

DEUBLIN

General Purpose 55 Series Unions

- Monoflow and duoflow design
- Self-supported rotating union
- Radial housing connection
- Balanced mechanical seal
- 3 vent holes
- Forged brass housing
- Stainless steel rotor
- Special options:
threaded vent holes,
low torque design
- Lubrication Guide page 55



Operating Data

Maximum Water Pressure	Model 55-555	750 PSI	50 bar
Maximum Water Pressure	Model 655	600 PSI	41 bar
Maximum Saturated Steam Pressure (Intermittent)		15 PSI	1 bar
Maximum Hot Oil Pressure		100 PSI	6.6 bar
Maximum Speed NPT Threads	Model 55-555	1,500 RPM	1,500/min
	Model 655	750 RPM	750/min
Maximum Speed Straight Threads			
	Model 55-255	3,500 RPM	3,500/min
	Model 355	3,000 RPM	3,000/min
	Model 525-555	2,500 RPM	2,500/min
	Model 655	750 RPM	750/min

Maximum Temperature

250°F

>250°F consult **DEUBLIN**

Seal Combinations

- Carbon Graphite/Bronze for water - Standard
- Carbon Graphite/Ceramic for hot oil, hot water and saturated steam - Optional
- Multi-purpose applications

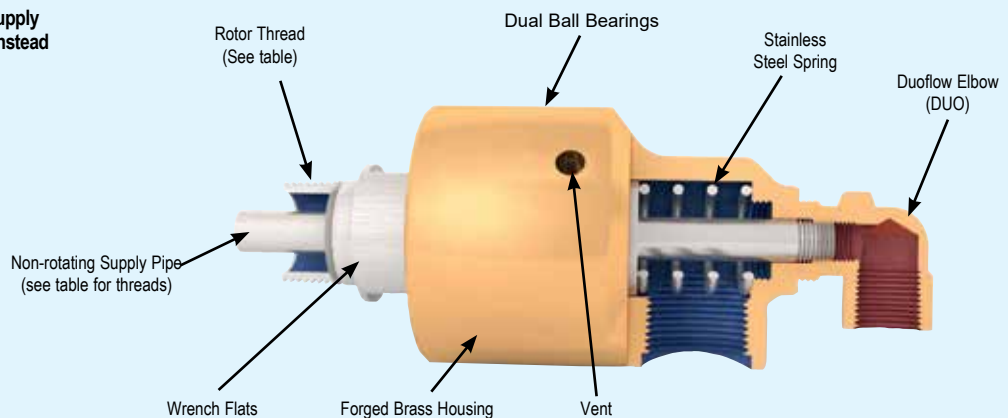
Seal Combination - E.L.S.

- Tungsten Carbide/Ceramic for severe conditions (poor water quality), max. temperature 200°F

Torque Ratings 55 Series

Size	ft.lbs	Nm
55	¼	0.34
155	⅜	0.50
255	½	0.68
355	1½	1.80
525	1½	1.80
555	2½	3.40
655	3	4.07

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



DEUBLIN

57 Series with Silicon Carbide Seals, for Water Service



- Monoflow and duoflow design
- Self-supported rotating union
- Radial housing connection
- Balanced mechanical seal
- Keyed rotor seal
- Easy and quick replacement of sealing components (rotor seal, floating seal)
- Ball bearings lubricated for life
- For poor water quality (E.L.S.)
- 3 vent holes
- Forged brass housing
- Stainless steel rotor
- Special options:
threaded vent holes

Operating Data

Maximum Water Pressure		150 PSI	10 bar
Maximum Speed NPT Threads	Model 57-557	1,500 RPM	1,500/min
	Model 657	750 RPM	750/min
Maximum Speed Straight Threads			
	Model 57-257	3,500 RPM	3,500/min
	Model 357	3,000 RPM	3,000/min
	Model 527-557	2,500 RPM	2,500/min
	Model 657	750 RPM	750/min

Maximum Water Temperature 200°F >200°F consult **DEUBLIN**

Seal Combination

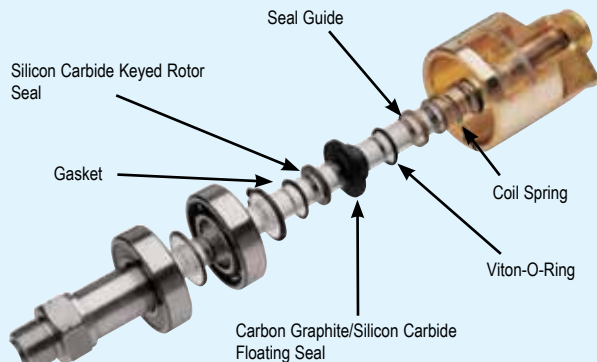
- Carbon Graphite/Silicon Carbide - Standard

Seal Combination - E.L.S.

- Silicon Carbide/Silicon Carbide for severe conditions (poor water quality)

Torque Ratings 57 Series

Size	ft.lbs	Nm
57	¼	0.25
157	½	0.50
257	¾	1.00
357	1½	2.00
527	1½	2.20
557	2¼	2.90
657	3½	4.50



Union Repair

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.

For Ordering Number of Repair Kit see page 5.

55 & 57 Series Monoflow Union Specifications

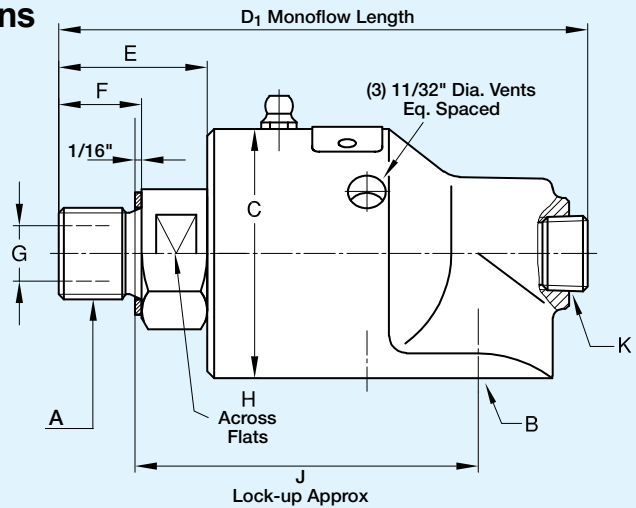


Chart Instructions

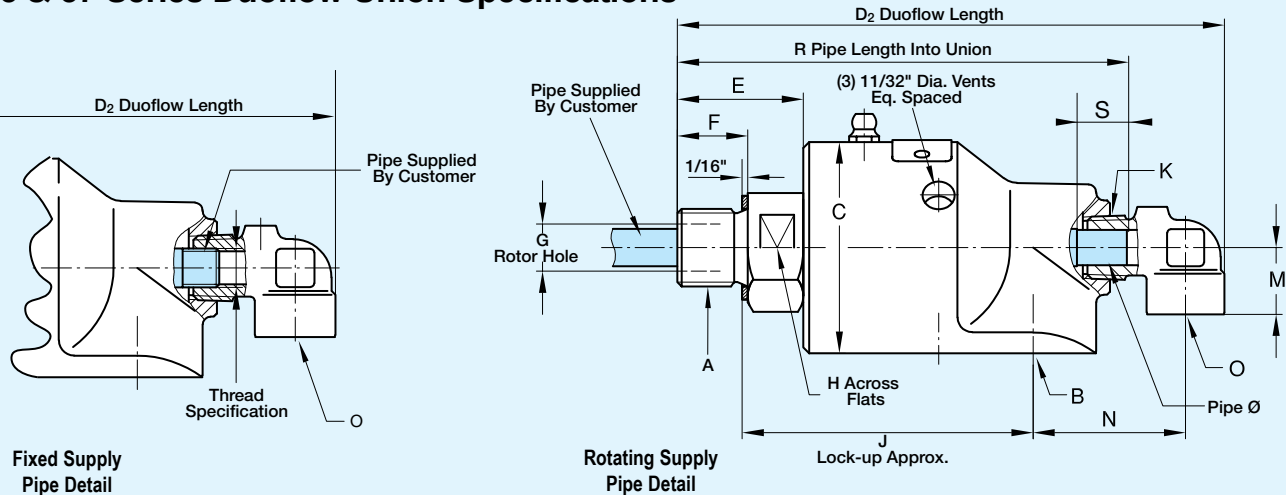
Select Union Size and Rotor Thread. Follow this line to opposite page to find Duoflow Elbow Specifications. Add Duoflow Elbow Suffix to the end of the Ordering Number.

