

DEUBLIN[®]

Engineered for Performance



CORRUGATING SOLUTIONS

STEAM JOINT AND SIPHON SYSTEM FOR **ALL CORRUGATING APPLICATIONS**

To achieve maximum heat transfer to the surface of the roll, the condensate from inside the roll must be evacuated.

Corrugating machines use stationary or rotating siphons to evacuate condensate. A large majority of siphon systems used in corrugating operations employ stationary siphons.

Maintaining minimal clearance between the siphon and the surface of the roll and its orientation in the vertical, downward position requires a rigid siphon support system. This configuration is available in all *DEUBLIN* steam joint and stationary siphon systems.

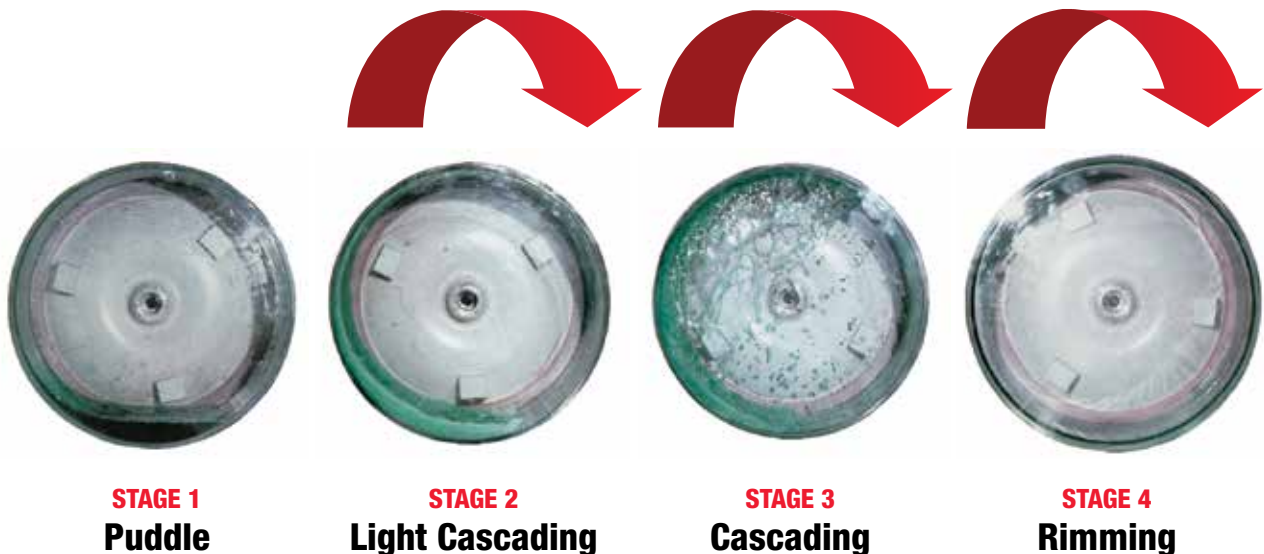
Various stages of condensate behavior are shown below. As machine speeds increase, the condensate eventually transitions to a rimming condition. Maximum heat transfer is achieved by maintaining a minimum condensate layer thickness.

Key considerations for corrugating efficiency include siphon size, minimal and stable clearance between the siphon pipe and the roll, and maintaining the siphon in the vertical, downward position. Finally, the siphon system must withstand machine vibration without compromising the siphon clearance.

DEUBLIN meets the challenge of reducing the condensate layer inside the roll to a minimum with our innovative design feature that allows siphon clearance adjustment from outside the roll. The benefits of reduced siphon clearance are:

- *Reduced condensate layer inside the roll, which increases the temperature on the roll surface improving production*
- *Elimination of roll flooding – accelerates start up*
- *Increased product uniformity and quality with reduced scrap rates*

Condensate Behavior



WARNING DEUBLIN unions should not be used to convey flammable media (flash point $\leq 140^{\circ}\text{F}$ or 60°C) as leakage may result in explosions or fires. DEUBLIN 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.

