Content

Product range

Filtration


Suction filters


Clogging indicators


Ventilating filters


Return filters


Pressure filters


Return-suction filters


High pressure filters


Return-suction filters

Description

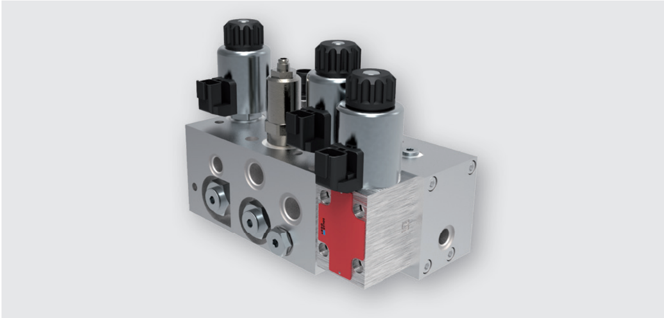
ARGO-HYTOS produces sophisticated filter solutions together with hydraulic and lubrication systems. The range of solutions we have implemented extends from fixed-position industrial plants to mobile applications.

As well as customized developments, exactly adjusted to the individual requirements of the customer, ARGO-HYTOS offers a comprehensive range of innovative standard solutions for a wide variety of applications:

› Suction filters
› Return-suction filters and return filters
› Pressure and high-pressure filters
› Filling and ventilating filters
› Filter accessories

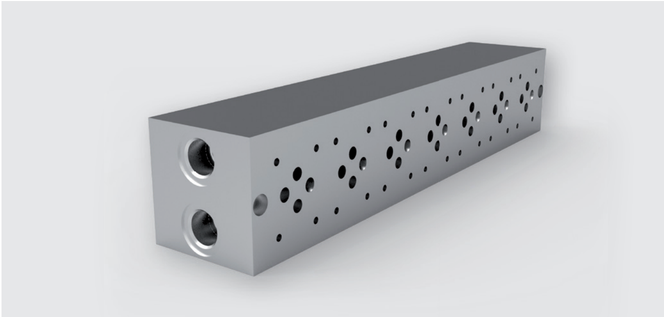
Fluid and Motion Control

Customized solutions



Control solutions

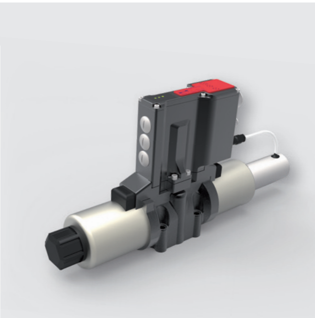
Gear pumps



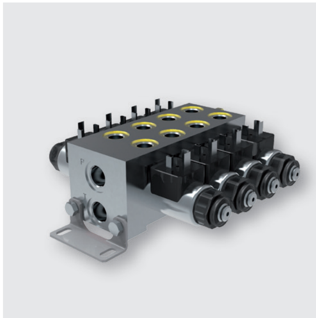
Plates

Product range

Fluid and Motion Control


Directional and proportional valves

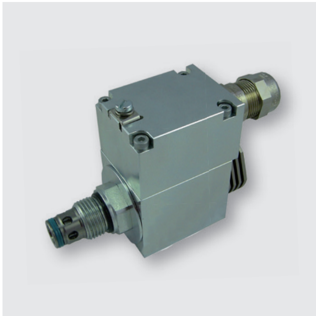

Modular valves

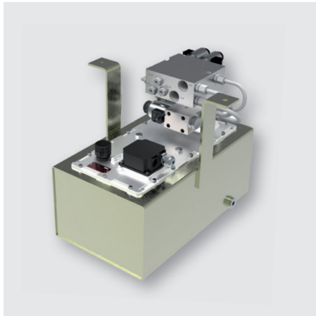

Sandwich valves


Screw-in cartridge valves


Slip-in cartridge valves


Load motion cartridges


Explosion proof valves


Hydraulic power packs

Description

ARGO-HYTOS' expertise in control technology is the fruit of more than 65 years' experience. We focus here on a wide range of valves, power units and integrated manifolds featuring all commonly used design features and functions, together with proportional valves and the associated control electronics:

› Directly operated directional valves in CETOP 02 to CETOP 05 and pilot operated directional valves in CETOP 07 and CETOP 08
› Valves sub-plate and sandwich type – flow control, pressure and check valves in CETOP 02 to CETOP 05
› Cartridge valves
› Directly activated proportional valves with compensator sandwich valve, in CETOP 02 to CETOP 05
› Analog and digital control electronics – on-board, or for installation in control cabinets
› Power pack assembly kits
› Customized control blocks

Fluid Management


Off-line filter


Off-line filter


Off-line filter unit


Off-line filter unit


Oil service unit


Oil service unit


Dewatering system


Dewatering system

Description

As well as reducing maintenance and servicing costs, effective fluid management is also a key factor in boosting the reliability, productivity and cost-effectiveness of the operation.
ARGO-HYTOS supplies application-oriented products for manual and automatic cleaning of hydraulic fluids:

› Off-line filters
› Off-line filter units
› Filter cooling systems
› Oil service units
› Dewatering systems

Sensors and Measurement


Portable particle counter


Portable oil lab


Particle monitor


Wear sensor


Condition sensors


Pressure sensor


Remote interfaces / display units


Valve electronics

Description

Systems that provide reliable assessment of the condition of hydraulic fluids are the key feature of continuous fluid monitoring.

Sensors and measurement technology from ARGO-HYTOS precisely target this range of tasks. Our fluid monitoring products comprise equipment and system solutions to enable online monitoring during continuous operation as well as analysis of bottled samples under laboratory conditions.

› Portable oil diagnosis equipment
› Stationary and portable particle monitor
› Oil condition sensors
› Software to evaluate data and analyze trends

Guideline

Tips and information on how to select the optimal hydraulic filter

ARGO-HYTOS Return-Suction Filter E 198

Preface

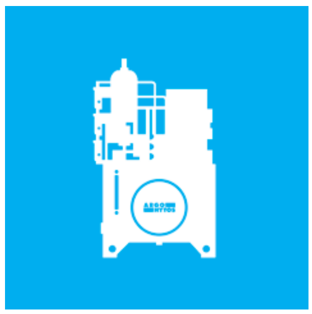
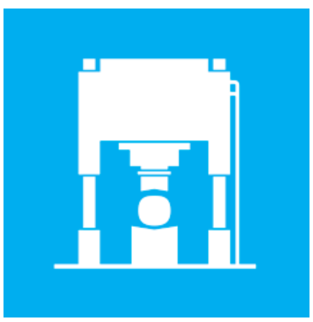
When determining the required cleanliness in a hydraulic system, additionally to the technical requirements of the hydraulic components and to the operating pressure, the user's expectations to availibility, safety and service life of a machine become increasingly important. These aspects were particularly taken into account in the present ARGO-HYTOS guideline.
Detailed attention is also given to two filter concepts which are becoming increasingly important: return-suction filters and off-line filters.
More than ever before, the ARGO-HYTOS Guidelines offer useful advice on selecting technically and economically ideal filter concepts for hydraulic systems, and experts will also find that they contain important information.

Did you know that …

- fresh oil can often contain 10 times more dirt particles than are acceptable for hydraulic systems of high technical quality?
- if the operating pressure is increased by only 50 %, the number of dirt particles in the oil must be reduced by a factor of 3 to avoid a deterioration in the lifetime of the components?
- even a filtration quotient of $\beta = 200$ corresponds to filtration efficiency of 99,5 % for all dirt particles that are larger than the specified size, and a β-value of only 10 still corresponds to 90 % efficiency?
- even oil sample bottles declared as clean can contain considerably more dirt particles than the examined oil, if it comes from hydraulic systems with good filtration?
- a lifetime of 1.000 service hours for a hydraulic filter corresponds to a mileage of about 60.000 km of a passenger car?
- only an online count can determine the actual values for cleanliness classes < 10 (ISO 4406)?

Our know-how - your benefit




At ARGO-HYTOS, the focus is consistently on the customer – and a major element of our development work is to implement customer-specific solutions for filters and systems.