† Recessed O-Ring in Rotor End in Place of Copper Gasket

B Port NPT	Ordering Number				A* Rotor Thread	C	D ₁	D ₂	E	F	G	H**	J
	55 Series All Purpose	55 Series E.L.S.	57 Series Water Service	57 Series E.L.S.									
3/8"	55-000-001	55-147-151	57-000-001	57-050-001	3/8" NPT RH	1 3/4"	3 15/16"	4 13/16"	1"	5/8"	3/8"	22	2 11/16"
	55-000-002	55-147-152	57-000-002	57-050-002	3/8" NPT LH	1 3/4"	3 15/16"	4 13/16"	1"	5/8"	3/8"	22	2 11/16"
	55-000-003	55-147-149	57-000-003	57-050-003	5/8"-18 UNF RH	1 3/4"	3 15/16"	4 13/16"	1"	5/8"	3/8"	22	2 1/2"
	55-000-004	55-147-150	57-000-004	57-050-004	5/8"-18 UNF LH	1 3/4"	3 15/16"	4 13/16"	1"	5/8"	3/8"	22	2 1/2"
	55-000-094	55-147-192	57-000-094	57-050-094	G 3/8" (BSP) RH	44.5	102	123	26	16	9.5	22	63
55-000-095	55-147-193	57-000-095	57-050-095	G 3/8" (BSP) LH	44.5	102	123	26	16	9.5	22	63	
1/2"	155-000-001	155-208-113	157-000-001	157-050-001	1/2" NPT RH	2 1/4"	4 13/16"	5 7/8"	1 1/16"	7/8"	1/2"	30	3 1/2"
	155-000-002	155-208-114	157-000-002	157-050-002	1/2" NPT LH	2 1/4"	4 13/16"	5 7/8"	1 1/16"	7/8"	1/2"	30	3 1/2"
	155-000-021	155-208-185	157-000-021	157-050-021	3/4"-16 UNF RH	2 1/4"	4 11/16"	5 3/4"	1 5/16"	3/4"	1/2"	30	3 1/16"
	155-000-022	155-208-229	157-000-022	157-050-022	3/4"-16 UNF LH	2 1/4"	4 11/16"	5 3/4"	1 5/16"	3/4"	1/2"	30	3 1/16"
	155-000-151	155-208-252	157-000-151	157-050-151	G 1/2" (BSP) RH	57.2	120	148	34	19	12.7	30	78
	155-000-152	155-208-253	157-000-152	157-050-152	G 1/2" (BSP) LH	57.2	120	148	34	19	12.7	30	78
3/4"	255-000-020	255-052-255	257-000-020	257-050-020	3/4" NPT RH	2 7/8"	5 5/16"	6 3/4"	1 1/16"	7/8"	1 1/16"	32	4 1/16"
	255-000-021	255-052-256	257-000-021	257-050-021	3/4" NPT LH	2 7/8"	5 5/16"	6 3/4"	1 1/16"	7/8"	1 1/16"	32	4 1/16"
	255-000-003	255-052-258	257-000-135†	257-050-135†	1"-14 UNS RH	2 7/8"	5 7/16"	6 5/8"	1 5/16"	3/4"	2 1/32"	32	3 11/16"
	255-000-027	255-052-257	257-000-136†	257-050-136†	1"-14 UNS LH	2 7/8"	5 7/16"	6 5/8"	1 5/16"	3/4"	2 1/32"	32	3 11/16"
	255-000-284	255-052-445	257-000-284	257-050-284	G 3/4" (BSP) RH	73	138	168	34	19	17.5	36	94
255-000-285	255-052-446	257-000-285	257-050-285	G 3/4" (BSP) LH	73	138	168	34	19	17.5	36	94	
1"	355-000-002	355-064-186	357-000-002	357-050-002	1" NPT RH	3 1/4"	6 13/16"	8 5/16"	1 15/16"	1 1/8"	1"	36	4 11/16"
	355-000-003	355-064-187	357-000-003	357-050-003	1" NPT LH	3 1/4"	6 13/16"	8 5/16"	1 15/16"	1 1/8"	1"	36	4 11/16"
	355-000-019	355-064-328	357-000-019	357-050-019	1 1/2"-12 UNF RH	3 1/4"	6 13/16"	8 5/16"	1 15/16"	1 1/8"	1"	36	4 1/4"
	355-000-074	355-064-329	357-000-074	357-050-074	1 1/2"-12 UNF LH	3 1/4"	6 13/16"	8 5/16"	1 15/16"	1 1/8"	1"	36	4 1/4"
	355-000-222	355-064-378	357-000-222	357-050-222	G 1" (BSP) RH	83	166	204	42	21.5	22.2	36	108
	355-000-223	355-064-379	357-000-223	357-050-223	G 1" (BSP) LH	83	166	204	42	21.5	22.2	36	108
1 1/4"	525-000-001	525-097-043	527-000-001	527-050-001	1 1/4" NPT RH	3 5/8"	7 7/16"	9 3/8"	2 3/16"	1 1/8"	1 1/4"	46	5 1/4"
	525-000-002	525-097-044	527-000-002	527-050-002	1 1/4" NPT LH	3 5/8"	7 7/16"	9 3/8"	2 3/16"	1 1/8"	1 1/4"	46	5 1/4"
	525-000-026	525-097-095	527-000-026	527-050-026	1 3/4"-12 UN RH	3 5/8"	7 7/16"	9 3/8"	2 3/16"	1 1/8"	1 1/4"	46	4 11/16"
	525-000-027	525-097-096	527-000-027	527-050-027	1 3/4"-12 UN LH	3 5/8"	7 7/16"	9 3/8"	2 3/16"	1 1/8"	1 1/4"	46	4 11/16"
	525-000-054	525-097-122	527-000-054	527-050-054	G 1 1/4" (BSP) RH	90.5	191	234	54	27	30.2	46	119
525-000-055	525-097-123	527-000-055	527-050-055	G 1 1/4" (BSP) LH	90.5	191	234	54	27	30.2	46	119	
1 1/2"	555-000-001	555-033-154	557-000-001	557-050-001	1 1/2" NPT RH	4 1/4"	8 1/2"	10 5/16"	2 7/16"	1 3/8"	1 1/2"	55	6"
	555-000-002	555-033-160	557-000-002	557-050-002	1 1/2" NPT LH	4 1/4"	8 1/2"	10 5/16"	2 7/16"	1 3/8"	1 1/2"	55	6"
	555-000-395	555-033-399	557-000-395	557-050-395	2"-12 UN RH	4 1/4"	8 7/8"	10 11/16"	2 13/16"	1 1/8"	1 1/2"	55	5 13/16"
	555-000-396	555-033-382	557-000-396	557-050-396	2"-12 UN LH	4 1/4"	8 7/8"	10 11/16"	2 13/16"	1 1/8"	1 1/2"	55	5 13/16"
	555-000-198	555-033-288	557-000-198	557-050-198	G 1 1/2" (BSP) RH	108	225	268	71	29	35	55	147
	555-000-199	555-033-289	557-000-199	557-050-199	G 1 1/2" (BSP) LH	108	225	268	71	29	35	55	147
2"	655-500-116	655-502-116	657-000-116	657-050-116	2" NPT RH	4 5/8"	10 1/16"	11 3/4"	3"	1 1/2"	1 7/8"	60	7"
	655-500-117	655-502-117	657-000-117	657-050-117	2" NPT LH	4 5/8"	10 1/16"	11 3/4"	3"	1 1/2"	1 7/8"	60	7"
	655-500-124	655-502-124	657-000-124	657-050-124	G 2" (BSP) RH	117	246	289	65	28.6	47	60	164
	655-500-125	655-502-125	657-000-125	657-050-125	G 2" (BSP) LH	117	246	289	65	28.6	47	60	164

*Metric threads and other thread sizes are available. Contact factory for further information. For 2", 2 1/2", 3", 4" and 5" capacity unions refer to pages 11-13 and 16-20. **Metric