CORRUGATING OVERVIEW

Steam Joints

DEUBLIN steam joint and siphon systems enhance productivity by more reliably inducing steam into the rolls and removing condensate.

DEUBLIN systems eliminate a number of common problems:

- ⊗ Broken siphons
- ⊗ Short seal life
- ⊗ Leaking gaskets
- ⊗ Cold spots
- ⊗ Inability to adjust siphons
- ⊗ Broken rotors
- ⊗ Blistering

Types of Steam Joints:

Self-Supported, Rod-Supported and Bell-Supported

Self-supported steam joints are single-piece units that mount directly onto the roll journal, simplifying installation and replacement. Carbon graphite bushings support the steam joint housing relative to the rotor.

Rod-supported steam joints are mounted on support rods that are secured to the frame of the machine. This rigid support allows the steam joint to withstand side loads applied by the steam and condensate hoses.

Bell-supported steam joints are mounted to an existing bearing surface. The Bell is fabricated and rigidly secured to the bearing cover of the roll.

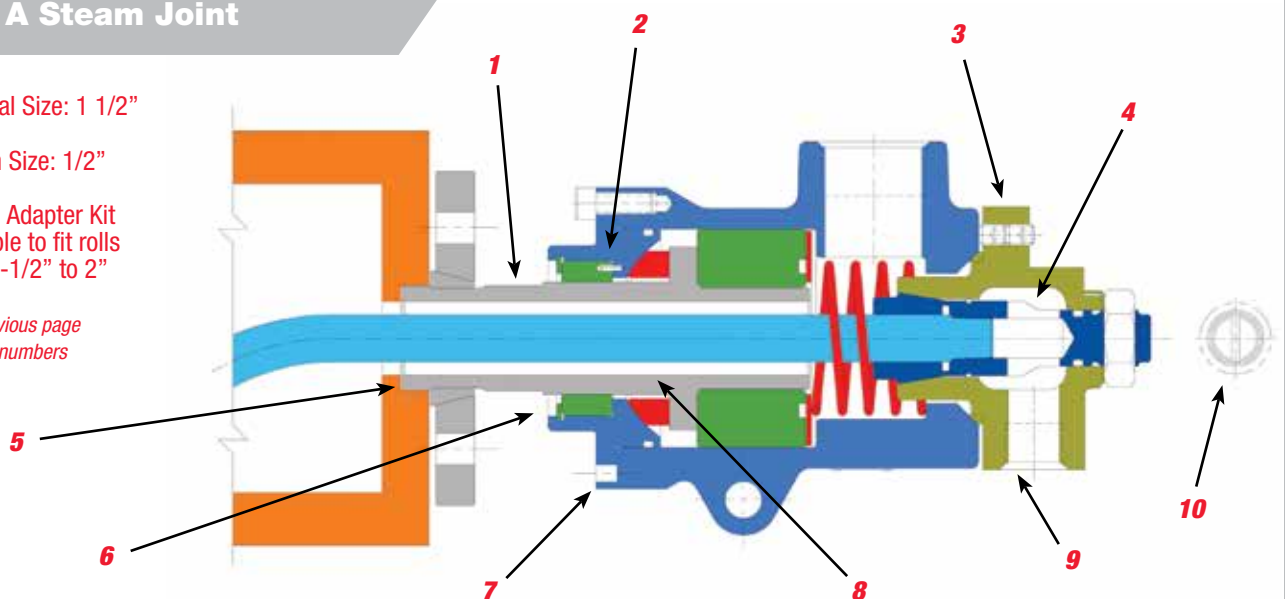
Features

- 1.** Heavy Duty Rotor eliminates rotor breakage and enhances operator mechanic safety
- 2.** Convex Seal Ring keeps carbon in compression (4 times stronger than concave rings in tension) to better withstand vibration, mechanical and thermal shock and pressure spikes
- 3.** Exclusive externally adjustable siphon orientation and clearance provides optimum condensate removal, improves heat transfer and helps eliminate blistering
- 4.** Clamping siphon support for increased siphon rigidity
- 5.** Large contact surface area provides better gasket sealing surface
- 6.** Seal Wear Indicator aids planned maintenance
- 7.** Jacking Screw allows ease of disassembly
- 8.** Heavy-duty thick wall rotor withstands greater torsion stress; eliminates rotor failures and enhances worker safety
- 9.** Adjustable End Cap can be oriented at multiple angles
- 10.** Alignment Slot ensures siphon drop leg at vertical downward position within the roll; split collar ensures rigid and secure attachment of siphon pipe