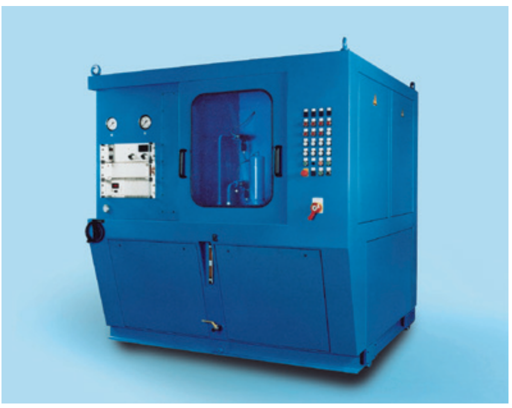
Continuous improvement of our filter elements is another major goal of our development work: for example, this includes increasing the dirt capacity while keeping the installed volume as small as possible. This optimization goal is excellently achieved by our range of standard return-suction filters – just one example of many.

Our sales engineers are just as reliable as our filters themselves. They are trained and experienced filter specialists who speak YOUR language. We believe that before the actual sales discussion there should be the best possible technical advice and assistance with planning if requested. This is the only way to ensure that our customers make the right purchase.

Another benefit from ARGO-HYTOS:

Spare parts can be delivered from our factories in the shortest possible time – and what is more, our subsidiaries in all important industrial countries and representatives all over the world always keep minimum stocks available. This ensures you rapid access to our know-how and our products.

Multi-Pass test rig



Collaps/burst pressure test rig

Test rig to determine pressure drop

The key feature of the entire hydraulics sector is that – for understandable reasons – users are setting demanding (and ever increasing) requirements for the quality and efficiency of the filters that are used. The testing technology used to develop filters must also meet these requirements. And this is where the difference between "filters" and ARGO-HYTOS filters emerges very clearly!

ARGO-HYTOS operates testing rigs that are equipped with ultra-modern technology, enabling fast test sequences, extended testing procedures and accurate documentation of all the parameters:

› Multi-Pass test rig
› Collapse/burst pressure test rig
› Test rig to determine pressure drop
› Test rig to prove the flow-fatigue resistance characteristics
› Pressure pulse test rig to confirm fatigue strength

The ARGO-HYTOS Test Department is highly equipped with efficient testing equipment and human resources, and it plays a major part in the development of new technologies. Practical requirements can already be taken into account during filter trials in the test laboratory. Individual customer requirements are incorporated into the development process in the form of load tests which reflect practical conditions. The performance parameters of the test rigs we have installed allow us to test all filters throughout their performance ranges.

The state-of-the-art **Multi-Pass test rig** enables us to determine filter efficiency data according to ISO 16889.

The **collapse/burst pressure test rig** (for testing according to ISO 2941) is used to determine the specified permissible differential pressure; if this pressuredifference is exceeded, the element would be damaged.

The **test rig to determine pressure drop** in filters and their components (such as housings, filter elements and valves) is based on ISO 3968. It is suitable for testing the pressure loss in relation to the flow rate, and in relation to the kinematic viscosity. This also makes it possible to determine the pressure loss in a filter for unfavourable operating conditions – for example, at a cold start.

Here at ARGO-HYTOS, the **flow fatigue resistance characteristics** of filter elements are determined on the test rig according to ISO 23181, in such a way that a Multi-Pass test can be carried out afterwards. After the fatigue test, this means that the filter characteristics can be compared with the values of a new filter. Tests carried out on this rig are very important as they regard extending the intervals between filter element changes. Long-term loads of 1 million cycles or more may occur during practical use: these can be simulated within a short time on the test rig using a testing frequency of up to 1 Hz.

The **pressure pulse test** rig is used to validate filter casings to maximum pressure for lifetime, up to 5 weeks, in order to test fatigue strength – and this can be done up to 600 bar.

Alongside the laboratory tests, "field trials" are carried out at customers' applications. The filters are put to the test in practice, under tough operating conditions. Thanks to these "field trials" which can often go on for months, even the smallest weak point is sure to be discovered. The result:

ARGO-HYTOS offers tested quality and safety from A–Z.

ARGO-HYTOS service vehicle in use

The ARGO-HYTOS service vehicle

Oil cleanliness requirements are becoming stricter as time goes on. Filters are now expected to offer service lifetimes of 1.000 hours or more. Oils that stay clean not only extend the usual intervals between oil changes – they also prevent faults during operation, and they substantially extend the lifetimes of all the hydraulic components. Only in rare instances do we know how clean or dirty the pressure fluid in a hydraulic system really is. In many cases, the medium is only examined when a failure occurs or when damage is noticed. ARGO-HYTOS has developed its mobile customer service so that potential risks can be identified.

The ARGO-HYTOS service vehicle can travel to you whenever you need it. Oil samples can be analyzed on the spot, and we can determine the type and size of the dirt particles in the pressure fluid just a short time after the samples have been taken. This means that we can make appropriate suggestions about improving or redesigning the filtration in your hydraulic system while we are still on site.

Furthermore, the ARGO-HYTOS service vehicle plays a vital part in our development work resp. in carrying out on-site field tests.

Portable oil diagnostic device OPCount

Oil diagnostic systems

Portable oil diagnostic systems make it possible for you, the user, to carry out oil analyses yourself on your own systems – at any time.

This instrument can be used in two different ways:

Analysis of samples in bottles
Small quantities of oil are taken from a suitable location in the system; the samples are filled in bottles and examined. Maximum cleanliness must be ensured both for the sampling process and the bottles themselves, so that the results of the measurements are not unintentionally affected by dirt from external sources.

Online analysis
Online analysis is based on continuous sampling with the help of a measuring hose – so external influences on the measured results can be virtually ruled out in this case. Depending on the sampling location, the oil diagnostic equipment must also be able to withstand the maximum system pressure, as well as to provide reliable measurements at low pressures.

The most important benefit of portable oil diagnostic systems is that the results are always available after just a few minutes. This means that any action that is needed can be initiated as quickly as possible. Convenient evaluation and documentation of the results is provided thanks to a PC interface and appropriate software, making it easy to identify any changes and trends.

It is possible to monitor the cleaning procedure by using oil diagnostic equipment in combination with mobile off-line filter systems. As soon as the desired level of oil cleanliness has been reached, the filtration process is stopped. This also makes it possible to fill systems with oil that has a defined level of cleanliness.

Permanently installed equipment for online oil cleanliness monitoring is ideal for cyclical monitoring of oil cleanliness in hydraulic and lubrication systems, and it also offers benefits in terms of preventive maintenance and early detection of damage in large systems. Suitable interfaces can be used to provide a direct link to the machine control system.

Suction filters

Return filters

Pressure filters

High-pressure filters

The ARGO-HYTOS procedure for selecting a filter

The selection procedure described below makes it easy for you to select the right filters for hydraulic systems. To simplify matters, the procedure is broken down into these steps:

› determine the right filter type
› determine the filter fineness that is needed
› determine the filter size that is needed
› other considerations

This filter selection procedure is based on many years of practical experience with countless mobile and industrial hydraulic systems that are equipped with correctly chosen ARGO-HYTOS filters.

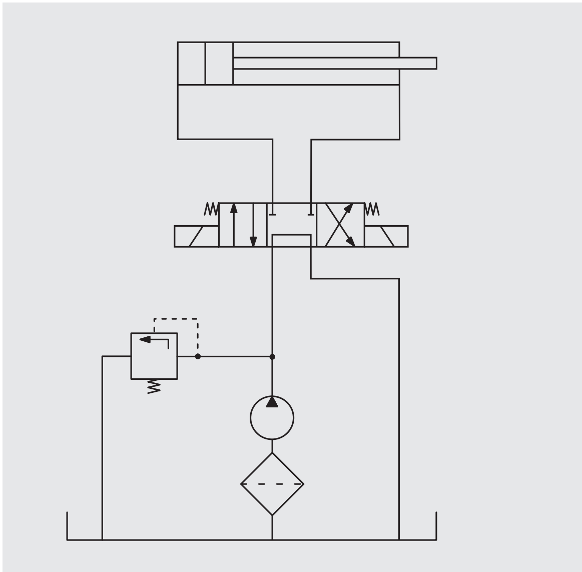
How to determine the proper filter type

Unfortunately, there is no generally applicable concept which dictates the proper type of filter for each of the different hydraulic systems. To a large extent, the decision on whether to use suction, return, pressure or high-pressure filters – or a combination of these types – depends on these factors:

› the contamination sensitivity of the components in the existing or planned system
› the priority given to protect the function of the component, or to prevent wear
› design or requirements of pumps,motors and valves, which may result in specified requirements from the compone manufacturer
› the way dirt is generated, the locationswhere it occurs and the possibility of ingression from outside

Depending on these factors, the criteria detailed below should be taken into account when you are choosing from possible types of filters. A basic distinction can be made here between protective filters that protect the function of components, and working filters that attain a specified level of cleanliness for the pressure fluid.

