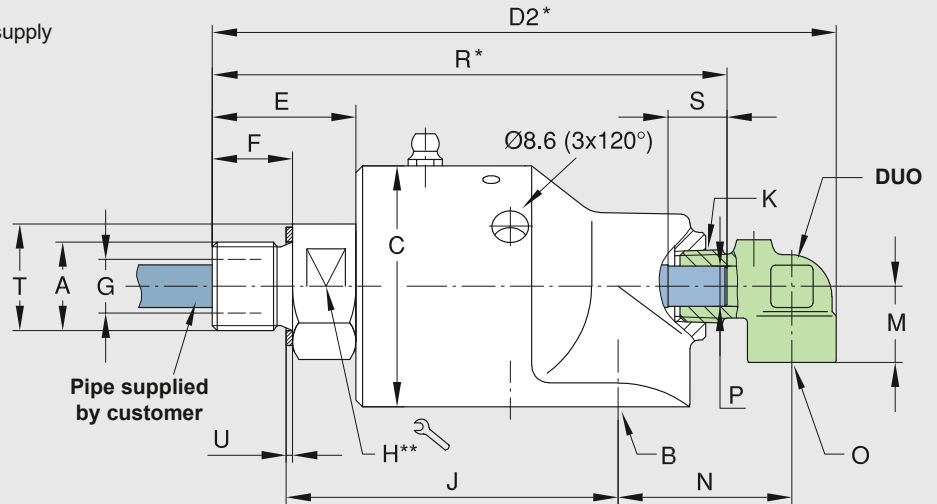
57 Series – Elbows DN 10 – 50 for Rotating Supply Pipe

Duoflow unions are used when supply and return lines are connected to one side of the cylinder or roll; max. speed 1,000 RPM; for higher speeds divided supply pipes must be used.

For Rotary Unions with pilot rotor, additional basic models and weight refer to page 6.

* Values are based on the NPT RH models. Refer to difference in E values on page 6 for length on other models or IC drawings on Deublin's website.

** DN 10 – 20 = hexagon
DN 25 – 50 = two wrench flats



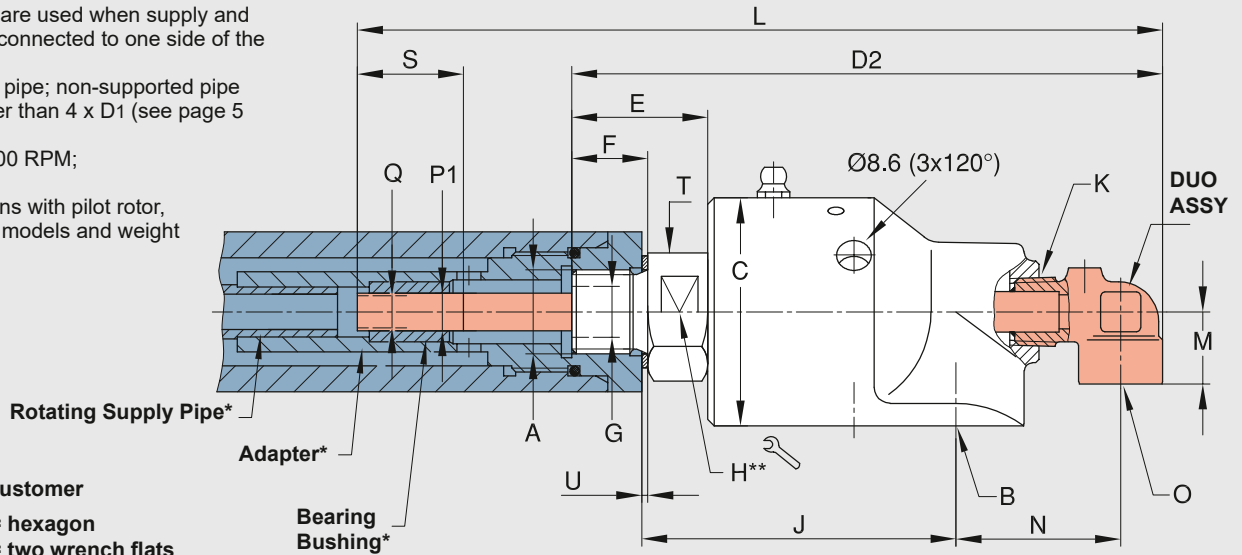
57 Series – Elbows DN 10 – 50 with Divided Siphon Pipe (soldered)

Duoflow unions are used when supply and return lines are connected to one side of the cylinder or roll; soldered supply pipe; non-supported pipe lengths no longer than 4 x D1 (see page 5 and 6); max. speed 3,500 RPM;

For Rotary Unions with pilot rotor, additional basic models and weight refer to page 6.

* supplied by customer

** DN 10 – 20 = hexagon
DN 25 – 50 = two wrench flats



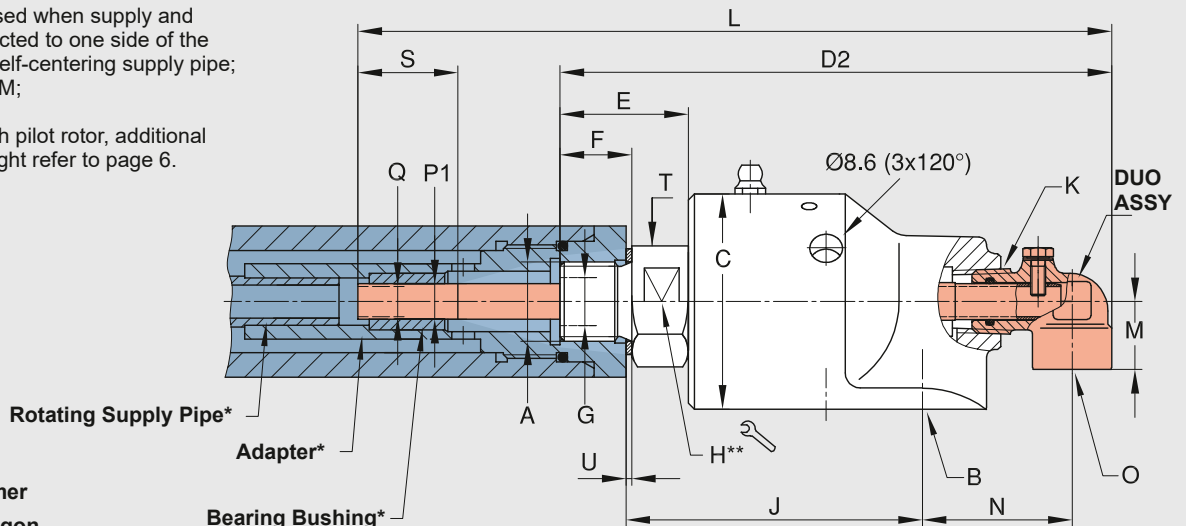
57 Series – Elbows DN 10 – 50 with Flexible, Self-Centering Supply Pipe

Duoflow unions are used when supply and return lines are connected to one side of the cylinder or roll; fixed self-centering supply pipe; max. speed 3,500 RPM;

For Rotary Unions with pilot rotor, additional basic models and weight refer to page 6.

* supplied by customer

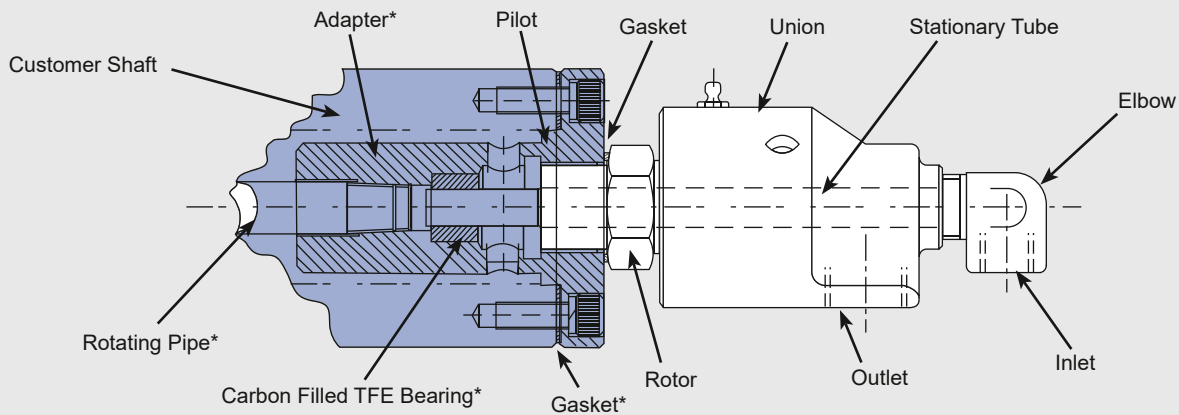
** DN 10 – 20 = hexagon
DN 25 – 50 = two wrench flats



Duoflow Supply Pipe Installations

Deublin water service unions can be adapted for Duoflow applications where a single media is circulated through and around the supply pipe. Duoflow elbows are available in 3 styles to accept a variety of different supply systems. The guidelines shown below should be carefully considered. A poorly designed supply system can contribute to premature union failure.

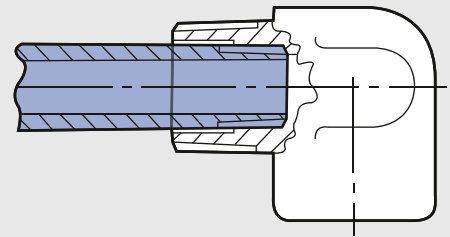
Where long pipes or high speeds are required, an adapter should be used to avoid transmitting stresses from heavy pipes, cascading water or vibrations to the union. A typical adapter is illustrated.



* Supplied by customer.

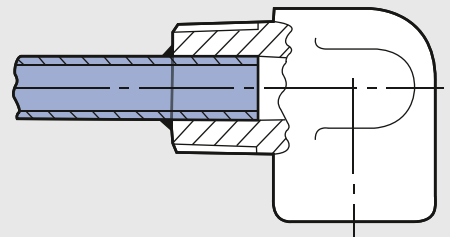
Threaded Pipe

The largest threaded supply pipe achieves the maximum flow rates available for a particular size union. Stresses at the pipe thread can cause breakage allowing the pipe to fall into the roll. For this reason pipe lengths longer than 4 union lengths (4 x D1) and rotational speeds above 1,000 RPM should be avoided.



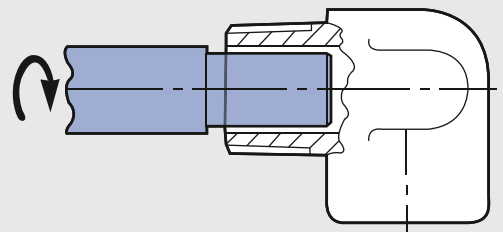
Fixed Tube

Thin wall stainless steel tube silver soldered into the Duoflow elbow produces the strongest, lightest weight assembly. The thinner wall sections allow greater flow rates than the threaded pipe. Maximum flow rates are obtained with the largest tube available for a given size union. Tube lengths is usually limited to 6 union lengths (6 x D1). Speeds to 3,500 RPM are possible.



Rotating Pipe

Rotating pipes are fastened internally to rotate with the roll. The Duoflow elbow helps to support the pipe and restrict crosstalk between passages. The pipe must be straight and concentric to the center line to avoid excessive loading of the union. The union must also have a rotor with a straight thread (Example 1" - 14 UNS) rather than a tapered pipe thread to assure concentricity. Rotational speeds above 1,000 RPM should be avoided.





DEUBLIN

Monoflow Rotary Unions 57 series

“Hot Media” for Hot Water and Hot Oil

DN 15 - 50

- Monoflow and duoflow design
- Self-supported Rotary Union
- Radial housing connection
- Balanced mechanical seal
- Keyed rotor seal
- 3 vent holes
- Forged brass housing
- Stainless steel rotor
- Seal combination – standard: Carbon Graphite/Silicon Carbide
- Lubrication guide see Operating Manual 040-550-2 (available from our website)

Operating Data

| | | | | |
|---|-------|-----------|-----------|-------------------------|
| Max. Water Pressure | Model | 157 – 357 | 750 PSI | 50 bar |
| | | 527 – 657 | 300 PSI | 20 bar |
| Max. Hot Oil Pressure | Model | 157 – 657 | 100 PSI | 6,6 bar |
| Max. Speed, | | | | |
| Rotor with Straight Threads: | Model | 157 – 257 | 3,500 rpm | 3.500 min ⁻¹ |
| | | 357 | 3,000 rpm | 3.000 min ⁻¹ |
| | | 527 – 557 | 2,500 rpm | 2.500 min ⁻¹ |
| | | 657 | 750 rpm | 750 min ⁻¹ |
| Max. Temperature | Model | 157 – 657 | 320°F | 160°C |
| For higher temperature, please consult Deublin. | | | | |

For further information, please contact Deublin or your local representative.

Monoflow Rotary Union for Hot Water

| DN | A Rotor Connections | B | Rotor with BSP Threads | | Rotor with NPT Threads | | DN |
|----|---------------------|------|------------------------|--------------|------------------------|--------------|----|
| | | | RH | LH | RH | LH | |
| 15 | G ½ | G ½ | 157-2013-151 | 157-2013-152 | 157-2012-001 | 157-2012-002 | 15 |
| 20 | G ¾ | G ¾ | 257-2695-284 | 257-2695-285 | 257-2418-020 | 257-2418-021 | 20 |
| 25 | G 1 | G 1 | 357-2897-222 | 357-2897-223 | 357-2517-002 | 357-2517-003 | 25 |
| 32 | G 1¼ | G 1¼ | 527-2673-054 | 527-2673-055 | 527-2637-001 | 527-2637-002 | 32 |
| 40 | G 1½ | G 1½ | 557-2544-198 | 557-2544-199 | 557-2514-001 | 557-2514-002 | 40 |
| 50 | G 2 | G 2 | 657-2983-124 | 657-2983-125 | 657-2827-116 | 657-2827-117 | 50 |
| 50 | Flange | G 2 | 657-2983-421 | | 657-2827-421 | | 50 |

Monoflow Rotary Union for Hot Oil

| DN | A Rotor Connections | B | Rotor with BSP Threads | | Rotor with NPT Threads | | DN |
|----|---------------------|------|------------------------|--------------|------------------------|--------------|----|
| | | | RH | LH | RH | LH | |
| 15 | G ½ | G ½ | 157-2014-151 | 157-2014-152 | 157-2003-001 | 157-2003-002 | 15 |
| 20 | G ¾ | G ¾ | 257-2475-284 | 257-2475-285 | 257-2318-020 | 257-2318-021 | 20 |
| 25 | G 1 | G 1 | 357-2556-222 | 357-2556-223 | 357-2279-002 | 357-2279-003 | 25 |
| 32 | G 1¼ | G 1¼ | 527-2718-054 | 527-2718-055 | 527-2583-001 | 527-2583-002 | 32 |
| 40 | G 1½ | G 1½ | 557-2241-198 | 557-2241-199 | 557-2483-001 | 557-2483-002 | 40 |
| 50 | G 2 | G 2 | 657-2823-124 | 657-2823-125 | 657-2511-116 | 657-2511-117 | 50 |
| 50 | Flange | G 2 | 657-2823-421 | | 657-2511-421 | | 50 |

Information: For dimensions of the Hot Media Rotary Unions, refer to page 5.
For the duoflow design, elbows and siphon pipes are available. Refer to page 7 – 9.

DEUBLIN

Rotary Union 57 Series

ATEX-Certified, DN 15 - 50

- Monoflow and duoflow design
- Self-supported Rotary Union
- Radial housing connection
- Balanced mechanical seal
- Keyed rotor seal
- Easy and quick replacement of sealing components (rotor seal, floating seal)
- 3 vent holes
- Forged brass housing
- Stainless steel rotor
- Seal combination – standard: Carbon Graphite/Silicon Carbide
- Lubrication guide page 45

For further information, please contact Deublin or your local representative.



Operating Data

| | | | | |
|------------------------------|-------|-----------|-----------|-------------------------|
| Max. Water Pressure | Model | 157 – 657 | 150 PSI | 10 bar |
| Max. Speed, | | | | |
| Rotor with Straight Threads: | Model | 157 – 257 | 3,500 rpm | 3.500 min ⁻¹ |
| | | 357 | 3,000 rpm | 3.000 min ⁻¹ |
| | | 527 – 557 | 2,500 rpm | 2.500 min ⁻¹ |
| | | 657 | 750 rpm | 750 min ⁻¹ |
| Max. Temperature | Model | 157 – 657 | 250°F | 121°C |

For higher temperature, please consult Deublin.

Legend

| | |
|---------|---|
| CE | = Declaration of conformity |
| Ex | = Hazardous area |
| II | = Group of devices |
| - | = Device does not convey any potentially explosive atmosphere |
| 2 or 3 | = Device category 2 for use in zone 1 and/or zone 21 3 for use in zone 2 and/or zone 22 |
| G | = Hazardous area due to gases, vapours, mist |
| D | = Hazardous area due to dust |
| c | = Design safety (protection by safe design) |
| IIB | = Explosion group of gases |
| IIIC | = Explosion group of dust |
| T195 °C | = Maximum surface temperature (less 5K for type approval test); Classification of dust |
| T383 °F | |
| T3 | = Temperature class (classification of gases) |

Example of ATEX identification

ATEX-compliant rotary union with limited operating time.

Max. usage time: 4,000 h.

ATEX Classification:

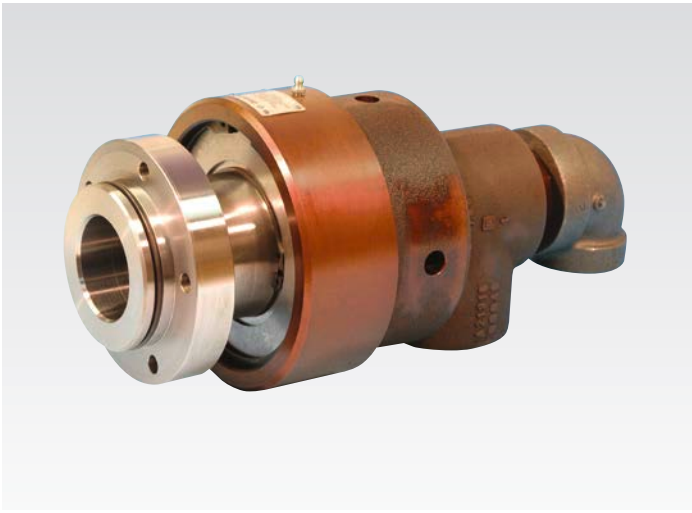
CE Ex II-/2G Ex h IIB T3 Gb
Ex II-/2D Ex h IIIC T195°C Db
+3°C ≤ Ta ≤ 40°C

Attention

Ex Deublin Rotary Unions for use in zone 1 and/or 21 have to be operated with a differential pressure or flow monitoring system as protective equipment to prevent an excessive temperature rise occurring due to dry operation of the axial face seal.

Monoflow Rotary Union for ATEX

| DN | A Rotor Connections | B | Rotor with BSP Threads | |
|----|---------------------|------|------------------------|-------------|
| | | | RH | LH |
| 15 | G ½ | G ½ | 157X130-151 | 157X130-152 |
| 20 | G ¾ | G ¾ | 257X130-284 | 257X130-285 |
| 25 | G 1 | G 1 | 357X130-222 | 357X130-223 |
| 32 | G 1¼ | G 1¼ | 527X130-054 | 527X130-055 |
| 40 | G 1½ | G 1½ | 557X130-198 | 557X130-199 |
| 50 | G 2 | G 2 | 657X130-124 | 657X130-125 |



DEUBLIN

Rotary Union with Flange Rotor, DN 50 and 65

- Monoflow and duoflow design
- Self-supported Rotary Union
- Radial housing connection
- 3 or 6 vent holes
- Forged brass housing (DN 50) and Cast iron housing (DN 65)
- Steel rotor
- Balanced mechanical seal – standard:
Carbon Graphite/Ceramic
- Lubrication Guide page 45

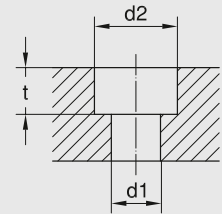
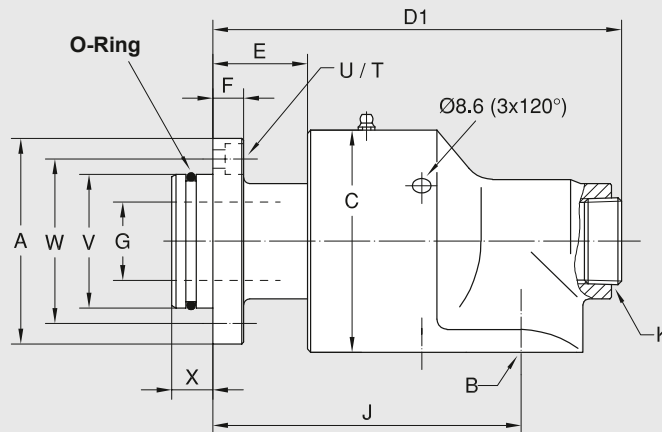
For further information, please contact Deublin or your local representative.

Operating Data

| | | | | |
|------------------------------------|-------|----------|-----------|-------------------------|
| Max. Water Pressure | Model | 657, 755 | 200 PSI | 14 bar |
| Max. Sat. Steam Pressure (intern.) | | | 15 PSI | 1 bar |
| Max. Speed | Model | 657, 755 | 1,000 rpm | 1,000 min ⁻¹ |
| Max. Temperature | | | 250 °F | 121 °C |

For higher temperature, please consult Deublin.

Monoflow Rotary Union



Flange O-Ring

(supplied by Deublin) for:
Model O-Ring Size
657 73 x 4 Viton

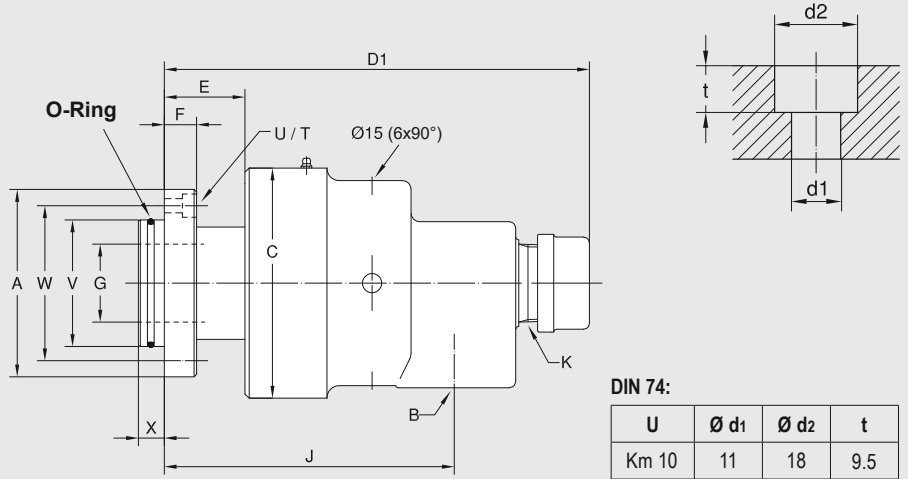
DIN 74:

| U | Ø d1 | Ø d2 | t |
|-------|------|------|-----|
| Km 10 | 11 | 18 | 9.5 |

Monoflow Rotary Union

| DN | B NPT | Ordering-No | A Ø | C Ø | D1 | E | F | G Ø | J | K NPT | T | U | Vf7 Ø PT | W Ø | X | kg |
|----|----------|-------------|--------|--------|-----|----|----|--------|-----|----------|---------|-------|-------------|--------|----|----|
| 50 | G 2 | 657-130-421 | 124 | 117.5 | 228 | 46 | 16 | 47.6 | 172 | 1 ¼ | 5 x 72° | Km 10 | 80 | 100 | 20 | 9 |

Monoflow Rotary Union



Flange O-Ring

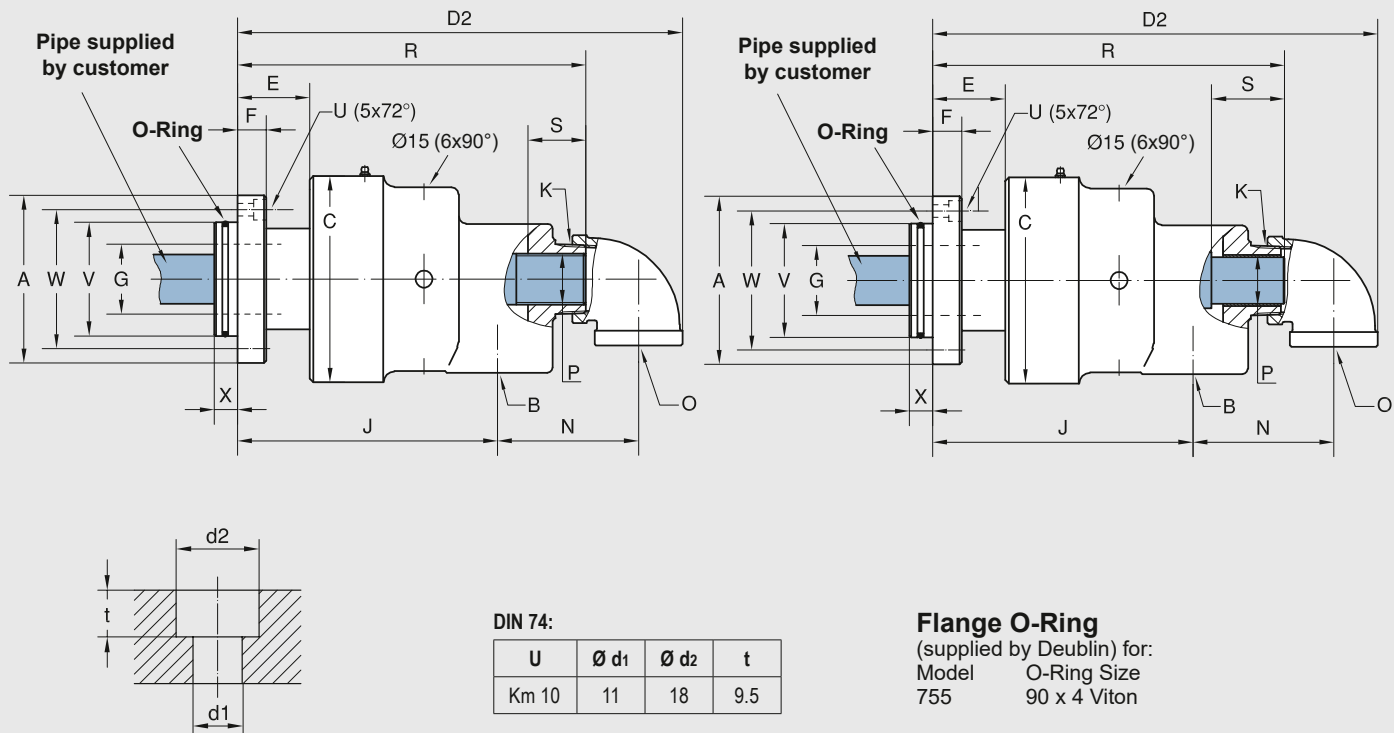
(supplied by Deublin) for:
 Model O-Ring Size
 755 90 x 4 Viton

Monoflow Rotary Union

| DN | B NPT | O | Ordering-No | A Ø | C Ø | D1 | E | F | G Ø | J | K NPT | T | U | V77 Ø PT | W Ø | X | kg |
|----|----------|---|-------------|--------|--------|-----|----|----|--------|-----|----------|---------|-------|-------------|--------|----|----|
| 65 | 2 1/2 | - | 755-713-495 | 145 | 178 | 317 | 63 | 26 | 60.3 | 225 | 2 | 5 x 72° | Km 10 | 98 | 120 | 20 | 22 |
| | 2 1/2 | - | 755-747-495 | 145 | 178 | 323 | 63 | 26 | 60.3 | 227 | 2 | 5 x 72° | Km 10 | 98 | 120 | 20 | 22 |

