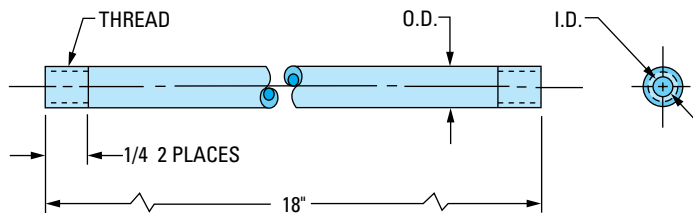


# Bubbler Tubes and Brass Diverting Plugs & Rods

## Bubbler Tubes

Available in brass or 304 stainless steel

DME Bubbler Tubes are used for cooling cores in moulds or dies. They are supplied threaded at both ends, thus permitting two threaded tubes to be cut from the 18" length supplied. They can be used as replacement tubes in Cascade Water Junctions.



### Brass Bubbler Tubes – BT

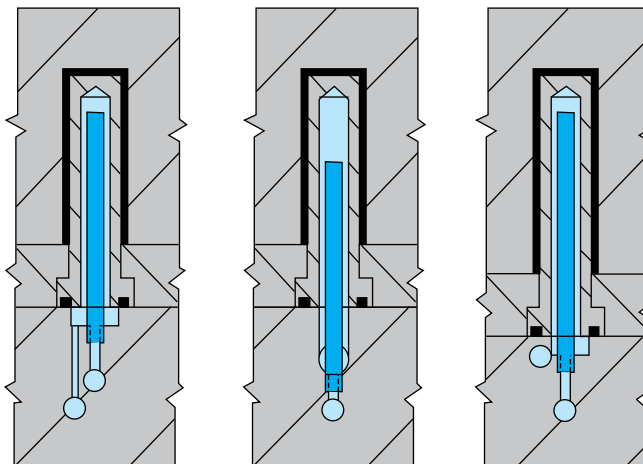
ITEM NUMBER	O.D.	I.D.	THREAD	Ø CHANNEL
BT-105	.125 <sup>+0.000</sup> / <sub>-.004</sub>	.069	NO. 5-44	.144
BT-210	.190 <sup>+0.000</sup> / <sub>-.004</sub>	.126	NO. 10-32	.228
BT-340	.250 <sup>+0.000</sup> / <sub>-.005</sub>	.170	1/4-28	.302
BT-450	.312 <sup>+0.000</sup> / <sub>-.006</sub>	.214	5/16-24	.377
BT-570	.437 <sup>+0.000</sup> / <sub>-.006</sub>	.307	7/16-20	.531

### 304 Stainless Steel Bubbler Tubes – BTS

ITEM NUMBER	O.D.	I.D.	THREAD	Ø CHANNEL
BTS-100	.093 <sup>+0.000</sup> / <sub>-.004</sub>	.078	NONE*	.120
BTS-105	.125 <sup>+0.000</sup> / <sub>-.004</sub>	.069	NO. 5-44	.144
BTS-210	.190 <sup>+0.000</sup> / <sub>-.004</sub>	.126	NO. 10-32	.228
BTS-340	.250 <sup>+0.000</sup> / <sub>-.005</sub>	.170	1/4-28	.302
BTS-450	.312 <sup>+0.000</sup> / <sub>-.006</sub>	.214	5/16-24	.377
BTS-570	.437 <sup>+0.000</sup> / <sub>-.006</sub>	.307	7/16-20	.531

\*Press fit

### Typical Applications

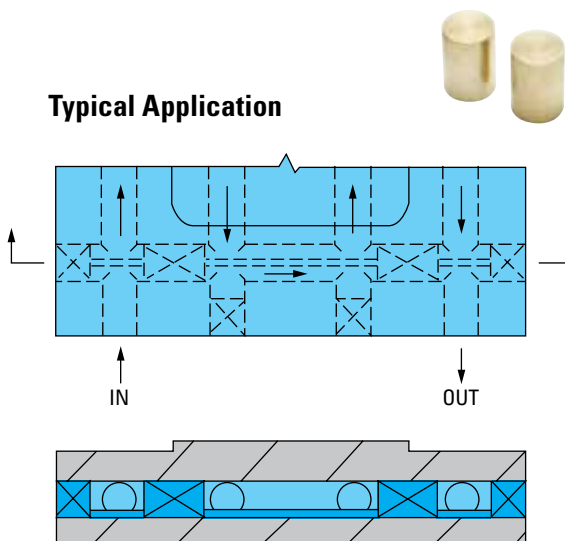


## Brass Diverting Plugs and Rod for Steam and Waterlines

DME Brass Diverting Plugs and Rods are used to redirect water flow through waterlines drilled in a mould or die.