55 & 57 Series Duoflow Union Specifications



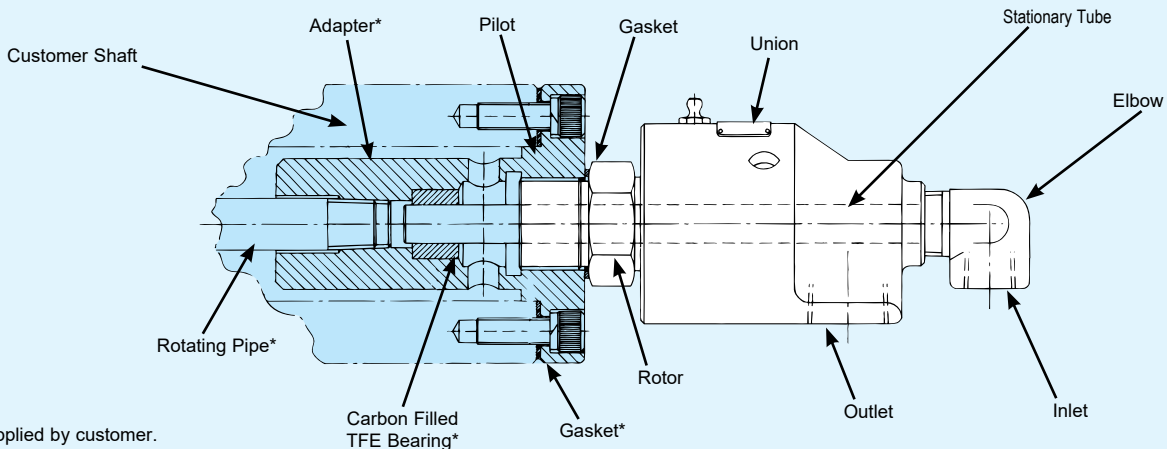
For Description See Page 10

Fixed Supply Pipe			Fixed Supply Tube			Rotating Supply Pipe									
Elbow Suffix	Thread	R	Elbow Suffix	Tube OD	R	Elbow Suffix	Pipe Size	Pipe Dia.	S	R	K NPT	M	N	O NPT	Shpg. Wt.
—	—	—	-030	.250"	4 ³ / ₁₆ "	—	—	—	—	—	1/4"	1 ¹ / ₁₆ "	1 ³ / ₁₆ "	1/4"	2#
—	—	—	-030	.250"	4 ³ / ₁₆ "	—	—	—	—	—	1/4"	1 ¹ / ₁₆ "	1 ³ / ₁₆ "	1/4"	2#
-120	M6X1	98.5	—	—	—	—	—	—	—	—	1/4"	18	35	1/4"	0.9 Kg
-012	1/8" NPT	4 ³ / ₄ "	-061	.375"	5 ⁵ / ₁₆ "	—	—	—	—	—	3/8"	1 ¹ / ₁₆ "	1 ¹ / ₂ "	3/8"	3#
-012	1/8" NPT	4 ³ / ₄ "	-061	.375"	5 ⁵ / ₁₆ "	-061	1/8"	.371" .370"	1 ¹ / ₁₆ "	5"	3/8"	1 ¹ / ₁₆ "	1 ¹ / ₂ "	3/8"	3#
-199	G ¹ / ₂ " (BSP)	117	—	—	—	-471	—	9.93 9.90	30	127	3/8"	18	38	3/8"	1.4 Kg
-043	1/4" NPT	5 ¹ / ₄ "	-075	.500"	5 ¹³ / ₁₆ "	—	—	—	—	—	1/2"	1"	1 ³ / ₄ "	1/2"	5#
-044	1/8" NPT	5 ¹ / ₄ "	-026	.437"		—	—	—	—	—	—	1/2"	1"	1 ³ / ₄ "	1/2"
-043	1/4" NPT	5 ¹ / ₄ "	-075	.500"	5 ¹³ / ₁₆ "	-075	1/4"	.496" .495"	1 ¹ / ₄ "	5 ¹¹ / ₁₆ "	1/2"	1"	1 ³ / ₄ "	1/2"	5#
-044	1/8" NPT	5"	-026	.437"		-075	1/4"	.496" .495"	1 ¹ / ₄ "	5 ¹¹ / ₁₆ "	1/2"	1"	1 ³ / ₄ "	1/2"	5#
-368	G ¹ / ₄ " (BSP)	136.5	—	—	—	-681	—	12.95 12.90	31	146.5	1/2"	26	45	1/2"	2.3 Kg
-367	G ³ / ₈ " (BSP)	132.5	—	—	—	—	—	—	—	—	—	—	—	—	—
-083	3/8" NPT	7 ¹ / ₁₆ "	-163	.625"	7 ⁷ / ₈ "	—	—	—	—	—	3/4"	1 ¹ / ₁₆ "	2 ⁵ / ₁₆ "	1/2"	8#
-084	1/2" NPT	7"				—	—	—	—	—	—	—	3/4"	1 ¹ / ₁₆ "	2 ⁵ / ₁₆ "
-083	3/8" NPT	7 ¹ / ₁₆ "	-163	.625"	7 ⁷ / ₈ "	-163	3/8"	.621" .619"	1 ¹ / ₄ "	7"	3/4"	1 ¹ / ₁₆ "	2 ⁵ / ₁₆ "	1/2"	8#
-084	1/4" NPT	7"				—	—	—	—	—	—	—	—	—	—
-255	G ³ / ₈ " (BSP)	162	—	—	—	-347	—	15.95 15.90	31	175	3/4"	27	59	1/2"	3.6 Kg
-007	1/2" NPT	8 ¹ / ₈ "	-104	.750"	8 ¹ / ₄ "	—	—	—	—	—	1"	1 ¹ / ₈ "	2 ¹ / ₁₆ "	3/4"	10#
-007	1/2" NPT	8 ¹ / ₈ "	-104	.750"	8 ¹ / ₄ "	-104	1/2"	.745" .743"	1 ¹ / ₂ "	8 ³ / ₁₆ "	1"	1 ¹ / ₈ "	2 ¹ / ₁₆ "	3/4"	10#
-079	G ¹ / ₂ " (BSP)	185.5	—	—	—	-237	—	21.94 21.89	38	201.5	1"	35	72	3/4"	4.5 Kg
-013	3/4" NPT	8 ¹ / ₁₆ "	-263	1.000"	9 ¹ / ₂ "	—	—	—	—	—	1 ¹ / ₄ "	1 ¹ / ₂ "	3 ¹ / ₁₆ "	3/4"	16#
-036	1/2" NPT	8 ¹ / ₂ "				—	—	—	—	—	—	—	—	1 ¹ / ₄ "	1 ¹ / ₂ "
-013	3/4" NPT	9 ¹ / ₁₆ "	-263	1.000"	9 ¹ / ₂ "	-144	3/4"	1.000" .998"	1 ³ / ₄ "	9 ⁵ / ₁₆ "	1 ¹ / ₄ "	1 ¹ / ₂ "	3 ¹ / ₁₆ "	3/4"	16#
-036	1/2" NPT	9 ¹ / ₂ "				—	—	—	—	—	—	—	—	—	—
-221	G ³ / ₄ " (BSP)	222	—	—	—	-468	—	25.91 25.81	44	244	1 ¹ / ₄ "	38	78	3/4"	7.2 Kg
-013	3/4" NPT	10 ¹ / ₄ "	-263	1.000"	10 ³ / ₈ "	—	—	—	—	—	1 ¹ / ₄ "	1 ¹ / ₂ "	3 ¹ / ₁₆ "	3/4"	17#
-183	1" NPT	10 ³ / ₈ "				—	—	—	—	—	—	—	—	1 ¹ / ₄ "	
-221	G ³ / ₄ " (BSP)	243	—	—	—	-468	—	25.91 25.81	44	250	1 ¹ / ₄ "	38	78	3/4"	7.7 Kg

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.

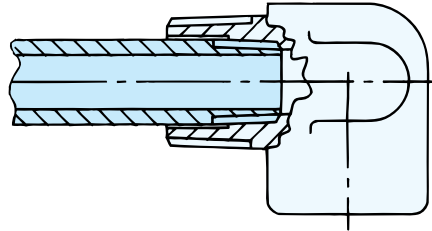
Where long pipes or high speeds are required, an adapter should be used to avoid transmitting stresses from heavy pipes, cascading water or vibrations to the union. A typical adapter is illustrated.



*Supplied by customer.

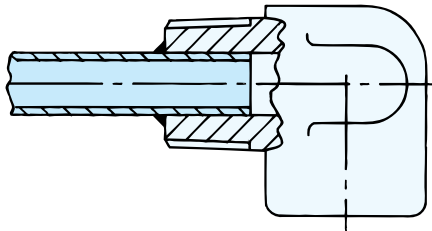
Threaded Pipe

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 ($4 \times D1$) and rotational speeds above 1000 RPM should be avoided.



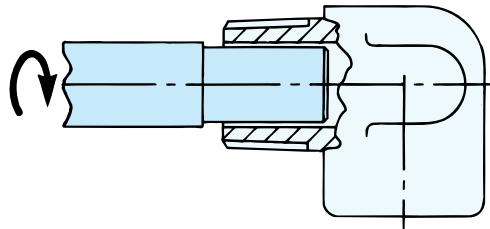
Fixed Tube

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 length is usually limited to 6 union lengths ($6 \times D1$). Speeds to 3500 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 1000 RPM should be avoided.





DEUBLIN

2 1/2" Field Repairable All Purpose Unions

- Monoflow and duoflow design
- Self-supported rotating union
- Radial housing connection
- Balanced mechanical seal
- 3 vent slots
- Cast iron housing - standard
Cast iron housing nickel-plated - optional
- Steel rotor
- Lubrication Guide page 55

Operating Data

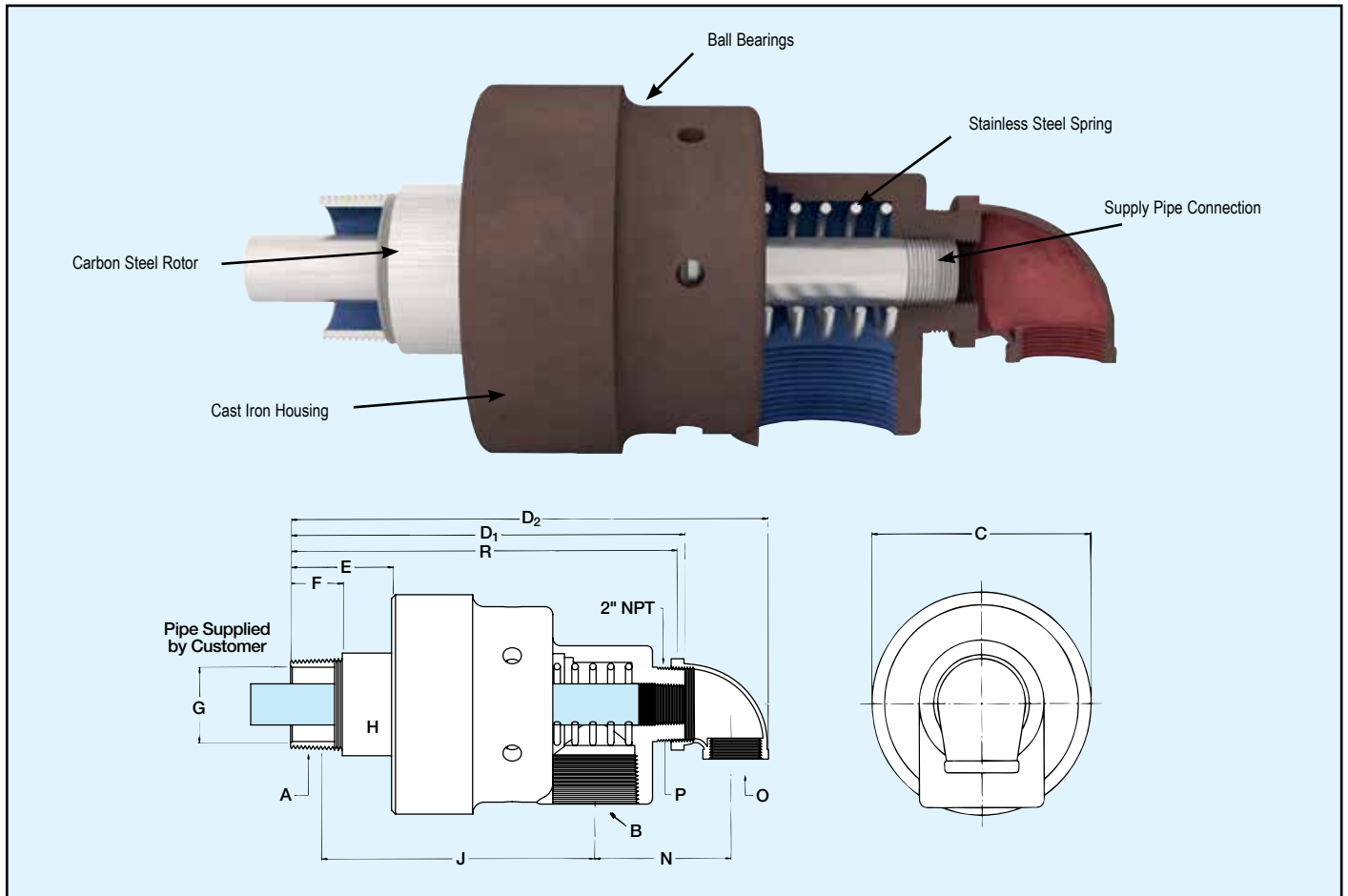
Maximum Water Pressure	200 PSI	14 bar
Maximum Saturated Steam Pressure (Intermittent)	15 PSI	1 bar
Maximum Speed	750 RPM	750/min
Torque at 120 PSI/8.2 bar	4 ft.lbs.	5.4 Nm
Maximum Temperature	250°F	>250°F consult DEUBLIN

Seal Combination

- Carbon Graphite/Tungsten Carbide - Standard

Seal Combination - E.L.S.

- Tungsten Carbide/Ceramic for severe conditions (poor water quality), max. temperature 200°F



B Port NPT	Ordering Number*		A Rotor Thread	C Dia.	D ₁	D ₂	E	F	G Rotor Hole	H Dia.	J Lock- up	N	O NPT	P NPT	R	Shpg. Wt.
	All Purpose	E.L.S.														
2 1/2"	755-700-413-117	755-701-413-117	2 1/2" NPT RH	7"	13 1/2"	15"	3/4"	1 7/8"	2 3/8"	3 3/2"	8 5/8"	4 1/4"	1 1/4"	1"	12 1/8"	44#
	755-700-415-117	755-701-415-117	2 1/2" NPT LH													
2 1/2"	755-700-330-117	755-701-330-117	G2 1/2" (BSP) RH	178	343	381	82.5	38.1	60.3	83.3	207	108	1 1/4"	1"	308	20 Kg
	755-700-411-117	755-701-411-117	G2 1/2" (BSP) LH													
2 1/2"	755-702-413-139	755-703-413-139	2 1/2" NPT RH	7"	13 1/2"	15 1/4"	3/4"	1 7/8"	2 3/8"	3 3/2"	8 5/8"	4 3/8"	1 1/2"	** 1 1/2"	12 1/8"	44#
	755-702-415-139	755-703-415-139	2 1/2" NPT LH													

* Monoflow unions can be specified by omitting the -117 or -139 suffix. Flange rotor available upon request. Duoflow rotating pipe models available upon request.