Duoflow Rotary Union for Threaded Supply Pipe

Duoflow Rotary Union for Rotating Supply Pipe



Duoflow Rotary Union

| DN | B NPT | O NPT | Ordering-No | A Ø | C Ø | D2 | E | F | G Ø | J | K NPT | N | P Pipe | R | S | U DIN 74 | V77 Ø PT | W Ø | X | kg |
|----|----------|----------|----------------|--------|--------|-----|----|----|--------|-----|----------|-----|-----------|-----|----|-------------|-------------|--------|----|----|
| 65 | 2 1/2 | 1 1/2 | 755-713-495139 | 145 | 178 | 372 | 63 | 26 | 60.3 | 225 | 2 | 112 | G 1 1/2 | 301 | 45 | Km 10 | 98 | 120 | 20 | 23 |
| | 2 1/2 | 1 1/2 | 755-729-495139 | 145 | 178 | 372 | 63 | 26 | 60.3 | 225 | 2 | 112 | Ø39.3 h13 | 308 | 70 | Km 10 | 98 | 120 | 20 | 23 |



DEUBLIN

Rotary Union General Purposes, DN 65

- Monoflow and duoflow design
- Self-supported Rotary Union
- Radial housing connection
- 6 vent holes
- Cast iron housing
- Steel rotor
- Balanced mechanical seal – standard:
Carbon Graphite/Ceramic
- Lubrication Guide page 45

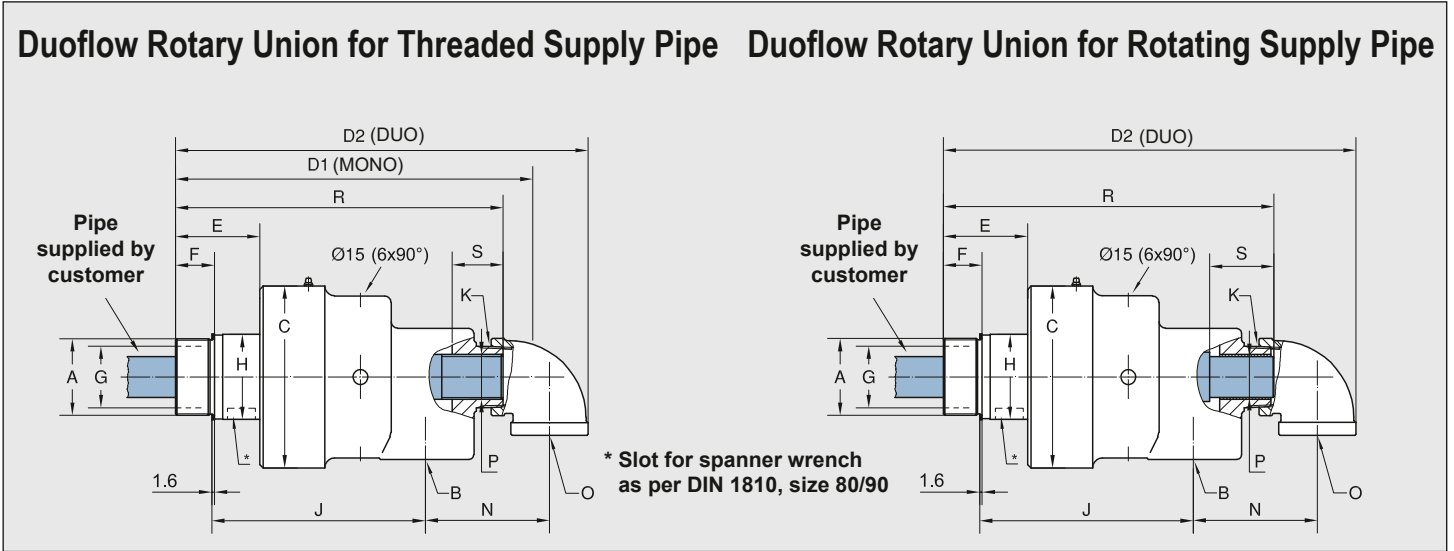
Operating Data

| | | |
|------------------------------------|----------|-----------------------|
| Max. Water Pressure | 200 PSI | 14 bar |
| Max. Sat. Steam Pressure (intern.) | 15 PSI | 1 bar |
| Max. Speed | 750 rpm | 750 min ⁻¹ |
| Torque at 120 PSI / 8 bar | 4 FT.LBS | 5,4 Nm |
| Max. Temperature | 250 °F | 121 °C |

For higher temperature, please consult Deublin.

For further information, please contact Deublin or your local representative.

Duoflow Rotary Union for Threaded Supply Pipe Duoflow Rotary Union for Rotating Supply Pipe



Monoflow Rotary Union

| DN | B NPT | O NPT | Ordering-No | A Rotor Connections | C Ø | D1 | E | F | G Ø | H Ø | J | K | P Pipe | R | S | kg |
|----|----------|----------|-------------|------------------------|--------|-----|----|----|--------|--------|-----|-------|-----------|-----|----|----|
| 65 | 2 1/2 | - | 755-700-330 | G 2 1/2 RH | 178 | 337 | 83 | 38 | 60.3 | 83 | 210 | 2 NPT | - | - | - | 20 |
| | 2 1/2 | - | 755-700-411 | G 2 1/2 LH | 178 | 337 | 83 | 38 | 60.3 | 83 | 210 | 2 NPT | - | - | - | 20 |
| | 2 1/2 | - | 755-700-413 | 2 1/2 NPT RH | 178 | 336 | 82 | 48 | 60.3 | 83 | 219 | 2 NPT | - | - | - | 20 |
| | 2 1/2 | - | 755-700-415 | 2 1/2 NPT LH | 178 | 336 | 82 | 48 | 60.3 | 83 | 219 | 2 NPT | - | - | - | 20 |
| | 2 1/2 | - | 755-707-330 | G 2 1/2 RH | 178 | 344 | 82 | 38 | 60.3 | 83 | 210 | 2 NPT | G 1 1/2 | 319 | 45 | 20 |
| | 2 1/2 | - | 755-707-411 | G 2 1/2 LH | 178 | 344 | 82 | 38 | 60.3 | 83 | 210 | 2 NPT | G 1 1/2 | 319 | 45 | 20 |

Duoflow Rotary Union

| DN | B NPT | O NPT | Ordering-No | A Rotor Connections | C Ø | D2 | E | F | G Ø | H Ø | J | K | N | P Pipe | R | S | kg |
|----|----------|----------|----------------|------------------------|--------|-----|----|----|--------|--------|-----|-------|-----|-----------|-----|----|----|
| 65 | 2 1/2 | 1 1/4 | 755-700-413117 | 2 1/2 NPT RH | 178 | 393 | 82 | 48 | 60.3 | 83 | 219 | 2 NPT | 112 | 1 NPT | 316 | - | 20 |
| | 2 1/2 | 1 1/4 | 755-700-415117 | 2 1/2 NPT LH | 178 | 380 | 81 | 48 | 60.3 | 83 | 223 | 2 NPT | 112 | 1 NPT | 316 | 43 | 20 |
| | 2 1/2 | 1 1/2 | 755-702-413139 | 2 1/2 NPT RH | 178 | 381 | 82 | 48 | 60.3 | 83 | 219 | 2 NPT | 112 | 1 NPT | 313 | 43 | 20 |
| | 2 1/2 | 1 1/2 | 755-707-330139 | G 2 1/2 RH | 178 | 391 | 82 | 38 | 60.3 | 83 | 208 | 2 NPT | 112 | G 1 1/2 | 320 | 45 | 20 |
| | 2 1/2 | 1 1/2 | 755-707-411139 | G 2 1/2 LH | 178 | 391 | 82 | 38 | 60.3 | 83 | 208 | 2 NPT | 112 | G 1 1/2 | 320 | 45 | 20 |
| | 2 1/2 | 1 1/2 | 755-732-330139 | G 2 1/2 RH | 178 | 391 | 82 | 38 | 60.3 | 83 | 208 | 2 NPT | 112 | Ø39.9 h13 | 320 | 45 | 20 |
| | 2 1/2 | 1 1/2 | 755-732-411139 | G 2 1/2 LH | 178 | 391 | 82 | 38 | 60.3 | 83 | 208 | 2 NPT | 112 | Ø39.9 h13 | 320 | 45 | 20 |
| | 2 1/2 | 1 1/2 | 755-769-049139 | G 2 1/2 RH | 178 | 391 | 81 | 38 | 60.3 | 83 | 209 | 2 | 112 | G 1 1/2 | 319 | 45 | 23 |
| | 2 1/2 | 1 1/2 | 755-901-898139 | G 2 1/2 LH | 178 | 392 | 82 | 53 | 60.3 | 83 | 246 | 2 | 112 | G 1 1/2 | 320 | 45 | 23 |

DEUBLIN

Rotary Union 857 Series

Water Service, DN 80

- Monoflow and duoflow design
- Self-supported Rotary Union
- Radial housing connection
- Balanced mechanical seal
Carbon Graphite/Tungsten Carbide
- Full-media flow
- Easy and quick replacement of sealing components
(rotor seal, floating seal)
- Vent holes
- Cast iron housing
- Steel rotor
- Lubrication Guide page 45

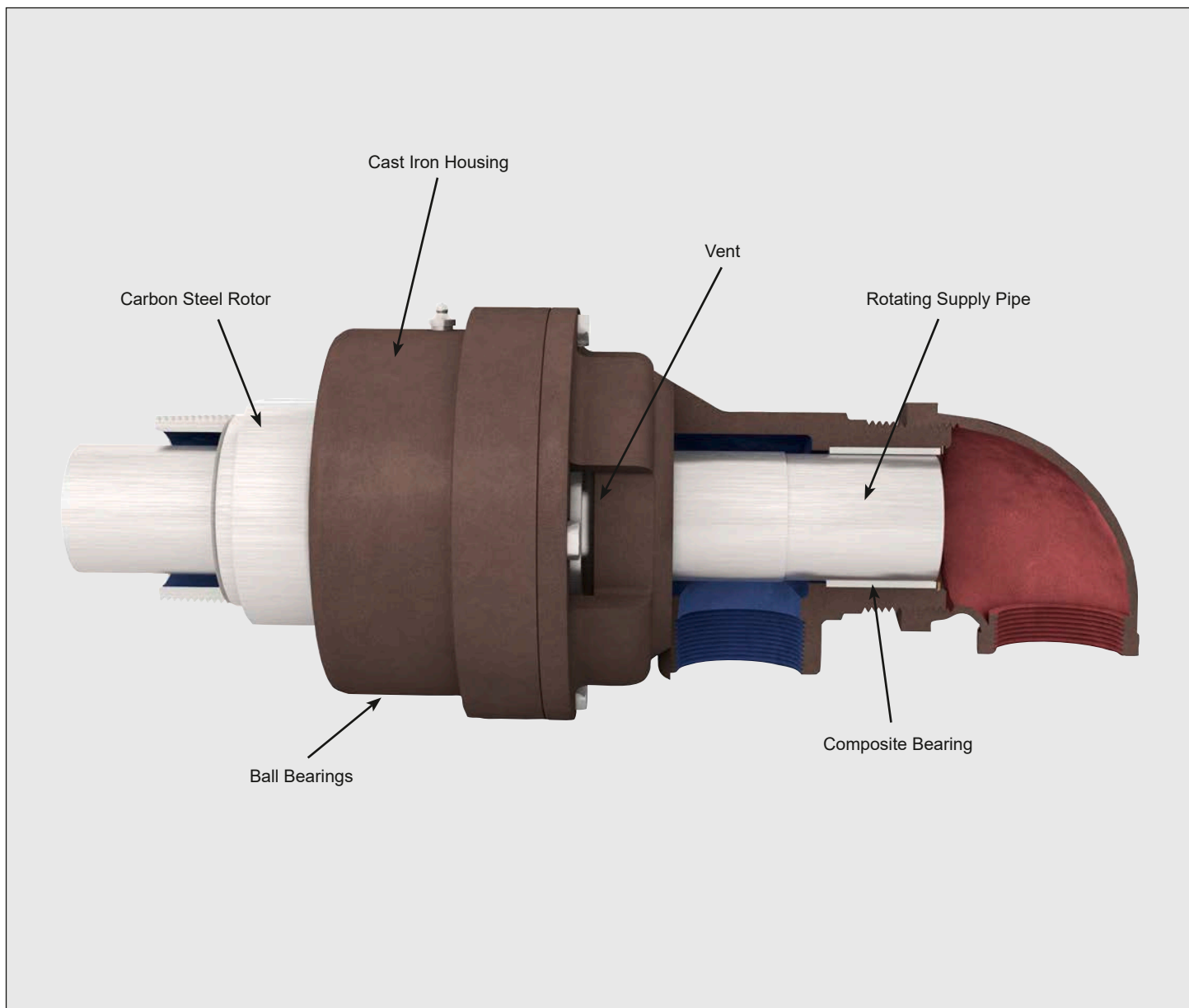


Operating Data

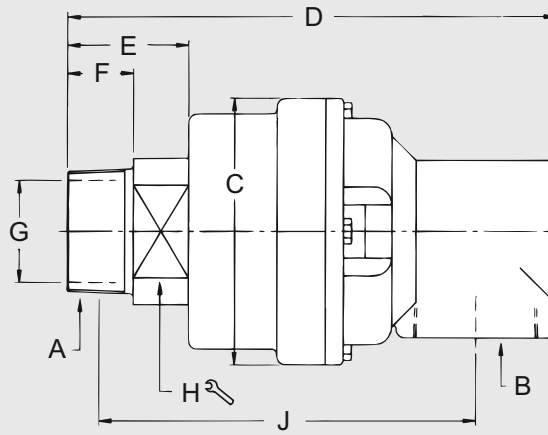
| | | |
|------------------------------------|----------|-----------------------|
| Max. Water Pressure | 150 PSI | 10 bar |
| Max. Sat. Steam Pressure (interm.) | 15 PSI | 1 bar |
| Max. Speed | 500 rpm | 500 min ⁻¹ |
| Torque at 150 PSI / 10 bar | 6 FT.LBS | 8,2 Nm |
| Max. Temperature | 250 °F | 121 °C |

For higher temperature, please consult Deublin.

For further information, please contact Deublin or your local representative.



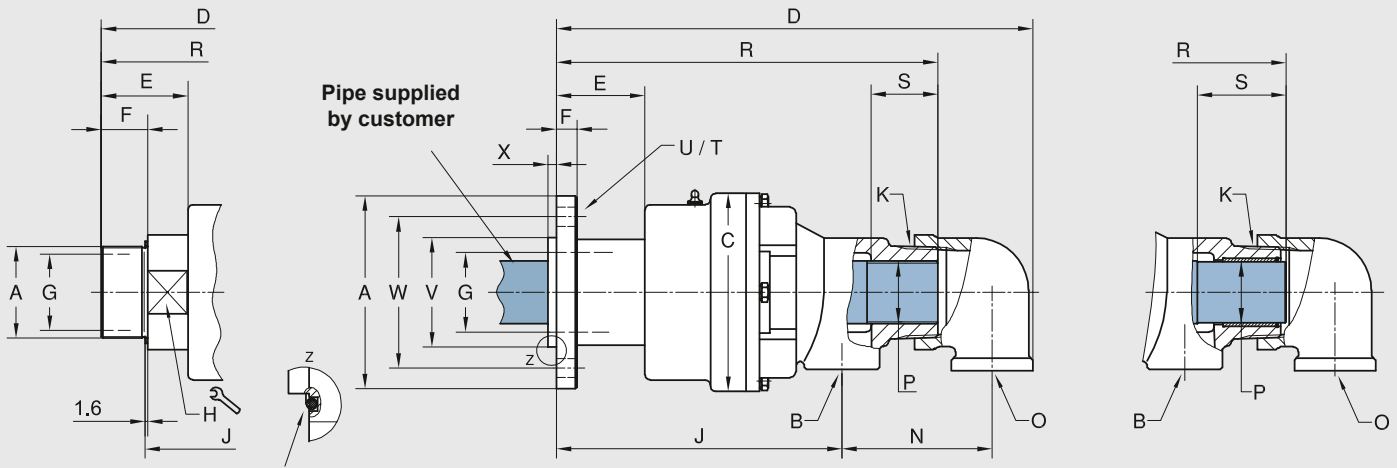
Monoflow Rotary Union



| DN | B NPT | Ordering-No | A Rotor Connections | | C Ø | D | E | F | G Ø | H ⌀ | J | kg |
|----|----------|-------------|------------------------|----|--------|-----|----|----|--------|--------|-----|----|
| 80 | 3 | 857-000-101 | 3 NPT | RH | 190 | 349 | 87 | 48 | 73 | 102 | 267 | 23 |
| | 3 | 857-000-102 | 3 NPT | LH | 190 | 349 | 87 | 48 | 73 | 102 | 267 | 23 |
| | 3 | 857-000-118 | G 3 | RH | 190 | 345 | 84 | 45 | 73 | 102 | 247 | 23 |
| | 3 | 857-000-119 | G 3 | LH | 190 | 345 | 84 | 45 | 73 | 102 | 247 | 23 |

Duoflow Rotary Union for Threaded Supply Pipe

Rotating Supply Pipe Design



Flange O-Ring
 126.37 x 5.33 Viton (857-002-132)
 113.89 x 3.53 Viton (857-002-145)
 (supplied by Deublin)

| DN | B NPT | O NPT | Ordering-No | A Rotor Connections | | C Ø | D | E | F | G Ø | H ⌀ | J | K NPT | N | P | R | S | T | U Ø | V ØPT | W Ø | X | kg |
|----|----------|----------|-------------|------------------------|----|--------|-----|----|----|--------|--------|-----|----------|-----|----------|-----|----|---------|--------|------------------|--------|-----|----|
| 80 | 2 | 2 | 857-001-101 | 3 NPT | RH | 190 | 446 | 87 | 48 | 73 | 102 | 246 | 3 | 144 | 2 NPT | 351 | - | - | - | - | - | - | 25 |
| | 2 | 2 | 857-001-102 | 3 NPT | LH | 190 | 446 | 87 | 48 | 73 | 102 | 246 | 3 | 144 | 2 NPT | 351 | - | - | - | - | - | - | 25 |
| | 2 | 2 | 857-002-118 | G 3 | RH | 190 | 453 | 84 | 45 | 73 | 102 | 228 | 3 | 144 | 58.7 h13 | 364 | 85 | - | - | - | - | - | 29 |
| | 2 | 2 | 857-002-119 | G 3 | LH | 190 | 453 | 84 | 45 | 73 | 102 | 228 | 3 | 144 | 58.7 h13 | 364 | 85 | - | - | - | - | - | 29 |
| | 2 | 2 | 857-002-132 | Flange Ø229 | | 190 | 450 | 91 | 22 | 76 | - | 277 | 3 | 144 | 58.7 h13 | 366 | 85 | 6 x 60° | 17 | 101.68 101.58 | 192 | 6.4 | 30 |
| | 2 | 2 | 857-002-145 | Flange Ø185 | | 190 | 454 | 85 | 20 | 73 | - | 271 | 3 | 144 | 58.7 h13 | 365 | 85 | 4 x 90° | 18 | 105.00 104.95 | 145 | 8 | 29 |

DEUBLIN

Rotary Union 54 Series

Stainless Steel for Water, DN 10 – 40

- Monoflow design – for duoflow design refer to page 18
- Self-supported Rotary Union
- Radial and axial housing connection
- Media contacting parts made of stainless steel
- Suitable for the food, chemical & pharmaceutical industries
- Full-media flow
- Seal combination:
Tungsten Carbide/Ceramic

For further information, please contact Deublin or your local representative.



Operating Data

| | | |
|------------------------------------|------------------------|-------------------------|
| Max. Water Pressure and Max. Speed | see Diagram on page 18 | |
| Max. Speed NPT Threads | 1,500 rpm | 1,500 min ⁻¹ |
| Max. Temperature | 160 °F | 71 °C |

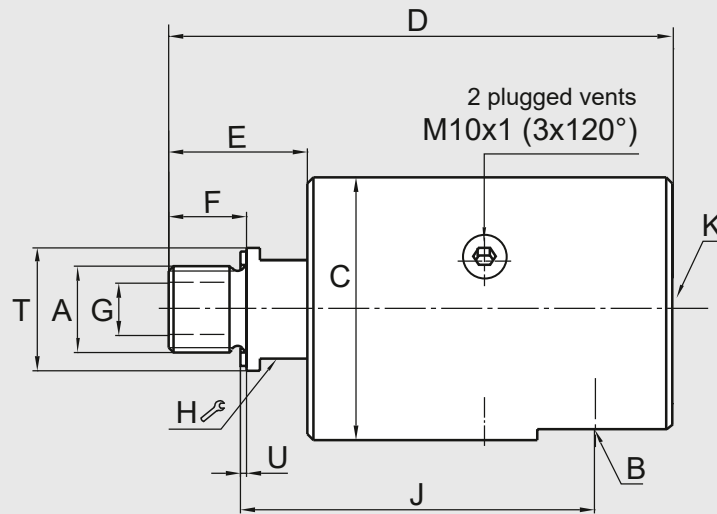
For higher temperature, please consult Deublin.

Temperature > 71 °C / 160 °F – max. 90 °C / 194 °F only if max. pressure ≤ 10 bar (150 PSI) and media is liquid (not gaseous).



DO NOT RUN DRY

Monoflow Rotary Union



Monoflow Rotary Union

| DN | B | Ordering-No | A Rotor Connections | | C Ø | D | E | F | G Ø | H ⌀ | J | K | T Øh11 | U | kg |
|----|---------|-------------|------------------------|----|--------|-----|------|----|--------|--------|-----|---------|-----------|-----|-----|
| 10 | G 3/8 | 54-020-110 | G 3/8 | RH | 49 | 101 | 26 | 16 | 9.5 | 19 | 72 | G 3/8 | 22 | 1.6 | 1.1 |
| | G 3/8 | 54-020-112 | 3/8 NPT | RH | 49 | 103 | 28 | 16 | 9.5 | 19 | 81 | G 3/8 | 22 | – | 1.1 |
| 15 | G 1/2 | 154-020-110 | G 1/2 | RH | 64 | 123 | 34 | 19 | 12.7 | 24 | 89 | G 3/8 | 30 | 1.6 | 1.8 |
| | G 1/2 | 154-020-112 | 1/2 NPT | RH | 64 | 123 | 34 | 19 | 12.7 | 24 | 96 | G 3/8 | 30 | – | 1.8 |
| 20 | G 3/4 | 254-020-110 | G 3/4 | RH | 73 | 138 | 36.7 | 19 | 17.5 | 30 | 97 | G 3/4 | 35 | 1.6 | 2.6 |
| | G 3/4 | 254-020-112 | 3/4 NPT | RH | 73 | 136 | 34.6 | 19 | 17.5 | 30 | 102 | G 3/4 | 35 | – | 2.6 |
| 25 | G 1 | 354-020-110 | G 1 | RH | 94 | 162 | 43.5 | 22 | 25 | 36 | 116 | G 3/4 | 45 | 1.6 | 5.1 |
| | G 1 | 354-020-112 | 1 NPT | RH | 94 | 162 | 44 | 22 | 25 | 36 | 124 | G 3/4 | 45 | – | 5.1 |
| 32 | G 1 | 524-020-110 | G 1 1/4 | RH | 99 | 182 | 54.5 | 27 | 31.8 | 41 | 123 | G 1 1/4 | 50 | 1.6 | 6 |
| 40 | G 1 1/4 | 554-020-110 | G 1 1/2 | RH | 108 | 200 | 58 | 29 | 35 | 50 | 135 | G 1 1/4 | 60 | 1.6 | 8.2 |
| | G 1 1/4 | 554-020-112 | 1 1/2 NPT | RH | 108 | 199 | 57 | 30 | 35 | 50 | 147 | G 1 1/4 | 60 | – | 8.2 |



DEUBLIN

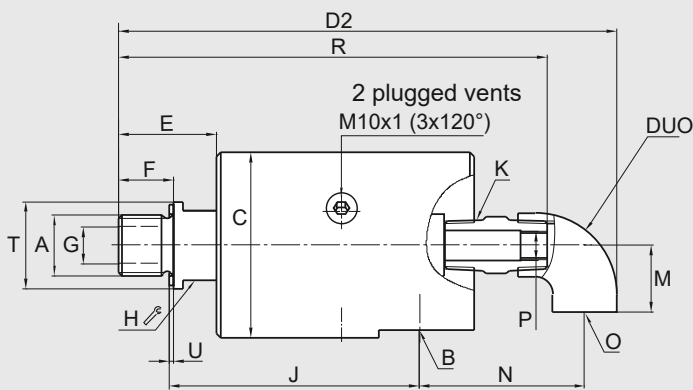
Rotary Union 54 Series

Stainless Steel for Water, DN 10 – 40

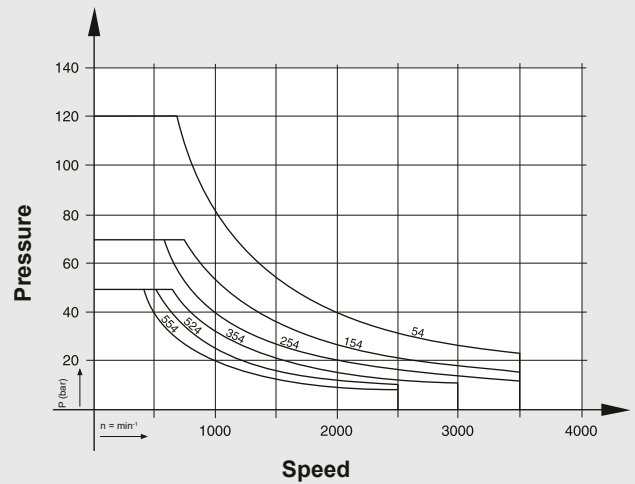
- Duoflow design – for monoflow design refer to page 17
- Self-supported Rotary Union
- Radial and axial housing connection
- Media contacting parts made of stainless steel
- Suitable for the food, chemical & pharmaceutical industries
- Full-media flow
- Seal combination:
Tungsten Carbide/Ceramic

For further information, please contact Deublin or your local representative.

Monoflow Rotary Union + Elbow = Duoflow Rotary Union



Note: 1,000 RPM max.
for Duoflow



Monoflow Rotary Union + Elbow = Duoflow Rotary Union

| DN | Ordering-No Monoflow Union | Ordering-No Elbow | D2 | M | N | O | P | R | kg |
|----|----------------------------|-------------------|-----|----|-----|---------|-------|-----|-----|
| 10 | 54-020-110 | 54-150 | 154 | 23 | 57 | G 3/8 | M6 | 128 | 1.3 |
| | 54-020-112 | 54-150 | 156 | 23 | 57 | G 3/8 | M6 | 130 | 1.3 |
| 15 | 154-020-110 | 154-150 | 176 | 23 | 59 | G 3/8 | G 1/8 | 150 | 2.1 |
| | 154-020-112 | 154-150 | 176 | 23 | 59 | G 3/8 | G 1/8 | 150 | 2.1 |
| 20 | 254-020-110 | 254-150 | 216 | 33 | 85 | G 3/4 | G 1/4 | 176 | 2.8 |
| | 254-020-112 | 254-150 | 214 | 33 | 85 | G 3/4 | G 1/4 | 174 | 2.8 |
| 25 | 354-020-110 | 354-150 | 240 | 33 | 87 | G 3/4 | G 3/8 | 200 | 5.3 |
| | 354-020-112 | 354-150 | 240 | 33 | 87 | G 3/4 | G 3/8 | 200 | 5.3 |
| 32 | 524-020-110 | 524-150 | 290 | 45 | 118 | G 1 1/4 | G 1/2 | 234 | 6.3 |
| 40 | 554-020-110 | 554-150 | 308 | 45 | 120 | G 1 1/4 | G 3/4 | 251 | 8.6 |
| | 554-020-112 | 554-150 | 307 | 45 | 120 | G 1 1/4 | G 3/4 | 250 | 8.6 |

DEUBLIN

Rotary Union 6000 Series Water Service, DN 50 – 100

- Monoflow and duoflow design
- Self-supported Rotary Union
- Radial housing connection
- Steel banded floating seal
- Easy and quick replacement of sealing components (rotor seal, floating seal)
- Full-media flow
- Vent slots
- Cast iron housing
- Steel rotor
- Balanced mechanical seal – standard: Carbon Graphite/Tungsten Carbide
- Lubrication Guide page 45

For further information, please contact Deublin or your local representative.



