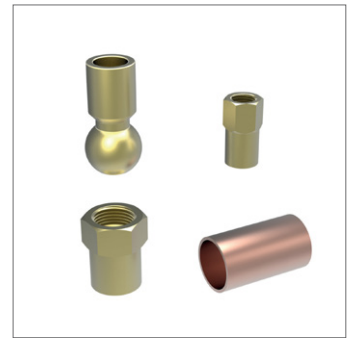
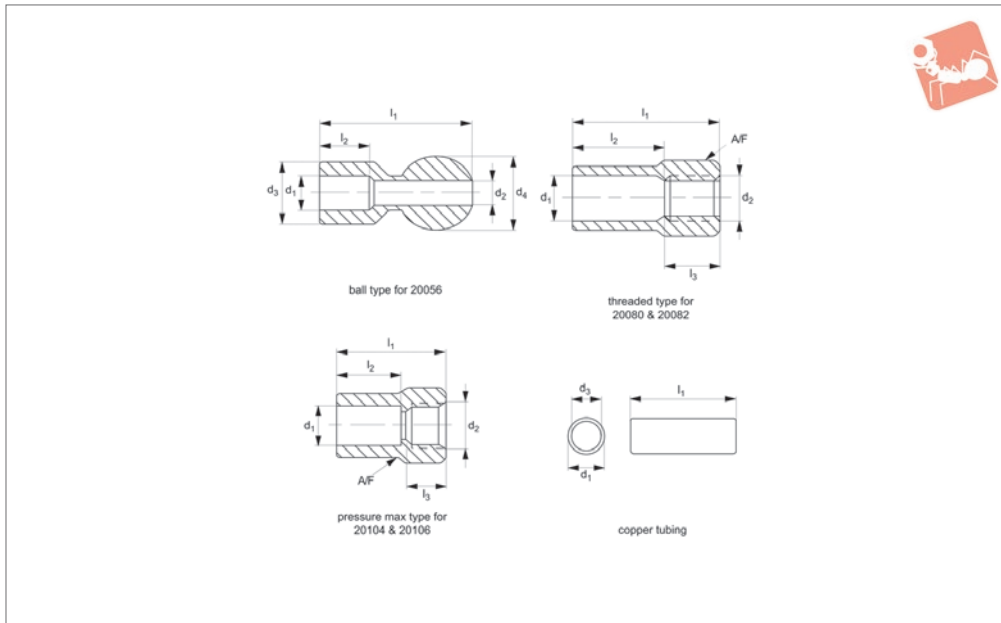




Sweat Fittings - for Coolant Nozzles

for adapting coolant nozzles to copper tubing

Coolant Nozzles



20093

COOLANT NOZZLES

Material

Brass.

Technical Notes

Max. temperature: 70°C.

Max. pressure: 33 bar.

Tips

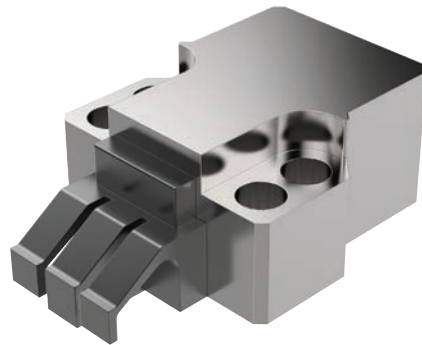
Sweat fittings allow a wide variety of coolant nozzles to be mounted to copper tubing, increasing reliability through use of short rigid hose. For use with coolant

nozzles 20056, 20080, 20082, 20104 and 20106. See table for compatibility. Easy to solder.

Order No.	Type	For use with	d ₁	d ₂	d ₃	d ₄	l ₁	l ₂	l ₃	A/F
20093.W0250	Ball Type	20056	6.4	5.6	9.6	12	25.1	9.6	-	-
20093.W0310	Ball Type	20056	7.9	5.6	11.2	12	26.7	11.2	-	-
20093.W0370	Ball Type	20056	9.5	5.6	12.4	12	29.2	12.4	-	-
20093.W1190	Threaded Type	20080/20082	4.8	M 5x0,80	-	-	14.2	7.9	6.4	6.4
20093.W1250	Threaded Type	20080/20082	6.4	M 6x1,00	-	-	15.7	9.4	6.4	7.9
20093.W1340	Threaded Type	20080/20082	7.9	M 8x1,25	-	-	20.6	12.7	7.9	9.7
20093.W1370	Threaded Type	20080/20082	9.5	1/8" NPT/BSPT	-	-	23.9	14.2	6.4	12.7
20093.W2250	Pressure Max Type	20104/20106	6.4	5/16"-24 UNJF	-	-	17.3	9.7	5.0	11.2
20093.W2251	Pressure Max Type	20104/20106	6.4	7/16"-20 UNJF	-	-	19.0	10.7	5.0	14.2
20093.W2310	Pressure Max Type	20104/20106	7.9	7/16"-20 UNJF	-	-	19.0	11.2	5.0	14.2
20093.W2311	Pressure Max Type	20104/20106	7.9	1/2"-20 UNJF	-	-	25.4	14.2	6.3	15.7
20093.W2370	Pressure Max Type	20104/20106	9.5	7/16"-20 UNJF	-	-	19.0	11.2	5.0	14.2
20093.W2371	Pressure Max Type	20104/20106	9.5	1/2"-20 UNJF	-	-	25.4	14.2	6.3	15.7
20093.W5190	Copper Tubing	Copper Tube	4.8	-	3.0	-	3000.0	-	-	-
20093.W5250	Copper Tubing	Copper Tube	6.4	-	4.6	-	3000.0	-	-	-
20093.W5310	Copper Tubing	Copper Tube	7.9	-	6.3	-	3000.0	-	-	-
20093.W5370	Copper Tubing	Copper Tube	9.5	-	7.9	-	3000.0	-	-	-