HPS A Steam Joint

- Nominal Size: 1 1/2"
- Siphon Size: 1/2"
- Flange Adapter Kit available to fit rolls from 1-1/2" to 2"

See previous page for part numbers



CMS50

Series for High Pressure Steam Service in Corrugators

CMS50S STEAM JOINT WITH STATIONARY SIPHON

The CMS50S has been designed for drop down stationary siphon application. The housing features a collet mechanism to offer a rigid support of the stationary siphon. This also allows the siphon pick-up surface to be held at a uniform clearance from the surface of the roll. In addition, the siphon clearance can be adjusted by an external siphon clearance adjustment mechanism.

CMS50R STEAM JOINT WITH ROTATING SIPHON

The CMS50R has been designed for a rotating siphon application commonly used in gun-drilled rolls. Sealing between the rotating siphon pipe and the housing is accomplished by an end face mechanical seal. The sealing pressure across the internal mechanical seal is equivalent to the differential pressure between the inlet of the steam and outlet of the condensate/steam mixture. Due to the reduced magnitude of pressure across the seal, torque, friction and wear of the seal are minimized, extending the service life of the seal.



Operating Data

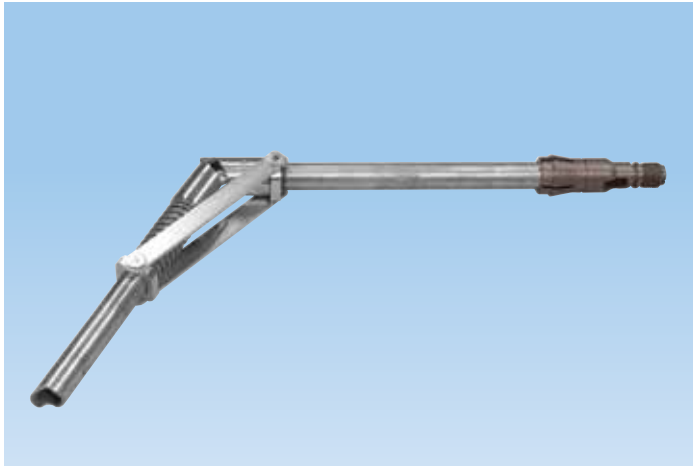
Maximum Saturated Steam Pressure	250 PSI	17 bar
Maximum Speed	400 RPM	400/min
Maximum Temperature	400°F	205°C



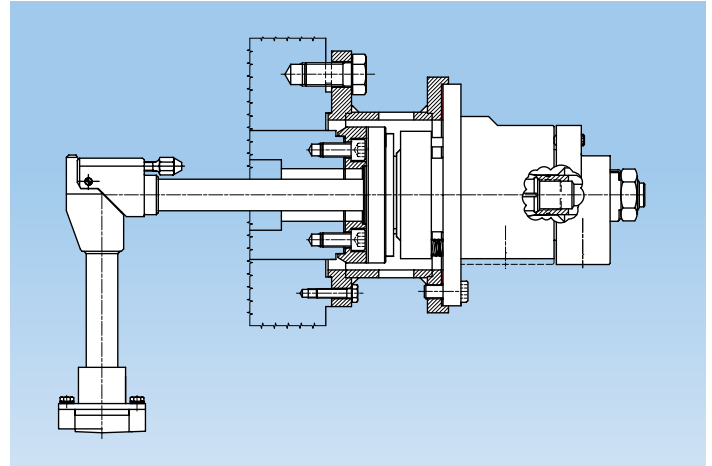
CMS Corrugating Steam Joints – Features and Benefits