Operating Data

| | | | | |
|---------------------|-------|---------|-----------------------|---------|
| Max. Water Pressure | | 150 PSI | 10 bar | |
| Max. Speed | | 750 rpm | 750 min ⁻¹ | |
| Torque for | Model | 6200 | 4 FT.LBS | 5,4 Nm |
| | | 6250 | 7 FT.LBS | 9,5 Nm |
| | | 6300 | 8 FT.LBS | 10,9 Nm |
| | | 6400 | 10 FT.LBS | 13,6 Nm |
| Max. Temperature | | 250 °F | 121 °C | |

For higher temperature, please consult Deublin.

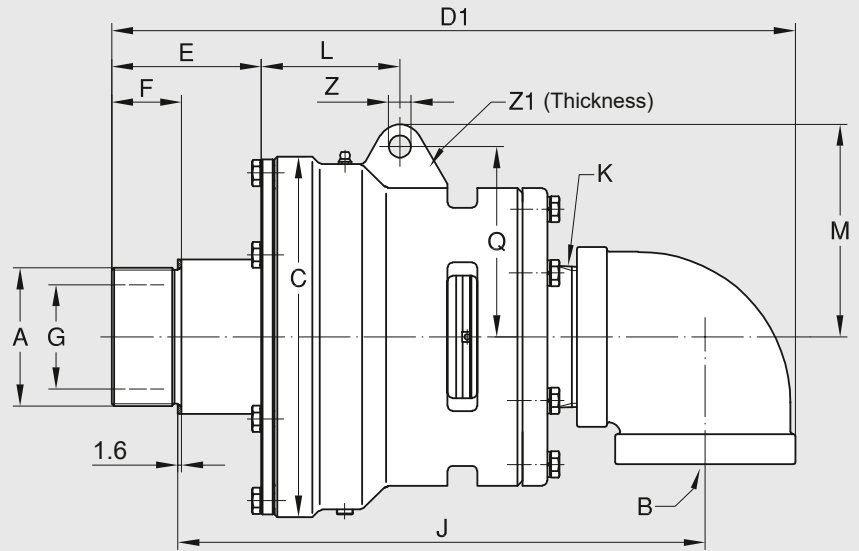
Deublin Exclusive On-The-Machine Repair Cartridge

Seals are replaced quickly and easily. There's no need to remove hose connections or use special tools.

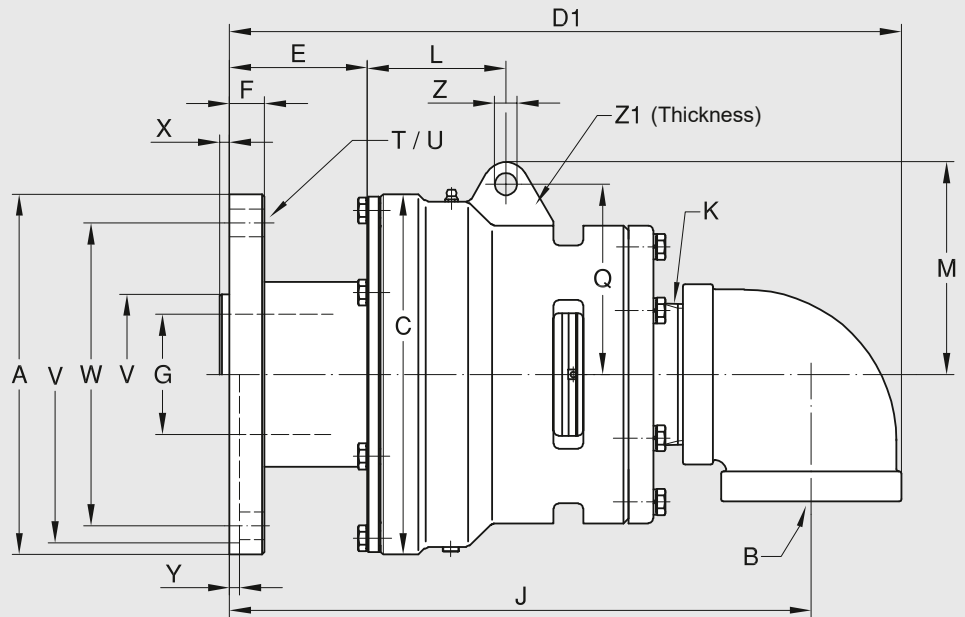
Make sure the system is cold and pressureless! Simply remove 6 hex bolts and end cap then remove floating seal cartridge and rotor seal face and replace with new seals. Rotor seal is keyed and sealed to the rotor with a built-in O-Ring. Replace end cap, hex bolts and safety wire. Detailed instructions available from Deublin.

Monoflow Rotary Union

Threaded Rotor



Flanged Rotor

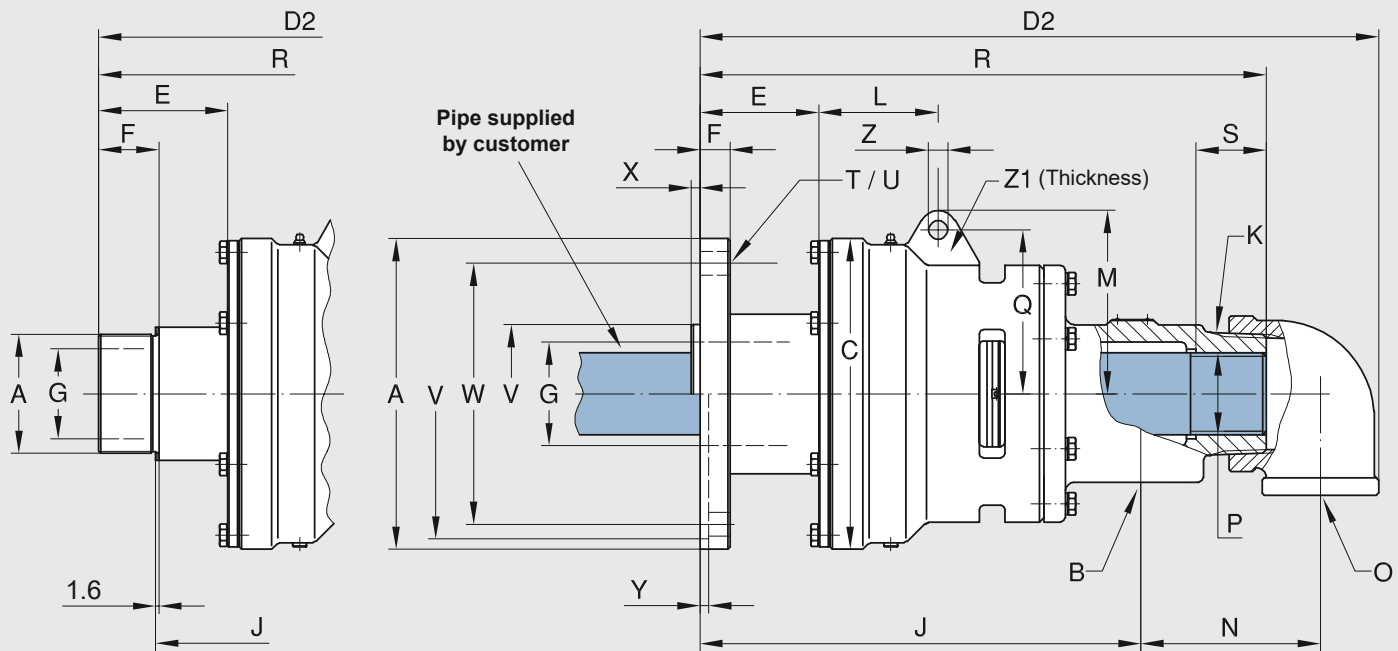


Flange O-Ring

(supplied by Deublin) for:
 Model O-Ring Size
 6200 94.6 x 5.33 Viton
 6250 94.6 x 5.33 Viton
 6300 126.4 x 5.33 Viton
 6400 151.8 x 5.33 Viton

| DN | B NPT | Ordering-No STD | A Rotor Connections | | C Ø | D1 | E | F | G Ø | J | K NPT | L | M | Q | T | U Ø | V ØPT | W Ø | X | Y | Z Ø | Z1 | kg | |
|-----|----------|--------------------|------------------------|----|--------|-----|-----|----|--------|-------|----------|-------|-----|-----|-----|---------|----------|------------------|-------|-----|--------|------|------|------|
| 50 | 2 | 6200-001-123 | 2 NPT | RH | 133 | 298 | 74 | 41 | 47.6 | 245 | 2 | 73 | 89 | 78 | - | - | - | - | - | - | 12.7 | 25.4 | 9.5 | |
| | 2 | 6200-001-135 | 2 NPT | LH | 133 | 298 | 74 | 41 | 47.6 | 245 | 2 | 73 | 89 | 78 | - | - | - | - | - | - | 12.7 | 25.4 | 9.5 | |
| | 2 | 6200-001-137 | G 2 | RH | 133 | 292 | 66 | 29 | 47.6 | 228 | 2 | 73 | 90 | 78 | - | - | - | - | - | - | 12.7 | 25.4 | 9.5 | |
| | 2 | 6200-001-139 | G 2 | LH | 133 | 292 | 66 | 29 | 47.6 | 228 | 2 | 73 | 90 | 78 | - | - | - | - | - | - | 12.7 | 25.4 | 9.5 | |
| | 2 | 6200-001-115 | Flange Ø228.6 | | | 133 | 308 | 82 | 25.4 | 47.6 | 270 | 2 | 73 | 90 | 78 | 4 x 90° | 17.5 | 211.25 211.20 | 162 | - | 6.4 | 12.7 | 25.4 | 16.5 |
| 65 | 2 1/2 | 6250-001-115 | 2 1/2 NPT | RH | 178 | 367 | 84 | 48 | 60.3 | 296 | 2 1/2 | 95 | 113 | 98 | - | - | - | - | - | - | 14.3 | 25.4 | 23 | |
| | 2 1/2 | 6250-001-119 | 2 1/2 NPT | LH | 178 | 367 | 84 | 48 | 60.3 | 296 | 2 1/2 | 95 | 113 | 98 | - | - | - | - | - | - | 14.3 | 25.4 | 23 | |
| | 2 1/2 | 6250-001-121 | G 2 1/2 | RH | 178 | 367 | 84 | 38 | 60.3 | 283 | 2 1/2 | 95 | 113 | 98 | - | - | - | - | - | - | 14.3 | 25.4 | 23 | |
| | 2 1/2 | 6250-001-123 | G 2 1/2 | LH | 178 | 367 | 84 | 38 | 60.3 | 283 | 2 1/2 | 95 | 113 | 98 | - | - | - | - | - | - | 14.3 | 25.4 | 23 | |
| | 2 1/2 | 6250-001-300 | Flange Ø228.6 | | | 178 | 373 | 90 | 25.4 | 60.3 | 325 | 2 1/2 | 95 | 113 | 98 | 4 x 90° | 17.5 | 211.25 211.20 | 162 | - | 6.4 | 14.3 | 25.4 | 27.7 |
| 80 | 3 | 6300-001-157 | 3 NPT | RH | 229 | 432 | 99 | 48 | 73 | 354 | 3 | 88 | 135 | 121 | - | - | - | - | - | - | 14.3 | 25.4 | 45.5 | |
| | 3 | 6300-001-158 | 3 NPT | LH | 229 | 432 | 99 | 48 | 73 | 354 | 3 | 88 | 135 | 121 | - | - | - | - | - | - | 14.3 | 25.4 | 45.5 | |
| | 3 | 6300-001-103 | Flange Ø228.6 | | | 229 | 424 | 88 | 22.2 | 76.2 | 370 | 3 | 88 | 135 | 121 | 6 x 60° | 17.5 | 101.70 101.65 | 192 | 6.4 | - | 14.3 | 25.4 | 52 |
| 100 | 4 | 6400-030-330 | Flange Ø276 | | | 280 | 483 | 78 | 22.2 | 101.6 | 411 | 4 | 94 | 156 | 133 | 6 x 60° | 20.6 | 120.62 120.55 | 228.6 | 7.5 | - | 16 | 32 | 77 |

Duoflow Rotary Union for Threaded Supply Pipe

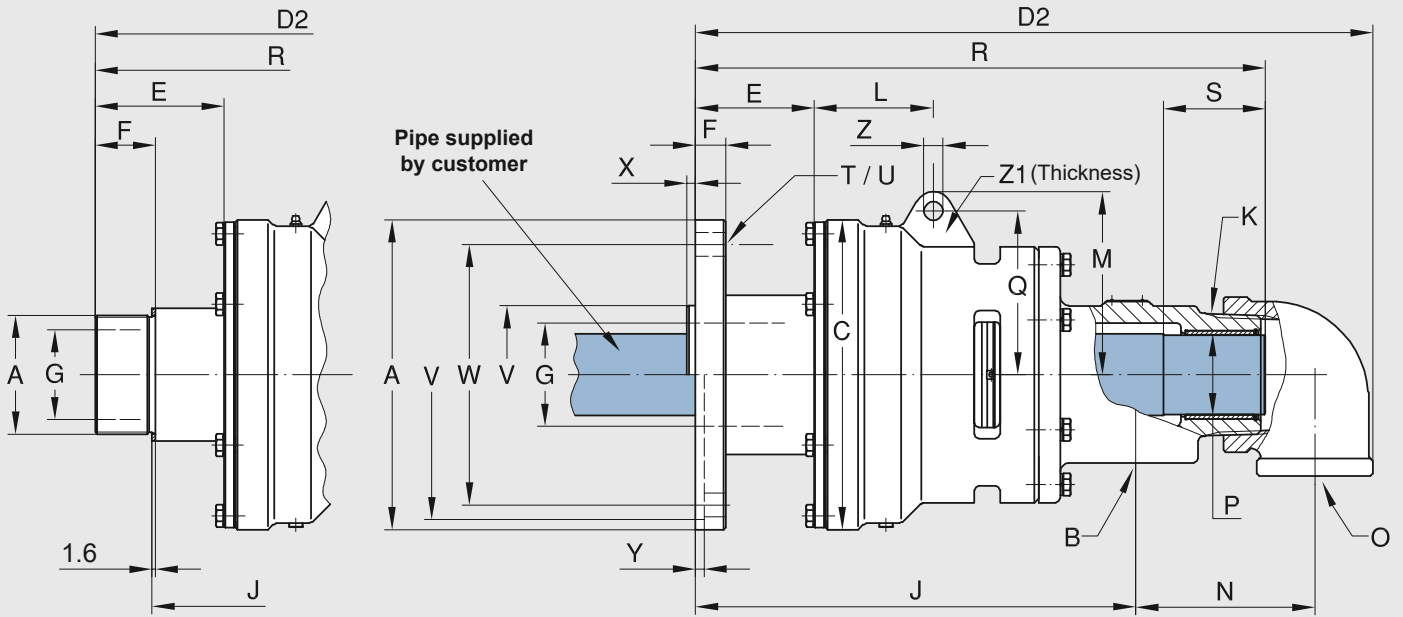


Duoflow Rotary Union

| DN | B + O NPT | Ordering-No | A Rotor Connections | | C Ø | D ₂ | E | F | G Ø | J | K NPT | L | M | N | P Pipe |
|-----|--------------|--------------|------------------------|----|--------|----------------|----|------|--------|-----|----------|----|-----|-----|-----------|
| 50 | (2) x 1 | 6200-011-135 | 2 NPT | LH | 133 | 331 | 74 | 38 | 47.6 | 216 | 2 | 73 | 90 | 86 | 1 ½ NPT |
| 65 | (2) x 1 ½ | 6250-025-121 | G 2 ½ | RH | 178 | 410 | 84 | 38 | 60.3 | 234 | 2 ½ | 95 | 111 | 110 | G 1 ½ |
| | (2) x 1 ½ | 6250-025-123 | G 2 ½ | LH | 178 | 410 | 84 | 38 | 60.3 | 234 | 2 ½ | 95 | 111 | 110 | G 1 ½ |
| | (2) x 1 ½ | 6250-025-300 | Flange Ø228.6 | | 178 | 416 | 90 | 25 | 60.3 | 275 | 2 ½ | 95 | 111 | 110 | G 1 ½ |
| 80 | (2) x 2 | 6300-006-103 | Flange Ø228.6 | | 229 | 499 | 87 | 22.2 | 76 | 324 | 3 | 88 | 135 | 132 | 2 NPT |
| | (2) x 2 | 6300-025-103 | Flange Ø228.6 | | 229 | 502 | 87 | 22 | 76 | 324 | 3 | 88 | 135 | 132 | G 2 |
| 100 | (2) x 2 ½ | 6400-024-330 | Flange Ø276 | | 280 | 548 | 78 | 22.2 | 101.6 | 350 | 4 | 95 | 156 | 144 | 2 ½ NPT |
| | (2) x 2 ½ | 6400-053-330 | Flange Ø276 | | 280 | 548 | 78 | 22.2 | 101.6 | 350 | 4 | 95 | 156 | 144 | G 2 ½ |

| DN | B + O NPT | Ordering-No | Q | R | S | T | U Ø | V ØPT | W Ø | X | Y | Z Ø | Z ₁ | kg |
|-----|--------------|--------------|-----|-----|----|---------|--------|--------------------|--------|-----|-----|--------|----------------|------|
| 50 | (2) x 1 | 6200-011-135 | 78 | 276 | - | - | - | - | - | - | - | 12.7 | 25.4 | 13.2 |
| 65 | (2) x 1 ½ | 6250-025-121 | 98 | 347 | 25 | - | - | - | - | - | - | 14.3 | 25.4 | 25.2 |
| | (2) x 1 ½ | 6250-025-123 | 98 | 347 | 25 | - | - | - | - | - | - | 14.3 | 25.4 | 25.2 |
| | (2) x 1 ½ | 6250-025-300 | 98 | 353 | 25 | 4 x 90° | 17.5 | 211.25 211.20 | 162 | - | 6.4 | 14.3 | 25.4 | 29 |
| 80 | (2) x 2 | 6300-006-103 | 121 | 416 | 28 | 6 x 60° | 17.5 | 101.70 101.65 | 192 | 6.4 | - | 14.3 | 25.4 | 55 |
| | (2) x 2 | 6300-025-103 | 121 | 416 | 28 | 6 x 60° | 17.5 | 101.70 101.65 | 192 | 6.4 | - | 14.3 | 25.4 | 55 |
| 100 | (2) x 2 ½ | 6400-024-330 | 133 | 445 | - | 6 x 60° | 20.6 | 120.625 120.600 | 228.6 | 7.5 | - | 16 | 32 | 77 |
| | (2) x 2 ½ | 6400-053-330 | 133 | 445 | 40 | 6 x 60° | 20.6 | 120.625 120.600 | 228.6 | 7.5 | - | 16 | 32 | 77 |

Duoflow Rotary Union for Rotating Supply Pipe



| DN | B + O NPT | Ordering-No | A Rotor Connections | | C Ø | D ₂ | E | F | G Ø | J | K NPT | L | M | N | P Pipe |
|-----|--------------|--------------|------------------------|----|--------|----------------|----|------|--------|-----|----------|----|-----|-----|---------------|
| 50 | (2) x 1 | 6200-002-123 | 2 NPT | RH | 133 | 344 | 75 | 38 | 47.6 | 205 | 2 | 73 | 90 | 86 | 31.62 - 31.49 |
| | (2) x 1 | 6200-002-137 | G 2 | RH | 133 | 321 | 66 | 29 | 47.6 | 181 | 2 | 73 | 90 | 86 | 31.62 - 31.49 |
| | (2) x 1 | 6200-002-139 | G 2 | LH | 133 | 321 | 66 | 29 | 47.6 | 181 | 2 | 73 | 90 | 86 | 31.62 - 31.49 |
| | (2) x 1 | 6200-002-115 | Flange Ø228.6 | | 133 | 337 | 82 | 25.4 | 47.6 | 223 | 2 | 73 | 90 | 86 | 31.62 - 31.49 |
| 65 | (2) x 1 1/2 | 6250-002-115 | 2 1/2 NPT | RH | 178 | 412 | 84 | 38 | 60.3 | 247 | 2 1/2 | 95 | 113 | 110 | 47.42 - 47.37 |
| | (2) x 1 1/2 | 6250-002-119 | 2 1/2 NPT | LH | 178 | 412 | 84 | 38 | 60.3 | 247 | 2 1/2 | 95 | 113 | 110 | 47.42 - 47.37 |
| | (2) x 1 1/2 | 6250-002-121 | G 2 1/2 | RH | 178 | 412 | 84 | 38 | 60.3 | 233 | 2 1/2 | 95 | 113 | 110 | 47.42 - 47.37 |
| | (2) x 1 1/2 | 6250-002-123 | G 2 1/2 | LH | 178 | 412 | 84 | 38 | 60.3 | 233 | 2 1/2 | 95 | 113 | 110 | 47.42 - 47.37 |
| | (2) x 1 1/2 | 6250-002-300 | Flange Ø228.6 | | 178 | 420 | 90 | 25.4 | 60.3 | 275 | 2 1/2 | 95 | 113 | 110 | 47.42 - 47.37 |
| 80 | (2) x 2 | 6300-002-157 | 3 NPT | RH | 229 | 509 | 98 | 48 | 73 | 310 | 3 | 88 | 135 | 132 | 58.62 - 68.47 |
| | (2) x 2 | 6300-002-103 | Flange Ø228.6 | | 229 | 499 | 87 | 22.2 | 76 | 324 | 3 | 88 | 135 | 132 | 58.62 - 68.47 |
| 100 | (2) x 2 1/2 | 6400-031-330 | Flange Ø276 | | 280 | 550 | 78 | 22.2 | 101.6 | 350 | 4 | 95 | 156 | 144 | 69.72 - 69.65 |
| | (2) x 2 1/2 | 6400-040-330 | Flange Ø276 | | 280 | 549 | 78 | 22.2 | 101.6 | 350 | 4 | 95 | 156 | 144 | 74.80 - 74.34 |

| DN | B + O NPT | Ordering-No | Q | R | S | T | U Ø | V ØPT | W Ø | X | Y | Z Ø | Z ₁ | kg |
|-----|--------------|--------------|-----|-----|-----|---------|--------|-------------------|--------|-----|-----|--------|----------------|------|
| 50 | (2) x 1 | 6200-002-123 | 78 | 271 | 48 | - | - | - | - | - | - | 12.7 | 25.4 | 13.2 |
| | (2) x 1 | 6200-002-137 | 78 | 267 | 48 | - | - | - | - | - | - | 12.7 | 25.4 | 13.2 |
| | (2) x 1 | 6200-002-139 | 78 | 267 | 48 | - | - | - | - | - | - | 12.7 | 25.4 | 13.2 |
| | (2) x 1 | 6200-002-115 | 78 | 284 | 48 | 4 x 90° | 17.5 | 211.25 - 211.20 | 162 | - | 6.4 | 12.7 | 25.4 | 18.2 |
| 65 | (2) x 1 1/2 | 6250-002-115 | 98 | 340 | 54 | - | - | - | - | - | - | 14.3 | 25.4 | 25.2 |
| | (2) x 1 1/2 | 6250-002-119 | 98 | 340 | 54 | - | - | - | - | - | - | 14.3 | 25.4 | 25.2 |
| | (2) x 1 1/2 | 6250-002-121 | 98 | 346 | 54 | - | - | - | - | - | - | 14.3 | 25.4 | 25.2 |
| | (2) x 1 1/2 | 6250-002-123 | 98 | 346 | 54 | - | - | - | - | - | - | 14.3 | 25.4 | 25.2 |
| | (2) x 1 1/2 | 6250-002-300 | 98 | 352 | 54 | 4 x 90° | 17.5 | 211.25 - 211.20 | 162 | - | 6.4 | 14.3 | 25.4 | 31.8 |
| 80 | (2) x 2 | 6300-002-157 | 121 | 411 | 75 | - | - | - | - | - | - | 14.3 | 25.4 | 55 |
| | (2) x 2 | 6300-002-103 | 121 | 420 | 75 | 6 x 60° | 17.5 | 101.700 - 101.695 | 192 | 6.4 | - | 14.3 | 25.4 | 55 |
| 100 | (2) x 2 1/2 | 6400-031-330 | 133 | 451 | 76 | 6 x 60° | 20.6 | 120.625 - 120.600 | 228.6 | 7.5 | - | 16 | 32 | 77 |
| | (2) x 2 1/2 | 6400-040-330 | 133 | 446 | 100 | 6 x 60° | 20.6 | 120.625 - 120.600 | 228.6 | 7.5 | - | 16 | 32 | 77 |

DEUBLIN

Rotary Union F Series Water Service, DN 125

- Monoflow and duoflow design
- Self-supported Rotary Union
- Balanced mechanical seal:
Carbon Graphite/Tungsten Carbide
- Two widely spaced ball bearings
- Labyrinth seal protects bearings
- Cast iron housing
- High corrosion resistant
- Steel flange rotor
- On-the-machine seal replacement capability
- Inlet/outlet flange:
Standard DIN,
Optional ANSI, JIS



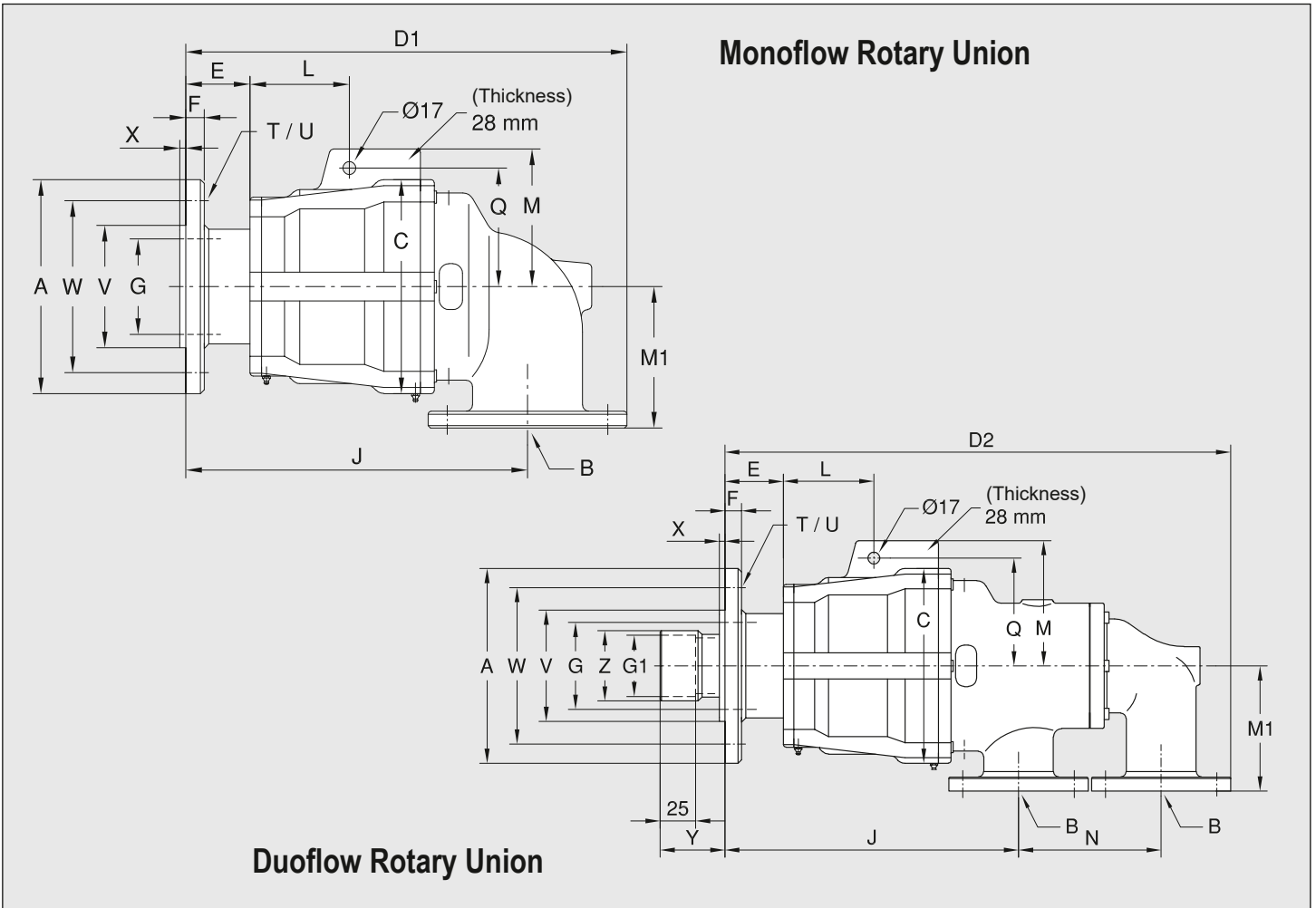
Operating Data

| | | |
|---------------------|---------|-----------------------|
| Max. Water Pressure | 150 PSI | 10 bar |
| Max. Speed | 750 rpm | 750 min ⁻¹ |
| Max. Temperature | 250 °F | 121 °C |

For higher temperature, please consult Deublin.

