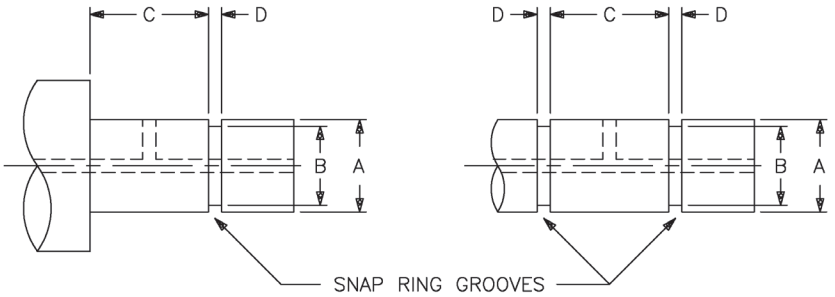
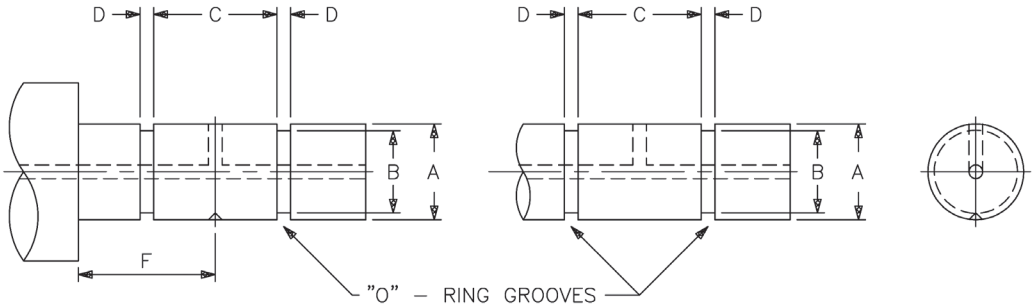
SHANK MOUNTING SPECIFICATIONS FOR THE GEORGE WHALLEY CO. STANDARD AND HIGH RPM ONE-PIECE ROTARY COOLANT GLANDS



A SHANK O.D.	B SNAP RING GROOVE O.D.	C GLAND BEARING WIDTH	D SNAP RING WIDTH	FOR USE WITH COOLANT GLAND NUMBER
0.9360/0.9340	0.8790/0.8850	1.380/1.385	0.046/0.048	CGH/CGS - 0937
1.249/1.247	1.172/1.180	1.380/1.385	0.056/0.060	CGH/CGS - 1250
1.624/1.622	1.524/1.534	1.630/1.635	0.068/0.072	CGH/CGS - 1625
2.249/2.247	2.114/2.126	1.815/1.820	0.086/0.091	CGH/CGS - 2250
2.749/2.747	2.596/2.608	1.755/1.760	0.103/0.108	CGH/CGS - 2750
3.499/3.497	3.310/3.322	1.815/1.820	0.103/0.108	CGH - 3500
3.999/3.997	3.786/3.798	2.002/2.006	0.120/0.125	CGH - 4000

SHANK MOUNTING SPECIFICATIONS FOR THE GEORGE WHALLEY CO. HIGH RPM TWO-PIECE ROTARY COOLANT GLANDS



A SHANK O.D.	B O-RING GROOVE O.D.	C GLAND BEARING WIDTH	D O-RING WIDTH	F SET SCREW POINT LOCATION	FOR USE WITH COOLANT GLAND NUMBER
1.249/1.247	1.135	1.000	0.090/0.094	0.906	CGH2 - 0937
1.499/1.497	1.380	1.000	0.090/0.094	1.000	CGH2 - 1250
1.999/1.997	1.885	1.250	0.090/0.094	1.063	CGH2 - 1625
2.561/2.559	2.375	1.500	0.138/0.142	1.188	CGH2 - 2250
4.249/4.247	4.025	1.500	0.175/0.185	1.531	CGH2 - 2750
1.999/1.997	1.885	1.250	0.090/0.094	0.906	801 - 083A
2.449/2.497	2.390	1.500	0.090/0.094	0.969	801 - 091

BREAK IN AND OPERATING RECOMMENDATIONS FOR AUTOMATIC AND MANUAL TOOL CHANGE COOLANT GLANDS

In order to assure proper lubrication, even wear, and proper seating, high RPM glands should be broken in at 100 RPM for 3 minutes with coolant introduced at a pressure and volume between 100 PSI and 500 PSI to prevent overloading seals. Repeat procedure at 500 RPM for 3 minutes, and again at 1000 RPM. After break in procedure is complete, units may be run at pressures between 100 PSI and 750/1000 PSI.

For maximum life and performance of these coolant glands and seals the following conditions are recommended:

1. Coolant filtration: 30 to 50 micron minimum; 5 micron optimum
2. Proper type & viscosity of coolant: preferably a good water soluble synthetic with good lubrication and heat dissipation under pressure.
3. Coolant pressure: minimum of 100 lbs. coolant pressure at high R.P.M's (1800 SFM or more based on I.D. dimension of coolant gland or O.D. bearing diameter of tool holder). Maximum pressure of 750/1000 PSI.
4. Coolant volume must be sufficient to properly lubricate cutting tool as recommended by its manufacturer. The combination of volume and pressure can not exceed the coolant orifice delivery capability of your tool or premature gland failure may result due to excessive heat build up.