Features	Benefits
Stationary and Rotating Siphon models available	<ul style="list-style-type: none"> Accommodates all corrugating machine types
Cartridge, flat-faced balanced mechanical seal	<ul style="list-style-type: none"> Reduces pressure, torque and wear, extending seal life Compensates for angular misalignment
Cartridge seal	<ul style="list-style-type: none"> Simplifies and reduces maintenance when servicing the seal
Wear indicator	<ul style="list-style-type: none"> Allows for visual inspection for preventative maintenance
Enclosed springs	<ul style="list-style-type: none"> Prevents spring hangup and premature failure
Rotating Siphon design utilizes dual Mechanical Seals	<ul style="list-style-type: none"> Eliminates Short Circuit of steam

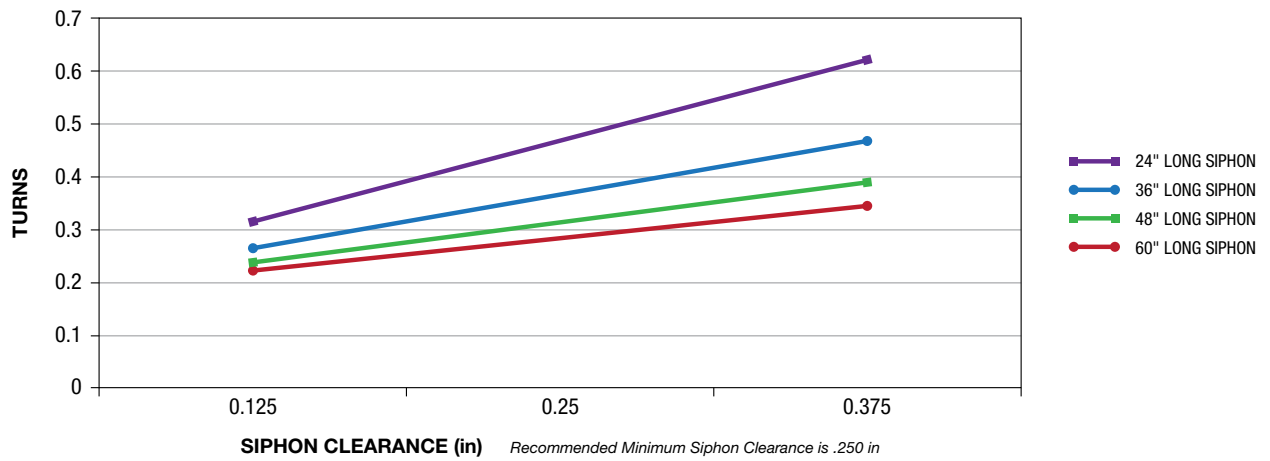
Spring Reinforced Siphon (SRS) Elbow Siphon



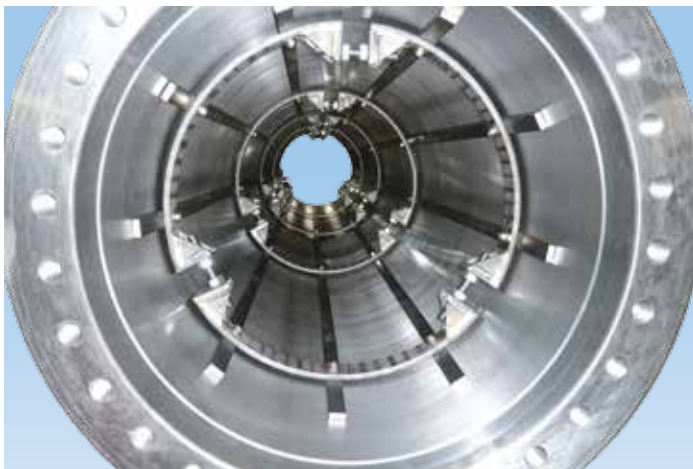
90° Elbow Siphon



ADJUSTMENT SCREW VS. SIPHON CLEARANCE



Turbulence Bars - breaks rimming condensate and improves heat transfer



CMS50R (Rotating Siphon)





Operating Data

Maximum Saturated Steam Pressure	250 PSI	17 bar
Maximum Speed	400 RPM	400/min
Maximum Temperature	400°F	205°C