Operation at max. pressure combined with max. speed is not permissible.
If operating conditions are marginal, please consult our Engineering Department.

For further information, please contact Deublin or your local representative.



Monoflow Rotary Union

| DN | B Flange | Ordering-No | A Ø | C Ø | D1 | E | F | G Ø | J | L | M | M1 | Q | T | U Ø | V ØPT f8 | W Ø | X | kg |
|-----|----------|--------------|-----|-----|-----|----|----|-----|-----|-----|-----|-----|-----|---------|-----|----------|-----|---|-----|
| 125 | DIN 125 | F127-055-200 | 280 | 280 | 577 | 84 | 25 | 125 | 447 | 130 | 180 | 185 | 155 | 6 x 60° | 18 | 160 | 225 | 8 | 100 |
| | 5" ANSI | F127-011-200 | 280 | 280 | 577 | 84 | 25 | 125 | 447 | 130 | 180 | 185 | 155 | 6 x 60° | 18 | 160 | 225 | 8 | 100 |

Duoflow Rotary Union

| DN | B Flange | Ordering-No | A Ø | C Ø | D2 | E | F | G Ø | G1 Ø | J | L | M | M1 | N | Q | T | U Ø | V ØPT f8 | W Ø | X | Y | Z | kg |
|-----|----------|-----------------|-----|-----|-----|----|----|-----|----------|-----|-----|-----|-----|-----|-----|---------|-----|----------|-----|---|----|-----|-----|
| 125 | 3" ANSI | F127-023-204701 | 280 | 280 | 820 | 84 | 25 | 125 | 88.3+0.1 | 422 | 130 | 180 | 180 | 205 | 155 | 6 x 60° | 18 | 160 | 225 | 8 | 93 | 101 | 120 |



DEUBLIN

Rotary Union

Air or Hydraulic Oil Service, DN 6 – 40

- Monoflow design
- Self-supported Rotary Union
- Radial housing connection
- Balanced mechanical seal:
Carbon Graphite/hardened Tool Steel or
Carbon Graphite/Ceramic
- Felt oiler in seal cavity for air service
- Oiler for relubrication (3 – 5 drops/month)
- Low torque
- Weight optimised design
- Aluminium housing
- Stainless steel or steel rotor (respective of model)
- Lubrication guide see Instruction Manual

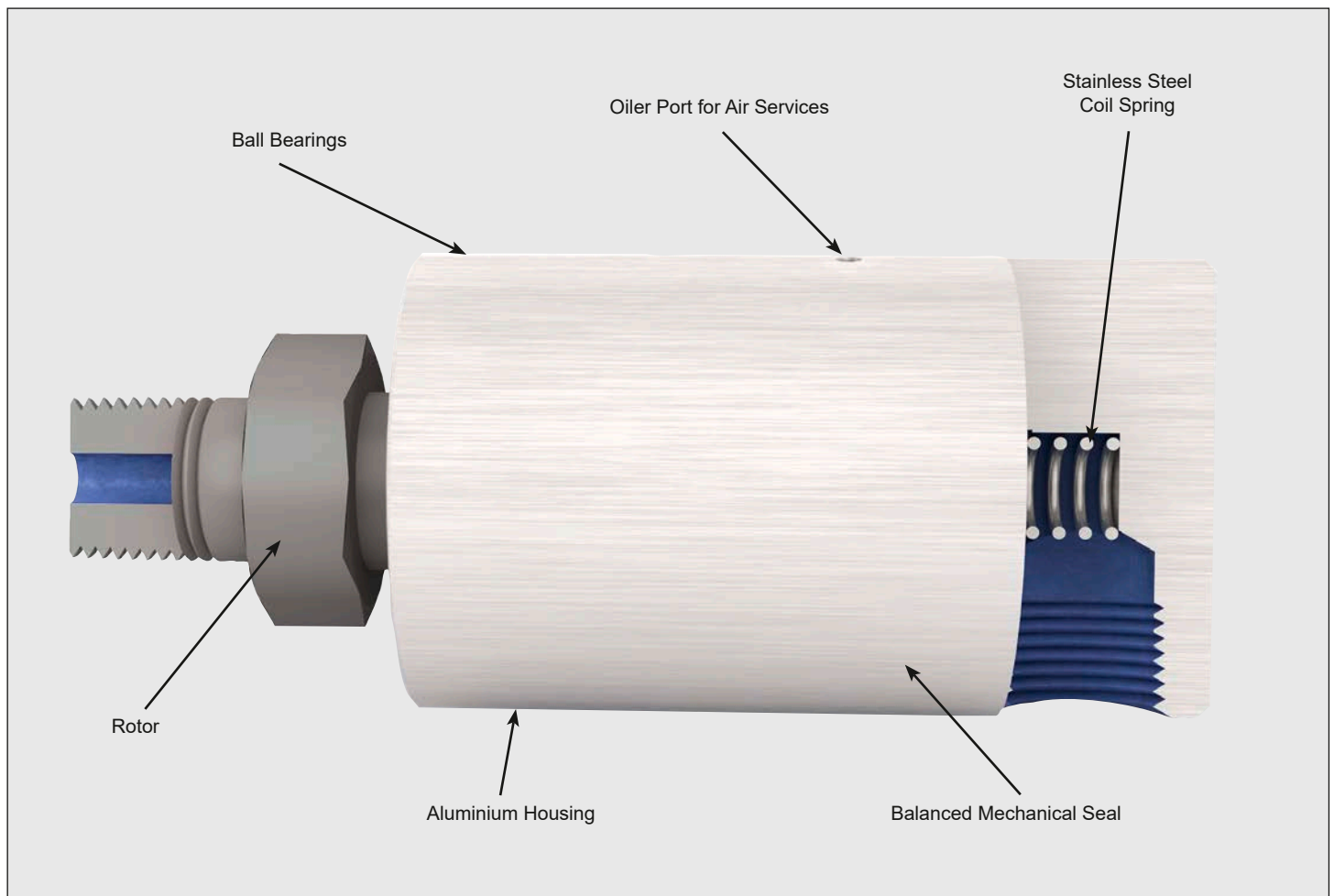
Operating Data

| | | | |
|-----------------------------|-------|-----------|-------------------------|
| Max. Air Pressure | | 150 PSI | 10 bar |
| Max. Vacuum | | 28" Hg | 6,75 kPa |
| Max. Hydraulic Pressure | Model | 1005 | 1,000 PSI |
| | | 1102 | 1,000 PSI |
| | | 1115 | 500 PSI |
| | | 1205 | 750 PSI |
| | | 250-094 | 1,000 PSI |
| Max. Speed Straight Threads | Model | 1005-1205 | 3,500 rpm |
| | | 250-094 | 3,500 rpm |
| | | 355-021 | 3,000 rpm |
| | | 452-000 | 2,500 rpm |
| Max. Speed NPT Threads | | 1,500 rpm | 1,500 min ⁻¹ |
| | | 1,500 rpm | 1,500 min ⁻¹ |
| Max. Temperature | | 250 °F | 121 °C |

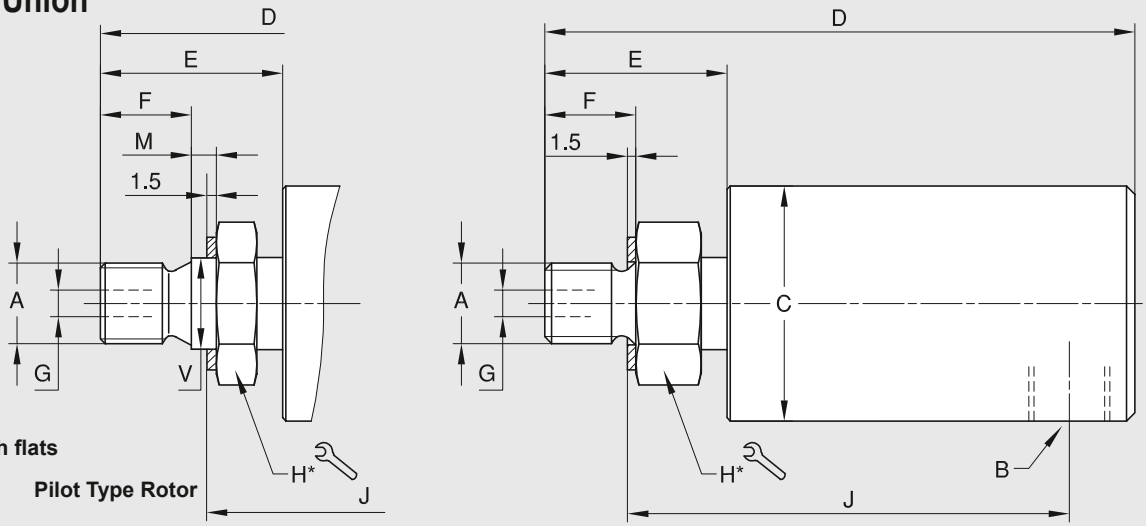
For higher temperature, please consult Deublin.

Operation at max. pressure combined with max. speed is not permissible.

For further information, please contact Deublin or your local representative.



Monoflow Rotary Union



| DN | B NPT | Ordering-No | A Rotor Connections | | C Ø | D | E | F | G Ø | H ⌀ | J | M | V Ø | kg |
|-----|--------------|--------------|------------------------|------------|--------|-------|------|------|--------|--------|-------|------|-----------------|-----|
| 6 | 1/8 | 1005-020-019 | 3/8-24 UNF | RH | 28.37 | 71 | 22 | 11.1 | 3.2 | 17 | 52 | - | - | 0.2 |
| | 1/8 | 1005-020-037 | M 10 x 1 | RH | 28.37 | 71 | 22 | 11.1 | 3.2 | 17 | 54 | - | - | 0.2 |
| | 1/8 | 1005-020-038 | 1/8 NPT | RH | 28.37 | 71 | 22 | 12.7 | 3.2 | 17 | 59 | - | - | 0.2 |
| | 1/8 | 1005-020-039 | 3/8-24 UNF | LH | 28.37 | 71 | 22 | 11.1 | 3.2 | 17 | 52 | - | - | 0.2 |
| | 1/8 | 1005-020-045 | M 10 x 1 | RH | 28.37 | 71 | 22 | 11 | 3.2 | 17 | 49 | 3 | 11.000 - 10.989 | 0.2 |
| | 1/8 | 1005-020-049 | G 1/4 | RH | 28.37 | 71 | 22 | 13 | 3.2 | 17 | 52 | - | - | 0.2 |
| | 1/8 | 1005-113-063 | 1/8 NPT | RH | 28.37 | 71 | 22 | 13 | 3.2 | 16 | 57 | - | - | 0.2 |
| | 1/8 | 1005-113-110 | 5/16-24 UNF | | | 28.37 | 70 | 21 | 11 | 3 | 16 | 52 | - | - |
| 8 | 1/4 | 1102-070-029 | 5/8-18 UNF | RH | 41 | 80.8 | 28.4 | 16 | 6.4 | 22 | 55.4 | - | - | 0.4 |
| | 1/4 | 1102-070-079 | 5/8-18 UNF | LH | 41 | 80.8 | 28.4 | 16 | 6.4 | 22 | 55.4 | - | - | 0.4 |
| | 1/4 | 1102-070-081 | 1/4 NPT | RH | 41 | 80.9 | 28.6 | 16 | 6.4 | 22 | 62.5 | - | - | 0.4 |
| | 1/4 | 1102-070-082 | 1/4 NPT | LH | 41 | 80.9 | 28.6 | 16 | 6.4 | 22 | 62.5 | - | - | 0.4 |
| | 1/4 | 1102-070-103 | G 1/4 | RH | 41 | 81 | 28 | 13 | 6.4 | 22 | 58 | - | - | 0.4 |
| | 1/4 | 1102-070-104 | G 1/4 | LH | 41 | 81 | 28 | 13 | 6.4 | 22 | 58 | - | - | 0.4 |
| | 10 | 3/8 | 1115-000-001 | 5/8-18 UNF | RH | 44 | 100 | 27 | 16 | 8.7 | 24 | 72 | - | - |
| 3/8 | 1115-000-002 | 3/8 NPT | RH | 44 | 99 | 26 | 16 | 8.7 | 24 | 78 | - | - | 0.7 | |
| 3/8 | 1115-000-017 | 5/8-18 UNF | LH | 44 | 100 | 27 | 16 | 8.7 | 24 | 72 | - | - | 0.7 | |
| 3/8 | 1115-000-200 | M 16 x 2 | RH | 44 | 99 | 26 | 16 | 8.7 | 24 | 71 | - | - | 0.7 | |
| 3/8 | 1115-000-205 | G 3/8 | RH | 44 | 100 | 27 | 16 | 8.7 | 24 | 72 | - | - | 0.7 | |
| 15 | 1/2 | 1205-000-001 | 1-14 UNS | RH | 57 | 112 | 33 | 19 | 16 | 36 | 78 | - | - | 0.7 |
| | 1/2 | 1205-000-003 | 1/2 NPT | RH | 57 | 113 | 34 | 22 | 12.7 | 28 | 83.1 | - | - | 0.7 |
| | 1/2 | 1205-000-025 | 3/4-16 UNF | LH | 57 | 114 | 35 | 19 | 12.7 | 28 | 79 | - | - | 0.7 |
| | 1/2 | 1205-000-039 | 3/4-16 UNF | RH | 57 | 114 | 35 | 19 | 12.7 | 30 | 79 | - | - | 0.7 |
| | 1/2 | 1205-000-151 | G 1/2 | RH | 57 | 114 | 34 | 19 | 12.7 | 30 | 79 | - | - | 0.7 |
| | 1/2 | 1205-000-152 | G 1/2 | LH | 57 | 114 | 34 | 19 | 12.7 | 30 | 79 | - | - | 0.7 |
| | 1/2 | 1205-000-170 | M 20 x 1.5 | RH | 57 | 115 | 36 | 14 | 12.7 | 30 | 79 | 5 | 21.993 - 21.980 | 0.7 |
| 20 | 3/4 | 250-094-002 | 1-14 UNS | RH | 73 | 127 | 34 | 17 | 16.7 | 32 | 93 | - | - | 1.6 |
| | 3/4 | 250-094-012 | M 22 x 1.5 | RH | 73 | 124 | 31 | 14 | 14.3 | 36 | 95 | 3 | 26.993 - 26.980 | 1.6 |
| | 3/4 | 250-094-016 | 1-14 UNS | RH | 73 | 148 | 54 | 19.1 | 15.9 | 41 | 101 | 12.7 | 31.700 - 31.687 | 1.6 |
| | 3/4 | 250-094-020 | 3/4 NPT | RH | 73 | 130 | 36.5 | 22 | 17.4 | 32 | 103 | - | - | 1.6 |
| | 3/4 | 250-094-284 | G 3/4 | RH | 73 | 128 | 34 | 19 | 17.5 | 36 | 94 | - | - | 1.6 |
| | 3/4 | 250-094-285 | G 3/4 | LH | 73 | 128 | 34 | 19 | 17.5 | 36 | 94 | - | - | 1.6 |
| 25 | 1 | 355-021-002 | 1 NPT | RH | 82 | 157 | 49 | 28.6 | 25.4 | 38 | 117.3 | - | - | 2.1 |
| | 1 | 355-021-016 | 1 1/2-12 UNF | RH | 82 | 167 | 59 | 19.1 | 25 | 38 | 107.8 | 12.7 | 39.649 - 39.637 | 2.1 |
| | 1 | 355-021-017 | 1 1/2-12 UNF | LH | 82 | 167 | 59 | 19.1 | 25 | 38 | 107.8 | 12.7 | 39.649 - 39.637 | 2.1 |
| | 1 | 355-021-019 | 1 1/2-12 UNF | RH | 82 | 156 | 48 | 27 | 25.4 | 38 | 107.2 | - | - | 2.1 |
| | 1 | 355-021-222 | G 1 | RH | 82 | 151 | 42 | 22 | 25 | 36 | 108 | - | - | 2.1 |
| 40 | 1 1/2 | 452-000-001 | 1 1/2 NPT | RH | 108 | 196 | 62 | 30 | 38 | 54 | 144 | - | - | 4.5 |
| | 1 1/2 | 452-000-198 | G 1 1/2 | RH | 108 | 206 | 71 | 29 | 38 | 55 | 147 | - | - | 4.5 |
| | 1 1/2 | 452-000-395 | 2-12 UNF | RH | 108 | 208 | 74 | 29 | 38 | 55 | 148 | - | - | 4.5 |

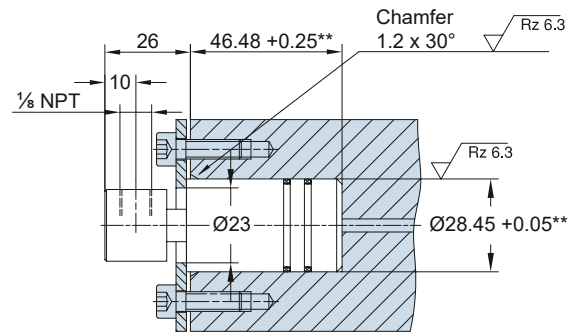
Deublin Rotary Unions – In-the-Shaft Mounted

To meet the specifications of engineering designs requiring minimum overhang, Deublin can provide unions which can be mounted in the shaft. With these models the only extensions beyond the end of the shaft are the supply line connections. Detailed drawings suggesting the application of these Deublin Rotary Unions to your installation will be submitted on request and without obligation.

Model 1005-000-001, DN 6

Operating Data

| | | |
|----------------------------|-----------|-------------------------|
| Maximum Air Pressure | 150 PSI | 10 bar |
| Maximum Hydraulic Pressure | 1,000 PSI | 70 bar |
| Maximum Speed | 3,500 RPM | 3.500 min ⁻¹ |
| Maximum Temperature | 250 °F | 121 °C |

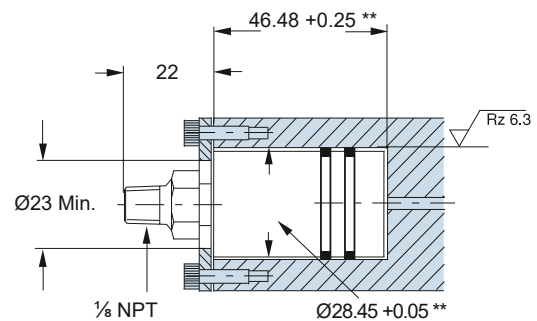


** Dimensions of Shaft Bore

Model 1005-000-038, DN 6

Operating Data

| | | |
|----------------------------|-----------|-------------------------|
| Maximum Air Pressure | 150 PSI | 10 bar |
| Maximum Hydraulic Pressure | 1,000 PSI | 70 bar |
| Maximum Speed | 3,500 RPM | 3.500 min ⁻¹ |
| Maximum Temperature | 250 °F | 121 °C |

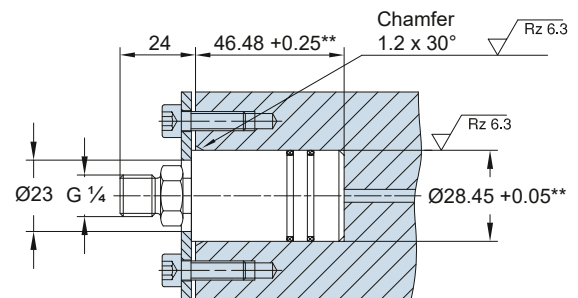


** Dimensions of Shaft Bore

Model 1005-000-049, DN 6

Operating Data

| | | |
|----------------------------|-----------|-------------------------|
| Maximum Air Pressure | 150 PSI | 10 bar |
| Maximum Hydraulic Pressure | 1,000 PSI | 70 bar |
| Maximum Speed | 3,500 RPM | 3.500 min ⁻¹ |
| Maximum Temperature | 250 °F | 121 °C |

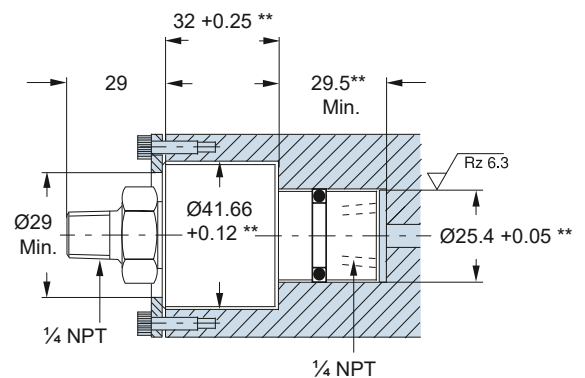


** Dimensions of Shaft Bore

Model 1102-025-081, DN 8

Operating Data

| | | |
|----------------------------|-----------|-------------------------|
| Maximum Air Pressure | 150 PSI | 10 bar |
| Maximum Hydraulic Pressure | 1,000 PSI | 70 bar |
| Maximum Speed | 3,500 RPM | 3.500 min ⁻¹ |
| Maximum Temperature | 250 °F | 121 °C |



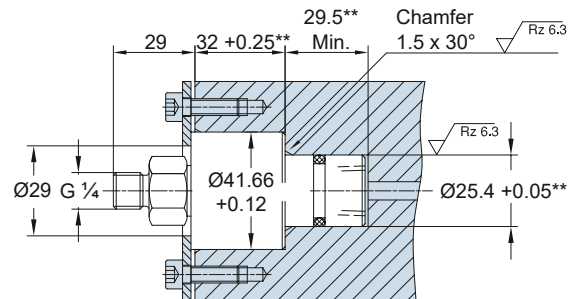
** Dimensions of Shaft Bore

Deublin Rotary Unions – In-the-Shaft Mounted

To meet the specifications of engineering designs requiring minimum overhang, Deublin can provide unions which can be mounted in the shaft. With these models the only extensions beyond the end of the shaft are the supply line connections. Detailed drawings suggesting the application of these Deublin Rotary Unions to your installation will be submitted on request and without obligation.

Model 1102-025-103, DN 8

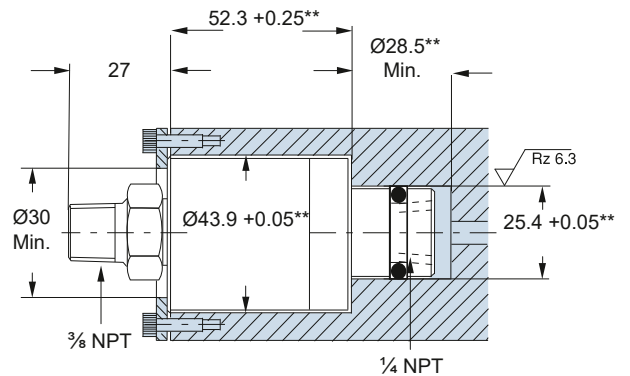
| Operating Data | | |
|----------------------------|-----------|-------------------------|
| Maximum Air Pressure | 150 PSI | 10 bar |
| Maximum Hydraulic Pressure | 1,000 PSI | 70 bar |
| Maximum Speed | 3,500 RPM | 3.500 min ⁻¹ |
| Maximum Temperature | 250 °F | 121 °C |



** Dimensions of Shaft Bore

Model 1115-130-002, DN 10

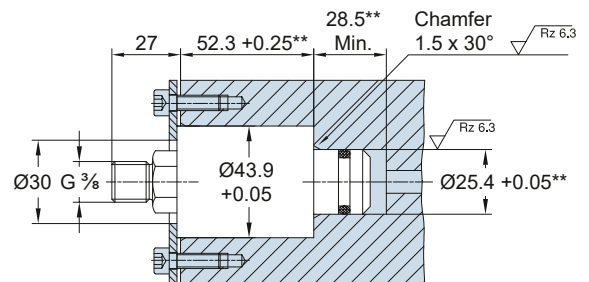
| Operating Data | | |
|----------------------------|-----------|-------------------------|
| Maximum Air Pressure | 150 PSI | 10 bar |
| Maximum Hydraulic Pressure | 500 PSI | 34 bar |
| Maximum Speed | 3,500 RPM | 3.500 min ⁻¹ |
| Maximum Temperature | 250 °F | 121 °C |



** Dimensions of Shaft Bore

Model 1115-130-205, DN 10

| Operating Data | | |
|----------------------------|-----------|-------------------------|
| Maximum Air Pressure | 150 PSI | 10 bar |
| Maximum Hydraulic Pressure | 500 PSI | 34 bar |
| Maximum Speed | 3,500 RPM | 3.500 min ⁻¹ |
| Maximum Temperature | 250 °F | 121 °C |



** Dimensions of Shaft Bore

Model 1116-319-248, DN 10

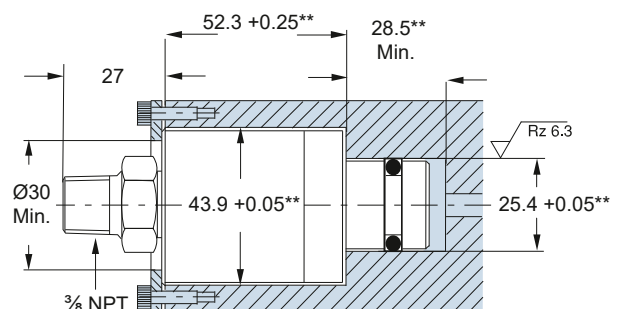
| Operating Data | | |
|----------------------------|-----------|-------------------------|
| Maximum Hydraulic Pressure | 1,000 PSI | 70 bar |
| Maximum Speed | 3,500 RPM | 3.500 min ⁻¹ |
| Maximum Temperature | 250 °F | 121 °C |



DO NOT RUN DRY

This model contains E.L.S. seals of silicon carbide to silicon carbide for long life on abrasive applications.

