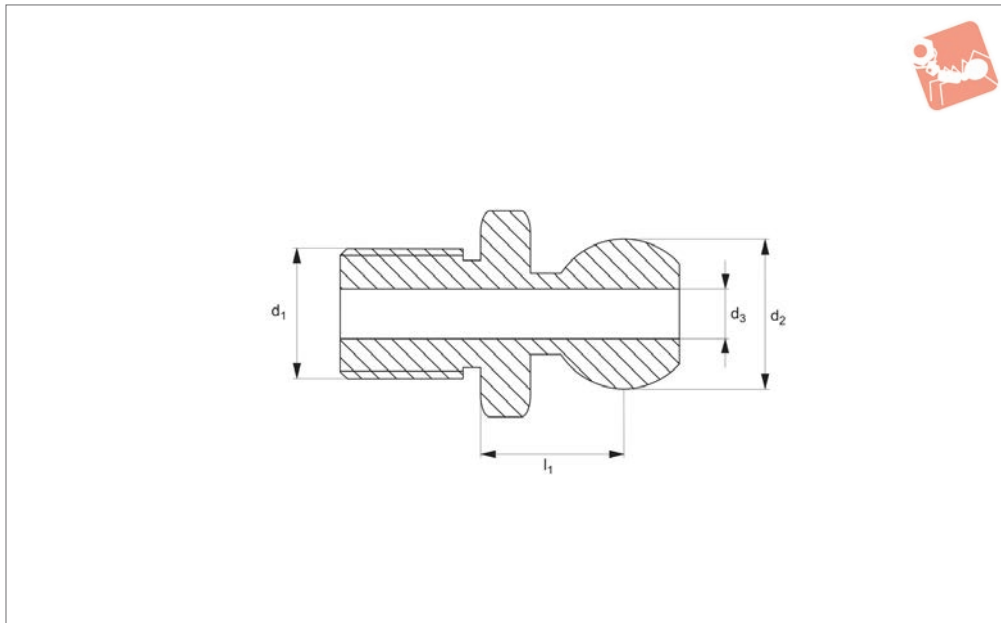




# Swivel Max. - Acetal Base Element

modular coolant nozzle system - max. 6,7 bar

## Coolant Nozzles



**20052**

COOLANT NOZZLES

### Material

Acetal.

Max. pressure: 6,7 bar.

### Technical Notes

Max. temperature: 43°C.

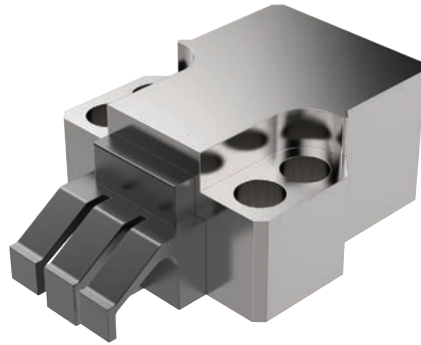
### Tips

For use with our Swivel Max. coolant nozzle system (20051 to 20059).

Order No.	Type	d <sub>1</sub>	d <sub>2</sub>	d <sub>3</sub>	l <sub>1</sub>
20052.W0100	Metric Fine	M10x1,25	12	5	10.2
20052.W0120	Metric Fine	M12x1,25	12	5	10.2
20052.W0140	Metric Fine	M14x1,00	12	5	10.2
20052.W1100	Metric Coarse	M10x1,50	12	5	10.2
20052.W1120	Metric Coarse	M12x1,75	12	5	10.2
20052.W1140	Metric Coarse	M14x2,00	12	5	10.2
20052.W2120	NPT/BSPT	1/8"	12	5	10.2
20052.W2250	NPT/BSPT	1/4"	12	5	10.2

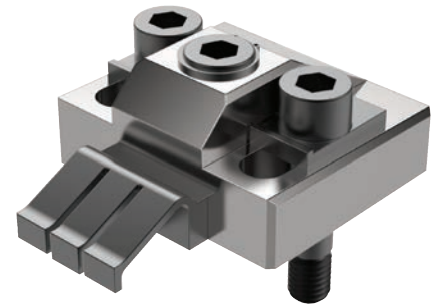


## Clamping Torque



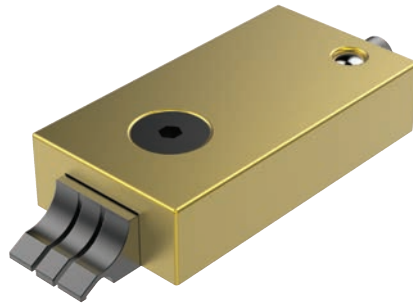
11040/CL2040

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
<b>Orifice diameter (mm)</b>	<b>Flow rate (litres/minute)</b>						
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
<b>Orifice diameter (mm)</b>	<b>Flow rate (litres/minute)</b>						
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