** For recirculating water service (equal in and out flow) use 1 1/2" supply pipe.

DEUBLIN

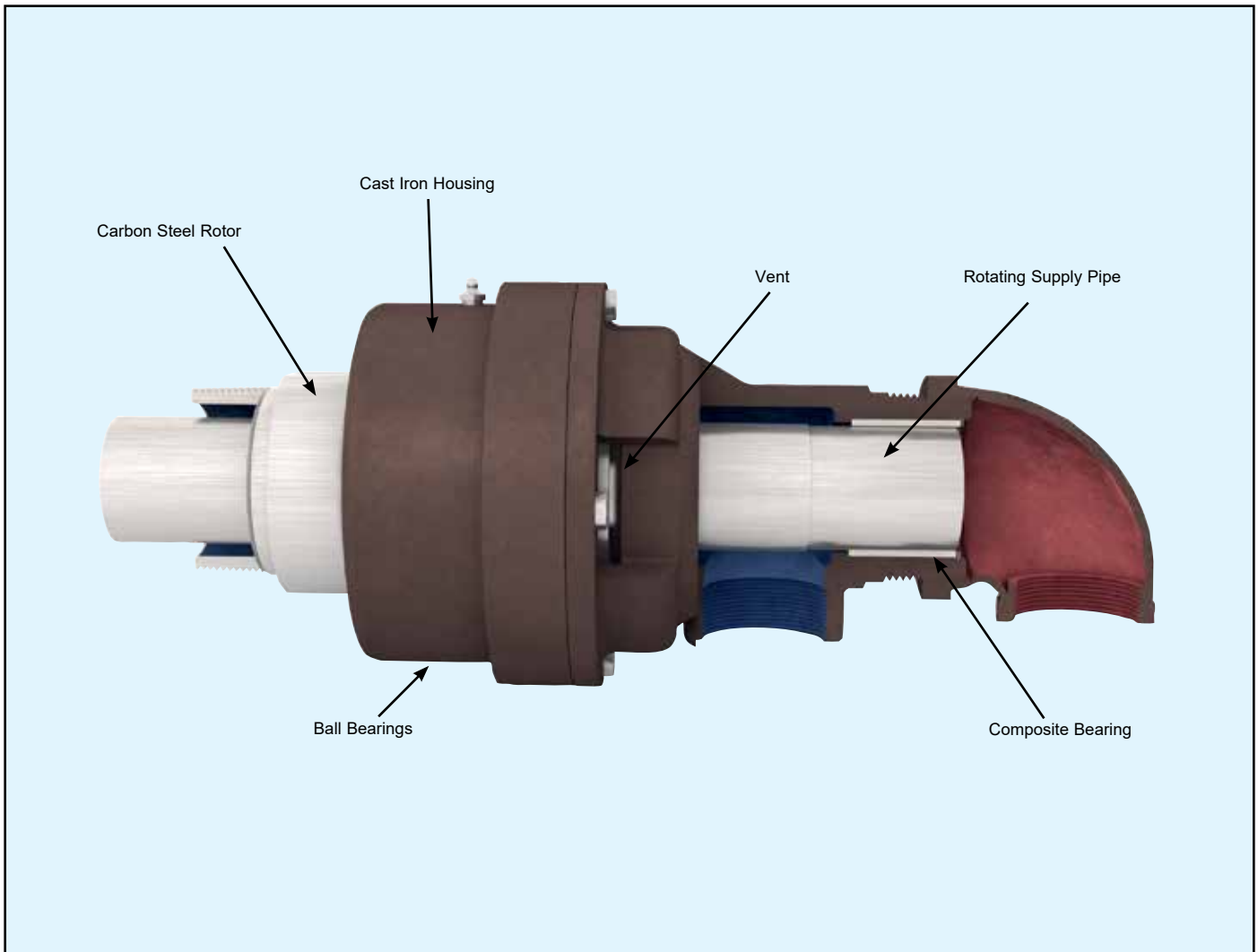
3" Union for Rubber and Plastic Application

- Monoflow and duoflow design
- Self-supported rotating union
- Radial housing connection
- Balanced mechanical seal
- Seal combination:
Carbon Graphite/Tungsten Carbide
- Full-media flow
- Easy and quick replacement of sealing components (rotor seal, floating seal)
- Vented housing
- Cast iron housing - standard
- Steel rotor
- Lubrication Guide page 55

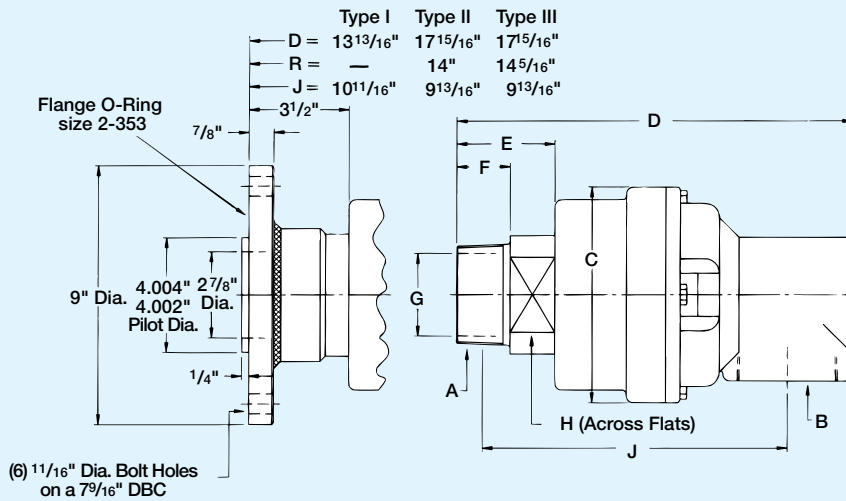


Operating Data

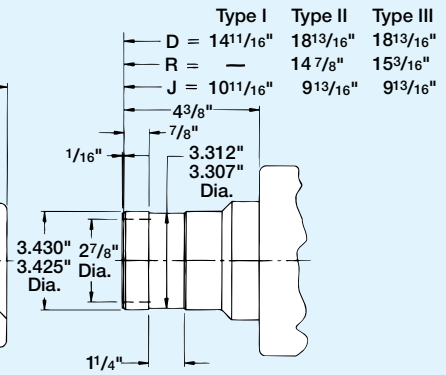
Maximum Water Pressure	150 PSI	10 bar
Maximum Saturated Steam Pressure (Intermittent)	15 PSI	1 bar
Maximum Speed	500 RPM	500/min
Torque @ 150 PSI/10bar	6 ft.lbs	8.2 Nm
Maximum Water Temperature	250°F	>250°F consult DEUBLIN



857 Series Specifications

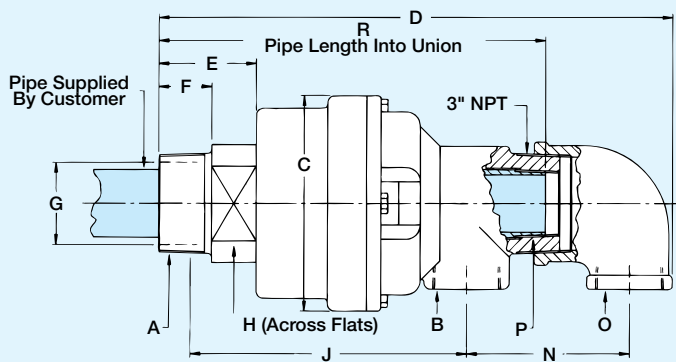


857-132 Flanged Rotor Detail

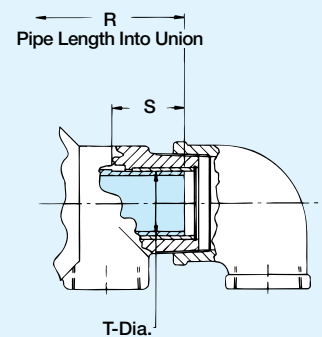


857-128 Quick Connect Rotor Detail

Type I Monoflow



Type II Duoflow Fixed Pipe



Type III Duoflow Rotating Pipe

B Port NPT	Ordering Number	A Rotor Thread	C Dia.	D	E	F	G	H*	J	N	O NPT	P NPT	R	S	T	Shpg. Wt.
Type I 3"	857-000-101	3" NPT RH	7 1/2"	13 3/4"	3 3/8"	1 1/8"	2 7/8"	100	10 9/16"	-	-	-	-	-	-	50#
	857-000-102	3" NPT LH														
	857-000-118	G3" (BSP) RH	190	344	83	44	73	100	244	-	-	-	-	-	-	23 Kg
	857-000-119	G3" (BSP) LH														
Type II 2"	857-001-101	3" NPT RH	7 1/2"	17 7/8"	3 3/8"	1 7/8"	2 7/8"	100	9 3/4"	5 1/16"	2"	2"	13 5/16"	-	-	55#
	857-001-102	3" NPT LH														
	857-001-118	G3" (BSP) RH	190	451	83	44	73	100	228	144	2"	2"	351	-	-	25 Kg
	857-001-119	G3" (BSP) LH														
Type III 2"	857-002-101	3" NPT RH	7 1/2"	17 7/8"	3 3/8"	1 7/8"	2 7/8"	100	9 3/4"	5 1/16"	2"	-	14 1/4"	2 3/4"	2.308"	55#
	857-002-102	3" NPT LH													2.302"	
	857-002-118	G3" (BSP) RH	190	451	83	44	73	100	228	144	2"	-	355	70	58.62	25 Kg
	857-002-119	G3" (BSP) LH													58.47	

*Metric

DEUBLIN

Stainless Steel Unions

- Monoflow and duoflow (available) design
- Self-supported rotating union
- Radial or axial (available) housing connection
- Wetted parts made of 316 stainless steel
- Suitable for the food, chemical & pharmaceutical industries
- Full-media flow

Seal Combination

- Carbon Graphite/Ceramic - Standard

Seal Combination - E.L.S.