1



Hydraulic system with suction filter

2

Suction filter ES 075

Suction filters

Hydraulic systems have to be fitted with a suction filter if there is a particularly high risk of damage to the pump from coarse contamination (Figure 1).

Typical applications of this sort include:

› systems with a common oil reservoir for working hydraulics and gear transmissions.
› units with oil tanks of large dimensions and/or complex shapes, or those which are welded or casted. Experience shows that 100% cleaning of the tank prior to assembly is impossible under these circumstances.
› systems that are filled under difficult conditions in the field.

Often relatively coarse suction filters (e.g. screen filter elements with a mesh size of 40 - 125 µm) are planned that can only guarantee functional protection for the pump. In this case, the required protection against wear on the hydraulic components must be ensured by a finer filter at another location.

Specialized literature and company publications sometimes advance the opinion that the use of finer suction filters with paper or glassfiber elements is either impractical or inadvisable: however, this view is not tenable. Positive field experience – even with filter finenesses of 16 µm abs. – in hydraulic systems (especially in the mobile sector) have demonstrated that these objections are not justified.

However, it is essential to consider the following criteria when designing a hydraulic system with a suction filter:

› low pressure drop on the clean filter, due to optimal design of the filter element and housing, also taking account of high start viscosities
› filter monitoring with a vacuum switch or vacuum manometer
› the filter element must be easily accessible and simple to replace for maintenance purposes
› the suction pipe should be designed with the lowest possible pressure drop, i.e. large nominal width (inner diameter), few and/or constant changes of direction (bent pipe instead of 90° fittings) and shortest possible length
› the oil tank should be positioned higher than the pump (gravitation drop)
› the system should be designed so that the planned operating temperature is reached as soon as possible after a cold start (tank volume should not be too large, oil cooler should be bypassed during the cold start phase)
› the hydraulic oils used should have the lowest permitted viscosity and a low increase in viscosity if the temperature drops (high viscosity index)
› the pump types used should not be very sensitive to cavitation (e.g. gear pumps).

ARGO-HYTOS's ES filter line offers a range of easy-to-maintain tank-mounted suction filters that have proven their excellence, especially in hydrostatic transmissions on mobile equipment (Figure 2).

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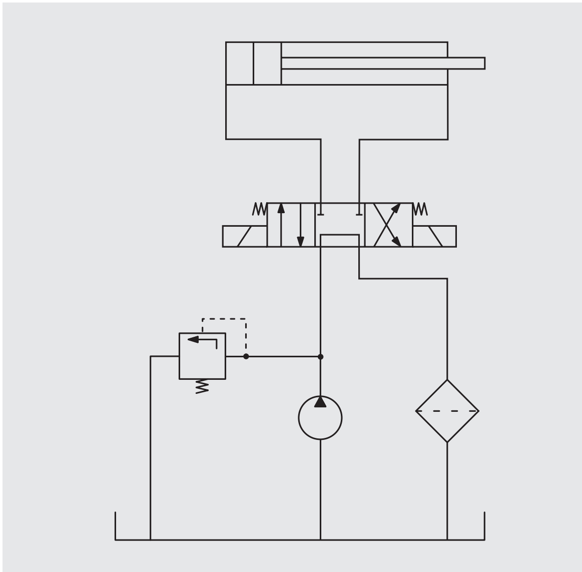
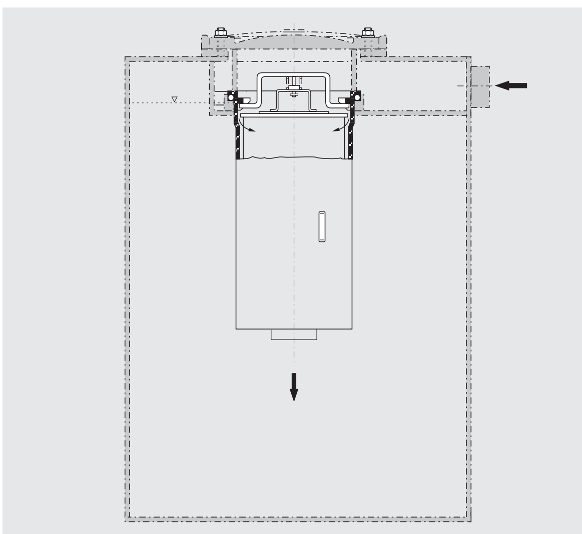


Hydraulic system with return filter

2



Return filter E 441 ... E 700 for installation in tanks

3

Return filter E 103 for tank installation with integrated tank ventilating filter

Return filters

It is particularly beneficial to use filters that are mounted on the tank or integrated in it, because this method allows filtering of the entire oil flow (full flow filtration) at low cost and with low space requirements (Figure 1).

Full flow filtration in the return flow protects the pumps against dirt which penetrates the system from outside (especially via hydraulic cylinders) or which is generated by abrasion.

When selecting the right filter size, it is essential to consider the maximum possible flow rate. Depending on the area ratio between the piston and piston rod side of the hydraulic cylinder, this is larger than the flow rate for the pump(s) (for cylinders with single-ended piston rod.

Full flow filtering in the return may be problematic, and is therefore inadvisable. If the maximum flow rate is very high in relation to the pump flow rate (for example due to a large area ratio for the cylinders, and/or due to the emptying of hydro-accumulators.

The maximum pressure build-up (mainly determined by the actuating pressure and characteristic curve of the bypass valve) should be considered on the basis of these conditions:

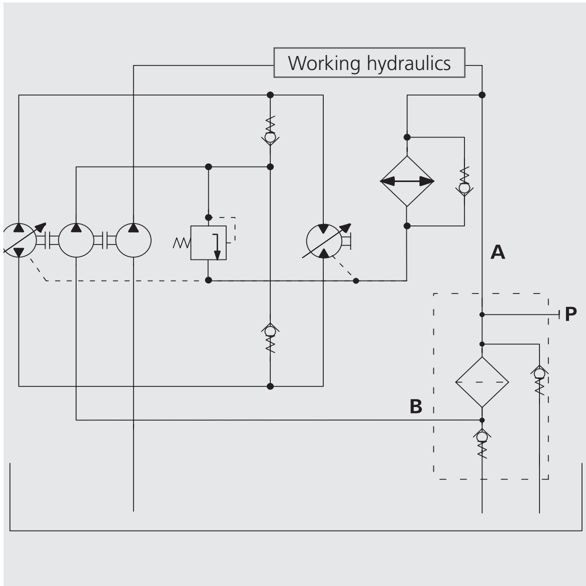
› if drain lines for pumps and/or hydro-motors are connected to the return filter system, the maximum pressure build-up specified for these components by the manufacturer must not be exceeded. (The limitation is usually on the sealing rings of the input/output shafts).
› in certain cases where several components are connected in a system, high pressure build-up can trigger uncontrolled functions – for example, the hydraulic cylinders may be moved out unintentionally.

To prevent oil foaming in the tank, it is essential to ensure that the oil out et is always below the oil level under all operating conditions. The distance from the tank bottom should be 2 to 3 x the diameter of the outlet (extension pipe diameter), in order to avoid swirling particles which have already settled on the bottom.

At a very early stage, ARGO-HYTOS pushed the consistent introduction of return filters for mobile units mounted below the tank surface, in a separate oil return chamber.

As long ago as 1971, ARGO-HYTOS was the first manufacturer to launch tankmounted return filters on the market, with integrated tank ventilating filter within the filter head (Figure 3).

1



Hydraulic system with return-suction filter

2

ARGO-HYTOS return-suction filters

Return-suction filters

ARGO-HYTOS first developed its return suction filters in the mid-1980's. On equipment with a hydrostatic drive and combined working hydraulics, these filters replace the suction and/or pressure filters that were previously required for the filling pump of the closed hydrostatic drive, and in an open circuit they replace the return filter for the working hydraulics (Figure 1).