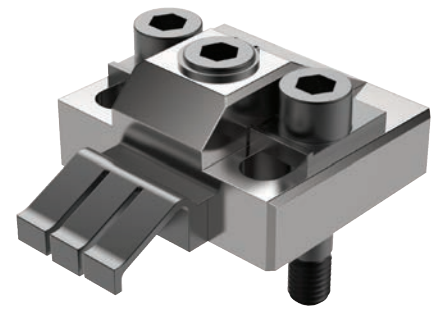


Clamping Torque



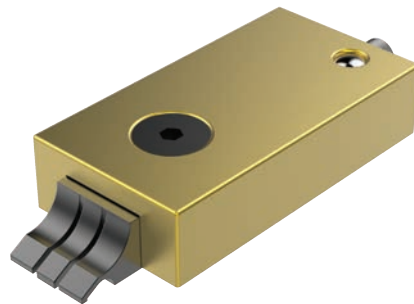
11040/CL2040

Clamping Torque N/m	Clamping Force N
50	23000
40	18000
30	12500
25	11500
20	9500



11070/CL2070

Clamping Torque N/m	Clamping Force N
60	16500
50	15000
40	12000
30	10000
25	8000
20	7000



11081/CL2081

Clamping Torque N/m	Clamping Force N
5	6600
4.5	5500
4	4900



10940/CL0030

Clamping Torque N/m	Clamping Force N
8.5	4000
8	3800
7	3400
6	3000
5	2500
4	2000



What Flow Rate of Coolant is Required?

Choose a nozzle with an orifice size that matches your pump's capacity.

Select an orifice size too big and coolant pressure will drop off, an orifice size too small and an inadequate amount of coolant will reach the tool tip and can result in damage.

Note: Flow rates are based on water at 20°. Actual results may vary with fluid type, extension length and aiming angle.

Calculating Coolant Velocity

Nozzle Extensions

A Word About Coolant Pumps

System pressure (bar)	0.35	0.7	1.4	2.0	2.8	4.1	5.5
Orifice diameter (mm)	Flow rate (litres/minute)						
1.02	0.32	0.45	0.64	0.77	0.91	1.18	1.41
1.57	0.86	1.14	1.68	2	2.32	2.82	3.32
2.18	1.64	2.32	3.27	3.86	4.55	5.46	6.82
2.79	2.91	4.09	6.36	7.27	8.18	10	11.37
4.06	6.36	9.09	12.73	15.91	18.18	21.82	25.46
5.59	11.37	16.82	23.64	30.46	35.46	42.28	48.19

System pressure (bar)	6.9	10.3	13.8	20.7	34.5	69.0	103.5
Orifice diameter (mm)	Flow rate (litres/minute)						
1.02	1.59	1.86	2.09	2.77	4	5.46	6.36
1.57	3.64	4.55	5.46	6.82	9.55	13.64	17.28
2.18	7.73	9.09	10.46	12.73	16.82	23.64	28.64
2.79	14.09	16.37	18.64	23.64	29.55	40.46	49.55
4.06	28.19	34.55	41.37	49.1	63.65	90.01	110.47
5.59	53.64	65.46	75.01	89.1	114.56	161.39	197.75

To calculate the average coolant exit velocity (important in some grinding operations where it is often desirable to match or exceed the peripheral velocity of the wheel) refer to the formula below. Choose an orifice size that produces sufficient back pressure to achieve the desired velocity.

$$V = \frac{(17.11 \times 10^{-5}) \times F}{(d \times 10^{-3})^2}$$

Where;

V = Velocity in m/s

C = Constant of 17.11 x 10⁻⁵

F = Flow rate through orifice in litres/min (see table above)

d = Orifice diameter (mm) from product tables

Choose a nozzle extension that suits your application. Short projections are more compact and less likely to be knocked out of position by swarf or vibration. Longer extensions are easier to aim, produce a more streamline or laminar flow and shoot further.

The most common coolant pump on CNC machine tools is a single stage centrifugal pump, normally designed to move high volumes of water at low pressure (typically 0.2 to 1.4 bar). Multi-stage centrifugal pumps are capable of higher pressures (typically 1.4 to 14 bar) while still producing high flow rates. Positive displacement pumps are used for very high pressure applications up to 140 bar and are generally used with small diameter orifices due to their lower flow rates.