** Dimensions of Shaft Bore





DEUBLIN

Rotary Union AP Series

Water or Hydraulic Oil Service, DN 8 – 15

- Monoflow design
- Self supported Rotary Union
- Designed for high media pressure and high RPM
- Seals made of Tungsten Carbide
- Double row ball bearing, Lubricated for life
- Vent holes
- Steel housing nickel-plated
- Stainless steel end cap and rotor
- All parts in media contact are stainless steel and corrosion resistant

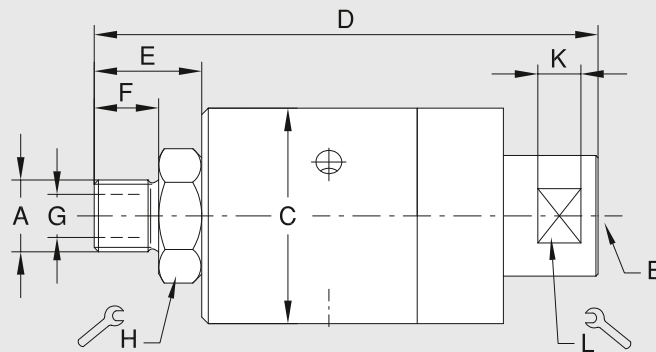
Operating Data

| | | |
|--------------------------------|-----------|-------------------------|
| Max. Hydraulic/Water Pressure* | 5,800 PSI | 400 bar |
| Max. Speed* | 1,500 rpm | 1,500 min ⁻¹ |
| Max. Temperature | 194 °F | 90 °C |

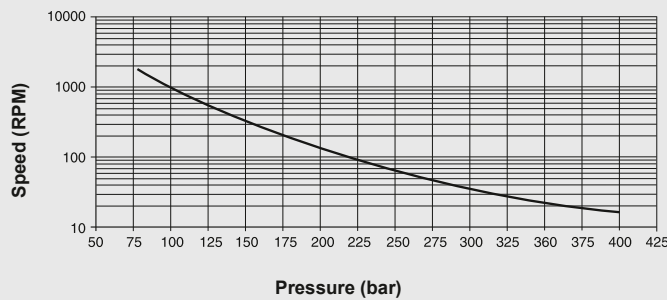
For higher temperature, please consult Deublin.

* Operation at max. pressure combined with max. speed is not permissible.

For further information, please contact Deublin or your local representative.



AP8 – AP12



Monoflow Rotary Union

| DN | B | Ordering-No | A Rotor Connections | C Ø | D | E | F | G Ø | H ⌀ | K | L ⌀ | kg |
|----|---------|--------------|------------------------|--------|-----|----|----|--------|--------|----|--------|-----|
| 8 | G 1/4 | AP8-010-210 | G 1/4 BSP RH | 50 | 117 | 25 | 15 | 7 | 27 | 10 | 25 | 0.8 |
| 10 | G 3/8 | AP10-010-210 | G 3/8 BSP RH | 50 | 117 | 25 | 15 | 10 | 27 | 10 | 25 | 0.8 |
| 15 | G 1/2 | AP12-010-210 | G 1/2 BSP RH | 50 | 122 | 30 | 20 | 12 | 27 | 10 | 25 | 1 |
| | 1/2 NPT | AP12-011-214 | 1/2 NPT RH | 50 | 122 | 30 | 20 | 12 | 27 | 10 | 25 | 1 |

DEUBLIN

Rotary Union 7100 Series High Pressure Hydraulic Service, DN 8 – 20, Duoflow

- Duoflow design
- Self-supported Rotary Union
- Hydrostatic bearing design
- Wear-resistant bearing
- Vent for controlled drainage
- Shaft seal for secondary sealing
- Stainless steel housing
- Hardened steel rotor

For further information, please contact Deublin or your local representative.



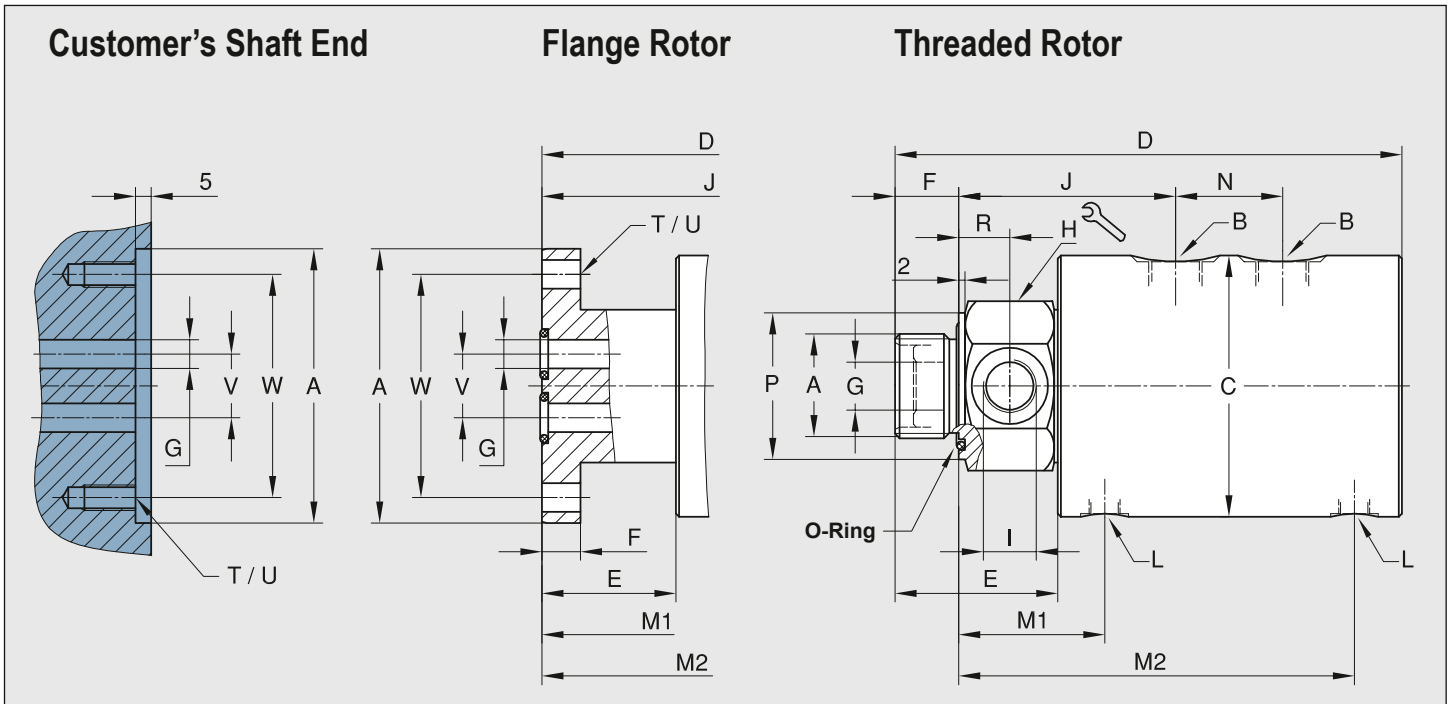
Operating Data

| | | |
|-------------------------|-----------|-----------------------|
| Max. Hydraulic Pressure | 3,630 PSI | 250 bar |
| Min. Hydraulic Pressure | 40 PSI | 3 bar |
| Max. Speed | 500 rpm | 500 min ⁻¹ |
| Max. Temperature | 158 °F | 70 °C |

Higher pressure and speed on request;

For higher temperature, please consult Deublin.

Required Oil Cleanliness: class 17/15/12, ISO 4406:2017



Duoflow Rotary Union

| DN | B | Ordering-No | A Rotor Connections | C Ø | D | E | F | G Ø | H ⌀ | I | J | L | M1/M2 | N | P Ø | R | T | U Ø | V Ø | W Ø | kg |
|--------|-------|-------------|------------------------|--------|-----|----|----|--------|--------|-------|-----|-------|------------|----|--------|----|---------|----------|--------|--------|-----|
| 2 x 8 | G 1/4 | 7100-773 | G 3/4 RH | 82 | 176 | 46 | 17 | 6.4 | 46 | G 1/4 | 76 | G 1/8 | 49.5/137.5 | 36 | 46 | 15 | - | - | - | - | 4.5 |
| | G 1/4 | 7100-852 | Flange Ø86 g6/H7 | 82 | 172 | 42 | 12 | 9 | - | - | 89 | G 1/8 | 62/151 | 36 | - | - | 4 x 90° | 9 M8 | 20 | 70 | 4.5 |
| 2 x 10 | G 3/8 | 7100-777 | G 1 RH | 82 | 181 | 51 | 20 | 8 | 46 | G 3/8 | 78 | G 1/8 | 52/140 | 36 | 46 | 16 | - | - | - | - | 4.4 |
| | G 3/8 | 7100-853 | Flange Ø86 g6/H7 | 82 | 172 | 42 | 12 | 9 | - | - | 89 | G 1/8 | 63/151 | 36 | - | - | 4 x 90° | 9 M8 | 20 | 70 | 4.4 |
| 2 x 15 | G 1/2 | 7100-711 | G 1 1/4 RH | 109 | 244 | 70 | 26 | 15 | 55 | G 1/2 | 101 | G 1/4 | 70.5/180.5 | 50 | 55 | 18 | - | - | - | - | 11 |
| | G 1/2 | 7100-854 | Flange Ø108 g6/H7 | 109 | 230 | 56 | 16 | 12.5 | - | - | 113 | G 1/4 | 82.5/192.5 | 50 | - | - | 4 x 90° | 11 M10 | 20.5 | 88 | 11 |
| 2 x 20 | G 3/4 | 7100-855 | Flange Ø148 g6/H7 | 148 | 288 | 78 | 25 | 19 | - | - | 153 | G 1/2 | 110.5/253 | 60 | - | - | 6 x 60° | 13.5 M12 | 33 | 126 | 28 |



DEUBLIN

Rotary Union

DEU-PLEX Air and Hydraulic Service,

DN 8 – 20

- Duoflow design
- Tandem model as triple passage design
- Self-supported Rotary Union
- Composite bearing
- Vent holes between passages
- Carbon-filled teflon seals
- Hardened sealing surface
- Aluminium housing
- Steel rotor

Operating Data

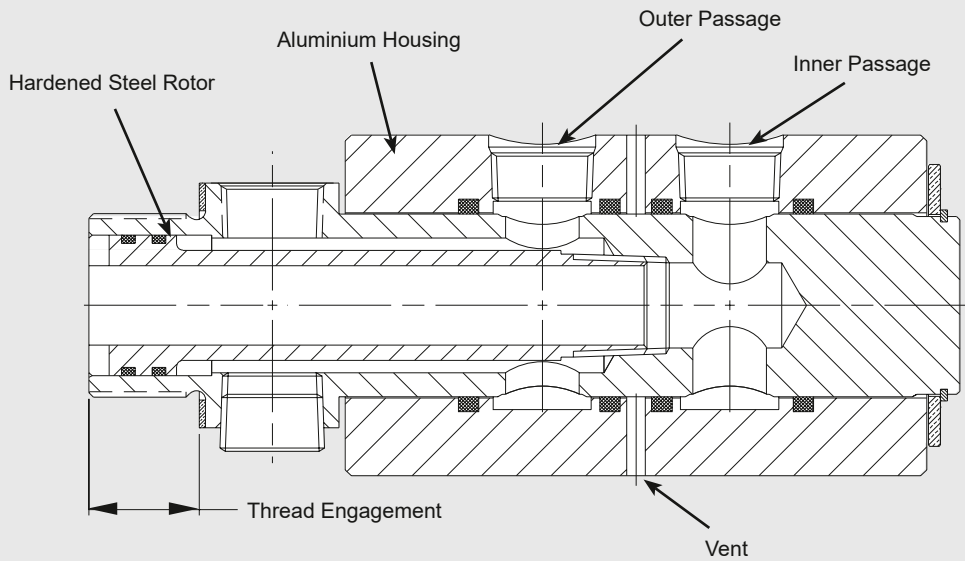
| | | | |
|--------------------------|-------|-----------|-----------------------|
| Max. Air Pressure | | 150 PSI | 10 bar |
| Max. Hydraulic Pressure* | | 3,050 PSI | 210 bar |
| Max. Speed (short-term)* | | 250 rpm | 250 min ⁻¹ |
| Torque for | Model | 1690 | 7 ft.lbs 9.5 Nm |
| | | 1790 | 18 ft.lbs 24 Nm |
| | | 1890 | 22 ft.lbs 29.8 Nm |
| Max. Temperature | | 239 °F | 115 °C |

For higher temperature, please consult Deublin.

* Operation at max. pressure combined with max. speed is not permissible.

For further information, please contact Deublin or your local representative.

Models with inner rotors



Models without inner rotors can be used for coaxial feed applications as shown below.

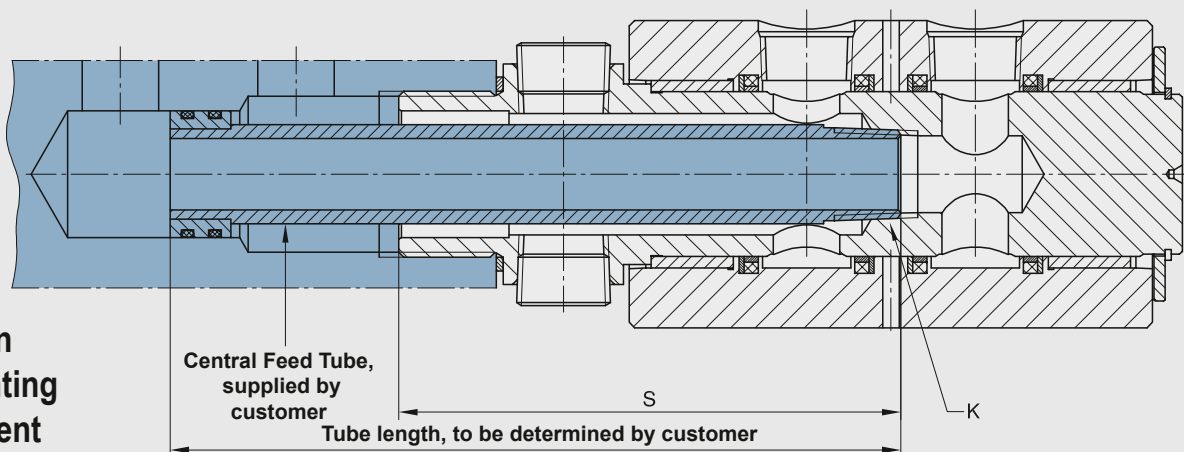
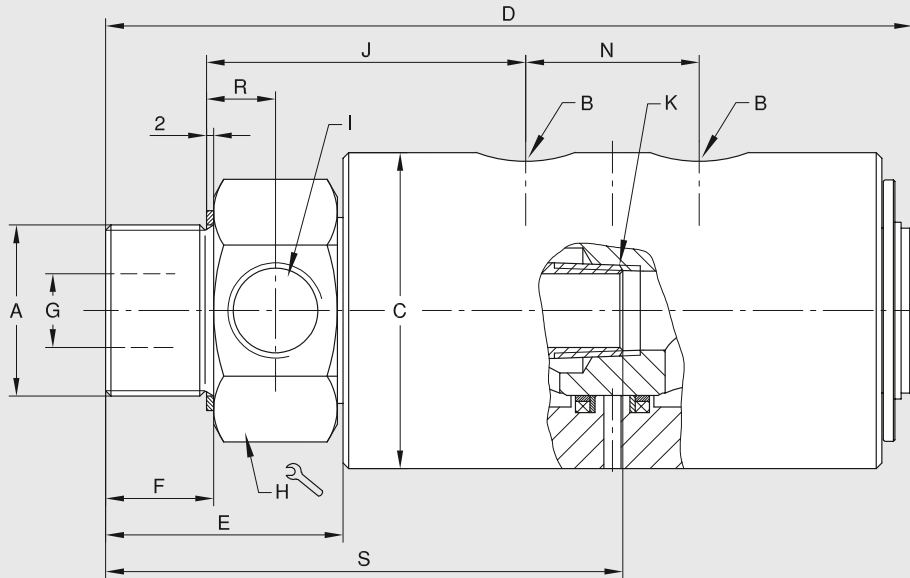


Illustration of a mounting arrangement

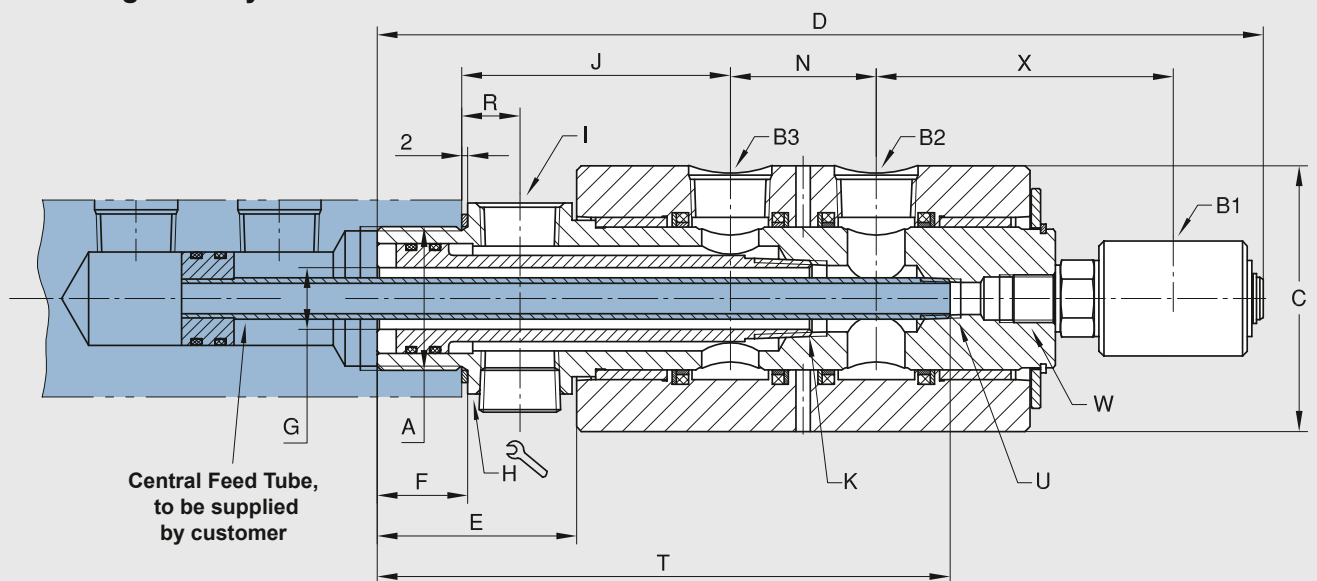
Duoflow Rotary Union



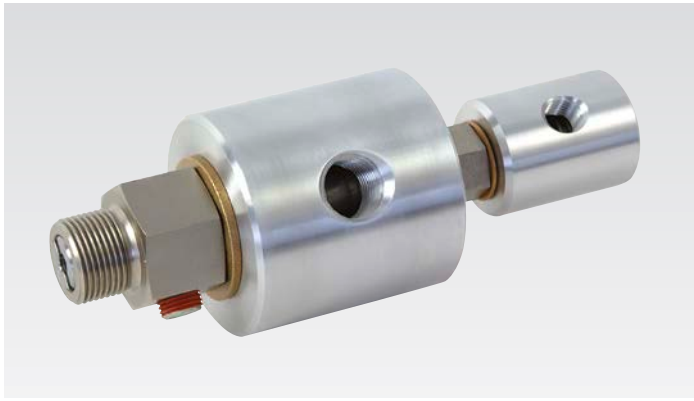
| DN | B NPT | Ordering-No | A Rotor Connections | | C Ø | D | E | F | G Ø | H Ø | I NPT | J | K NPT | N | R | S | kg |
|--------|----------|---------------|------------------------|----|--------|-------|------|------|--------|--------|----------|------|----------|------|------|-------|-----|
| 2 x 8 | 1/4 | 1690-000-102* | 1 NPT | | 66.4 | 150 | 55 | 28.6 | 22 | 46 | 1/4 | 66.6 | 1/4 | 28.6 | 23 | 97.4 | 1.6 |
| | 1/4 | 1690-000-105* | G 1 | RH | 66.4 | 150 | 55.5 | 18 | 8 | 46 | 1/4 | 68 | 1/4 | 29.5 | 19 | 97.4 | 1.6 |
| | 1/4 | 1690-000-115 | 1 NPT | | 66.4 | 150 | 55 | 28.6 | 7.9 | 46 | 1/4 | 66 | - | 29.5 | 23 | - | 1.6 |
| | 1/4 | 1690-000-168 | G 1 | RH | 66.4 | 150 | 55.5 | 18 | 17.5 | 46 | 1/4 | 68 | 1/4 | 29.5 | 19 | - | 1.6 |
| 2 x 15 | 1/2 | 1790-500-101* | 1 1/4 NPT | RH | 76 | 208 | 63 | 28 | 27 | 55 | 1/2 | 85 | 1/2 | 42 | 18 | - | 3.1 |
| | 1/2 | 1790-500-112* | G 1 1/4 | RH | 76 | 208 | 63 | 28 | 27 | 55 | 1/2 | 85 | 1/2 | 42 | 18 | 129.4 | 3.1 |
| | 1/2 | 1790-500-113 | 1 1/4 NPT | RH | 76 | 208 | 63 | 28 | 16 | 55 | 1/2 | 85 | 1/2 | 42 | 18 | 129.4 | 3.1 |
| | 1/2 | 1790-500-114 | G 1 1/4 | RH | 76 | 208 | 63 | 28 | 16 | 55 | 1/2 | 85 | 1/2 | 42 | 18 | - | 3.1 |
| 2 x 20 | 3/4 | 1890-500 | 1 1/2 NPT | RH | 87.6 | 225.4 | 66.6 | 30 | 20.6 | 65 | 3/4 | 104 | 1/2 | 49 | 18 | 144.5 | 4.4 |
| | 3/4 | 1890-560 | G 1 1/2 | RH | 87.6 | 226 | 66 | 30 | 20.6 | 65 | 3/4 | 89 | 3/4 | 49 | 19.5 | - | 4.4 |
| | 3/4 | 1890-570* | G 1 1/2 | RH | 87.6 | 226 | 66 | 30 | 34.9 | 65 | 3/4 | 89 | 3/4 | 49 | 19.5 | 149.4 | 4.2 |
| | 3/4 | 1890-581 | G 1 1/2 | RH | 87.6 | 225.4 | 66.6 | 30 | 20.6 | 65 | 3/4 | 69.9 | 3/4 | 48.9 | 19.2 | 144.5 | 4.2 |

*These models are delivered without inner rotors.

Triple Passage Rotary Union



| DN | B1 x B2 x B3 NPT | Ordering-No | A Rotor Connections | | C Ø | D | E | F | G Ø | H Ø | I NPT | J | K NPT | N | R | T | U NPT | W | X | kg | |
|---------|---------------------|-------------|------------------------|----|--------|-----|----|----|--------|--------|----------|----|----------|------|------|-----|----------|------------|----|----|-----|
| 8/20/20 | 1/4 x 3/4 x 3/4 | 1890-580 | G 1 1/2 | RH | 88.5 | 293 | 67 | 30 | 20.6 | 65 | 3/4 | 89 | 3/4 | 48.5 | 19.5 | 190 | 1/4 | 5/8-18 UNF | RH | 98 | 4.7 |



DEUBLIN

Rotary Union

Air, Hydraulic Oil and Vacuum Service, DN 8 and 15

- Monoflow and duoflow (Tandem) design
- Self-supported Rotary Union
- No interpassage leakage on the duoflow design
- Hardened sealing surface
- Oilite bearing
- Aluminium housing
- Steel rotor

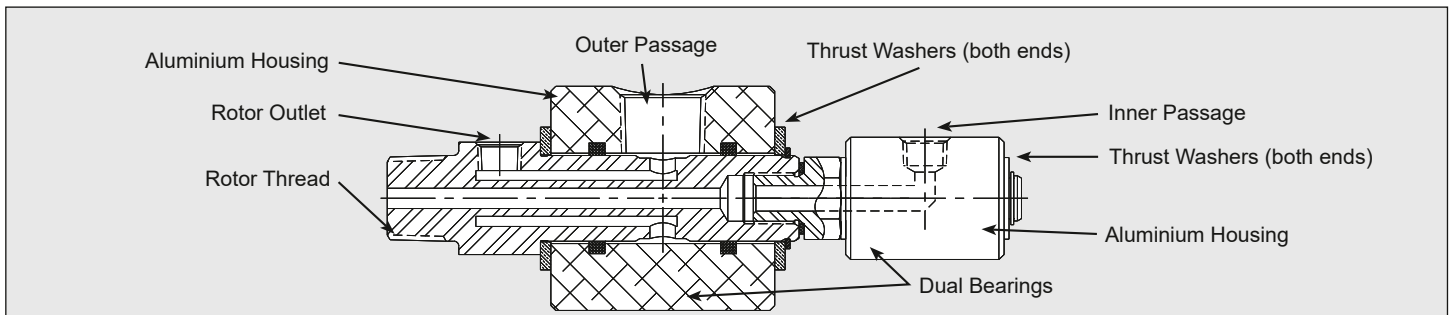
Operating Data

| | | |
|--------------------------|-----------|-----------------------|
| Max. Air Pressure | 150 PSI | 10 bar |
| Max. Vacuum | 28 "Hg | 6,75 kPa |
| Max. Hydraulic Pressure* | 3,000 PSI | 207 bar |
| Max. Speed (short-term)* | 250 rpm | 250 min ⁻¹ |
| Max. Temperature | 250 °F | 121 °C |

For further information, please contact Deublin or your local representative.

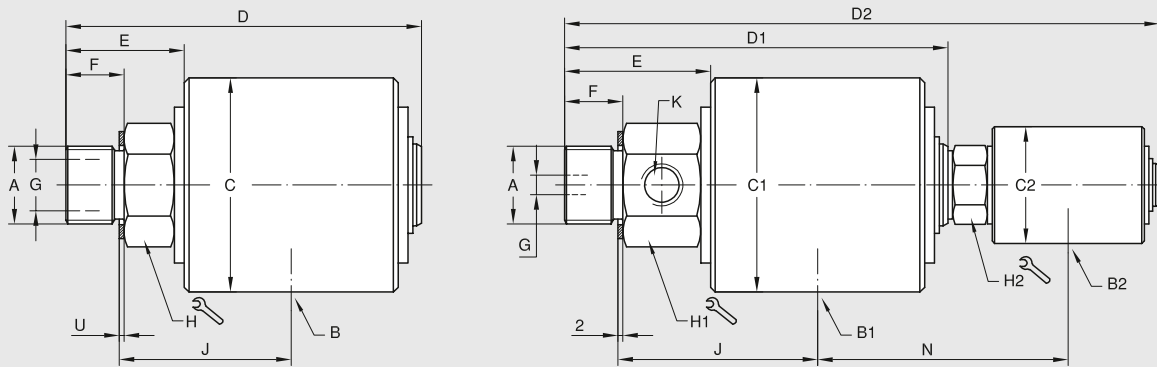
For higher temperature, please consult Deublin.

* Operation at max. pressure combined with max. speed is not permissible.



Monoflow Rotary Union

Tandem



Monoflow Rotary Union

| DN | B NPT | Ordering-No | A Rotor Connections | C Ø | D | E | F | G Ø | H | J | U | kg |
|----|-------|-------------|---------------------|-----|------|------|----|-----|----|------|-----|-----|
| 8 | 1/4 | 17-025-012 | 5/8-18 UNF RH | 38 | 83.3 | 29 | 16 | 8 | 22 | 39 | 1.5 | 0.3 |
| | 1/4 | 17-025-039 | G 3/8 RH | 38 | 83.3 | 29 | 16 | 8 | 22 | 39 | 1.5 | 0.3 |
| | 1/4 | 17-025-041 | 3/8 NPT RH | 38 | 83.3 | 29 | 16 | 8 | 22 | 46 | - | 0.3 |
| | 1/4 | 17-025-045 | 3/8 NPT (FEM) RH | 38 | 75.4 | 21 | - | 8 | 22 | 38 | - | 0.3 |
| | 1/4 | 17-025-046 | M16 x 2 RH | 38 | 83.3 | 29 | 16 | 8 | 22 | 39 | 1.5 | 0.3 |
| 15 | 1/2 | 21-001-101 | 3/4 NPT RH | 70 | 119 | 41.7 | 22 | 16 | 36 | 66.4 | - | 1.2 |
| | 1/2 | 21-001-122 | G 3/4 RH | 70 | 116 | 38.7 | 19 | 16 | 36 | 56.2 | 1.6 | 1.2 |

Duoflow Rotary Union (Tandem)

| DN | B1 x B2 NPT | Ordering-No | A Rotor Connections | C1 Ø | C2 Ø | D1 | D2 | E | F | G Ø | H1 | H2 | J | K NPT | N | kg |
|--------|-------------|--------------|---------------------|------|------|-----|-----|----|----|-----|----|----|----|-------|----|-----|
| 15 x 8 | 1/2 x 1/4 | 2117-001-103 | 1-14 UNS RH | 70 | 38 | 125 | 194 | 48 | 19 | 6.4 | 36 | 22 | 65 | 1/4 | 82 | 1.5 |
| | 1/2 x 1/4 | 2117-001-105 | G 3/4 RH | 70 | 38 | 125 | 194 | 48 | 19 | 6.4 | 36 | 22 | 66 | 1/4 | 81 | 1.5 |
| | 1/2 x 1/4 | 2117-001-109 | 3/4 NPT | 70 | 38 | 128 | 194 | 51 | 22 | 6.4 | 36 | 22 | 71 | 1/4 | 82 | 1.5 |

DEUBLIN

Rotary Union 1379 and 1479 Series 4-Passage for Various Media

- Four independent passages for applications such as clamping and unclamping, work piece or tool sensing, and spindle cooling
- Vent between passages 2 and 3 allows use of two different media without cross contamination. For example, air in passages 1 and 2 and hydraulic oil in passages 3 and 4
- Stainless steel and brass components resist corrosion
- Hardened chrome sealing surface and elastomer-energized seals
- Dual, widely spaced ball bearings absorb large side loads

For further information, please contact Deublin or your local representative.