The benefit of these filters is that filtered oil is fed to the filling pump at an overpressure of 0,5 bar, avoiding the risk of cavitation in the filling pump so that excellent cold start characteristics are possible.

In order to maintain a boost pressure of approx. 0,5 bar at the connection to the filling pump, a surplus between the return and suction flow is required under all operating conditions.

A pressure relief valve is used to feed the oil directly into the tank starting from a Δp of 2,5 bar (so no bypass for the closed circuit!).

If the drain oil from the hydrostatic drive is fed through the filter as well as the flow in the open circuit, remember that – in order to protect the radial shaft seals – the permissible drainline pressure must not be exceeded (taking account of the pressure drop in the drain lines, the oil cooler and the pressure relief valve on the filter).

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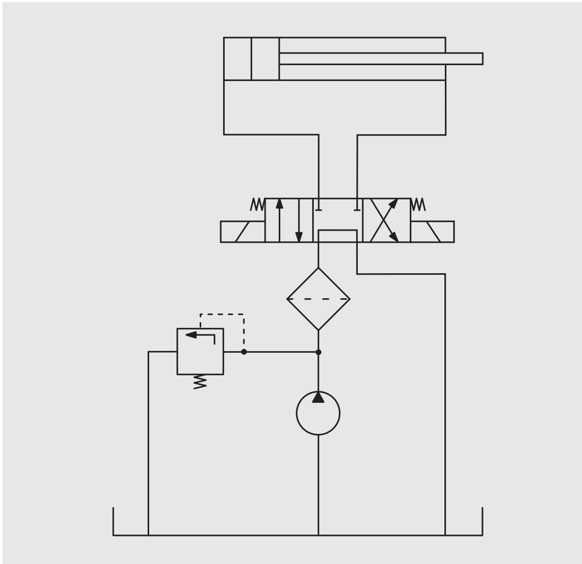


Hydraulic system with high-pressure filter

2

ARGO-HYTOS high-pressure filter HD 419

Pressure and high-pressure filters

The main function of this type of filter is to ensure that the functions of downstream hydraulic components are protected. For this reason, these filters are installed directly upstream of the components if possible (Figure 1).

Taking account of the risks of dirt penetrating the system from outside and the possibility of pump abrasion, the following aspects can be particularly decisive for the use of a pressure or high-pressure filter:

- the components are particularly sensitive to dirt (such as servo valves) and/or they are integral to the functioning of a complex system
- the components are particularly expensive (such as large cylinders, servo valves, hydromotors) and they are extremely important for the safety of the equipment (such as hydraulic steering, transmission or brake systems)
- exceptionally high costs are possible if a system is shut down due to malfunctions or damage to a hydraulic component caused by contamination.

High pressure filters must withstand the maximum system pressure, and in many cases the fatigue strength must also be guaranteed because there are frequent pressure peaks in the system.

ARGO-HYTOS is convinced that safety is very important. For example, casings must undergo a fatigue strength test before they are released for series production, and leakage tests are performed regularly during production.

In many cases, high-pressure filters carry out their function by filtering only part of the flow or only relatively coarse particles. In these cases, the filter basically operates as a safety filter. Under these conditions, a fine filter should be positioned at another point in the system so as to take account of the requirements for protection against wear.

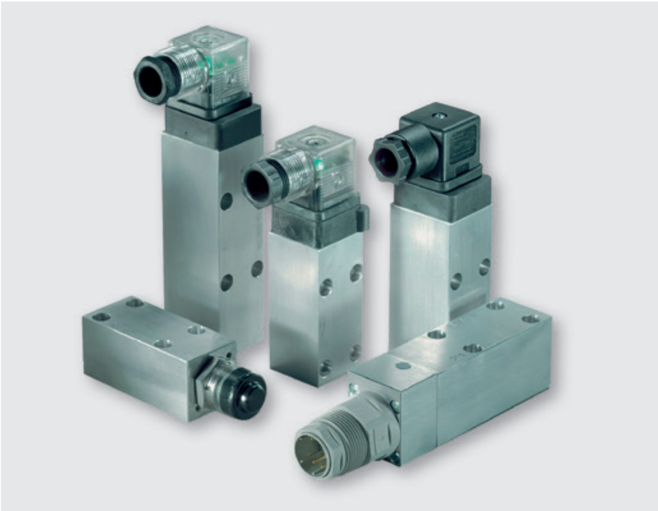
High-pressure filters that mainly work as safety filters should preferably be equipped with a differential pressure switch that monitors the contamination of the filter element. Only high-pressure filters without a bypass valve should be fitted upstream of particularly critical components. Those filter types must be fitted with a high collapse filter element that itself is able to withstand higher differential pressure loads without damage.

In this case, a decisive influence on the maximum differential pressure is the ratio between startup viscosity ν_2 and operating viscosity ν_1.

Assuming that the filter element is changed when the differential pressure indicator responds, the following formula can be used to determine the highest possible differential pressure that will occur on the element:

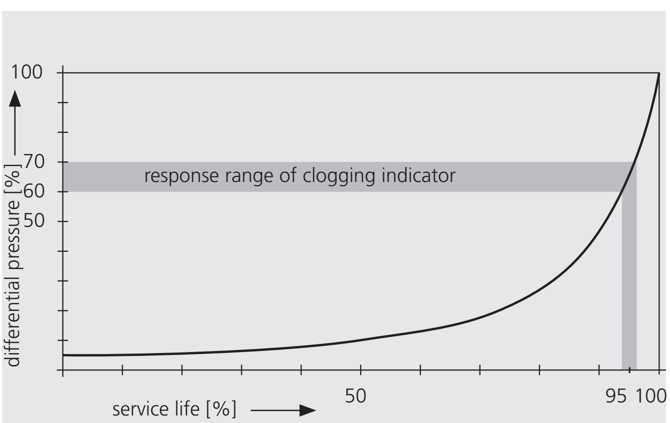
$$\Delta p_2 = \frac{\nu_2}{\nu_1} \times \Delta p_1$$

ν_1 = operating visocsity
ν_2 = start viscosity
Δp_1 = max. differential pressure switch reponds at operating viscosity ν_1
Δp_2 = max. differential pressure at start viscosity ν_2



ARGO-HYTOS differential pressure indicators

ARGO-HYTOS pressure switches and manometers



Typical progression of contaminatin of a filter element throughout its service life

Example of calculation:

- operating viscosity ν_1 = 35 mm²/s
- start viscosity ν_2 = 700 mm²/s
- switching pressure of differential pressure switch = 5±0,5 bar
- max. differential pressure Δp_1 = 5,5 bar

$$\Delta p_2 = \frac{700}{35} \times 5{,}5 \text{ bar} = 110 \text{ bar}$$

The differential pressure which occurs here would be 110 bar. ARGO-HYTOS's EXAPOR®MAX 2-elements, with a collapse pressure of 160 bar, have been specially developed to meet these demanding requirements.

The EXAPOR®MAX 2-filter elements that are used in ARGO-HYTOS high-pressure filters without a bypass valve have a collapse pressure of 160 bar and they are stable in response to differential pressure, so they satisfy the highest safety requirements:

- damage to the filter layer up to the specified differential pressure of 160 bar is impossible thanks to the exceptional support offered by the filter medium, together with its high intrinsic stability.
- there is consistent monitoring of the manufacturing process for filter elements, with continuous checks on production quality to ISO 2942.

Clogging indicators

As the duration of use of the filter element increases, the level of contamination and therefore the pressure drop will increase. This causes pressure build-up and/or differential pressure, which is monitored by the clogging indicator. When a preset value is reached, electrical and/or optical signals are given.

The following points should be noted here:
the pressure drop on the filter element increases with the flow rate, the contamination and the kinematic viscosity of the pressure fluid.

For these reasons, a filter element is only regarded as contaminated and in need of replacement when the contamination indicator responds at the operating temperature of the hydraulic system, and when the signal remains on continuously.