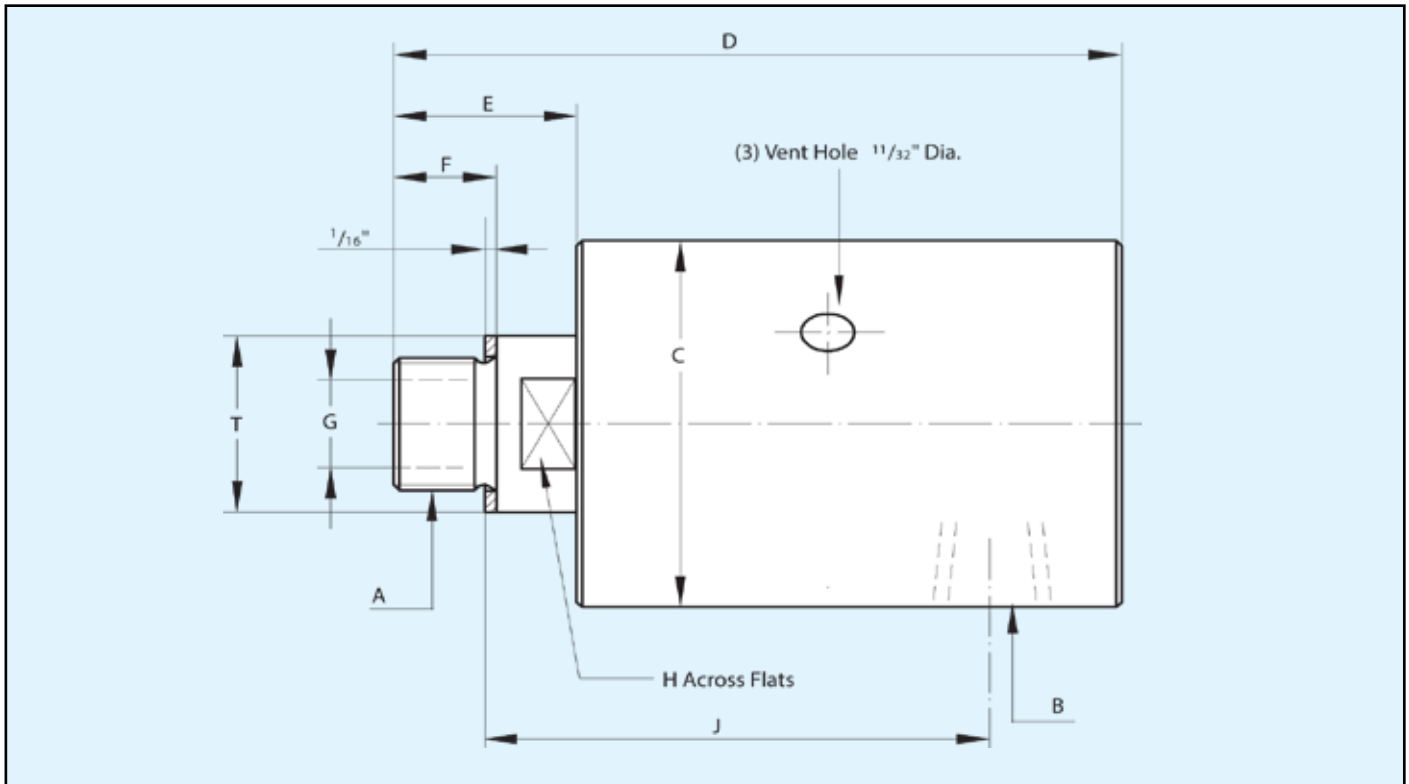
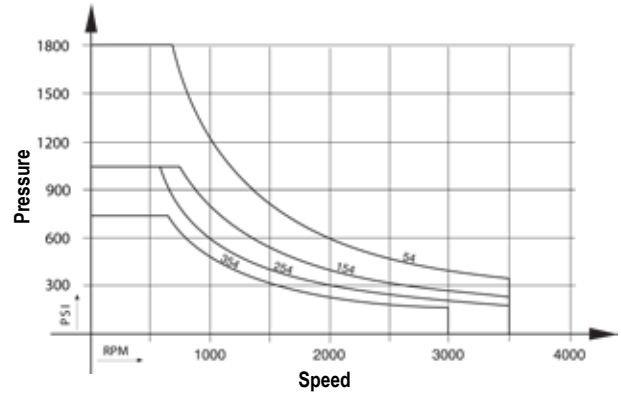
- Tungsten Carbide/Ceramic



Operating Data

Maximum Pressure and Maximum Speed	See Diagram	
Maximum Speed NPT	1,500 RPM	1,500/min
Maximum Temperature	200°F	>200°F consult DEUBLIN

(Temperatures above 160°F pressure should not exceed 150 PSI (10 bar) and media must be in liquid form.)



B Port NPT	Ordering Number		A Rotor Thread	C Dia.	D	E	F	G	H*	J	T	Shpg. Wt.
	Standard Model	E.L.S. Model										
3/8"	54-050-117	54-051-112	3/8" NPT RH	1 15/16"	4"	1 1/16"	5/8"	3/8"	19	3"	7/8"	1 1/2#
	54-050-178	54-051-110	G 3/8" (BSP) RH	49	101	26	16	9.5	19	71.5	22	1.1 Kg
1/2"	154-050-117	154-051-112	1/2" NPT RH	2 1/2"	4 15/16"	1 1/4"	7/8"	1/2"	24	3 3/4"	1 3/8"	2#
	154-050-178	154-051-110	G 1/2" (BSP) RH	64	123	34	19	12.7	24	89	30	1.8 Kg
3/4"	254-050-117	254-051-112	3/4" NPT RH	2 7/8"	5 7/8"	1 15/32"	7/8"	11/16"	30	4 1/16"	1 3/8"	5 3/4#
	254-050-178	254-051-110	G 3/4" (BSP) RH	73	135	34	19	17.5	30	98	35	2.6 Kg
1"	354-050-117	354-051-112	1" NPT RH	3 11/16"	6 9/16"	1 15/16"	1 1/8"	1"	36	4 7/8"	1 25/32"	11 1/4#
	354-050-178	354-051-110	G 1" (BSP) RH	94	161	43	22	25	36	117	45	5.1 Kg

Note: 1/4" & 1/2" available. *Metric

DEUBLIN

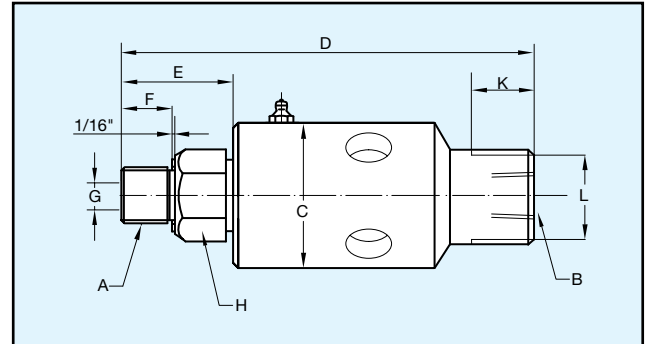
Model 927 High Pressure/ Low Torque Water Union



- Monoflow design
- Self-supported rotating union
- Axial housing connection
- Balanced mechanical seal
- Seal combination:
Tungsten Carbide/Tungsten Carbide
- Slinger and vents protect bearings
- Low torque design
- Stainless steel housing and rotor

Operating Data

Maximum Water Pressure	4,000 PSI	276 bar
Maximum Speed	2,000 RPM	2,000/min
Maximum Flow	4 GPM	15 L/min
Maximum Temperature	200°F	90°C



B Port NPT	Ordering Number	A Rotor Thread	C	D	E	F	G Rotor Hole	H* Across Flats	K	L Across Flats	Shpg. Wt.
3/8"	927-150-151	3/4"-16 UNF RH	2 1/4"	5 5/8"	1 1/8"	3/4"	3/8"	30	1"	1 1/4"	3#
	927-150-152	3/4"-16 UNF LH									



DEUBLIN

Model 22 Car Wash Union

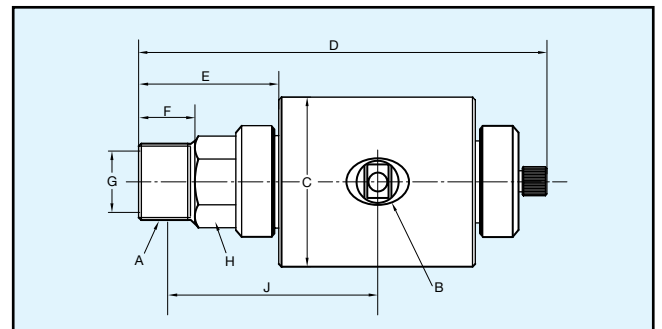
- Monoflow design
- Self-supported rotating union
- Radial housing connection
- Seal combination:
Silicon Carbide/Silicon Carbide
- Stainless steel housing and rotor

Operating Data

Maximum Water Pressure**	1,500 PSI	105 bar
Maximum Speed**	250 RPM	250/min
Maximum Temperature	250°F	121°C

** Union is designed for continuous operation at either maximum speed or maximum pressure. If operating conditions are close to maximum pressure and speed simultaneously, consult **DEUBLIN**.

(Not suitable for overhead boom.)



B Port NPT	Ordering Number	A Rotor Thread	C	D	E	F	G Rotor Hole	H* Across Flats	J Approx. Lock-up	Shpg. Wt.
3/4"	22-001-101	1/2" NPT RH	2 3/4"	5 5/8"	1 7/8"	1 1/16"	1/2"	30	2 1/16"	4 3/4#
3/4"	22-001-102	1/2" NPT LH								
3/4"	22-001-103	3/4" NPT RH	2 3/4"	5 3/4"	2 1/16"	7/8"	1/2"	30	2 7/8"	4 3/4#
3/4"	22-001-104	3/4" NPT LH								

*Metric

DEUBLIN

2", 2½", 3" & 4" Cartridge Water Unions

- Monoflow and duoflow design
- Self-supported rotating union
- Radial housing connection
- Balanced mechanical seal
- Steel-banded floating seal
- Easy and quick replacement of sealing components
- Full-media flow
- Vent slots
- Cast iron housing
- Steel rotor flanged/threaded
- Lubrication Guide page 55

Operating Data

Maximum Water Pressure	150 PSI	10 bar	
Maximum Speed		750 RPM	750/min
Torque for	Model 6200	4 ft.lbs	5.4 Nm
	Model 6250	7 ft.lbs	9.5 Nm
	Model 6300	8 ft.lbs	10.9 Nm
	Model 6400	10 ft.lbs	13.6 Nm