The plugs are pushed into the waterline, and the rods are cut to appropriate lengths to serve as spacers or stops between the plugs. All plugs are proportionately longer than their diameter to ensure that they will pass by intersecting waterlines without twisting into them.

### Typical Application



### Brass Diverting Plugs – BF

ITEM NUMBER	DIA ±.002	LENGTH
BF-50	5/16	.62
BF-70	7/16	.62
BF-90	9/16	.75
BF-110	11/16	.87
BF-150	15/16	1.25

### Brass Rod – BFR

(1/8 dia. x 18" long)

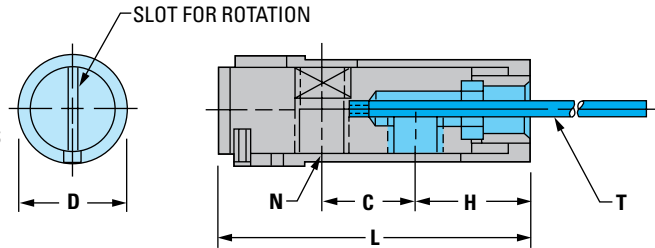
ITEM NUMBER
BFR-18

# Jiffy-Tite® Cascade Water Junctions

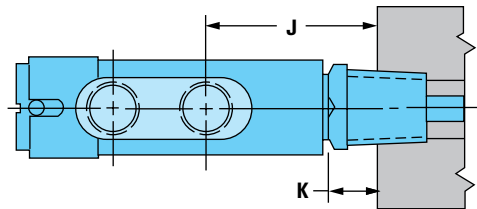
- Compact design
- 360° seal – leak proof
- Accurate predetermination of port locations
- Easy “one-piece” installation and removal



For cascade-type cooling applications, the Jiffy-Tite Cascade Water Junctions provide the utmost in versatility and ease of use. Their compact design makes them ideal for cooling inserted cores or spot cooling in hard to reach areas of moulds or dies. They can be rotated a full 360° without affecting their positive Jiffy-Tite seal and are easily connected and disconnected – even when installed internally.



Final location of the ports on the body of the Water Junction can be accurately predetermined, thus ensuring proper lateral alignment with pipe clearance holes. Waterlines may be connected to the same side or opposing sides of the Water Junction. A slot on the end of the Water Junction body indicates port position and can be turned with a screwdriver to align the ports with pipe clearance holes.



The brass tube has the rigidity to maintain uniform spacing inside the water channel and is threaded into the body for firm support.

## Jiffy-Tite® Cascade Water Junctions (JW)

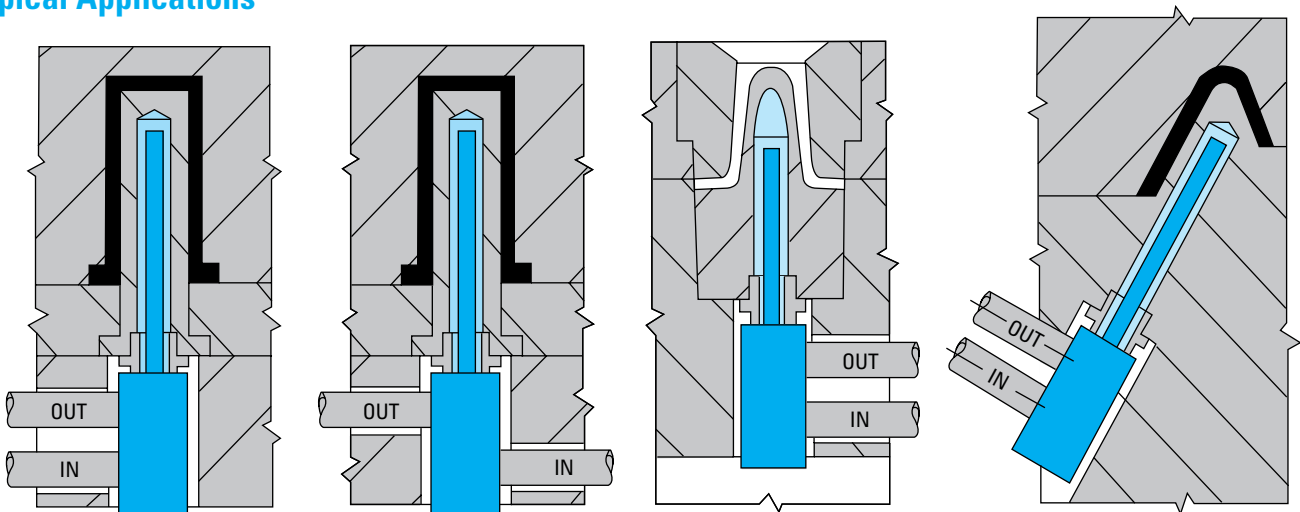
ITEM NUMBER	D	L	C	H	N N.P.T. (3 PLACES)	T 18" LONG TUBE SUPPLIED		
						O.D.	I.D.	THREAD
JW-220	.70	2.12	.69	.77	1/8	.190	.126	NO. 10-32
JW-320	.96	2.38	.69	1.03	1/8	.250	.170	1/4-28
JW-321	.96	2.69	1.00	1.03	1/8	.250	.170	1/4-28
JW-541	1.19	3.13	1.00	1.28	1/4	.437	.307	7/16-20