Effects of delaying the replacement of a filter element:

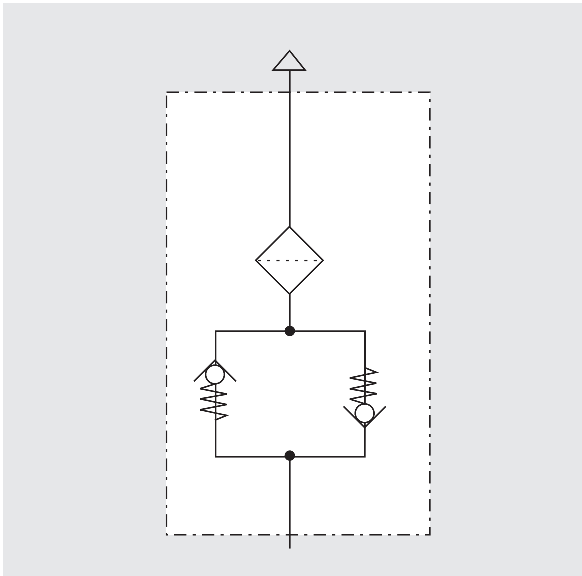
On filters with bypass valve:

- the more heavily the filter element is contaminated, the more frequently the bypass valve will respond, and part of the hydraulic fluid will not be filtered.

On filters without a bypass valve:

- the pressure drop on the filter element, and hence the loss of efficiency in the system, will increase continuously: this can lead to impermissible heating of the hydraulic oil.

1



Circuit diagram for ventilating filters with double check valve

2

ARGO-HYTOS ventilating filters

3

ARGO-HYTOS Vandalism Proof ventilating filters

Ventilating filters

Temperature changes, together with the use of cylinders and/or pressure accumulators, cause the oil level in the tanks of hydraulic systems to have constant fluctuations.

These create a difference in pressure with the surrounding environment, which is compen-sated by an exchange of air that can allow dirt to penetrate the tank.

A ventilating filter can prevent dirt from entering. Ideally, it should have at least the same fineness as the system filters in the hydraulic circuit.

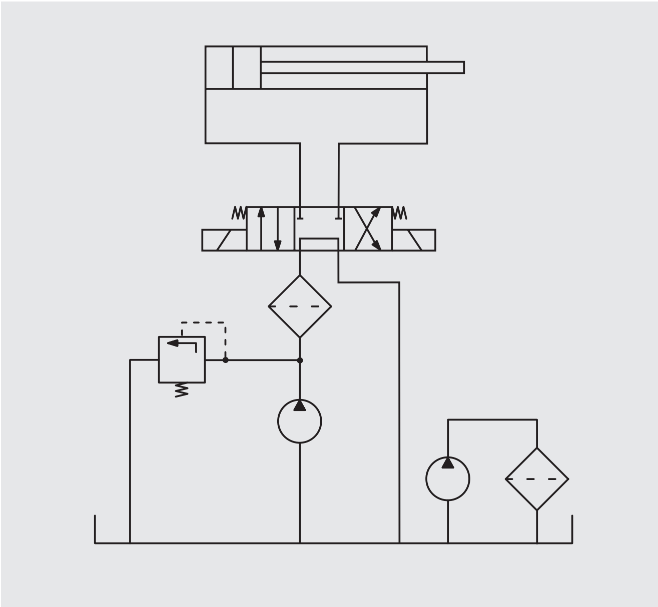
Ventilating filters with double check valves can be used to achieve a major reduction in the exchange of air between the tank and the environment, so that the entry of dirt and dust is minimized and the service life of the ventilating filter element can be prolonged (Figure 1).
An important factor here is that the air volume in the tank and the valve cracking pressure must be optimally coordinated with the specific design of the system.

With the specified air volume in the tank, higher response pressures tend to cause a reduction in the exchange of air. The air exchange at the defined response pressure of the ventilating filter can be reduced by increasing the air volume.

With a suitable design, a defined pressure level can be genera-ted in the tank in order to improve the suction conditions for the pumps.

A special feature: ARGO-HYTOS ventilating filters in the patented Vandalism-Proof version (Figure 3).

These ventilating filters can only be dismantled with a special spanner which is supplied with the product. This makes it considerably more difficult to remove the ventilating filter, or to pour dirt in through the filling/ventilation opening.



Hydraulic system with high-pressure filter and off-line filter unit

ARGO-HYTOS off-line filter unit with motor and pump

ARGO-HYTOS mobile filter unit with oil diagnostic system

Off-line filters

Increasingly, additional off-line filters are being used in systems that are subject to high stress in order to prevent the build-up of superfine particles. Unlike main flow filters, off-line filters only filter part of the total flow in the system. Depending on the influence of the environment (incidence of dirt) and the selected filter fineness, the partial flow (in l/min) should be approx. 2 to 10 % of the tank volume (in l).

In combination with superfine filter elements, outstanding levels of oil cleanliness can be achieved by continuous filtration, independently of the machine's working cycle. Furthermore, the load on the main filters is reduced, so that intervals between replacements can be extended.

Off-line filter systems should be used in addition to main flow filters; in this case, the latter can be designed as protective filters, i.e. they do not filter so finely.

A distinction is usually made between two different concepts:

Off-line filters with a flow control valve
From the pressure circuit of the system, the required quantity of oil initially flows via an integrated flow control valve and then it is fed into the tank via the offline filter. The small installation effort for this concept makes it especially suitable for retrofitting systems.

Off-line filter units
From the pressure circuit of the system, the required quantity of oil initially flows via an integrated flow control valve and then it is fed into the tank via the offline filter. The small installation effort for this concept makes it especially suitable for retrofitting systems.

Filter units

To guarantee the required level of oil cleanliness when a system is filled for the first time or refilled, the operating medium should be cleaned using filter units with superfine filter elements.

Mobile filter units are also suitable for cyclical cleaning of hydraulic or lubrication systems where no provision was made for off-line filters when the systems were equipped for the first time, and it is impossible to install them at a later stage.

Optimal results can be achieved if the cleaning and/or filling processes are monitored by an oil diagnosis system such as particle counters.

Definition of the filter fineness

The Multi-Pass test according to ISO 16889:1999 is used to determine the number of particles upstream and downstream of a filter, in relation to specified particle sizes. This makes it possible to calculate the respective beta value (the filtration ratio) which is the quotient of the numbers of particles upstream and downstream of the filter.

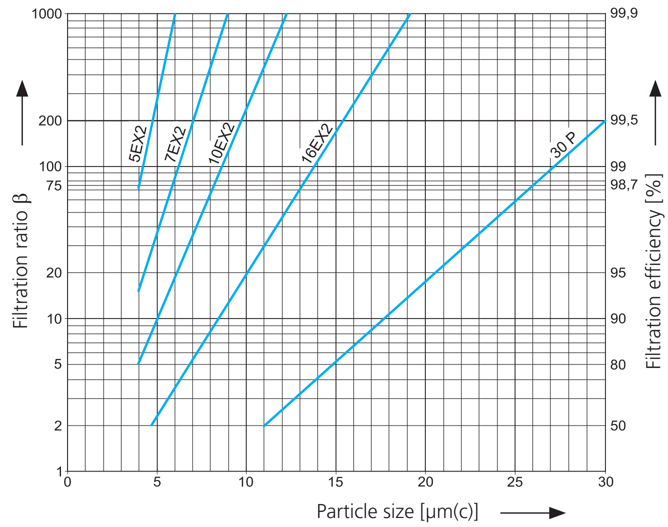
$$\text{Beta value } \beta = \frac{\text{number of particles upstream of filter}}{\text{number of particles downstream of filter}}$$

The filtration level (or filtration efficiency) can be calculated analogously.

$$\text{Filtration efficiency} = \frac{\text{no. of particles upstream of filter} - \text{no. of particles downstream of filter}}{\text{no. of particles upstream of filter}} \times 100\ \%$$

The following relation exists between the two values:

$$\text{Filtration efficiency (in \%)} = (1 - \frac{1}{\beta}) \times 100\ \%$$



ARGO-HYTOS filter fineness:
filtration ratio and filtration efficiency in relation to particle size to ISO 16889

The following table provides some numerical values.