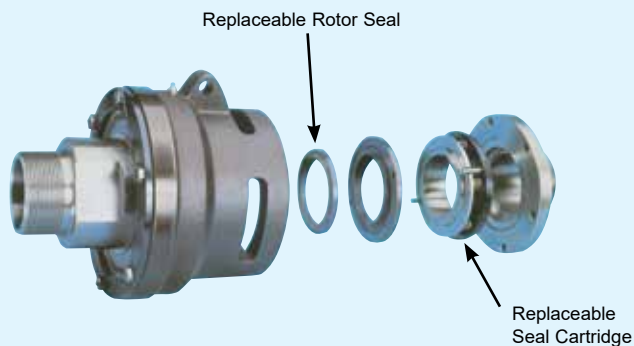
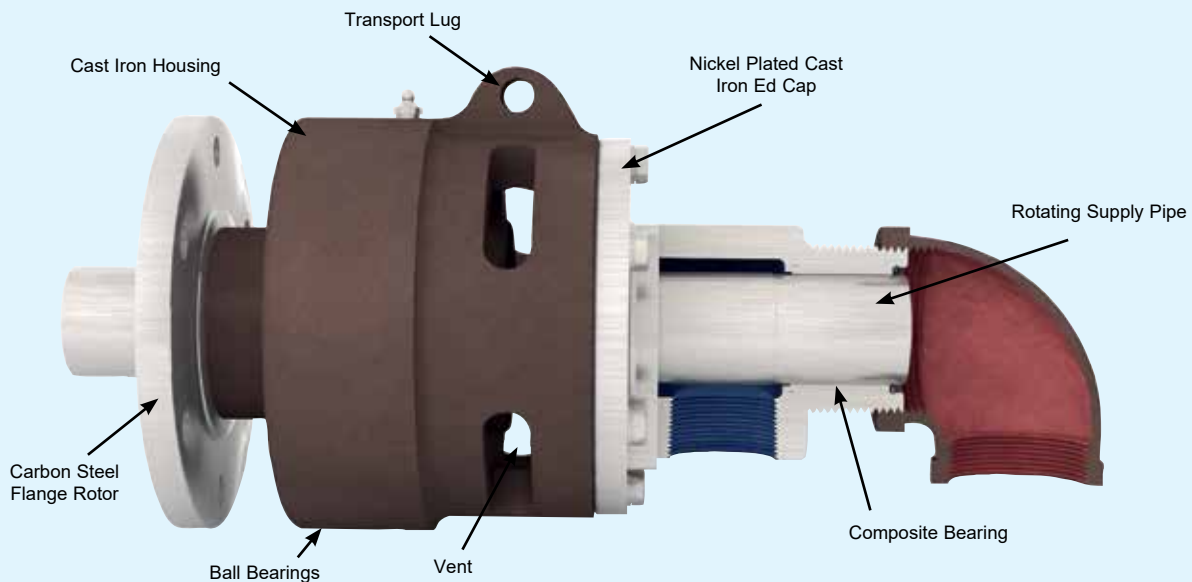
Maximum Temperature 250°F >250°F consult **DEUBLIN**

Seal Combination

- Carbon Graphite/Tungsten Carbide - Standard

Seal Combination - E.L.S.

- Silicon Carbide/Tungsten Carbide for severe conditions (poor water quality), max. temperature 200°F

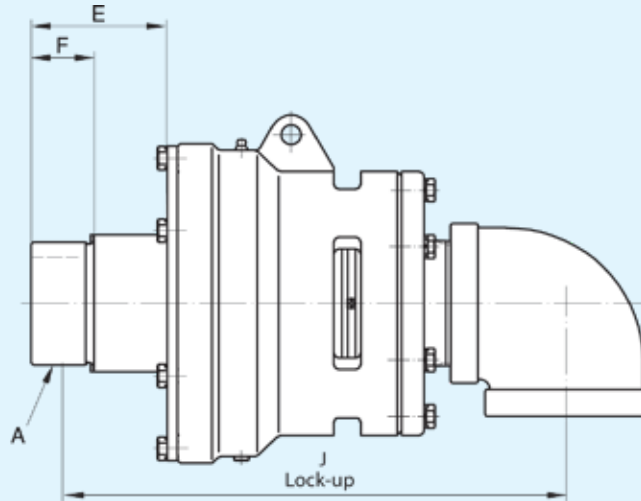


DEUBLIN Exclusive On-The-Machine Repair Cartridge

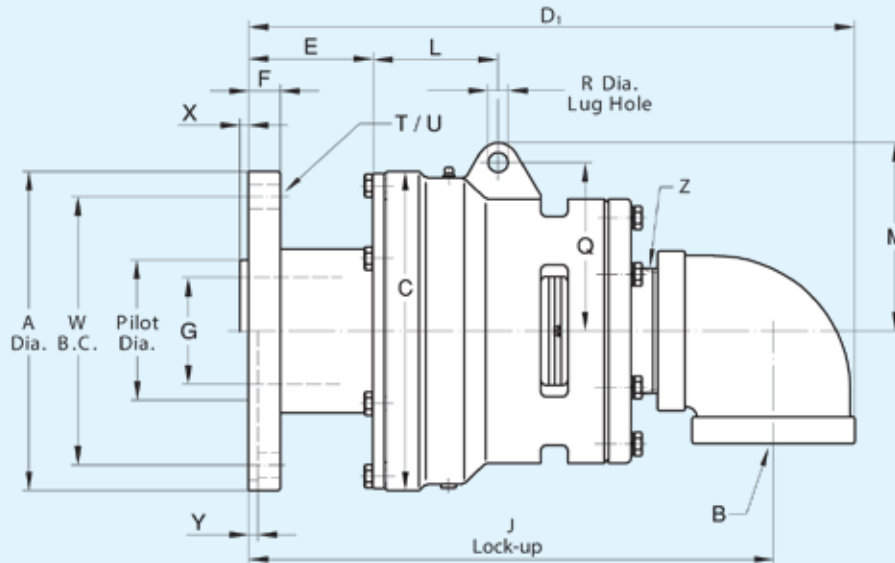
Seals are replaced quickly and easily. There's no need to remove hose connections or use special tools. Make sure the system is cold and pressureless! Simply remove 6 hex bolts and end cap, then remove floating seal cartridge and rotor seal face and replace with new seals. Rotor seal is keyed and sealed to the rotor with a built-in O-Ring. Replace end cap, hex bolts and safety wire. Detailed instructions available from **DEUBLIN**.

Monoflow Rotating Union

Threaded Rotor



Flanged Rotor



Flanged O-Ring

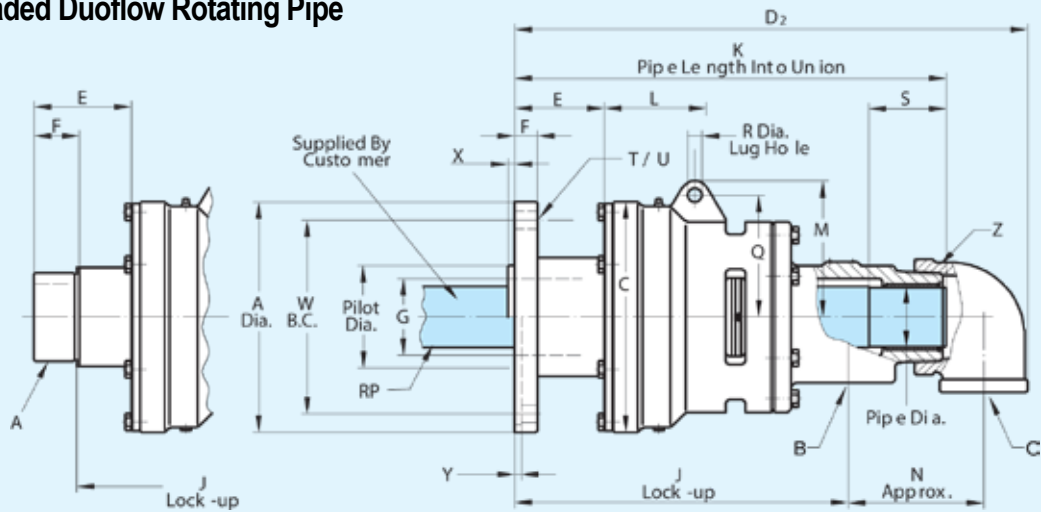
(supplied by DEUBLIN) for:

Model	O-Ring Size
6200	2-343 Viton
6250	2-343 Viton
6300	2-353 Viton
6400	2-361 Viton

B Port NPT	Ordering Number		A Rotor Thread	C	D ₁	E	F	G	J	L	M	Q	R	T	U	W	Pilot Dia.	X	Y	Z NPT	Shpg. Wt.
	Standard	E.L.S.																			
2"	6200-001-123	6200-016-123	2" NPT RH	5 1/4"	12"	2 1/8"	1 1/2"	1 1/8"	9 5/8"	2 7/8"	3 3/8"	3 1/8"	1/2"	-	-	-	-	-	-	2"	21#
	6200-001-135	6200-016-135	2" NPT LH																	2"	9.5 Kg
	6200-001-137	6200-016-137	G2"(BSP) RH	133	295	63.5	28.6	47	228	73	90	78	12.7	-	-	-	-	-	-	2"	
	6200-001-139	6200-016-139	G2"(BSP) LH																	2"	
	6200-001-115	6200-016-115	9" O.D. FLANGE	5 1/4"	12"	3 1/4"	1"	1 1/8"	10 1/4"	2 7/8"	3 3/8"	3 1/8"	1/2"	4	1 1/8"	6 3/8"	8.317" 8.315"	-	1/4"	2"	32#
2 1/2"	6250-001-115	6250-018-115	2 1/2" NPT RH	7"	14 3/8"	3 1/4"	1 1/8"	2 3/8"	12"	3 3/4"	4 1/8"	3 7/8"	5/8"	-	-	-	-	-	-	2 1/2"	44 1/2#
	6250-001-119	6250-018-119	2 1/2" NPT LH																	2 1/2"	
	6250-001-121	6250-018-121	G2 1/2"(BSP) RH	178	371	82.5	38.1	60	290	95	113	98	14.3	-	-	-	-	-	-	2 1/2"	20.2 Kg
	6250-001-123	6250-018-123	G2 1/2"(BSP) LH																	2 1/2"	
	6250-001-300	6250-018-300	9" O.D. FLANGE	7"	15"	3 5/8"	1"	2 3/8"	12 1/8"	3 3/8"	4 7/8"	3 7/8"	5/8"	4	1 1/8"	6 3/8"	8.317" 8.315"	-	1/4"	2 1/2"	59#
3"	6300-001-157	6300-015-157	3" NPT RH	9"	17 1/8"	3 7/8"	1 1/8"	2 1/8"	14"	3 3/8"	5 5/8"	4 3/4"	5/8"	-	-	-	-	-	-	3"	98#
	6300-001-158	6300-015-158	3" NPT LH																	3"	
	6300-001-161	6300-015-161	G3"(BSP) RH	229	433	95	44.4	73	335	87	135	121	14.3	-	-	-	-	-	-	3"	45.5 Kg
	6300-001-162	6300-015-162	G3"(BSP) LH																	3"	
	6300-001-103	6300-015-103	9" O.D. FLANGE	9"	16 3/4"	3 7/8"	7/8"	3"	14 1/2"	3 3/8"	5 5/8"	4 3/4"	5/8"	6	1 1/8"	7 3/8"	4.004" 4.002"	1/4"	-	3"	113#
4"	6400-030-330	6400-042-330	10 7/8" O.D. FLANGE	11"	19"	3"	7/8"	4"	16 3/8"	3 3/4"	6 1/8"	5 1/4"	5/8"	6	1 3/8"	9"	4.749" 4.746"	.300	-	4"	156#

Note: Threaded Rotors Not For Calendar Service.