HPS A

Series for High Pressure Steam Service in Corrugators

- Duoflow design
- Self-supported rotating union
- Seals and bearings made of special Carbon Graphite
- Convex seal ring better suited to handle mechanical and thermal shock
- External mechanism to adjust siphon pipe through end cap
- Stainless steel spring
- Heavy duty steel rotor design
- Dual bearings for extended service life
- Siphon Type: Stationary
- Siphon Size: 1/2"



Operating Data

Maximum Saturated Steam Pressure	250 PSI	17 bar
Maximum Speed	400 RPM	400/min
Maximum Temperature	400°F	205°C

HPS B

Series for High Pressure Steam Service in Corrugators

- Duoflow design
- Self-supported
- Seals and bearings made of special Carbon Graphite
- Convex seal ring better suited to handle mechanical and thermal shock
- External mechanism to adjust siphon pipe through end cap
- Stainless steel spring
- Heavy duty steel rotor design
- Dual bearings for extended service life
- Siphon Type: Stationary or Rotating
- Siphon Size: 3/4" Stationary; 3/4" & 1" Rotating



Operating Data

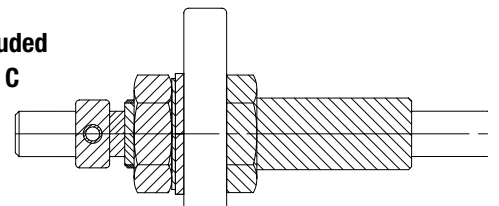
Maximum Saturated Steam Pressure	250 PSI	17 bar
Maximum Speed	400 RPM	400/min
Maximum Temperature	400°F	205°C

HPS C

Series for High Pressure Steam Service in Corrugators

- Duoflow design
- Rod Supported (by customer)
- Seals made of special Carbon Graphite
- Convex seal ring better suited to handle mechanical and thermal shock
- External mechanism to adjust siphon pipe through end cap
- Stainless steel spring
- Heavy duty steel rotor design
- Siphon Type: Stationary or Rotating
- Siphon Size: 3/4" Stationary; 3/4" & 1" Rotating

Rod Kit included with HPS C

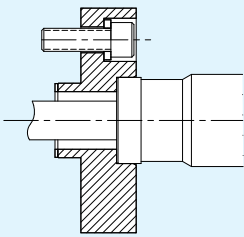


Mounting to DEUBLIN Supplied Rods

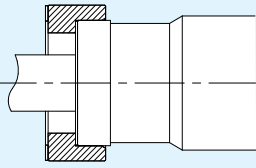
Flange Adapter Kits

1 1/4"

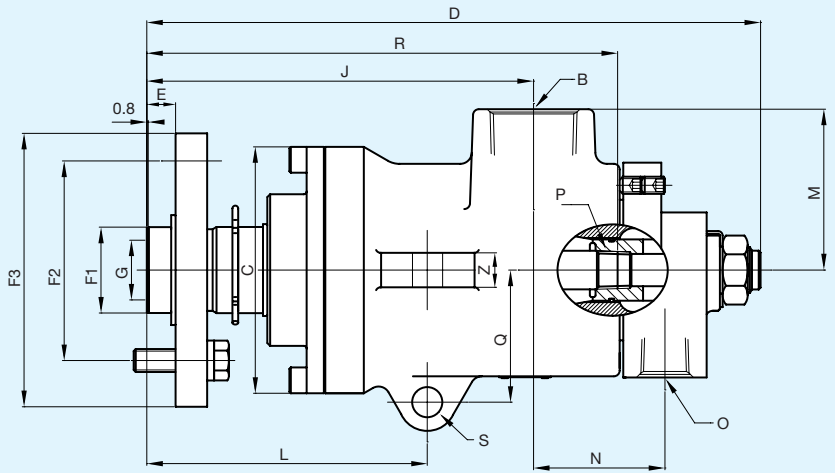
2"