Beta value β	1	1,5	2	5	10	20	50	75	100	200	1000	10000
Filtr. efficiency	0 %	33,33 %	50 %	80 %	90 %	95%	98 %	98,67 %	99%	99,5 %	99,9%	99,99%

Relation between beta value and filtration efficiency

ARGO-HYTOS filter fineness is based on the mean beta value 200 ($\bar{\beta}_{x(c)}$ = 200 according to ISO 16889:1999) corresponding to a filtration efficiency of 99,5%. The relevant characteristic filtration curves are shown in the chart.

This makes it easy to read the filtration ratio and the filtration efficiency in percent for various particle sizes, clearly showing the relationship between the various levels of fineness. The characteristics of the individual curves ultimately determine the level of cleanliness for the pressure fluid that can be achieved in practice.

Oil cleanliness classification

The classification systems ISO 4406 and NAS 1638 are most widespread. Both systems are used to describe the distribution of solid particles in hydraulic fluids according to number and size.

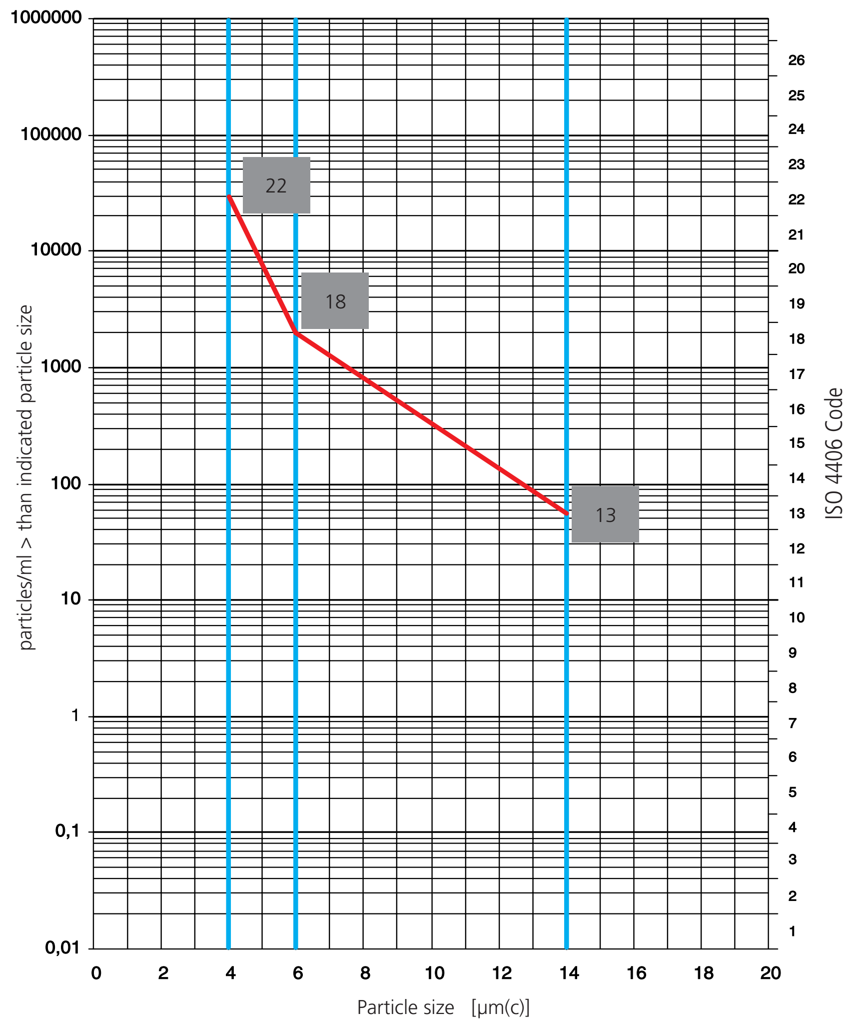
This is done by assigning the number of particles of a specific size to a code number or class. Each time the oil cleanliness deteriorates by a class, the number of particles is doubled. This relationship is shown in the table, using ISO 4406 as the example.

NAS 1638 uses different particle size ranges to describe the distribution of particles, whereas ISO 4406:1999 indicates the number of particles > 4 µm(c), > 6 µm(c) or > 14 µm(c) as codes.

The following chart shows the evaluation of an oil sample according to ISO 4406:1999.

No. of particles per 1 ml		Code number
from	up	
80.000	160.000	24
40.000	80.000	23
20.000	40.000	22
10.000	20.000	21
5.000	10.000	20
2.500	5.000	19
1.300	2.500	18
640	1.300	17
320	640	16
160	320	15
80	160	14
40	80	13
20	40	12
10	20	11
5	10	10
2,5	5	9
1,3	2,5	8
0,64	1,3	7
0,32	0,64	6
0,16	0,32	5
0,08	0,16	4
0,04	0,08	3
0,02	0,04	2
0,01	0,02	1

Extract from ISO 4406:1999



Evaluation of an oil sample according to ISO 4406:1999

1

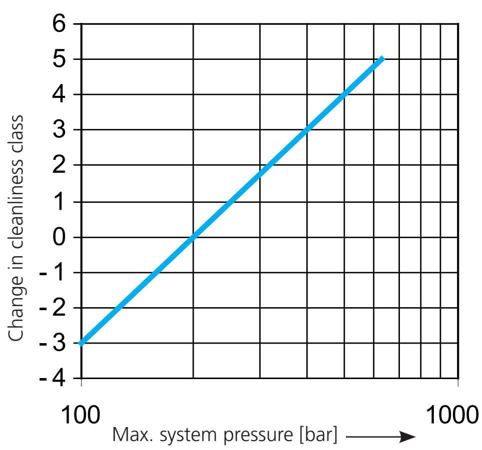
Pumps	
Axial piston pumps	21 / 18 / 15
Radial piston pumps	21 / 18 / 15
Gear pumps	21 / 18 / 15
Vane pumps	20 / 17 / 14
Motors	
Axial piston motor	21 / 18 / 15
Radial piston motor	21 / 18 / 15
Gear motors	21 / 18 / 15
Vane motors	20 / 17 / 14
Valves	
Directional control valves (solenoid valves)	21 / 18 / 15
Pressure valves	21 / 18 / 15
Flow control valves	21 / 18 / 15
Check valves	21 / 18 / 15
Proportional valves	20 / 17 / 14
Servo valves	17 / 14 / 11
Cylinders	21 / 18 / 15

Oil cleanliness level required for hydraulic components (160 … 210 bar)

2

Operating pressure	Change in oil cleanliness
0 ... 100 bar	3 classes worse
100 … 160 bar	1 class worse
160 … 210 bar	none
210 … 250 bar	1 class better
250 … 315 bar	2 classes better
315 … 420 bar	3 classes better
420 … 500 bar	4 classes better
500 … 630 bar	5 classes better

3



Influence of the operating pressure on required oil cleanliness

Required oil cleanliness

The oil cleanliness required in the system is determined by the component which is most sensitive to dirt. If the component manufacturer does not provide any specific information about the required oil cleanliness or filter fineness, it is advisable to determine the oil cleanliness on the basis of the ajoining tables (Figure 1.)

The listed reference values for normal components refer to a basic pressure range of 160 ... 210 bar.

If the operating pressure is increased in a system, it is necessary to improve the oil cleanliness in order to achieve the same wear lifetime for the components.

The ajoining table lists the required change in oil cleanliness when the operating pressure increases in relation to the basic pressure range of 160 ... 210 (Figure 2).

Using an example, we will now explain the influence of the operating pressure on the required oil cleanliness, and hence on the filter fineness.

In a system with gear pump and proportional valves, oil cleanliness of 20/17/14 to ISO 4406 is required for an operating pressure of up to 210 bar. If the operating pressure is raised to 250 bar, the table shows that the oil cleanliness must be improved by 1 class to 19/16/13.