Flanged/Threaded Duoflow Rotating Pipe



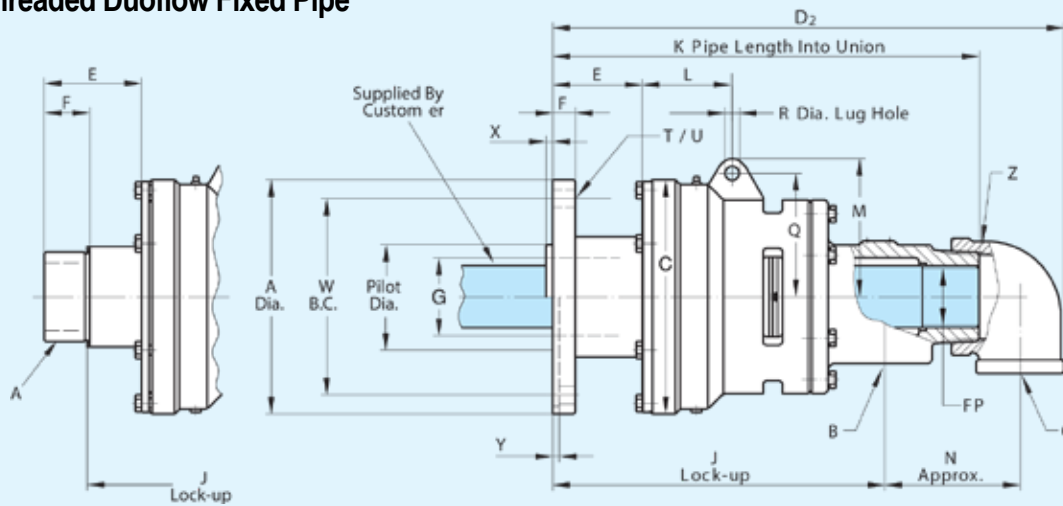
Duoflow Rotating Pipe Models

B & O Port NPT	Standard	E.L.S.	A	C	D ₂	E	F	G	J	K	L
(2) x 1"	6200-002-123	6200-030-123	2" NPT RH	5 1/4"	12 7/8"	2 15/16"	1 1/2"	1 7/8"	8"	10 5/8"	2 7/8"
	6200-002-135	6200-030-135	2" NPT LH								
	6200-002-137	6200-030-137	G2" (BSP) RH								
	6200-002-139	6200-030-139	G2" (BSP) LH								
	6200-002-115	6200-030-115	9" O.D. FLANGE.	5 1/4"	13 3/16"	3/4"	1"	1 7/8"	8 5/8"	10 15/16"	2 7/8"
(2) x 1 1/2"	6250-002-115	6250-030-115	2 1/2" NPT RH	7"	15 5/8"	3/4"	1 1/8"	2 3/8"	9 3/4"	13 3/8"	3 3/4"
	6250-002-119	6250-030-119	2 1/2" NPT LH								
	6250-002-121	6250-030-121	G2 1/2" (BSP) RH								
	6250-002-123	6250-030-123	G2 1/2" (BSP) LH								
	6250-002-300	6250-030-300	9" O.D. FLANGE	7"	16 1/4"	3 5/8"	1"	2 3/8"	10 9/16"	13 3/8"	3 3/4"
(2) x 2"	6300-002-157	6300-030-157	3" NPT RH	9"	20"	3 7/8"	1 1/8"	2 7/8"	12 1/4"	16 3/8"	3 1/16"
	6300-002-158	6300-030-158	3" NPT LH								
	6300-002-161	6300-030-161	G3" (BSP) RH								
	6300-002-162	6300-030-162	G3" (BSP) LH								
	6300-002-103	6300-030-103	9" O.D. FLANGE								
(2) x 2 1/2"	6400-031-330	6400-051-330	10 7/8" O.D. FLANGE	11"	21 3/8"	3"	7/8"	4"	13 3/4"	17 1/2"	3 3/4"

Duoflow Fixed Pipe Models

B & O Port NPT	Standard	E.L.S.	A	C	D ₂	E	F	G	J	K	L
(2) x 1"	6200-011-123	6200-040-123	2" NPT RH	5 1/4"	12 7/8"	2 15/16"	1 1/2"	1 7/8"	8"	10 1/8"	2 7/8"
	6200-011-135	6200-040-135	2" NPT LH								
	6200-013-137	6200-020-137	G2" (BSP) RH								
	6200-013-139	6200-020-139	G2" (BSP) LH								
	6200-011-115	6200-040-115	9" O.D. FLANGE	5 1/4"	13 3/16"	3/4"	1"	1 7/8"	8 5/8"	10 1/16"	2 7/8"
(2) x 1 1/2"	6250-006-115	6250-040-115	2 1/2" NPT RH	7"	15 5/8"	3/4"	1 1/8"	2 3/8"	9 3/4"	13"	3 3/4"
	6250-006-119	6250-040-119	2 1/2" NPT LH								
	6250-025-121	6250-035-121	G2 1/2" (BSP) RH								
	6250-025-123	6250-035-123	G2 1/2" (BSP) LH								
	6250-006-300	6250-040-300	9" O.D. FLANGE								
(2) x 2"	6300-006-157	6300-040-157	3" NPT RH	9"	20"	3 7/8"	1 1/8"	2 7/8"	12 1/4"	16 3/8"	3 1/16"
	6300-006-158	6300-040-158	3" NPT LH								
	6300-025-161	6300-035-161	G3" (BSP) RH								
	6300-025-162	6300-035-162	G3" (BSP) LH								
	6300-006-103	6300-040-103	9" O.D. FLANGE								
(2) x 2 1/2"	6400-024-330	6400-054-330	10 7/8" O.D. FLANGE	11"	21 3/8"	3"	7/8"	4"	13 3/4"	17"	3 3/4"

Flanged/Threaded Duoflow Fixed Pipe



M	N	O NPT	Pipe Dia.	RP	Q	R	S	T	U	W	Pilot Dia.	X	Y	Z NPT	Shpg. Wt.
3 ³ / ₁₆ "	3 ³ / ₈ "	1"	1.245" 1.240"	1"	3 ¹ / ₁₆ "	1/2"	1 1/2"	-	-	-	-	-	-	2"	29#
90	86	1"	31.62 31.49	1"	78	12.7	38	-	-	-	-	-	-	2"	13.2 Kg
3 ³ / ₁₆ "	3 ³ / ₈ "	1"	1.245" 1.240"	1"	3 ¹ / ₁₆ "	1/2"	1 1/2"	4	1 ¹ / ₁₆ "	6 ³ / ₁₆ "	8.317" 8.315"	-	1/4"	2"	40#
4 ⁷ / ₁₆ "	4 ¹ / ₂ "	1 1/2"	1.867" 1.865"	1 1/2"	3 ³ / ₁₆ "	9/16"	1 5/8"	-	-	-	-	-	-	2 1/2"	55 1/2#
113	103	1 1/2"	47.42 47.37	1 1/2"	98	14.3	41	-	-	-	-	-	-	2 1/2"	25.2 Kg
4 ⁷ / ₁₆ "	4 ¹ / ₂ "	1 1/2"	1.867" 1.865"	1 1/2"	3 ³ / ₁₆ "	9/16"	1 5/8"	4	1 ¹ / ₁₆ "	6 ³ / ₁₆ "	8.317" 8.315"	-	1/4"	2 1/2"	70#
5 ⁵ / ₁₆ "	5 ⁵ / ₁₆ "	2"	2.308" 2.302"	2"	4 ³ / ₄ "	9/16"	2 3/4"	-	-	-	-	-	-	3"	105#
135	132	2"	58.62 58.47	2"	121	14.3	70	-	-	-	-	-	-	3"	47.7 Kg
5 ⁵ / ₁₆ "	5 ⁵ / ₁₆ "	2"	2.308" 2.302"	2"	4 ³ / ₄ "	9/16"	2 3/4"	6	1 ¹ / ₁₆ "	7 ⁹ / ₁₆ "	4.004" 4.002"	1/4"	-	3"	120#
6 ¹ / ₈ "	5 ³ / ₄ "	2 1/2"	2.745" 2.742"	2 1/2"	5 ¹ / ₄ "	5/8"	2 1/2"	6	1 ³ / ₁₆ "	9"	4.749" 4.746"	.300"	-	4"	168#

M	N	O NPT	FP	Q	R	T	U	W	Pilot Dia.	X	Y	Z NPT	Shpg. Wt.
3 ³ / ₁₆ "	3 ³ / ₈ "	1"	1" NPT	3 ¹ / ₁₆ "	1/2"	-	-	-	-	-	-	2"	29#
90	86	1"	G1 (BSP)	78	12.7	-	-	-	-	-	-	2"	13.2 Kg
3 ³ / ₁₆ "	3 ³ / ₈ "	1"	1" NPT	3 ¹ / ₁₆ "	1/2"	4	1 ¹ / ₁₆ "	6 ³ / ₁₆ "	8.317" 8.315"	-	1/4"	2"	40#
4 ⁷ / ₁₆ "	4 ¹ / ₂ "	1 1/2"	1 1/2" NPT	3 ³ / ₁₆ "	9/16"	-	-	-	-	-	-	2 1/2"	55 1/2#
113	103	1 1/2"	G1 1/2" (BSP)	98	14.3	-	-	-	-	-	-	2 1/2"	25.2 Kg
4 ⁷ / ₁₆ "	4 ¹ / ₂ "	1 1/2"	1 1/2" NPT	3 ³ / ₁₆ "	9/16"	4	1 ¹ / ₁₆ "	6 ³ / ₁₆ "	8.317" 8.315"	-	1/4"	2 1/2"	70#
5 ⁵ / ₁₆ "	5 ⁵ / ₁₆ "	2"	2" NPT	4 ³ / ₄ "	9/16"	-	-	-	-	-	-	3"	105#
135	132	2"	G2" (BSP)	121	14.3	-	-	-	-	-	-	3"	47.7 Kg
5 ⁵ / ₁₆ "	5 ⁵ / ₁₆ "	2"	2" NPT	4 ³ / ₄ "	9/16"	6	1 ¹ / ₁₆ "	7 ⁹ / ₁₆ "	4.004" 4.002"	1/4"	-	3"	120#
6 ¹ / ₈ "	5 ³ / ₄ "	2 1/2"	2 1/2" NPT	5 ¹ / ₄ "	5/8"	6	1 ³ / ₁₆ "	9"	4.749" 4.746"	.300"	-	4"	168#