### NOTES:

1. Bubbler Tubes may be used as replacements in Water Junctions above.
2. The 200, 300 and 500 Series Water Junctions are equipped with 200, 300 and 500 series Viton seals respectively, rated at 1,379 kPa and suitable for temperatures up to 204°C.

REFERENCE DIMENSIONS FOR PORT LOCATION			
WATER JUNCTION ITEM NO	MATING JIFFY-TITE PLUG	J	K
JW-220	JP-251	.99	.21
	JP-252	1.24	.46
	JP-253	1.28	.50
JW-320 AND JW-321	JP-352	1.48	.42
	JP-353	1.51	.45
	JP-354	1.63	.56
JW-541	JP-554	1.96	.66
	JP-556	2.02	.72

## Typical Applications



# Cascade Water Junctions

DME Cascade Water Junctions are ideal for cooling plastics moulds and die-cast dies where drilled waterlines through the block are not possible due to interference with ejector pins, sprue puller pins, etc.

The brass tube has the rigidity to maintain uniform spacing inside the water channel and is threaded into the body for firm support. Waterlines may be connected to the same side or opposing sides of the brass hexagonal body.

The Nipple Type Water Junction provides low-cost rigid installation. The 2" long pipe nipple can be replaced with a longer pipe nipple to suit the application.

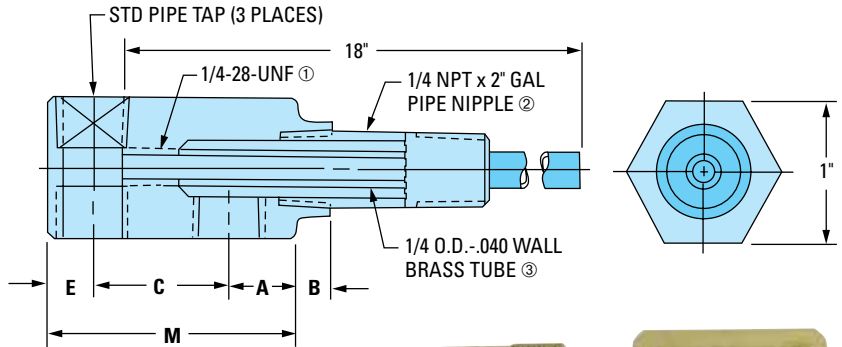
The Jiffy-Tite Socket Type is more easily connected and disconnected when mould is set-up, transported or stored. The socket is equipped with internal Viton seals (P300-8).

**NOTE:** Bubbler Tubes may be used as replacements in Water Junctions.



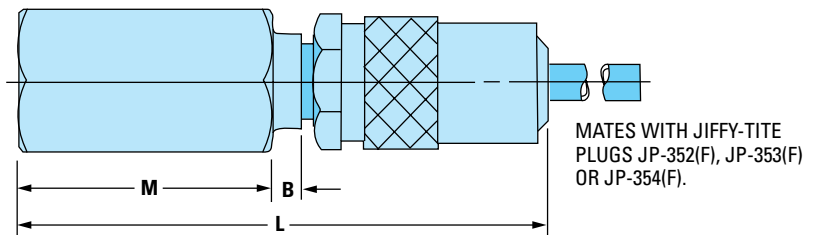
NIPPLE TYPE

## Nipple Type – DC (Includes pipe nipple and brass bubbler tube)



JIFFY-TITE SOCKET TYPE

## Jiffy-Tite Socket Type – JSC (Includes brass bubbler tube)



NIPPLE TYPE ITEM NUMBER	STD. PIPE TAP (3 PLACES)	M	E	A	B	C	L	JIFFY-TITE SOCKET TYPE
								ITEM NUMBER
DC-131	1/8	1.34	.33	.33	.22	.69	—	—
DC-131-A	1/4	1.34	.33	.33	.22	.69	3.29	JSC-304
DC-132	1/8	1.84	.34	.50	.25	1.00	—	—
DC-132-A	1/4	1.84	.34	.50	.25	1.00	3.82	JSC-314
DC-136-A*	1/4	1.84	.34	.50	.25	1.00	—	—

\*SPECIFICATIONS for DC-136-A (see drawing above): ① 5/16-24 UNF ② 3/8 NPT x 2" ③ 5/16 O.D. - .040 WALL

## Typical Applications