The required oil cleanliness is determined by other influencing variables as well as the operating pressure:

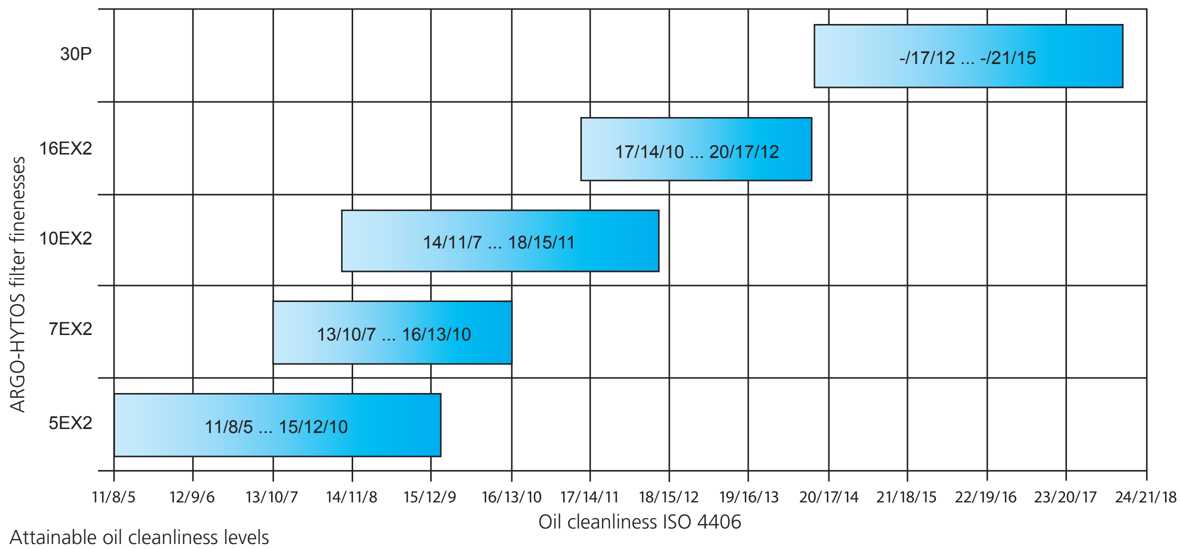
› expected lifetime of the machine
› costs of repairs/spare parts
› interruption costs due to shutdown times
› requirements for the safety of the system (these are not only influenced by the cleanliness of the oil!)

If one of these aspects is especially important, the required oil cleanliness should be improved by one class. If two or more criteria apply, the required oil cleanliness must be up-graded by two classes.

In the example given above, if high-grade cylinders are used as well, and if high interruption costs can be expected due to a system shutdown, 17/14/11 should be recommended as the oil cleanliness class instead of 19/16/13 (2 classes better).

Required ARGO-HYTOS filter finenesses

Continuous evaluation of oil samples for several decades has shown which level of oil cleanliness can be achieved with which filter fineness under specified system conditions. For full flow filtration under the least favorable conditions, cleanliness levels to ISO 4406:1999 can be achieved with ARGO-HYTOS filter finenesses as follows:



Attainable oil cleanliness levels

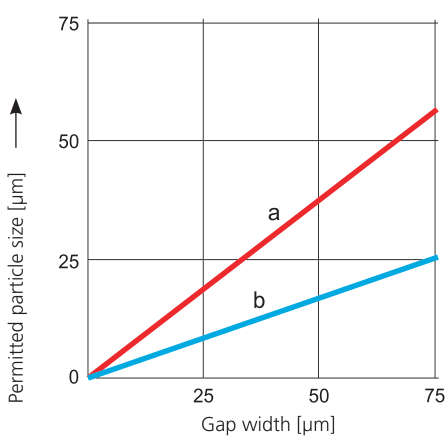
However, significantly better levels of oil cleanliness can be achieved depending on the environmental conditions and the specific circumstances of the system. Conditions that may have a positive influence on the cleanliness level include:

› design features that reduce the penetration of dirt from outside (high-quality packing seals in hydraulic cylinders, good shaft sealing rings)
› tank ventilating filters with fine filter elements
› uniform flow instead of pulsation (caused by variable displacement pumps, for example)
› low pressure drop, e.g. when suction filters or off-line filters are used

Depending on the influence of one or more of the criteria mentioned above, the oil cleanliness levels that are achieved will be at the left end of the bandwidths shown (in favorable cases) or at the right end (in unfavorable cases).

In the calculation example cited previously, an oil cleanliness level of 19/16/13 was required. Now we shall determine which ARGO-HYTOS filter fineness is required to achieve this.

According to the chart, filter fineness 16EX2 can be used to achieve oil cleanliness of 17/14/10 in the most favorable case. But under unfavorable conditions, it will only be possible to attain class 20/17/12. On the other hand, filter fineness 10EX2 can achieve the required oil cleanliness of 19/16/13 even under the most unfavorable conditions.



Permitted particle size in relation to gap width with (a) large and (b) small relative movement of the gap surfaces.

Fineness required to prevent gap blockage

Typical phenomena that cause functional failures on hydraulic components include blockage of gaps and nozzles. Flow control valves, restrictor valves and servo valves are particularly susceptible to this problem. If the relative movement of the gap surfaces is small, there is a greater risk that the gap will clog up when the size of the dirt particles exceeds 1/3 of the smallest gap height (characteristic b in the chart below). Bearing the possibility of blockage in mind, this means that the absolute filter fineness must be at least equal to the given value, or better less than this value. The ajoining chart shows how the gap width and the permitted particle size are related.

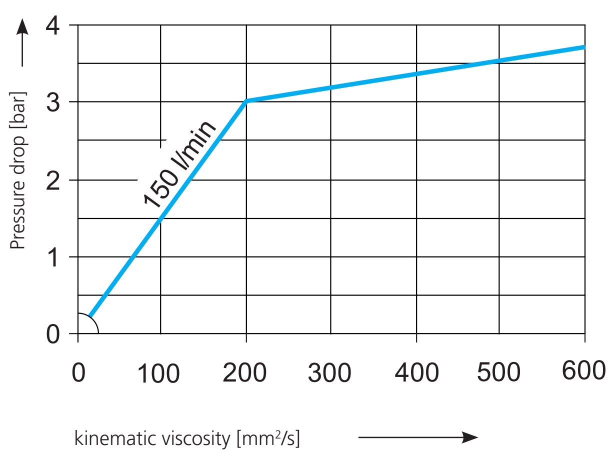
Nominal flow rate

The correct choice of filter size, taking account of application-specific operating conditions, is the only way to ensure that:

› economically acceptable filter lifetimes are achieved
› even with higher starting viscosity, 100% filtering guarantees the best possible functional protection for the hydraulic components, with pressure drops in the system kept to a minimum

These important criteria must be taken into account when the nominal flow of a hydraulic filter is determined.

› in practical operating conditions, the filter service life must be at least 1000 operating hours (for this purpose, ARGO-HYTOS's operational experience shows that a specific dirt accumulation of at least 0,07 g per l/min flow rate has to be taken as a basis).
› at nominal flow rate, the bypass valve of the filter must remain closed during first startup (new filter element) up to a starting viscosity of 200 mm²/s (see the following chart). This corresponds to a temperature of approx. 15 °C with an ISO VG 46 or HLP 46 hydraulic oil.



Pressure drop of a filter in relation to the kinematic viscosity

Given that the pressure drop on superfine filter elements is more or less proportional to the kinematic viscosity, the approximate permitted flow rate on a filter for pressure fluids that vary from ISO VG 46 can be determined as follows:

$$Q_{max} = Q_N \times \frac{\nu_1}{\nu_2}$$

Q_{max} = permitted maximum flow with a pressure fluid that varies from ISO VG 46

Q_N = nominal flow rate based on ISO VG 46

ν_1 = kinematic viscosity of the ISO VG 46 pressure fluid at 15 °C (corresponds to 200 mm²/s)

ν_2 = kinematic viscosity of the variant pressure fluid at 15 °C

When using hydraulic oils of higher viscosity, a lower flow rate is permitted as compared with the nominal flow rate. For media of lower viscosity, on the other hand, a higher flow rate is possible as compared with the nominal flow rate. The below listed flow rates have to be adhered to.

When hydraulic oils of different viscosity classes are used, this results in the following factors for Q_N:

ISO viscosity class	Factor for Q_N
22	2,60
32	1,60
46	1,00
68	0,60
100	0,38
150	0,23
220	0,14
320	0,09

The following flow speeds in pipes and hoses should not be exceeded:

› suction line: 1,5 m/s
› return line: 4,5 m/s
› pressure line up to 100 bar: 6 m/s
› pressure/high-pressure line up to 250 bar: 8 m/s
› high-pressure line up to 600 bar: 12 m/s

All nominal flow rates indicated by ARGO-HYTOS are based on the criteria listed before, which have been fully tried and tested in practice.