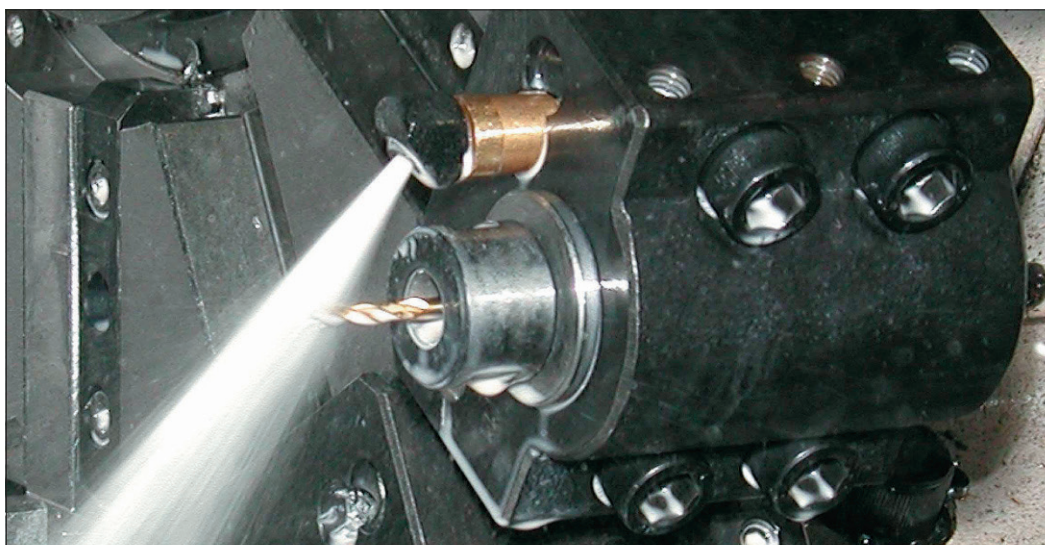
C = Constant of 17.11 x 10<sup>-5</sup>

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.

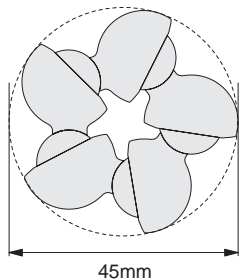




An extremely versatile system with an incredible range of motion in each joint – 72° either side of centreline! It's compact design is ideal for tight spaces. Available with fixed or variable flow nozzles and interchangeable orifices rated to 6.7 bar maximum and available with threaded or spherical bases. Vibration resistant joints provide superior reliability in CNC lathe turrets where inertial forces are high.

## Variations

Links swivel 72° either side of centreline enabling it to come full circle within a 45mm inscribed circle.

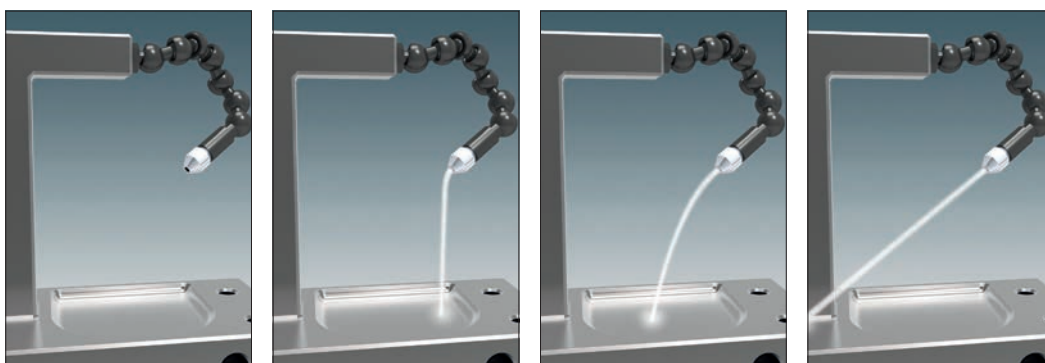


## Applications

The Swival Max coolant nozzle system with fixed flow end nozzles is ideal for CNC lathes due to its compactness and flexibility.



Variable flow end nozzles enable infinite flow control from full shutoff to full flow with fingertip control. They are ideal for manual and CNC mills.





# Swivel Max

## Modular Coolant Nozzle System

### 20051 - 20059

#### Fixing Elements

An extremely versatile coolant nozzle system compatible with new and existing installations.

### Build your flexible system for your application.



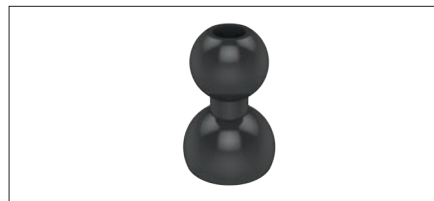
**20051 - Brass Base Element**  
For plain bore and screw location.

OR



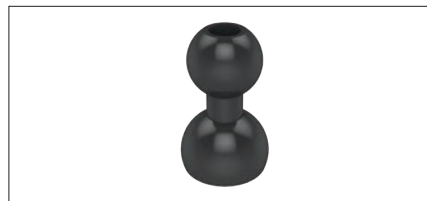
**20052 - Acetal Base Element**  
For easy screw in fixing.

**Base**



**20053.W0010 - Standard Swivel Max Extension Links**

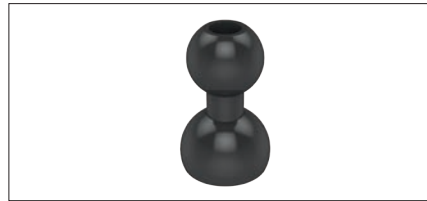
OR



**20053.W0120 - Connect from Swivel Max to LocLine.**

**Intermediate Links for Maximum Extension and Reach**

OR



**20053.W0130 - Connect from Swivel Max to SnapLoc.**



**20053.W0140 - Connect from LocLine to Swivel Max**

OR



**20053.W0150 - Connect from SnapLoc to Swivel Max.**

**Alternative Option**

Alternatively, connect from either LocLine or SnapLoc to our in-expensive and versatile swivel Max System.

COOLANT NOZZLES

ov-W20051-A-T-W20059-A-T-swivel-max-modular-coolant-nozzle-system-rnh - Updated - 26-10-2022