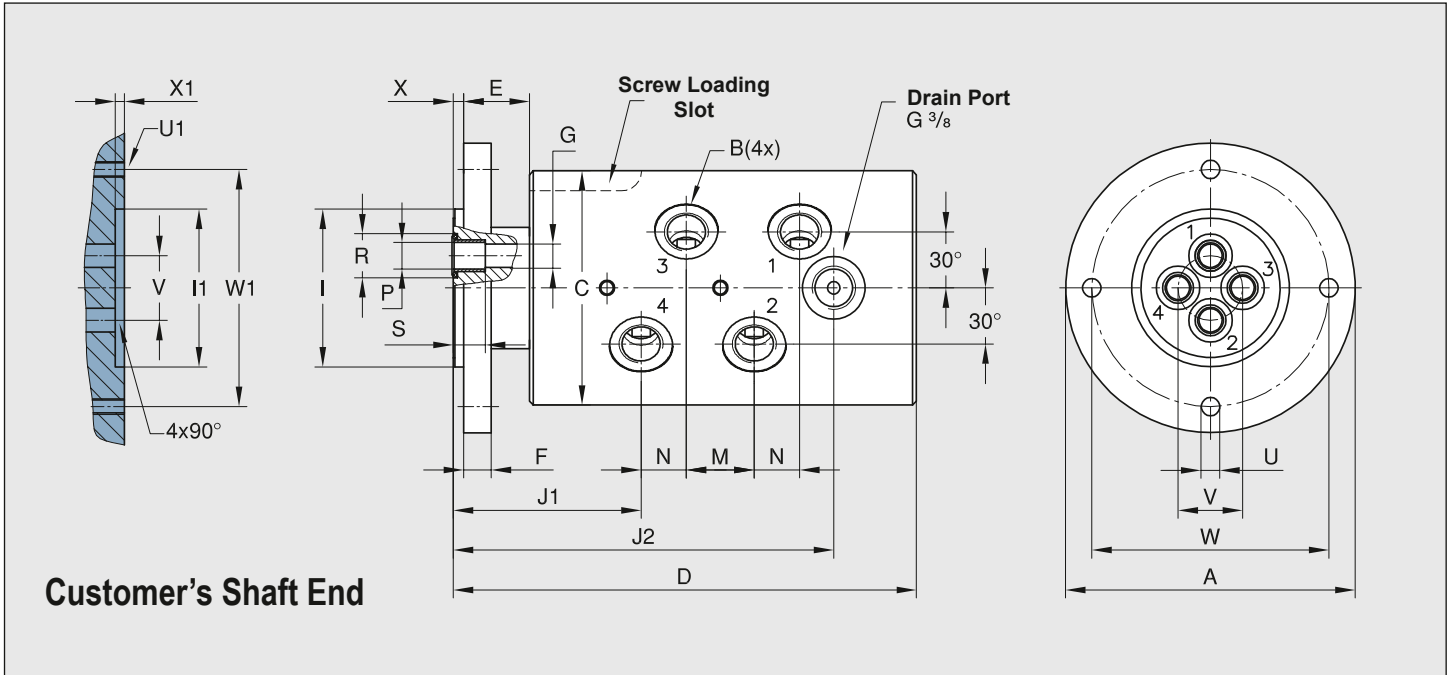
* Operating conditions vary depending on the application and must be adjusted so as not to exceed the maximum union housing temperature rating of 90 °C / 194 °F.



Operating Data

| | | | |
|--|-------------|-----------|-----------------------|
| Max. Air Pressure | | 150 PSI | 10 bar |
| Max. Hydraulic Pressure (rotating)* | | 850 PSI | 60 bar |
| Max. Hydraulic Pressure (very slow rotating) | | 3,600 PSI | 250 bar |
| Max. Vacuum | | 28 "Hg | 6,75 kPa |
| Max. Speed | | 250 rpm | 250 min ⁻¹ |
| Max. Flow per Passage | 1379 series | 14 gpm | 53 l/min |
| | 1479 series | 28.5 gpm | 108 l/min |
| Max. Temperature | | 175 °F | 80 °C |

For higher temperature, please consult Deublin.



4-Passage Rotary Union

| DN | B | Ordering No | A Ø | C Ø | D | E | F | G Ø | I ØPT | I1 ØPT | J1 | J2 | M | N | P Ø | R Ø | S | U Ø | U1 | V Ø | W Ø | X | X1 | W1 Ø | kg |
|--------------------------|---------|-------------|-----|-----|-----|----|------|-----|------------------|------------------|------|-----|----|----|-----|------|----|-----|----------|------|-----|---|-----|------|------|
| 4 x 10 | G 3/8 | 1379-160 | 110 | 88 | 176 | 25 | 11 | 9 | 60.000 59.981 | 60.060 60.030 | 71 | 145 | 26 | 17 | 12 | 16.7 | 12 | 7.2 | M6 4x90° | 24.5 | 90 | 4 | 3.5 | 90 | 7.6 |
| 4 x 10 | 3/8 NPT | 1379-460 | 110 | 88 | 176 | 25 | 11 | 9 | 60.000 59.981 | 60.060 60.030 | 71 | 145 | 26 | 17 | 12 | 16.7 | 12 | 7.2 | M6 4x90° | 24.5 | 90 | 4 | 3.5 | 90 | 7.6 |
| 4 x 10 + centr. Pass | G 3/8 | 1379-860 | 110 | 88 | 176 | 25 | 11 | 9 | 60.000 59.981 | 60.060 60.030 | 71 | 145 | 26 | 17 | 12 | 16.7 | 12 | 7.2 | M6 4x90° | 24.5 | 90 | 4 | 3.5 | 90 | 7.6 |
| 4 x 15 | G 1/2 | 1479-100 | 130 | 108 | 202 | 25 | 13.5 | 13 | 75.000 74.981 | 75.060 75.030 | 79.5 | 172 | 31 | 23 | 13 | 19.7 | 15 | 9 | M8 4x90° | 29 | 110 | 4 | 3.5 | 110 | 12.7 |
| 4 x 15 | 1/2 NPT | 1479-400 | 130 | 108 | 202 | 25 | 13.5 | 13 | 75.000 74.981 | 75.060 75.030 | 79.5 | 172 | 31 | 23 | 13 | 19.7 | 15 | 9 | M8 4x90° | 29 | 110 | 4 | 3.5 | 110 | 12.7 |
| 4 x 15 + centr. Pass. | G 1/2 | 1479-800 | 130 | 108 | 202 | 25 | 13.5 | 13 | 75.000 74.981 | 75.060 75.030 | 79.5 | 172 | 31 | 23 | 13 | 19.7 | 15 | 9 | M8 4x90° | 29 | 110 | 4 | 3.5 | 110 | 12.7 |



DEUBLIN

Rotary Union

DEU-PLEX Air Service, DN 10

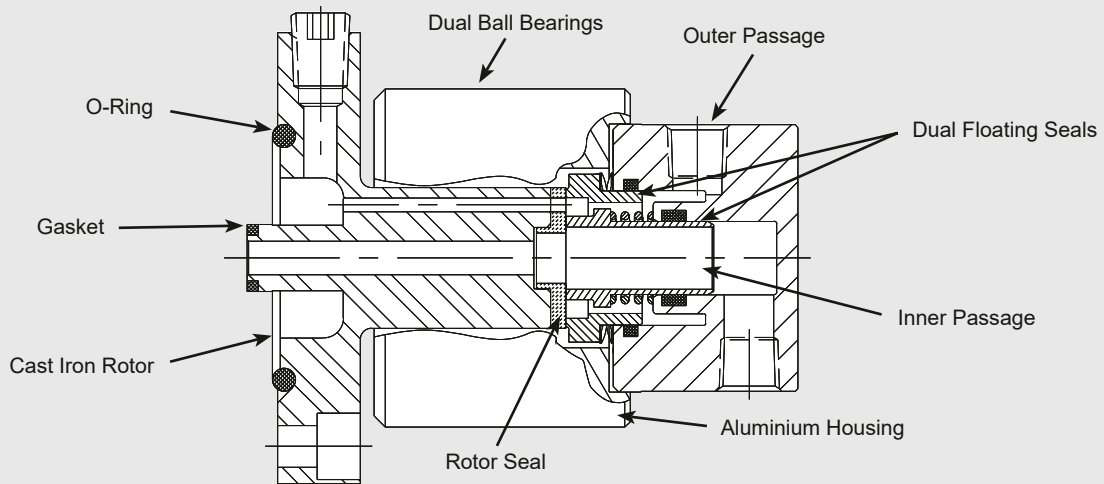
- Duoflow design
- Self-supported Rotary Union
- Flange rotor
- Radial housing connections
- Low torque
- Double-balanced mechanical seal
- Full-media flow
- Oiler for relubrication (3 – 5 drops/month)
- Aluminium housing
- Cast iron rotor
- Lubrication Guide page 45

Operating Data

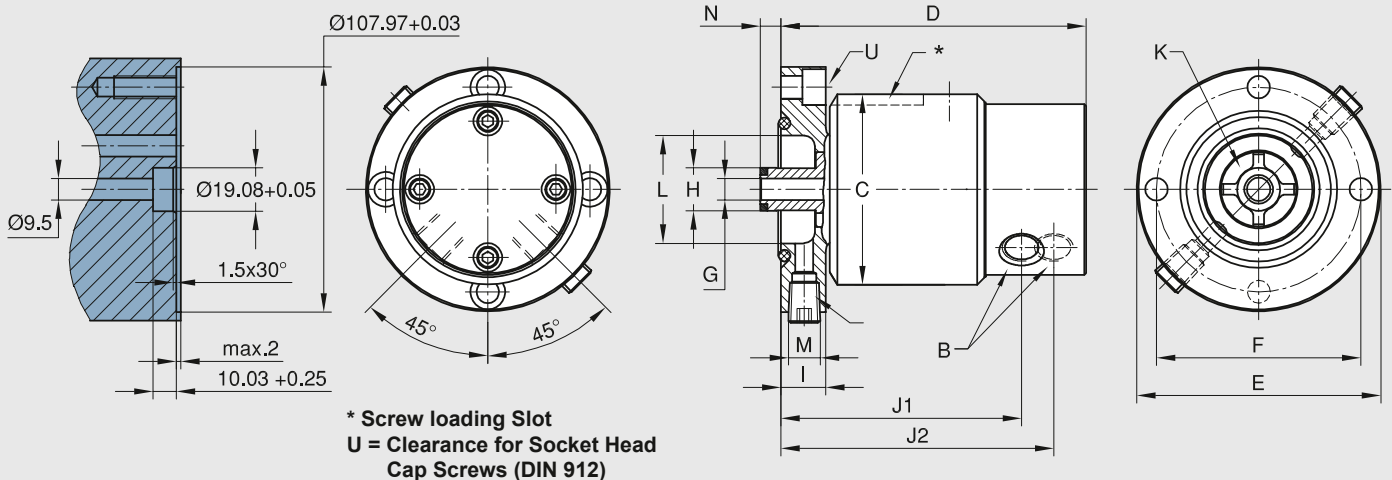
| | | |
|-------------------|-----------|-------------------------|
| Max. Air Pressure | 150 PSI | 10 bar |
| Max. Vacuum | 28 "Hg | 6,75 kPa |
| Max. Speed | 1,500 rpm | 1.500 min ⁻¹ |
| Max. Temperature | 250 °F | 121 °C |

For higher temperature, please consult Deublin.

For further information, please contact Deublin or your local representative.



Customer's Shaft End



| DN | B NPT | Ordering-No | C Ø | D | E ØPT | F Ø | G mm ² | H Ø | I | J ₁ | J ₂ | K mm ² | L Ø | M NPT | N | U Screws DN 912 | kg |
|--------|----------|-------------|--------|-----|------------------|--------|----------------------|----------------|----|----------------|----------------|----------------------|--------|----------|------|-----------------------|----|
| 2 x 10 | 3/8 | 1500-000 | 84 | 135 | 108.0 107.9 | 90.5 | 71 | 19.05 19.00 | 20 | 106 | 121 | 150 | 48 | 2 x 1/4 | 11.1 | 3/8-16 | 3 |
| | 3/8 | 1500-250 | 84 | 135 | 107.95 107.92 | 90.5 | 71 | 19.05 19.00 | 20 | 106 | 121 | 150 | 48 | 2 x 1/4 | 11.2 | M10 | 3 |

DEUBLIN

Rotary Union

DEU-PLEX Air and Hydraulic Oil Service, DN 15

- Duoflow design
- Self-supported Rotary Union
- Radial and axial housing connections
- Full-media flow
- Oiler for relubrication (3 – 5 drops/month)
- Aluminium housing
- Cast iron flange rotor
- Double-balanced mechanical seal – standard: Carbon Graphite/Ceramic
- Lubrication Guide page 45



Operating Data

| | | | |
|--------------------------------------|--------|-----------|-------------------------|
| Max. Air Pressure ¹ | (1590) | 150 PSI | 10 bar |
| Max. Hydraulic Pressure ² | (1579) | | |
| Outer passage | | 500 PSI | 34 bar |
| Inner passage | | 1,020 PSI | 70 bar |
| Max. Speed | | 1,500 rpm | 1.500 min ⁻¹ |
| Max. Temperature | | 250 °F | 121 °C |

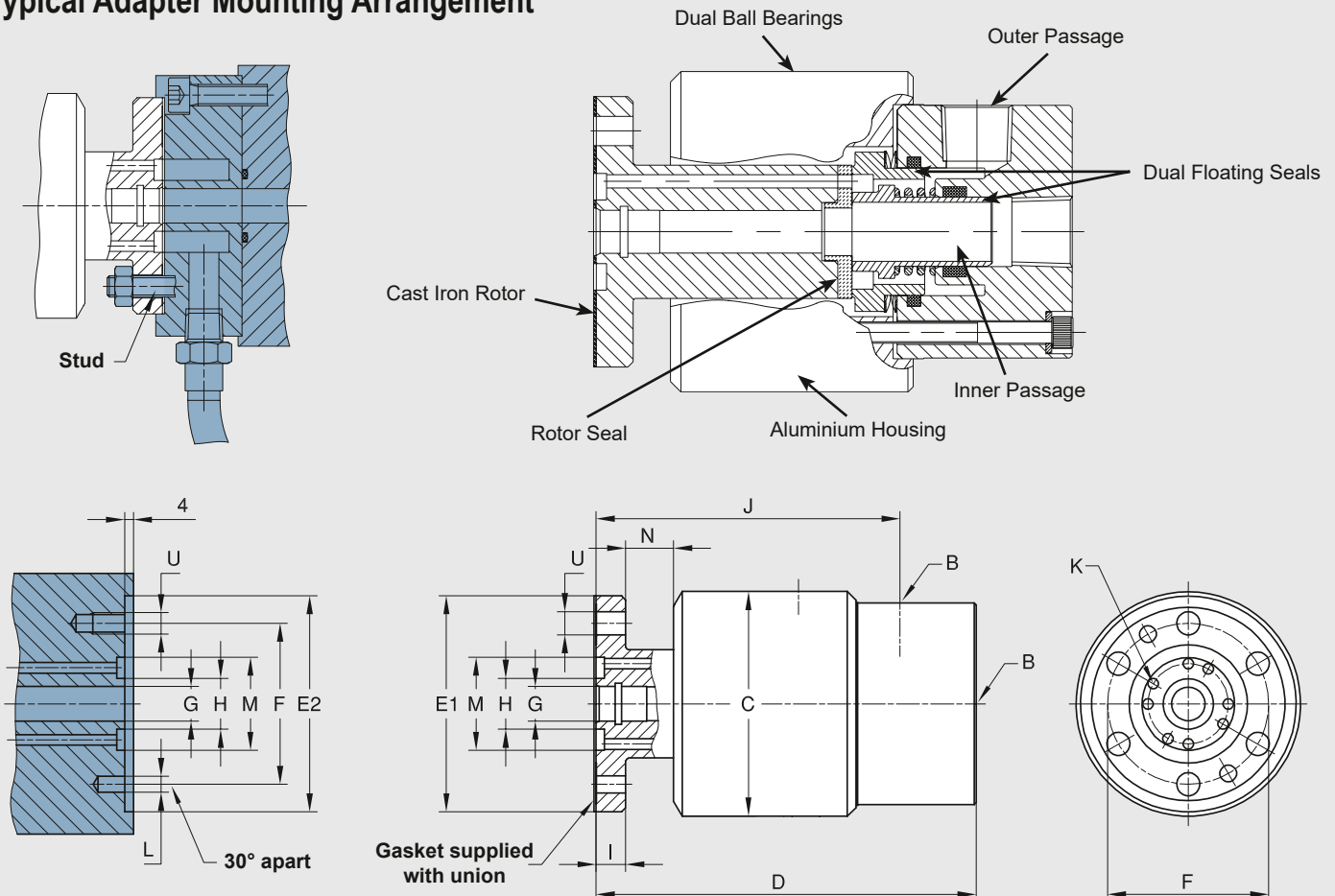
For higher temperature, please consult Deublin.

For further information, please contact Deublin or your local representative.

¹ Only one passage should be pressurized at a time.

² Operation at max. pressure combined with max. speed is not permissible. For the higher pressure use inner passage only.

Typical Adapter Mounting Arrangement



| DN | B NPT | Ordering-No | Media | C Ø | D | E1 ØPT | E2 Ø | F Ø | G mm ² | H Ø | I | J | K mm ² | L Ø dowel pin | M Ø | N | U Ø | kg |
|--------|-------|-------------|---------------|-----|-----|------------------|------------------|------|-------------------|-----|----|-----|-------------------|---------------|-----|----|--------|-----|
| 2 x 15 | 1/2 | 1579-000 | Hydraulic Oil | 84 | 143 | 81.000 80.988 | 81.050 81.020 | 60.3 | 126 | 19 | 11 | 114 | 100 | 6 | 35 | 18 | 8.7 M8 | 2.5 |
| | 1/2 | 1579-041 | Hydraulic Oil | 84 | 143 | 81.000 80.988 | 81.050 81.020 | 60.3 | 126 | 19 | 11 | 114 | 100 | 6 | 35 | 18 | 8.7 M8 | 2.5 |
| | 1/2 | 1579-074 | Hydraulic Oil | 96 | 143 | 81.000 80.988 | 81.050 81.020 | 60.3 | 126 | 19 | 11 | 113 | 100 | 6 | 35 | 12 | 8.7 M8 | 3.1 |
| | 1/2 | 1590-000 | Air | 84 | 143 | 81.000 80.988 | 81.050 81.020 | 60.3 | 126 | 19 | 11 | 114 | 100 | 6 | 35 | 18 | 8.7 M8 | 2.5 |



DEUBLIN

Rotary Union

BC-54000 Series

Water, Steam & Hot Oil Service, Fixed Siphon

- Duoflow, fixed siphon design
- Two widely spaced Carbon Bearings provide greater support to the siphon pipe and hoses
- Carbon Seal placed under compression add strength and shock resistance
- External seal wear indicator allows for planned maintenance reducing expensive downtime
- Cast Iron Housing
- Ferrous Rotor and End Cap

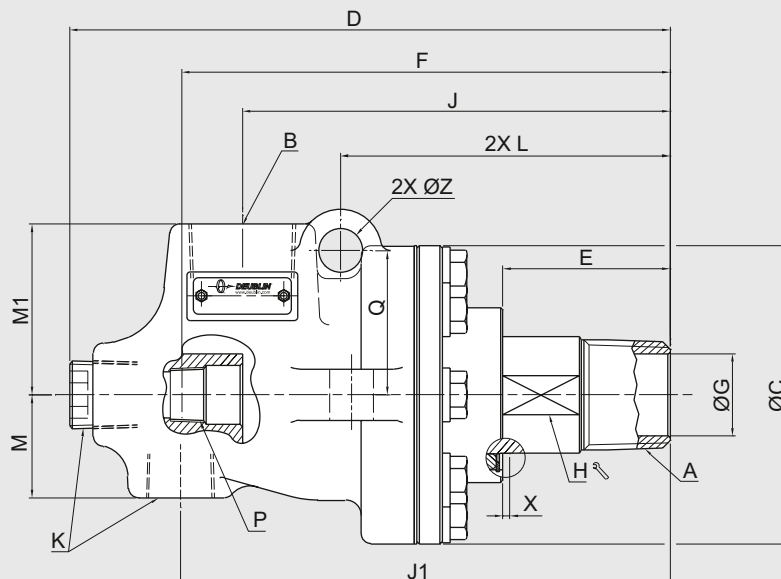
For further information, please contact Deublin or your local representative.

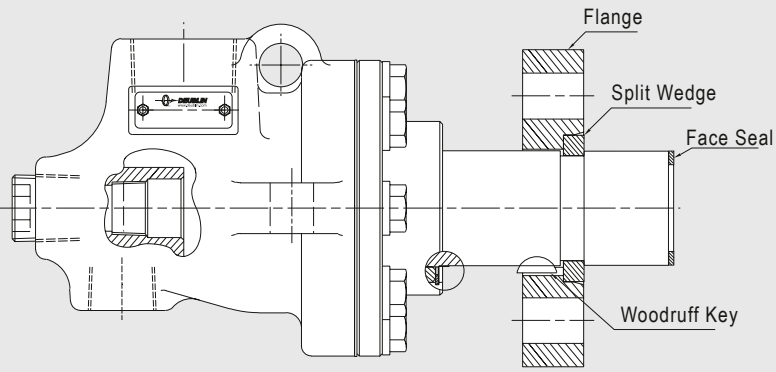
Operating Data

| | | | |
|------------------------------|--------------|---------|-----------------------|
| Max. Water or Steam Pressure | 1/2 to 1 1/2 | 250 PSI | 17.2 bar |
| | 2 to 3 | 225 PSI | 15.5 bar |
| Max. Hot Oil Pressure | 1/2 to 3 | 100 PSI | 6.9 bar |
| | | | |
| Max. Speed | 1/2 to 1 1/2 | 400 rpm | 400 min ⁻¹ |
| | 2 to 3 | 350 rpm | 350 min ⁻¹ |
| Max. Water Temperature | | 406 °F | 208 °C |
| Max. Hot Oil Temperature | | 446 °F | 232 °C |

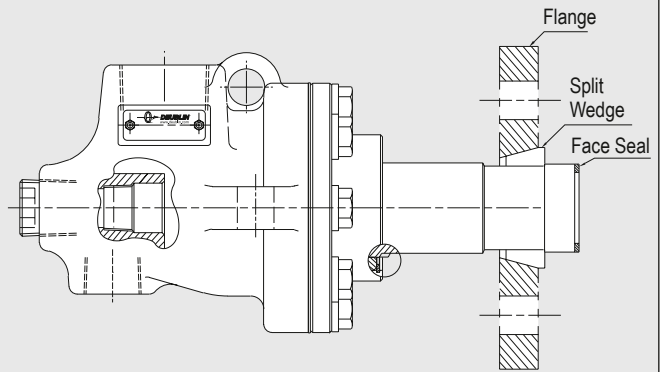
For higher temperature, please consult Deublin.

Duoflow Rotary Union with Fixed Siphon





"CF" Connection
BC-54XXX-XX-30

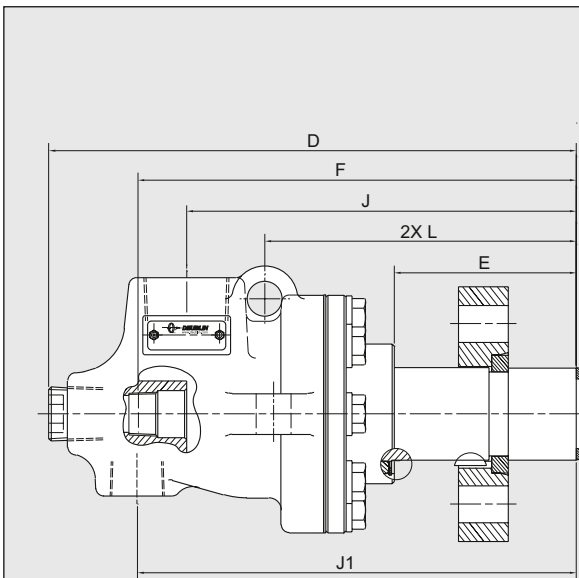
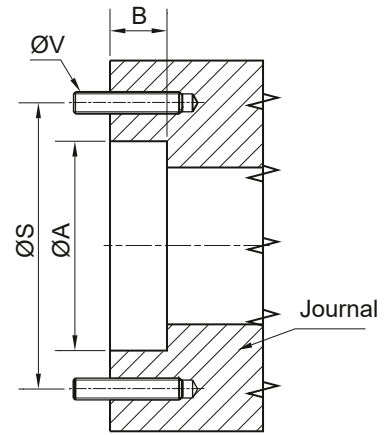


Quick Release Connection
BC-54XXX-XX-32

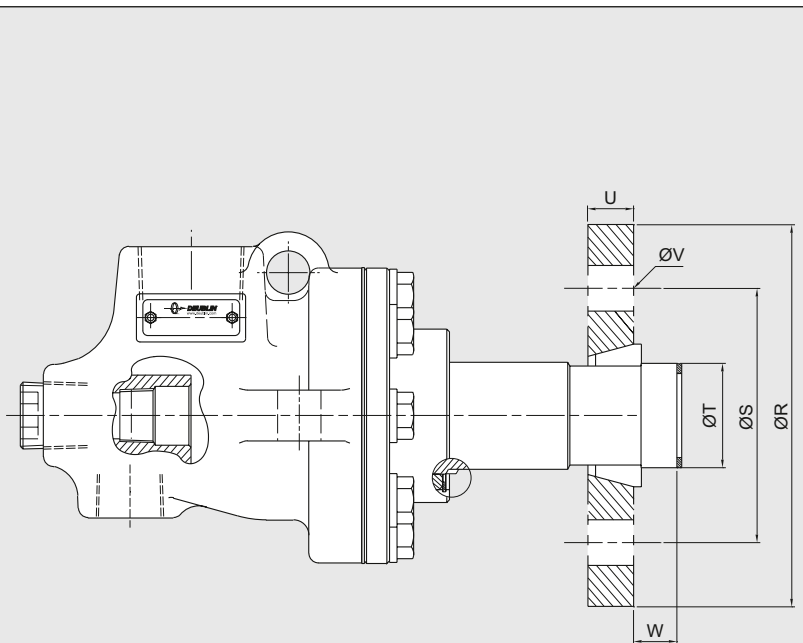
Journal Dimensions

| Joint Size | CF Connection | | Quick Release Connection | |
|------------|---------------|------|--------------------------|------|
| | ØA | B | ØA | B |
| 1 ½ | 53.31 - 53.24 | 26.7 | 47.60 - 47.70 | 9.5 |
| 2 | 69.19 - 69.11 | 26.7 | 58.98 - 59.08 | 12.7 |
| 2 ½ | 78.71 - 78.63 | 26.7 | 72.19 - 72.29 | 15.9 |
| 3 | 94.59 - 94.51 | 26.7 | 87.18 - 87.28 | 22.2 |

Quick Release Flanges and split wedges are available.
Contact Deublin for more information.