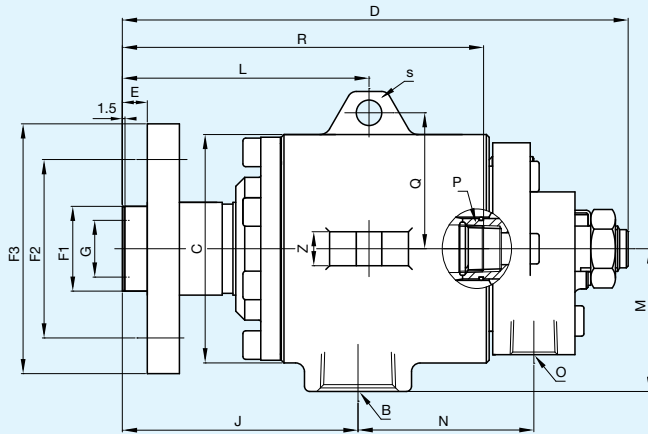
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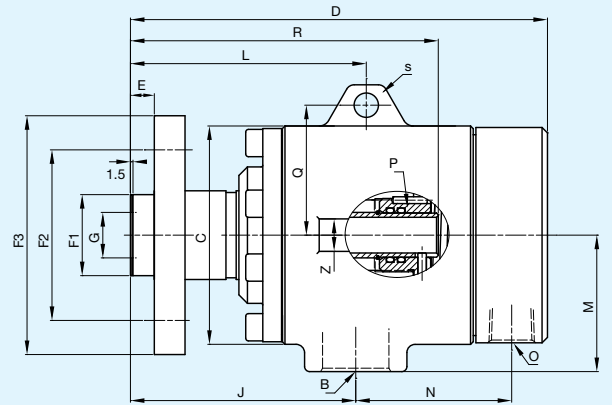
17894K



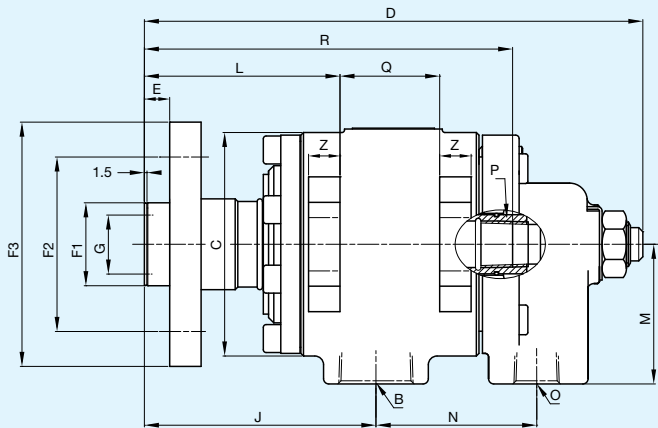
HPS A (HPS600012)



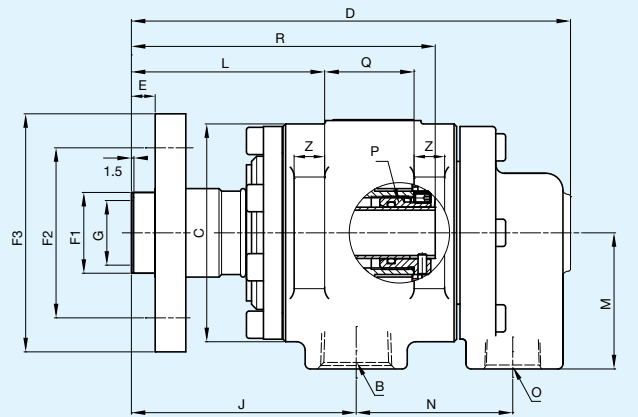
HPS B with Stationary Siphon (H40-052-220737)



HPS B with Rotating Siphon (H40-058-223741)



HPS C with Stationary Siphon (HS40-500013) with 7/8"-9 UNC Rods*
HPS C with Stationary Siphon (HS40-500014) with M20 x 2.5 Rods*



HPS C with Rotating Siphon (HS40-500016) with 7/8"-9 UNC Rods**
HPS C with Rotating Siphon (HS40-500015) with M20 x 2.5 Rods**