DEUBLIN

F Series 5" Water Union

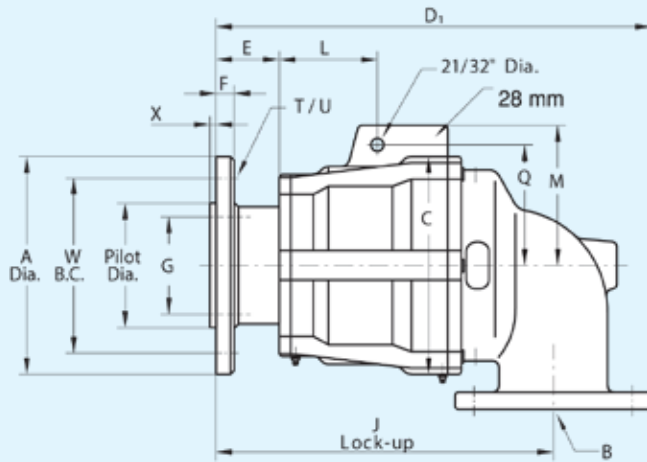
- Monoflow and duoflow design
- Self-supported rotating union
- Balanced mechanical seal
- Seal combination:
Carbon Graphite/Tungsten Carbide
- Two widely-spaced ball bearings
- Labyrinth seal protects bearings
- Cast iron housing
- High corrosion resistant
- Steel flanged rotor
- On-the-machine seal replacement capability
- Inlet/outlet flange:
standard ANSI
optional DIN, JIS
- Special designs up to 12" available upon request

Operating Data

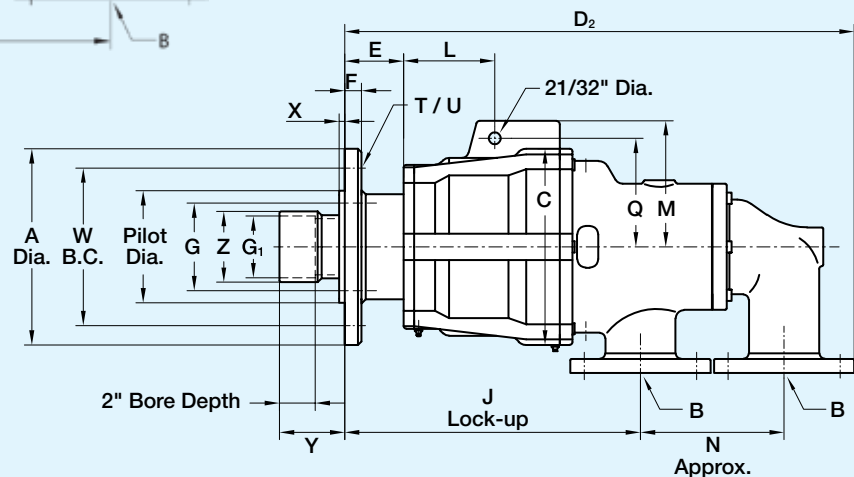
Maximum Water Pressure*	230 PSI	16 bar
Maximum Speed*	1,000 RPM	1,000/min
Maximum Temperature	250°F	>250°F consult DEUBLIN

*Union is designed for continuous operation at either maximum speed or maximum pressure. If operating conditions are close to maximum pressure and speed simultaneously, consult **DEUBLIN**.

Monoflow Rotating Union



Duoflow Rotating Union



Monoflow Union

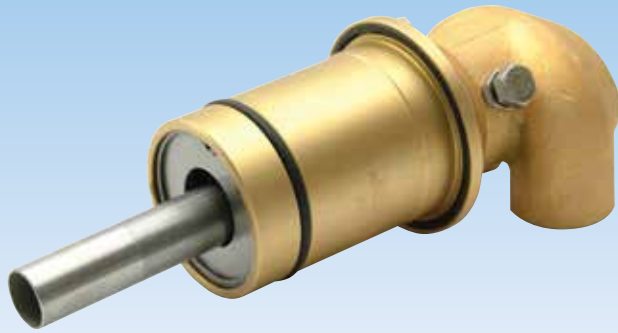
B Port	Ordering No.	A	C	D ₁	E	F	G	J	L	M	Q	T	U	W	X	Pilot Dia.	Shpg. Wt.
5" ANSI	F127-011-200	11"	11"	23"	3 ¹¹ / ₃₂ "	1"	4 ²⁹ / ₃₂ "	17 ²⁹ / ₃₂ "	5 ¹ / ₈ "	7 ³ / ₃₂ "	6 ¹ / ₃₂ "	6	2 ³ / ₃₂ "	8 ²⁷ / ₃₂ "	5 ¹ / ₁₆ "	6.295" 6.291"	220#

Duoflow Union

B Port	Ordering No.	A	C	D ₂	E	F	G ₁	J	L	M	N	Q	T	U	W	X	Y	Z	Pilot Dia.	Shpg. Wt.
(2) 3" ANSI	F127-023-204-701	11"	11"	28 ¹ / ₂ "	3 ¹¹ / ₃₂ "	1"	3.480" 3.476"	16 ²¹ / ₃₂ "	5 ¹ / ₈ "	7 ³ / ₃₂ "	8"	6 ¹ / ₃₂ "	6	2 ³ / ₃₂ "	8 ²⁷ / ₃₂ "	5 ¹ / ₁₆ "	3 ²¹ / ₃₂ "	3 ³¹ / ₃₂ "	6.295" 6.291"	264#

DEUBLIN

2400 Series Rotating Union

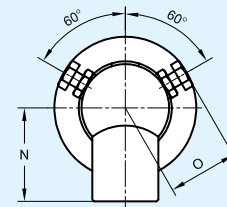
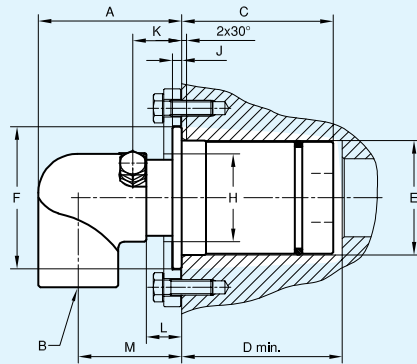


- Monoflow and duoflow design
- In-the-shaft mounted
- Self-supported rotating union
- Flanged housing or mounted with retaining plate
- Balanced mechanical seal
- Seal combination: Silicon Carbide/Silicon Carbide
- Brass housing and elbow
- Stainless steel rotor and supply pipe
- Engineered sleeve bearing
- Full-media flow
- Easily field repairable

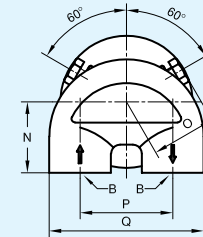
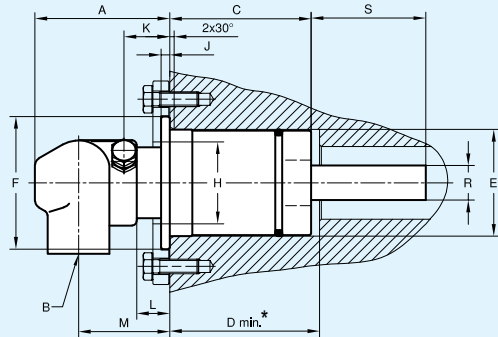
Operating Data

Maximum Water Pressure	150 PSI	10 bar
Maximum Speed	100 RPM	100/min
Maximum Temperature	250°F	>250°F consult DEUBLIN

Monoflow Rotating Union



Duoflow Rotating Union



	B Port	Ordering Number	A	C	D*	E Ø*	F Ø	H Ø	J	K	L	M	N	O	P	Q	R Ø	S	Shpg. Wt.
Monoflow	3/4" NPT	2420-001-125	2 2/64"	2 3/8"	2 1/16"	1.825 1.815	2 1/16"	1 15/16"	3/16"	1 1/32"	3/4"	1 2 1/2"	1 13/16"	1 1/16"	-	-	-	-	1 1/2#
	G 3/4" (BSP)	2420-001-139	59	60	62	46.35 46.10	59	49	5	26	19	42	46	36	-	-	-	-	.7 Kg
	1" NPT	2425-001-281	2 15/16"	3 1/16"	3 1/4"	2.323 2.313	2 7/8"	1 1/16"	3/16"	1 1/32"	3/4"	2 1/8"	1 13/16"	1 1/16"	-	-	-	-	3 1/2#
Duoflow	G 1" (BSP)	2425-001-172	75	78	83	59.00 58.75	73	36	5	26	19	54	46	39	-	-	-	-	1.6 Kg
	3/4" NPT	2420-001-135-180	2 15/16"	2 3/8"	2 1/16"	1.825 1.815	2 5/16"	1 15/16"	3/16"	1 1/32"	3/4"	2"	1 17/32"	1 1/16"	2"	3 1 1/2"	.511 .510	1 15/16"	2#
	G 3/4" (BSP)	2420-001-141-180	75	60	62	46.35 46.10	59	49	5	26	19	51	39	36	51	85	13.00 12.95	49	.9 Kg
	3/4" NPT	2425-001-283-180	2 15/16"	3 1/16"	3 1/4"	2.323 2.313	2 7/8"	1 1/16"	3/16"	1 1/32"	3/4"	2"	1 17/32"	1 1/16"	2"	3 1 1/2"	.748 .746	2 1/2"	4#
	G 3/4" (BSP)	2425-001-177-180	75	78	83	59.00 58.75	73	36	5	26	19	51	39	39	51	85	19.00 18.94	63.5	1.8 Kg
	1" NPT	2440-001-301-254	3 3/8"	3 3/16"	3 1 1/16"	2.805 2.795	3 3/8"	2"	3/16"	1 1/32"	3/4"	2 1 1/16"	1 11/16"	1 13/16"	2 1/2"	4 1/8"	1.130 1.125	1 7/8"	9#
G 1" (BSP)	2440-001-306-254	98	87	94	71.25 71.00	86	51	5	26	19	68	43	46	64	105	28.70 28.58	48	4 Kg	

*Denotes Shaft Dimension