"CF" Connection
BC-54XXX-XX-30




Quick Release Connection
BC-54XXX-XX-32

BC-54000 Series, Fixed Siphon

| DN | Hot Oil Part Number | Water or Steam Part Number | A | | B | ØC | D | E | F | ØG | H | J | J1 | K |
|----|---------------------|----------------------------|------------|----|------------|-----|-----|----|-----|------|-------|-----|-----|-----------|
| 15 | BC-54000-08-20 | BC-54000-08-50 | 1/2 NPT | RH | 1/2 NPT | 76 | 154 | 43 | 124 | 12.7 | 22.1 | 115 | 136 | 1/4 NPT |
| | BC-54000-08-21 | BC-54000-08-51 | 1/2 NPT | LH | 1/2 NPT | 76 | 154 | 43 | 124 | 12.7 | 22.1 | 115 | 136 | 1/4 NPT |
| 20 | BC-54000-12-20 | BC-54000-12-50 | 3/4 NPT | RH | 3/4 NPT | 86 | 160 | 43 | 132 | 19 | 27.6 | 115 | 131 | 1/2 NPT |
| | BC-54000-12-21 | BC-54000-12-51 | 3/4 NPT | LH | 3/4 NPT | 86 | 160 | 43 | 132 | 19 | 27.6 | 115 | 131 | 1/2 NPT |
| 25 | BC-54000-16-20 | BC-54000-16-50 | 1 NPT | RH | 1 NPT | 92 | 184 | 52 | 151 | 25 | 33.7 | 132 | 151 | 1/2 NPT |
| | BC-54000-16-21 | BC-54000-16-51 | 1 NPT | LH | 1 NPT | 92 | 184 | 52 | 151 | 25 | 33.7 | 132 | 151 | 1/2 NPT |
| | BC-54000-16-20B | BC-54000-16-50B | 1 BSPT | RH | 1 BSPT | 92 | 184 | 52 | 151 | 25 | 33.7 | 132 | 151 | 1/2 BSPT |
| | BC-54000-16-21B | BC-54000-16-51B | 1 BSPT | LH | 1 BSPT | 92 | 184 | 52 | 151 | 25 | 33.7 | 132 | 151 | 1/2 BSPT |
| 32 | BC-54000-20-20 | BC-54000-20-50 | 1 1/4 NPT | RH | 1 1/4 NPT | 111 | 226 | 48 | 179 | 32 | 42.9 | 170 | 178 | 3/4 NPT |
| | BC-54000-20-21 | BC-54000-20-51 | 1 1/4 NPT | LH | 1 1/4 NPT | 111 | 226 | 48 | 179 | 32 | 42.9 | 170 | 178 | 3/4 NPT |
| | - | BC-54000-20-50B | 1 1/4 BSPT | RH | 1 1/4 BSPT | 111 | 226 | 48 | 179 | 32 | 42.9 | 170 | 178 | 3/4 BSPT |
| 40 | BC-54000-24-20 | BC-54000-24-50 | 1 1/2 NPT | RH | 1 1/2 NPT | 121 | 237 | 54 | 186 | 38.1 | 49.28 | 179 | 190 | 3/4 NPT |
| | BC-54000-24-21 | BC-54000-24-51 | 1 1/2 NPT | LH | 1 1/2 NPT | 121 | 237 | 54 | 186 | 38.1 | 49.28 | 179 | 190 | 3/4 NPT |
| | BC-54000-24-20B | BC-54000-24-50B | 1 1/2 BSPT | RH | 1 1/2 BSPT | 121 | 237 | 54 | 186 | 38.1 | 49.28 | 179 | 190 | 3/4 BSPT |
| | - | BC-54000-24-60 | CF | | 1 1/2 NPT | 121 | 273 | 90 | 222 | 38.1 | - | 215 | 226 | 3/4 NPT |
| | - | BC-54000-24-62 | QR | | 1 1/2 NPT | 121 | 273 | 90 | 222 | 38.1 | - | 215 | 226 | 3/4 NPT |
| | - | BC-54000-24-62B | QR | | 1 1/2 BSPT | 121 | 273 | 90 | 222 | 38.1 | - | 215 | 226 | 3/4 BSPT |
| 50 | BC-54000-32-20 | BC-54000-32-50 | 2 NPT | RH | 2 NPT | 152 | 294 | 56 | 215 | 48 | 60.45 | 205 | 219 | 1 1/4 NPT |
| | - | BC-54000-32-51 | 2 NPT | LH | 2 NPT | 152 | 294 | 56 | 215 | 48 | 60.45 | 205 | 219 | 1 1/4 NPT |
| | - | BC-54000-32-60 | CF | | 2 NPT | 152 | 331 | 93 | 251 | 48 | - | 242 | 256 | 1 1/4 NPT |
| 65 | BC-54000-40-20 | BC-54000-40-50 | 2 1/2 NPT | RH | 2 1/2 NPT | 172 | 340 | 74 | 253 | 57.2 | 74.5 | 248 | 257 | 1 1/4 NPT |
| | - | BC-54000-40-51 | 2 1/2 NPT | LH | 2 1/2 NPT | 172 | 340 | 74 | 253 | 57.2 | 74.5 | 248 | 257 | 1 1/4 NPT |
| | - | BC-54000-40-60 | CF | | 2 1/2 NPT | 172 | 356 | 90 | 270 | 57.2 | - | 263 | 272 | 1 1/4 NPT |
| 80 | - | BC-54000-48-50 | 3 NPT | RH | 3 NPT | 200 | 358 | 78 | 274 | 73 | 89.5 | 271 | 276 | 1 1/2 NPT |
| | - | BC-54000-48-51 | 3 NPT | LH | 3 NPT | 200 | 358 | 78 | 274 | 73 | 89.5 | 271 | 276 | 1 1/2 NPT |
| | - | BC-54000-48-62 | QR | | 3 NPT | 200 | 369 | 91 | 285 | 73 | 89.5 | 284 | 287 | 1 1/2 NPT |

* BSPT Models are not supplied with siphon bushing

| L | M | M1 | P | P with bushing | Q | ØR | ØS | ØT | U | 4 X ØV | W | X | ØZ |  | DN |
|-----|----|----|-----------|----------------|----|-----|-------|--------------|----|--------|------|------|------|---|----|
| - | 30 | 42 | 1/8 NPT | - | - | - | - | - | - | - | - | 4.8 | - | 1.59 | 15 |
| - | 30 | 42 | 1/8 NPT | - | - | - | - | - | - | - | - | 4.8 | - | 1.59 | |
| - | 32 | 44 | 1/4 NPT | 1/8 NPT | - | - | - | - | - | - | - | 4.8 | - | 2.27 | 20 |
| - | 32 | 44 | 1/4 NPT | 1/8 NPT | - | - | - | - | - | - | - | 4.8 | - | 2.27 | |
| 102 | 32 | 53 | 3/8 NPT | 1/4 NPT | 44 | - | - | - | - | - | - | 6.3 | 13.5 | 2.72 | 25 |
| 102 | 32 | 53 | 3/8 NPT | 1/4 NPT | 44 | - | - | - | - | - | - | 6.3 | 13.5 | 2.72 | |
| 102 | 32 | 53 | 3/8 BSPT | - | 44 | - | - | - | - | - | - | 6.3 | 13.5 | 2.72 | |
| 102 | 32 | 53 | 3/8 BSPT | - | 44 | - | - | - | - | - | - | 6.3 | 13.5 | 2.72 | |
| 111 | 45 | 56 | 1/2 NPT | 3/8 NPT | 53 | - | - | - | - | - | - | 6.3 | 16 | 5.9 | 32 |
| 111 | 45 | 56 | 1/2 NPT | 3/8 NPT | 53 | - | - | - | - | - | - | 6.3 | 16 | 5.9 | |
| 111 | 45 | 56 | 1/2 BSPT | - | 53 | - | - | - | - | - | - | 6.3 | 16 | 5.9 | |
| 120 | 52 | 62 | 3/4 NPT | 1/2 NPT | 57 | - | - | - | - | - | - | 6.3 | 16 | 6.8 | 40 |
| 120 | 52 | 62 | 3/4 NPT | 1/2 NPT | 57 | - | - | - | - | - | - | 6.3 | 16 | 6.8 | |
| 120 | 52 | 62 | 3/4 BSPT | - | 57 | - | - | - | - | - | - | 6.3 | 16 | 6.8 | |
| 156 | 52 | 62 | 3/4 NPT | 1/2 NPT | 57 | 124 | 92 | 53.14 ± 0.02 | 19 | 17 | 26.2 | 6.3 | 16 | 8.62 | |
| 156 | 52 | 62 | 3/4 NPT | 1/2 NPT | 57 | - | - | - | - | - | - | 6.3 | 16 | 6.8 | |
| 156 | 52 | 62 | 3/4 BSPT | - | 57 | - | - | - | - | - | - | 6.3 | 16 | 6.8 | |
| 127 | 65 | 70 | 3/4 NPT | 1/2 NPT | 70 | - | - | - | - | - | - | 7.9 | 16 | 11.79 | 50 |
| 127 | 65 | 70 | 3/4 NPT | 1/2 NPT | 70 | - | - | - | - | - | - | 7.9 | 16 | 11.79 | |
| 164 | 65 | 70 | 3/4 NPT | 1/2 NPT | 70 | 140 | 108 | 68.96 ± 0.02 | 19 | 17.35 | 26 | 7.9 | 16 | 14.06 | |
| 161 | 64 | 76 | 1 NPT | 3/4 NPT | 78 | - | - | - | - | - | - | 6.3 | 19 | 14.97 | 65 |
| 161 | 64 | 76 | 1 NPT | 3/4 NPT | 78 | - | - | - | - | - | - | 6.3 | 19 | 14.97 | |
| 176 | 64 | 76 | 1 NPT | 3/4 NPT | 78 | 149 | 117.4 | 78.49 ± 0.02 | 19 | 17.35 | 26 | 6.3 | 19 | 18.14 | |
| 168 | 73 | 92 | 1 1/2 NPT | 1 NPT | 92 | - | - | - | - | - | - | 6.35 | 24 | 20.41 | 80 |
| 168 | 73 | 92 | 1 1/2 NPT | 1 NPT | 92 | - | - | - | - | - | - | 6.35 | 24 | 20.41 | |
| 181 | 73 | 92 | 1 1/2 NPT | 1 NPT | 92 | - | - | 87.15 ± 0.02 | - | - | - | 6.35 | 24 | 20.41 | |



DEUBLIN

Rotary Union

BC-54100 Series

Water, Steam & Hot Oil Service, Monoflow

- Monoflow design
- Carbon Seal placed under compression add strength and shock resistance
- External seal wear indicator allows for planned maintenance reducing expensive downtime
- Cast Iron Housing
- Ferrous Rotor and End Cap

For further information, please contact Deublin or your local representative.

Operating Data

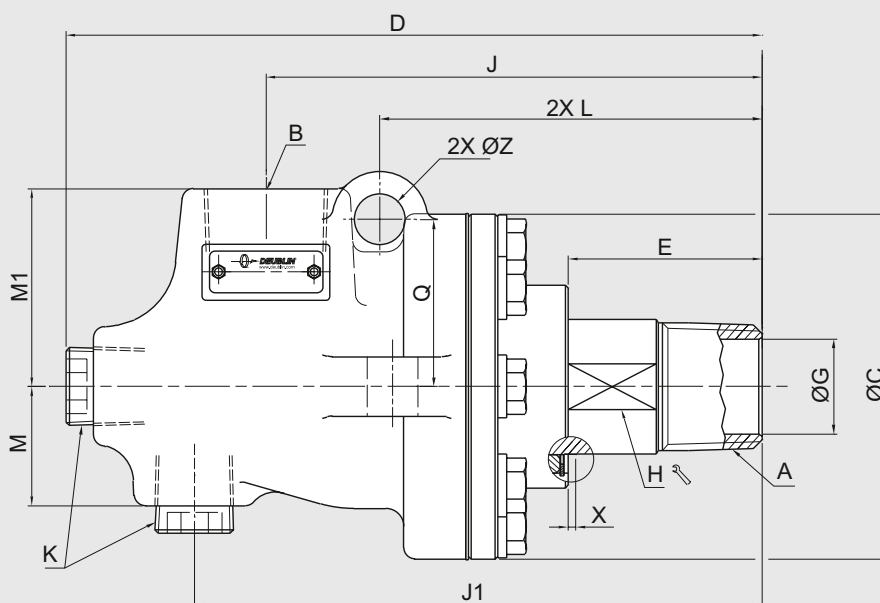
| | | | |
|------------------------------|--------------|---------|-----------------------|
| Max. Water or Steam Pressure | 1/2 to 1 1/2 | 250 PSI | 17.2 bar |
| Max. Hot Oil Pressure | 1/2 to 1 1/2 | 100 PSI | 6.9 bar |
| Max. Speed | 1/2 to 1 1/2 | 400 rpm | 400 min ⁻¹ |
| Max. Water Temperature | | 406 °F | 208 °C |
| Max. Hot Oil Temperature | | 446 °F | 232 °C |


For higher temperature, please consult Deublin.

BC-54100 Series, Monoflow

| DN | Hot Oil Part Number | Water or Steam Part Number | A | | B | ØC | D | E | ØG | H |
|----|---------------------|----------------------------|-----------|----|-----------|-----|-----|----|------|-------|
| 15 | BC-54100-08-20 | BC-54100-08-50 | 1/2 NPT | RH | 1/2 NPT | 76 | 154 | 43 | 12.7 | 22.1 |
| | BC-54100-08-21 | BC-54100-08-51 | 1/2 NPT | LH | 1/2 NPT | 76 | 154 | 43 | 12.7 | 22.1 |
| 20 | BC-54100-12-20 | BC-54100-12-50 | 3/4 NPT | RH | 3/4 NPT | 86 | 163 | 43 | 19 | 27.6 |
| | BC-54100-12-21 | BC-54100-12-51 | 3/4 NPT | LH | 3/4 NPT | 86 | 163 | 43 | 19 | 27.6 |
| 25 | BC-54100-16-20 | BC-54100-16-50 | 1 NPT | RH | 1 NPT | 92 | 184 | 52 | 25 | 33.7 |
| | BC-54100-16-21 | BC-54100-16-51 | 1 NPT | LH | 1 NPT | 92 | 184 | 52 | 25 | 33.7 |
| 40 | BC-54100-24-20 | BC-54100-24-50 | 1 1/2 NPT | RH | 1 1/4 NPT | 121 | 237 | 54 | 38.1 | 49.28 |
| | BC-54100-24-21 | BC-54100-24-51 | 1 1/2 NPT | LH | 1 1/4 NPT | 121 | 237 | 54 | 38.1 | 49.28 |
| 50 | BC-54100-32-20 | BC-54100-32-50 | 2 NPT | RH | 2 NPT | 152 | 270 | 56 | 47.8 | 60.5 |
| | BC-54100-32-21 | BC-54100-32-51 | 2 NPT | LH | 2 NPT | 152 | 270 | 56 | 47.8 | 60.4 |

Threaded Connection



| J | J1 | K | L | M | M1 | Q | X | ØZ |  | DN |
|-----|-----|-----------|-----|----|----|----|-----|------|---|----|
| 115 | 136 | 1/4 NPT | - | 30 | 42 | - | 4.8 | - | 1.59 | 15 |
| 115 | 136 | 1/4 NPT | - | 30 | 42 | - | 4.8 | - | 1.59 | |
| 115 | 131 | 1/2 NPT | - | 32 | 45 | - | 4.8 | - | 2.27 | 20 |
| 115 | 131 | 1/2 NPT | - | 32 | 45 | - | 4.8 | - | 2.27 | |
| 132 | 151 | 1/2 NPT | 102 | 32 | 53 | 44 | 6.3 | 13.5 | 2.72 | 25 |
| 132 | 151 | 1/2 NPT | 102 | 32 | 53 | 44 | 6.3 | 13.5 | 2.72 | |
| 179 | 190 | 3/4 NPT | 120 | 52 | 62 | 57 | 6.3 | 16 | 6.8 | 40 |
| 179 | 190 | 3/4 NPT | 120 | 52 | 62 | 57 | 6.3 | 16 | 6.8 | |
| 205 | 219 | 1 1/4 NPT | 127 | 65 | 70 | 70 | 7.9 | 16 | 11.8 | 50 |
| 205 | 219 | 1 1/4 NPT | 127 | 65 | 70 | 70 | 7.9 | 16 | 11.8 | |



DEUBLIN

Rotary Union

BC-54205 Series

Water, Steam & Hot Oil Service, Rotating Siphon

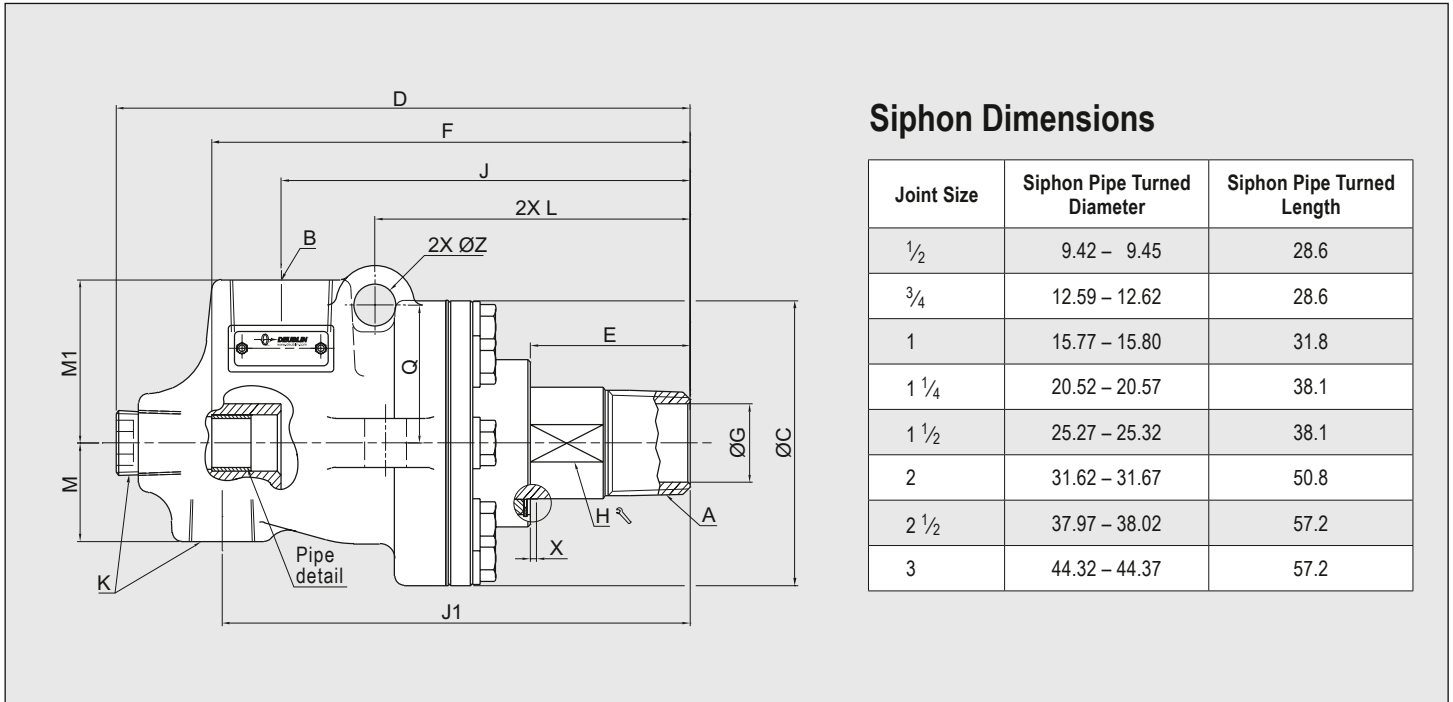
- Duoflow, Rotating Siphon design
- Two widely spaced Carbon Bearings provide greater support to the siphon pipe and hoses
- Carbon Seal placed under compression add strength and shock resistance
- External seal wear indicator allows for planned maintenance reducing expensive downtime
- Cast Iron Housing
- Ferrous Rotor and End Cap

Operating Data

| | | | |
|------------------------------|---------|---------|-----------------------|
| Max. Water or Steam Pressure | 2 to 3 | 225 PSI | 15.5 bar |
| Max. Hot Oil Pressure | ¾ to 1½ | 100 PSI | 6.9 bar |
| Max. Speed | ¾ to 1½ | 400 rpm | 400 min ⁻¹ |
| | 2 to 3 | 350 rpm | 350 min ⁻¹ |
| Max. Water Temperature | | 406 °F | 208 °C |
| Max. Hot Oil Temperature | | 446 °F | 232 °C |

For higher temperature, please consult Deublin.

For further information, please contact Deublin or your local representative.

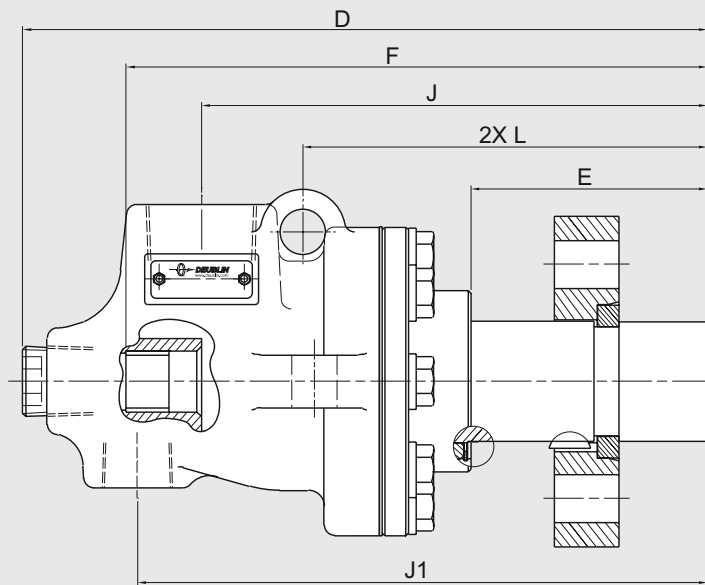
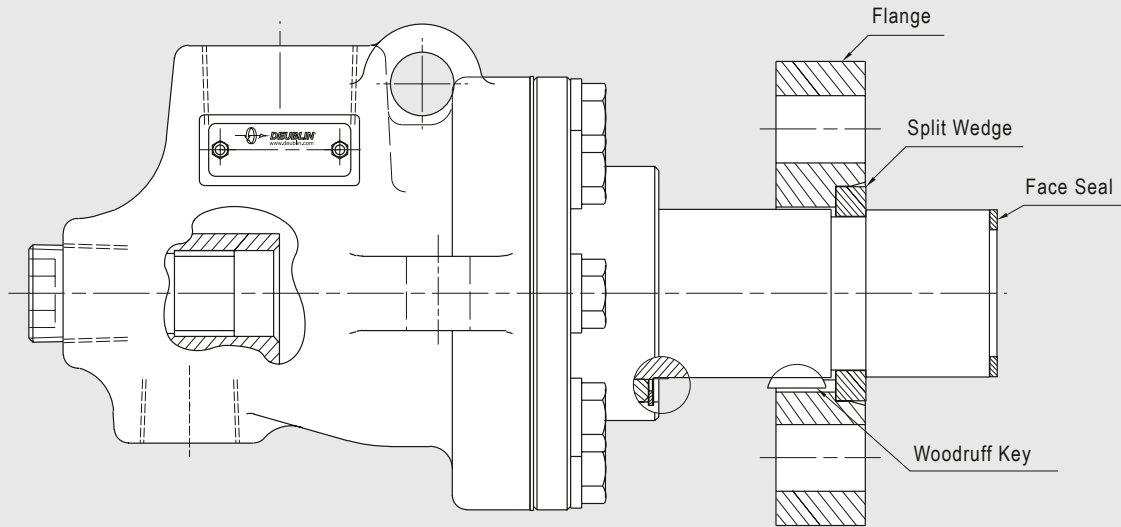



Siphon Dimensions

| Joint Size | Siphon Pipe Turned Diameter | Siphon Pipe Turned Length |
|------------|-----------------------------|---------------------------|
| ½ | 9.42 – 9.45 | 28.6 |
| ¾ | 12.59 – 12.62 | 28.6 |
| 1 | 15.77 – 15.80 | 31.8 |
| 1 ¼ | 20.52 – 20.57 | 38.1 |
| 1 ½ | 25.27 – 25.32 | 38.1 |
| 2 | 31.62 – 31.67 | 50.8 |
| 2 ½ | 37.97 – 38.02 | 57.2 |
| 3 | 44.32 – 44.37 | 57.2 |

| DN | Hot Oil Part Number | Water or Steam Part Number | A | B | ØC | D | E | F | ØG | H | J |
|----|---------------------|----------------------------|------------|---------|------|-----|----|-----|------|-------|-----|
| 20 | - | BC-54205-12-50 | ¾ NPT RH | ¾ NPT | 86.4 | 163 | 43 | 129 | 19.3 | 27.6 | 115 |
| | BC-54205-12-21 | - | ¾ NPT LH | ¾ NPT | 86.4 | 163 | 43 | 129 | 19.3 | 27.6 | 115 |
| 25 | BC-54205-16-21 | - | 1 NPT LH | 1 NPT | 92 | 184 | 52 | 154 | 25 | 33.7 | 132 |
| 40 | BC-54205-24-20 | - | 1 ½ NPT RH | 1 ½ NPT | 121 | 237 | 54 | 190 | 38.1 | 49.28 | 179 |
| | BC-54205-24-21 | - | 1 ½ NPT LH | 1 ½ NPT | 121 | 237 | 54 | 190 | 38.1 | 49.28 | 179 |
| 50 | - | BC-54205-32-50 | 2 NPT RH | 2 NPT | 152 | 294 | 56 | 212 | 48 | 60.45 | 205 |
| 65 | - | BC-54205-40-50 | 2 ½ NPT RH | 2 ½ NPT | 172 | 340 | 74 | 254 | 57 | 74.5 | 248 |
| 80 | - | BC-54205-48-60 | CF | 3 NPT | 200 | 370 | 91 | 293 | 73 | - | 284 |

Threaded End & Siphon Pipe



| J1 | K | L | M | M1 | Q | ØR | ØS | ØT | U | 4 X ØV | W | X | ØZ |  | DN |
|-----|-----------|-----|----|----|----|-----|--------|---------------|----|--------|------|-----|------|---|----|
| 136 | 1/2 NPT | - | 32 | 45 | - | - | - | - | - | - | - | 4.8 | - | 2.27 | 20 |
| 136 | 1/2 NPT | - | 32 | 45 | - | - | - | - | - | - | - | 4.8 | - | 2.27 | |
| 151 | 1/2 NPT | 102 | 32 | 53 | 44 | - | - | - | - | - | - | 6.3 | 13.5 | 2.72 | 25 |
| 190 | 3/4 NPT | 120 | 52 | 62 | 57 | - | - | - | - | - | - | 6.3 | 16 | 5.9 | 40 |
| 190 | 3/4 NPT | 120 | 52 | 62 | 57 | - | - | - | - | - | - | 6.3 | 16 | 5.9 | |
| 219 | 1 1/4 NPT | 127 | 65 | 70 | 70 | - | - | - | - | - | - | 7.9 | 16 | 11.79 | 50 |
| 258 | 1 1/4 NPT | 161 | 64 | 76 | 78 | - | - | - | - | - | - | 6.3 | 19 | 14.97 | 65 |
| 289 | 1 1/2 NPT | 181 | 73 | 92 | 92 | 165 | 133.35 | 94.36 ± 0.025 | 19 | 17.5 | 26.2 | 6.3 | 24 | 22.68 | 80 |

Sealing

Original Rotary Unions used the media pressure to maintain seal contact. Logic indicates that as pressure increases, so do the forces holding the seals together - more pressure = tighter, better sealing.