Union	Ordering Number	Siphon Size	B Port NPT	O Port NPT	C Ø	D	E	F1 Ø	F2 Ø	F3 Ø	G Ø	J	L	M	N	P	Q	R	S Ø	Z	Ship Weight
HPS A	HPS600012	1/2"	1 1/2"	3/4"	5 23/64"	13 23/64"	5/8"	1.870" / 1.868"	4 3/4" or 3 15/16" (4x) 9/16" Holes	5 61/64"	1 19/64"	8 27/64"	6 7/64"	3 1/2"	2 55/64"	1/2" NPT	2 7/8"	10 1/4"	2 1/32"	3/4"	38#
HPS B	H40-052-220737	3/4"	1 1/4"	3/4"	5 1/32"	11 5/32"	35/64"	1.870" / 1.868"	3 15/16" (4x) 9/16" Holes	5 33/64"	1 1/2"	5 13/64"	5 7/16"	3 5/32"	3 7/8"	3/4" NPT	3"	7 31/32"	9/16"	3/4"	38#
HPS B	H40-058-223741	3/4"	1 1/4"	3/4"	5"	9 5/8"	35/64"	1.870" / 1.868"	3 15/16" (4x) 9/16" Holes	5 33/64"	1 1/2"	5 13/64"	5 7/16"	3 5/32"	3 5/8"	1.017" / 1.015"	3"	7 7/64"	9/16"	3/4"	38#
HPS C	See above*	3/4"	1 1/4"	3/4"	5 3/64"	11 1/4"	5/16"	1.870" / 1.868"	3 15/16" (4x) 9/16" Holes	5 33/64"	1 1/2"	5 13/64"	4 13/32"	3 5/32"	3 5/8"	3/4" NPT	2 1/4"	8 5/16"	N/A	3/4"	45#
HPS C	See above**	1"	1 1/4"	3/4"	5 3/64"	10 1 1/64"	35/64"	1.870" / 1.868"	3 15/16" (4x) 9/16" Holes	5 33/64"	1 1/2"	5 13/64"	4 13/32"	3 5/32"	3 5/8"	1.187" / 1.185"	8 1/16"	7 1/32"	N/A	45/64"	45#



Since its establishment in 1945, Deublin has consistently adhered to a policy of producing the best product of its kind in the market. The result of this policy has been constant growth through the years. For this progress we are grateful to our many loyal customers. We cordially invite you to visit our modern manufacturing facilities in Waukegan, Illinois; Mainz, Germany; Monteveglio, Italy; and Dalian, China.

Sincerely,

Donald L. Deubler
Chairman of the Board



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



Mainz, Germany



Monteveglio, Italy



Dalian, China

AMERICAS

DEUBLIN USA

2050 Norman Drive
Waukegan, IL 60085-6747 U.S.A.
Phone: +1 847 689-8600
Fax: +1 847 689-8690
e-mail: customerservice@deublin.com

DEUBLIN Brazil

Rua Fagundes de Oliveira, 538 - A11 - Piraporinha
CEP: 09950-300 - Diadema - SP - Brazil
Phone: +55 11-2455-3245
Fax: +55 11-2455-2358
e-mail: deublinbrasil@deublinbrasil.com.br

EUROPE

DEUBLIN Germany

Florenz - Allee 1
55129 Mainz, Germany
Phone: +49 6131-4998-0
Fax: +49 6131-4998-109
e-mail: info@deublin.de

DEUBLIN Italy

Via Guido Rossa, 9
40053 Comune di Valsamoggia (BO), Italy
Phone: +39 051-835611
Fax: +39 051-832091
e-mail: info@deublin.it

ASIA

美 杜博林 Deublin 旋 接 授 代理

北方区联系方式：

信德迈科技(北京)有限公司 CNMEC Technology

地址：北京市朝阳区望京街 10 号望京 SOHO-T1-C 座 2115 室

*Tel: 010-8428 2935 | * Fax: 010-8428 8762

*手机：139 1096 2635

*电子邮件：sales@cnmec.biz

主页：<http://www.cnmec.net>



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