This is why they were called “pressure joints”.

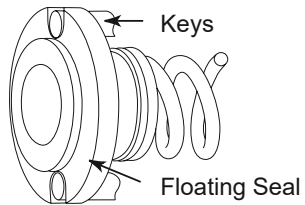
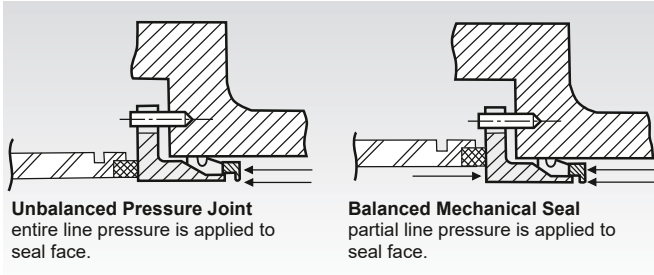
However, more pressure on the rotary seal face also meant more friction, higher torque and more wear. The resulting service life was not satisfactory.

Deublin was aware of the disadvantage and applied “Balanced Mechanical Seal Technology”, a decisive improvement.

This simply means the load or pressure on the seal faces is kept to a minimum regardless of media pressure, resulting in a freer turning union providing longer seal life.

Optimal balance ratio allows for a thin film of “lubricating” media between the seal faces.

In order to attain sealing in a non-pressurised system, the floating seal contact is maintained by the spring pressure.



Keyed Floating Seal

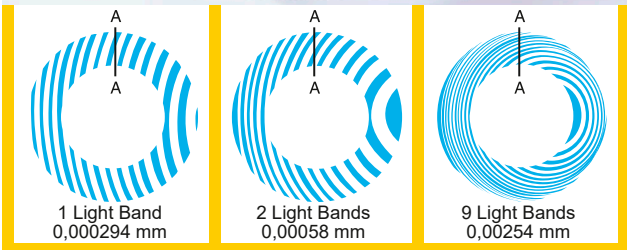
Manufacturing

The entire Deublin product range is manufactured with cutting edge technology from the very first drawing to the final production. Modern CNC machining centres transform highest quality materials into precision components. Cost-effective production is achieved by applying new technology and the most modern equipment.

Once assembled EVERY Rotary Union is dynamically pressure-tested for leakage as part of the final inspection procedure prior to despatch.

The core of a Rotary Union is the seal combination. Seal faces manufactured from tool steel, carbon graphite, bronze, ceramic, tungsten carbide or silicon carbide are micro-lapped to a surface finish of 0.025 RMS and an optical flatness of 2 light bands. To ensure the above specifications the near perfect flatness is checked under mono-chromatic light (refer to picture).

The Deublin Performance System (DPS) focuses production on customer's demand. Through demand-oriented production, available resources are balanced to efficiently produce just-in-time to meet customer requirements.



Micro-Lapped Seals

Thread Specifications used in this Catalogue

| Symbol | Description |
|----------|---|
| ½ NPT | (American) National Pipe Thread |
| ⅝-18 UNF | Unified National Fine Thread |
| 1-14 UNS | Unified National Special |
| RH / LH | Right Hand / Left Hand |
| Rp ½ | ISO 7/1 (DIN 2999) Pipe Thread (cylindrical internal) |

| Symbol | Description |
|----------|---|
| G ½ | ISO 228 (DIN 259) Straight Pipe Thread |
| M 22x1,5 | ISO Metric Thread |
| R ⅛ | ISO 7/1 (DIN 2999) Pipe Thread (tapered external) |
| Rc ¾ | ISO 7/1 (DIN 2999) Pipe Thread (tapered internal) |
| BSPT | British Standard Pipe Tapered |

Relubrication Guide for Deublin Rotary Unions

All Deublin Rotary Unions are factory lubricated and tested, ready for installation. Unions not equipped with grease fittings are lubricated for the life of the union and require no further maintenance. Rotary unions, which are equipped with grease fittings, may require periodic lubrication to replace the grease which has dissipated. Overgreasing can be as damaging to the union as undergreasing, particularly in high-speed applications. Relubrication frequency and amounts of grease vary greatly depending on union size, operating temperature, rotation speed, moisture, etc. The following charts and table provide approximate lubrication frequency and amounts of grease for light and moderate service conditions.

When relubricating Deublin Rotary Unions, use CHEVRON SRI GREASE NLGI 2. Only low-pressure grease equipment should be used to prevent damage to the bearings and seals. This is a general guide that should be used judiciously. The user must make adjustments as experience dictates. For more specific information, contact your local lubricant supplier.

For alternative greases, please refer to the Operating Manual at www.deublin.com / www.deublin.eu.

Relubrication

| Model | Amount of Grease (g) | Model | Amount of Grease (g) |
|-------|----------------------|-------|----------------------|
| 57 | 3.5 | 657 | 18 |
| 157 | 5.5 | 857 | 42 |
| 257 | 10 | 6200 | 18 |
| 357 | 10 | 6250 | 42 |
| 525 | 12 | 6300 | 68 |
| 555 | 18 | 6400 | 90 |

For further information please request our separate Lubrication Guide.

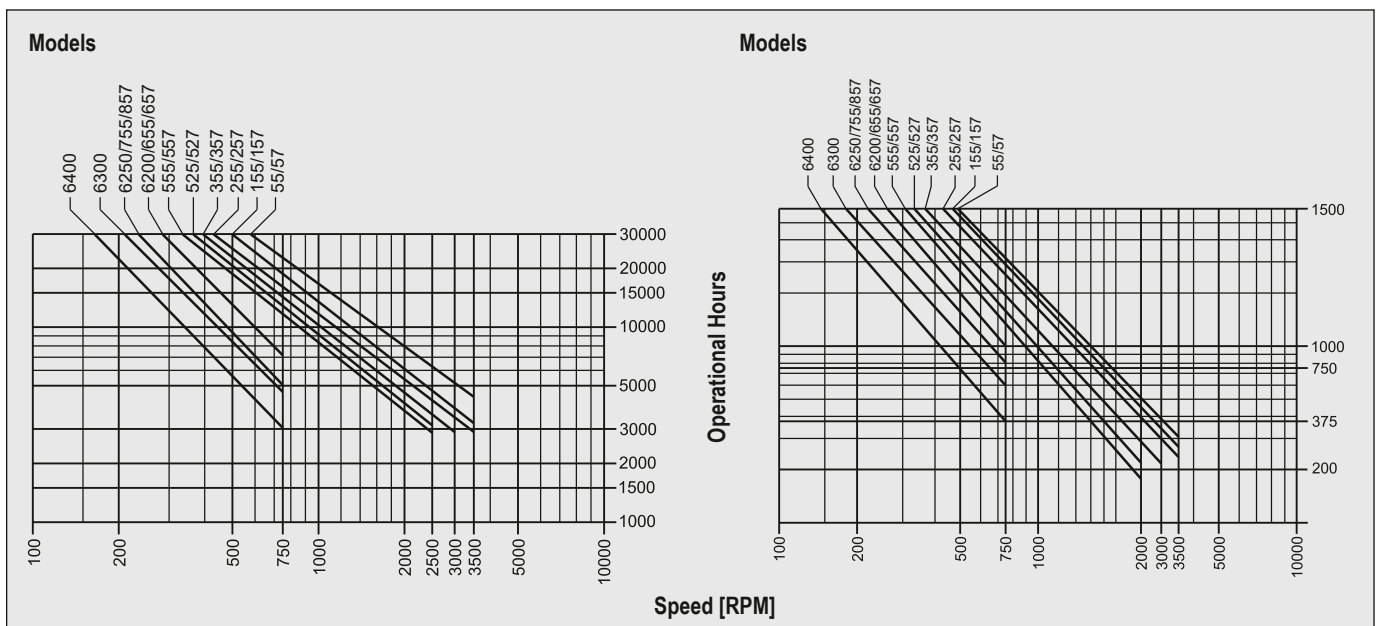
Relubrication Interval

Light Service

Temperatures up to 75 °C
little, if any, vibration or moisture (humidity)

Moderate Service

Temperatures 75 °C - 120 °C
some vibration and moisture present



Tightening Torque for Rotors

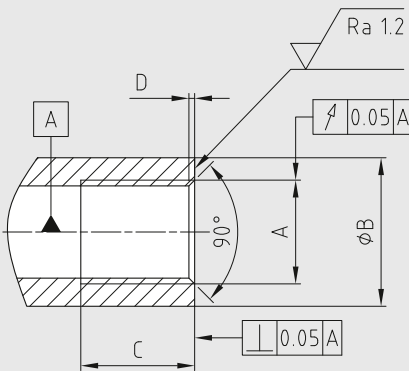
| Rotor Thread | Tightening Torque [Nm] | Operating Pressure [bar] |
|----------------|------------------------|--------------------------|
| 5/16 - 24 UNF | 5 | 70 |
| 3/8 - 24 UNF | 7 | 70 |
| 7/16 - 20 UNF | 10 | 70 |
| 9/16 - 20 UNF | 20 | 70 |
| 5/8 - 18 UNF | 35 | 70 |
| 3/4 - 16 UNF | 40 | 50 |
| 1 - 14 UNS | 90 | 50 |
| 1 1/4 - 12 UNF | 170 | 50 |
| G 1/8 A | 10 | 105 |
| G 1/4 A | 15 | 105 |
| G 3/8 A | 25 | 50 |
| G 1/2 A | 50 | 50 |
| G 3/4 A | 100 | 50 |
| G 1 A | 150 | 50 |
| G 1 1/4 A | 200 | 50 |
| G 1 1/2 A | 250 | 50 |
| G 2 A | 300 | 14 |
| G 2 1/2 A | 350 | 14 |
| G 3 A | 400 | 10 |

| Rotor Thread | Tightening Torque [Nm] | Operating Pressure [bar] |
|--------------|------------------------|--------------------------|
| M 8x1 | 4 | 140 |
| M 10x1 | 10 | 105 |
| M 12x1 | 15 | 140 |
| M 12x1.25 | 15 | 140 |
| M 12x1.5 | 15 | 140 |
| M 12x1.75 | 15 | 70 |
| M 14x1.5 | 25 | 70 |
| M 15x1 | 30 | 140 |
| M 16x2 | 35 | 70 |
| M 16x1.5 | 35 | 140 |
| M 18x1 | 40 | 70 |
| M 20x2.5 | 50 | 10 |
| M 20x1.5 | 50 | 50 |
| M 22x1.5 | 80 | 70 |
| M 27x1.5 | 115 | 50 |
| M 35x1.5 | 250 | 50 |
| M 50x1.5 | 350 | 50 |
| M 65x1.5 | 350 | 10 |

Note: Tightening torques correspond to shaft made from steel and apply for elastomer sealed rotors.

Exception: Rotors with British Standard Pipe Thread (G 1/8 A thru G 3A), normally sealed with gaskets per DIN 7603.

Installation of Deublin Series 55/57 Rotary Unions to customers interface / spindle end



| DN | Rotor Mounting Thread A | Min. Sealing contact ØB [mm] | Min. Screw-in depth C [mm] | Max. depth of Counterbore D [mm] |
|----|-------------------------|------------------------------|----------------------------|----------------------------------|
| 10 | G 3/8 | 25 | 20 | 1.1 |
| 15 | G 1/2 | 30 | 23 | 1.5 |
| 20 | G 3/4 | 37 | 23 | 1.5 |
| 25 | G 1 | 43 | 26 | 1.8 |
| 32 | G 1 1/4 | 53 | 32 | 1.8 |
| 40 | G 1 1/2 | 59 | 33 | 1.8 |
| 50 | G 2 | 75 | 33 | 1.8 |

Tightening Torque for Housings

| B Port Thread | Material of Housing or Endcap | | |
|------------------------|-------------------------------|-----------------|-----------------|
| | Brass | Aluminium Alloy | Stainless Steel |
| Tightening Torque [Nm] | | | |
| G 1/8 | 5 | 10 | 15 |
| G 1/4 | 10 | 15 | 25 |
| G 3/8 | 25 | 30 | 50 |
| G 1/2 | 50 | 80 | 125 |
| G 3/4 | 100 | 120 | 200 |
| G 1 | 150 | 300 | 400 |
| G 1 1/4 | 200 | 350 | 500 |
| G 1 1/2 | 250 | 400 | 600 |
| G 2 | 300 | 400 | 400 |
| G 2 1/2 | 400 | 400 | 400 |

Note: The tightening torques correspond to fittings sealed with gaskets per DIN 7603.

Tightening of fittings with NPT thread using the FFFT method

- Wrap the thread of the fitting in clockwise direction, beginning from thread end, with 1½ to 2 turns of Teflon tape. If any sealing compound is used, the first one or two thread pitches, beginning thread end, must remain untreated.
- Screw in the fitting firmly, finger-tight.
- Apply, with a waterproof marker a longitudinal marking onto any flat of the hexagon. Continue the marking on housing or endcap surface.
- Tighten the fitting further with a wrench by using the FFFT method (= Flats From Finger Tight) for the necessary number of flats (see table on the right).

Attention! Never untighten the pipe fitting to achieve any adjustment!

Between 3½ to 6 thread pitches must be engaged.
Any deviation indicates too lighter tightening or overtightened screw joint or thread beyond allowed tolerance limits.

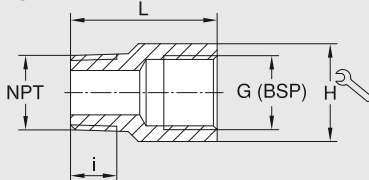
In case of too light tightened screw joints, retightening up to maximum one turn is permissible.

| Thread Size NPT | Number of Flats (FFFT) |
|-----------------|------------------------|
| 1/8 - 27 | 2.0 - 3.0 |
| 1/4 - 18 | 2.0 - 3.0 |
| 3/8 - 18 | 2.0 - 3.0 |
| 1/2 - 14 | 2.0 - 3.0 |
| 3/4 - 14 | 2.0 - 3.0 |
| 1 - 11½ | 1.5 - 2.5 |
| 1¼ - 11½ | 1.5 - 2.5 |
| 1½ - 11½ | 1.5 - 2.5 |
| 2 - 11½ | 1.5 - 2.5 |

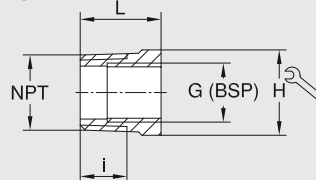
NPT → G (BSP) Stainless Steel Adapters

Deublin Rotary Unions are equipped with G (BSP) and NPT hose connections. Due to worldwide interchangeability our adapters allow the fitting of hoses with the appropriate NPT or G (BSP) threads.

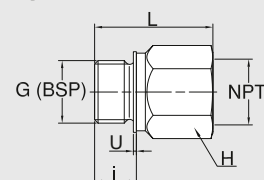
Type A



Type B



Type C



NPT → G (BSP)

| Ordering No. | NPT | G (BSP) | L | i | H | Type |
|--------------|-----|---------|----|------|----|------|
| 6301-012 | 1/8 | 1/4 | 28 | 6.7 | 17 | A |
| 6301-022 | 1/4 | 1/4 | 31 | 10.2 | 17 | A |
| 6301-032 | 3/8 | 1/4 | 18 | 10.4 | 19 | B |
| 6301-033 | 3/8 | 3/8 | 33 | 10.4 | 22 | A |
| 6301-042 | 1/2 | 1/4 | 24 | 13.6 | 22 | B |
| 6301-043 | 1/2 | 3/8 | 28 | 13.6 | 22 | B |
| 6301-044 | 1/2 | 1/2 | 37 | 13.6 | 27 | A |
| 6301-054 | 3/4 | 1/2 | 26 | 13.9 | 27 | B |
| 6301-055 | 3/4 | 3/4 | 41 | 13.9 | 32 | A |
| 6301-064 | 1 | 1/2 | 31 | 17.3 | 36 | B |

| Ordering No. | NPT | G (BSP) | L | i | H | Type |
|--------------|-----|---------|----|------|----|------|
| 6301-065 | 1 | 3/4 | 31 | 17.3 | 36 | B |
| 6301-066 | 1 | 1 | 48 | 17.3 | 41 | A |
| 6301-075 | 1¼ | 3/4 | 30 | 18 | 46 | B |
| 6301-077 | 1¼ | 1¼ | 51 | 18 | 50 | A |
| 6301-085 | 1½ | 3/4 | 34 | 18.4 | 50 | B |
| 6301-088 | 1½ | 1½ | 53 | 18.4 | 55 | A |
| 6301-097 | 2 | 1¼ | 50 | 19.2 | 65 | B |
| 6301-099 | 2 | 2 | 70 | 19.2 | 65 | A |
| 6301-108 | 2½ | 1½ | 80 | 22.5 | 75 | B |
| 6301-1010 | 2½ | 2½ | 80 | 22.5 | 90 | A |

G (BSP) → NPT

| Ordering No. | G (BSP) | NPT | L | i | H | U |
|--------------|---------|-----|----|----|----|-----|
| 6301-133 | 3/8 | 3/8 | 33 | 12 | 22 | 1.5 |
| 6301-144 | 1/2 | 1/2 | 40 | 14 | 27 | 1.5 |
| 6301-155 | 3/4 | 3/4 | 42 | 16 | 32 | 2 |

Vent Hole Fittings for the 57 Series

| Ordering No. | Fitting | Description |
|--------------|----------------|--|
| 55-617 | Vent Hole Plug | Plug |
| 55-591 | Vent Cartridge | Push-to-Connect Tube Fitting for 6mm Tube |
| 6075-201 | Vent Cartridge | Push-to-Connect Tube Fitting for 1/4 inch Tube |

Important Information

A Deublin Rotary Union is a precision-made piece of equipment and must be handled accordingly. Sealing between the rotating device – rotor – and the static device – stator – is mainly accomplished via floating seals. Improper use could result in premature leakage or failure.

Although Deublin Rotary Unions are of the highest quality and precision they are, by their very nature, a “wear and tear” product. It’s important that they should be inspected periodically. Moreover, when seals wear out, the Rotary Union must be replaced or serviced to avoid subsequent leakage. Once a union begins to leak, it is paramount that the union be serviced immediately. Never work with leaking unions!

Deublin Rotary Unions must never be used for applications other than those specified in the catalogue. It is strictly prohibited to use Deublin Rotary Unions with hydrocarbons or other flammable media as leakage may result in a fire or explosion. The use of our product on exotic or corrosive media is strictly prohibited without our prior approval. For applications other than those stated in the catalogue, Deublin Engineering Department should be contacted for proper instructions. These instructions are provided by Deublin as general guidelines and do not contain exhaustive information about the installation, use or maintenance of unions.

Operating instructions and installation manuals are available for Deublin products. Buyers and users of Deublin Rotary Unions should be certain that they have reviewed all of Deublin’s product information. The operating and installation instructions must be strictly followed when installing Deublin Rotary Unions.

Factory Testing

All Deublin Rotary Unions are factory-tested under pressure prior to shipment. This thorough check ensures that each single Deublin Union is completely operational when you receive it and can – in most cases – be installed with no further consideration.

Warranty

The buyer’s warranty rights assume that the product shipped be inspected upon receipt and all defects reported to Deublin in writing immediately or for no longer than a period of 2 weeks. Hidden defects must be reported to Deublin in writing immediately upon detection. The warranty is void when the Deublin Rotary Union is tampered with or misused in any way. Otherwise, our General Terms of Sale and Delivery are valid. It cannot be emphasised enough that all dynamic seal components are wear parts.

Deublin will not be held liable for damage resulting from improper use, incorrect warehousing, incorrect transport, faulty assembly, faulty operation, insufficient maintenance, incorrect handling, improper installation by the customer, the use of inappropriate accessories or spare parts and natural abrasion. Please request our General Terms of Sale and Delivery.

Lubrication and Maintenance

Depending on the Deublin product series and the operating parameters all Deublin Rotary Unions are either lubricated for life or have to be relubricated or serviced according to specially defined intervals. Please follow the respective operating instructions or the general “Relubrication Guide” for Deublin Rotary Unions.

Filtering

The service life of the seal is largely determined by filter quality and thus of vital importance for the proper operation of the Rotary Union. We recommend filtration of min. 60 µm. All installation and operating instructions must be carefully reviewed and strictly followed.

Service and Maintenance of Deublin Rotary Unions by Deublin

Use only Deublin spare parts for service of the Deublin Rotary Unions. Prior to service contact Deublin or any authorised Deublin representative. You can find a local Deublin representative at: www.deublin.com.

Most unions can be reconditioned in the field by use of Deublin Service Kits. Generally, we recommend having the Deublin Rotary Unions serviced by Deublin. Service is available at all Deublin factories. Factory rebuilt Rotary Unions carry a “New-Union-Warranty”.

Tension-free Installation

When installing Rotary Unions, special attention has to be paid to a flexible and tension-free hose connection. For additional recommendation please refer to our installation instructions.

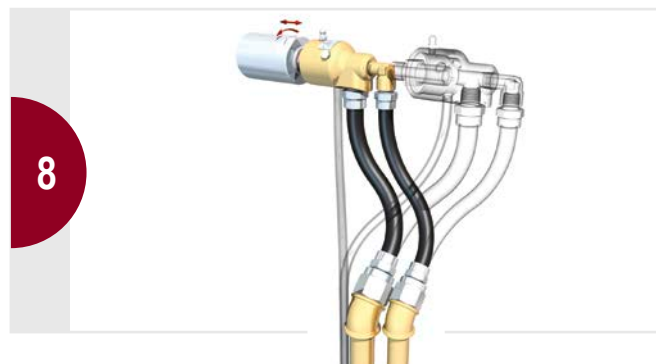
Warning

Deublin Rotary Unions should not be used to convey flammable media (flash point ≤ 140 °F or 60 °C) as leakage may result in explosions or fires. Deublin Rotary Unions should be used in accordance with standard safety guidelines for the media, and in a well-ventilated area. The use of our product on hazardous or corrosive media is strictly forbidden.

| | Units | Units of Measure in Common Use: | | | | | | | Conversion Factors |
|--------------------|------------|---------------------------------|-------------------|--------|-------|-------|-------------------|-------------------|--|
| | St | USA | D | E | F | I | NL | S | |
| Speed | 1/s | RPM | min ⁻¹ | r.p.m. | t/min | g/min | min ⁻¹ | min ⁻¹ | 1 RPM = min ⁻¹ = 1/60 h |
| Temperature | K (Kelvin) | °F | °C | °C | °C | °C | °C | °C | (°F-32) 5/9 ≅ °C ≅ K+273 |
| Pressure | Pa | PSI | bar | bar | bar | bar | bar | bar | 14.5 PSI ≅ 1 bar ≅ 1.02 kg/cm ² ≅ 100 kPa |
| Vacuum | Pa | "Hg | kPa | cmHg | cmHg | kPa | bara | kPa | 28" Hg (Vac) ≅ 28" Hg ≅ 5.08 cmHg ≅ 6.75 kPa ≅ 0.07 bara |
| Weight | kg | # (lbs) | kg | kg | kg | kg | kg | kg | 2.2 # ≅ 1.0 kg |

Instructions of Hose Installation and Assembly of Deublin Rotary Unions

Example Rotary Union 57 Series



NOTES

A large grid of dotted lines for taking notes, covering most of the page below the 'NOTES' header.

Since its founding in 1945 as a small, family-owned business, Deublin consistently has adhered to a policy of designing and building the best products of their kind in the world. The result of this policy has been continuous growth through the years, and for this we are grateful to our many loyal customers.

Today, Deublin is the world's largest manufacturer of Rotary Unions, with state-of-the-art factories, technical sales and service, and local stocking in 13 countries on four continents, as well as a worldwide distribution network operating in more than 60 countries. Our global organization and extensive catalog of field-tested products ensure a precise match between each customer's requirements and an engineered solution. Deublin has been part of the HOERBIGER Group since 2019 and forms the core of the Rotary Solutions division.

We cordially invite you to visit our modern manufacturing facilities in Waukegan, Illinois, USA; Mainz, Germany; Monteveglio, Italy; Dalian, China; and Sao Paulo, Brazil.



Our Global Headquarters in Waukegan, Illinois, U.S.A.



Mainz, Germany



Monteveglio (Bo), Italy



Dalian, China



Diadema, Brasil

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AMERICA

DEUBLIN USA

2050 Norman Drive
Waukegan, IL 60085-6747 U.S.A
Phone: +1 847-689 8600
Fax: +1 847-689 8690
E-Mail: info-us@deublin.com

DEUBLIN Brazil

Av. Fagundes de Oliveira, 538 – A10 / A11 -
Piraporinha
CEP: 09950-300 - Diadema - SP - Brasil
Phone: +55 11-2455 3245
Fax: +55 11-2455 2358
E-Mail: info-br@deublin.com

ASIA

DEUBLIN China

No. 2, 6th DD Street,
DD Port Dalian, 116620, China
Phone: +86 411-8754 9678
Fax: +86 411-8754 9679
E-Mail: info-cn@deublin.com

Room 15A07, Wangjiao Plaza
No. 175 East Yan'an Road, Huangpu District
Shanghai 200002
Phone: +86 21-5298 0791
Fax: +86 21-5298 0790
E-Mail: info-cn@deublin.com

DEUBLIN Asia Pacific

7 Temasek Boulevard #21-05
Suntec Tower One, Singapore 038987
Phone: +65 6259-92 25
Fax: +65 6259-97 23
E-Mail: info-sg@deublin.com

DEUBLIN Japan

2-13-1, Minamihanayashiki, Kawanishi City
Hyogo 666-0026, Japan
Phone: +81 72-757 0099
Fax: +81 72-757 0120
E-Mail: info-jp@deublin.com

2-4-10-3F, Ryogoku, Sumida-ku
Tokyo 130-0026, Japan
Phone: +81 35-625 0777
Fax: +81 35-625 0888
E-Mail: info-jp@deublin.com

4-1-13-201 Sakae
Ichinomiya, Aichi 491-0858, Japan
Phone: +81 586-73 0222
Fax: +81 586-73 0223
E-Mail: info-jp@deublin.com

DEUBLIN Korea

Star Tower #1003, Sangdaewon-dong 223-25,
Jungwon-gu, Seongnam-si, Gyeonggi-do,
South Korea
Phone: +82 31-8018 5777
Fax: +82 31-8018 5780
E-Mail: info-kr@deublin.com

EUROPE

DEUBLIN Germany

Florenz-Allee 1
55129 Mainz, Germany
Phone: +49 6131-49980
E-Mail: info-de@deublin.com

DEUBLIN Italy

Via Guido Rossa 9 - Loc. Monteveglio
40053 Comune di Valsamoggia (BO), Italy
Phone: +39 051-835611
Fax: +39 051-832091
E-Mail: info-it@deublin.com

DEUBLIN Austria

Lainzer Straße 35
1130 Wien, Austria
Phone: +43 1-8768450
Fax: +43 1-876845030
E-Mail: info-at@deublin.com

DEUBLIN France

61 Bis, Avenue de l'Europe
Z.A.C de la Malnoue
77184 Emerainville, France
Phone: +33 1-64616161
Fax: +33 1-64616364
E-Mail: info-fr@deublin.com

DEUBLIN Poland

ul. Bierutowaska 57-59
51-317 Wrocław, Poland
Phone: +48 71-3528152
Fax: +48 71-3207306
E-Mail: info-pl@deublin.com

DEUBLIN Spain

C/ Lola Anglada, 20
08228 Les Fonts (Terrassa), Spain
Phone: +34 93-221 1223
E-Mail: info-es@deublin.com

DEUBLIN United Kingdom

6 Sopwith Park, Royce Close, West Portway
Andover SP10 3TS, UK
Phone: +44 1264-33 3355
Fax: +44 1264-33 3304
E-Mail: info-uk@deublin.com



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