How to determine the required dirt capacity

In many cases, the user indicates either the required filter lifetime in operating hours (Bh in the formulas) or the dirt capacity in grams of ISO MTD.

If the lifetime is specified (usually it is identical to the intervals between replacements according to the operating and maintenance instructions), a safety factor of 1,2 to 2,0 should be applied in order to calculate the required ISO MTD capacity of the filter element.

The safety factor is based on the importance or weighting of criteria such as

- nature of influences from the environment (dust, moisture, temperature)
- following the maintenance instructions (original spare parts, oil quality, intervals between replacements)
- filter monitoring by electrical/optical indicators
- preventive replacement of filter elements

The required setpoint dirt capacity in grams ISO MTD is calculated according to this formula:

$$\text{Dirt capacity}_{\text{setpoint}} = \frac{\text{Specified lifetime}}{1000\ \text{Bh}} \times S \times SPS \times Q$$

Specified lifetime	= desired filter lifetime in operating hours (Bh)
S	= safety factor (1,2 ... 2,0)
SPS	= specific dirt ingression in g/l/min/1000Bh
Q	= pumped flow rate of the working pump in l/min

SPS values

SPS = specific dirt ingression, indicated in g/l/min pumping flow in 1000 operating hours.

In the Multi-Pass test, the dirt capacity of a filter is determined with the help of a test dust whose chemical and physical characteristics cannot be compared to those of dirt that occurs in practice. The filter lifetimes that can actually be achieved in various hydraulic systems under practical conditions can only be determined by extensive in-vestigations in the field. The SPS value represents the relationship between the dirt capacity determined in the Multi-Pass test and the filter lifetime that can be achieved in practice. SPS values for commonly used hydraulic systems are shown in the chart.

These experience-based values refer to a machine concept with a well-protected hydraulic cylinder and highly efficient tank ventilating filters.

For systems and equipment that are not included in this list, please consult ARGO-HYTOS for the relevant SPS value.

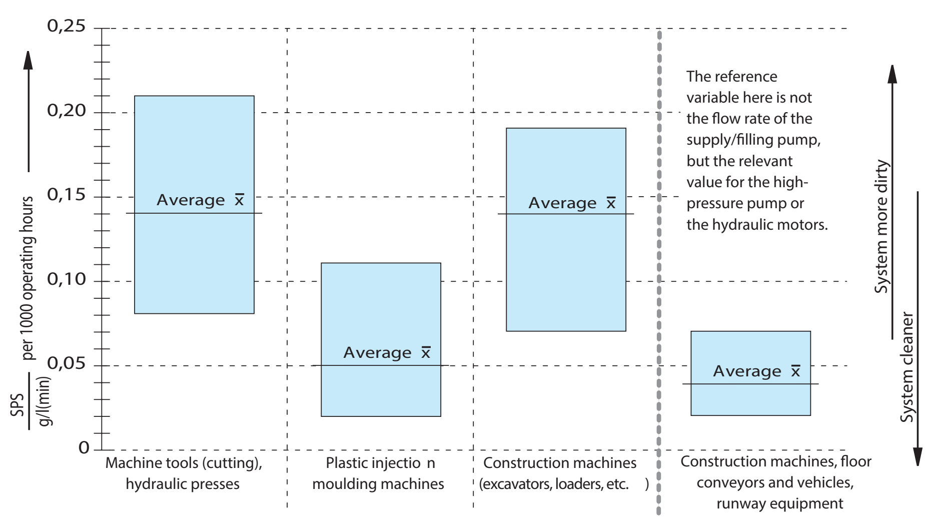
How to determine the lifetime

The calculated dirt capacity should now be compared with the ISO MTD values shown in the ARGO-HYTOS data sheets, taking account of the filter fineness that has already been determined, and the nominal flow rate.

If the selection table shows that the dirt capacity of the selected filter varies substantially from the calculated value, it may be necessary to select the next largest type. If the variance is insignificant, the decision is ultimately up to the user. The lifetime in hours can then be determined as follows:

$$\text{Lifetime}_{\text{actual}} = \frac{\text{Dirt capacity}_{\text{actual}}}{S \times SPS \times Q} \times 1000\ \text{Bh}$$

If the result varies substantially from the specified lifetime, you should again verify the initial data and safety factors, and check whether the system has been classified in the correct machine group based on the SPS value.



SPS values for typical hydraulic systems

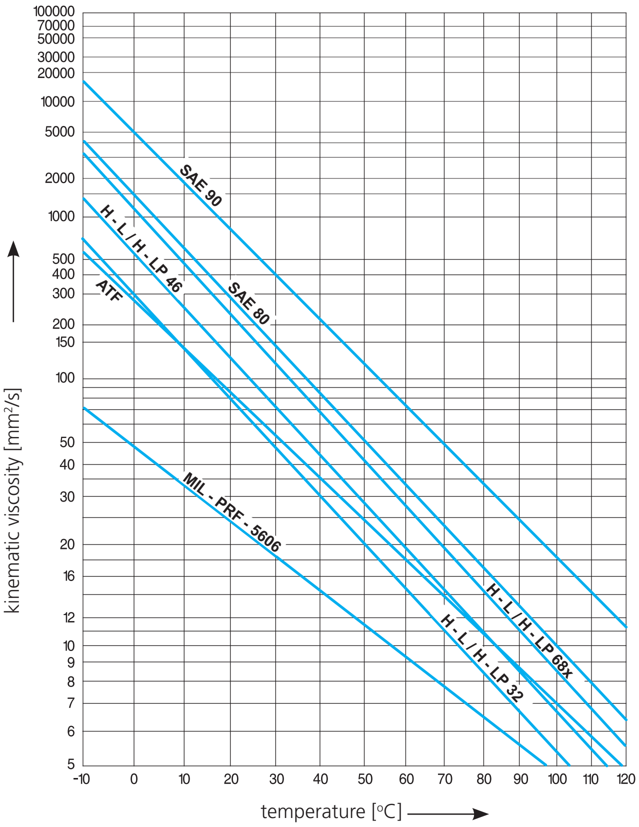
Clogging indicators

High-pressure filters with flanged / threaded connection

Before you finally determine the hydraulic filter that is suitable, you should also clarify these points:

Design-related factors:

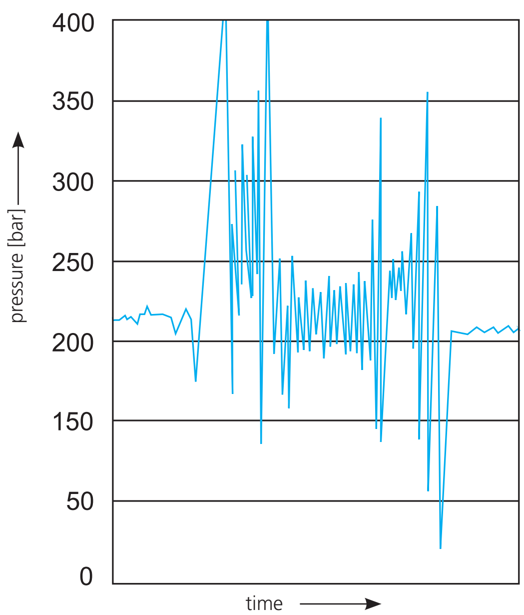
› accessibility for changing the filter element
› type of clogging indicator
› positioning/dimensions of the oil tank
› level differences/angles
› connection threads/flanges



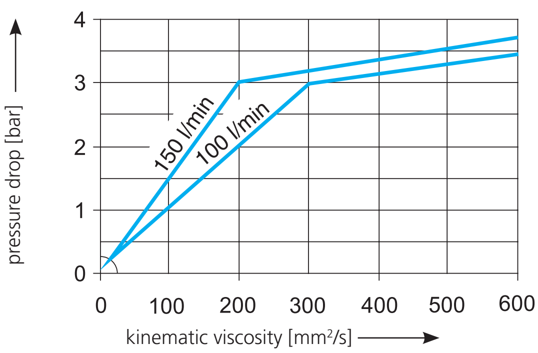
Viscosity

Hydraulic factors:

› type of fluid
› level/number of possible pressure peaks
› pressure drop at nominal flow
› viscosity
› electrical conductivity
› bypass valve required/allowed



Pressure peaks

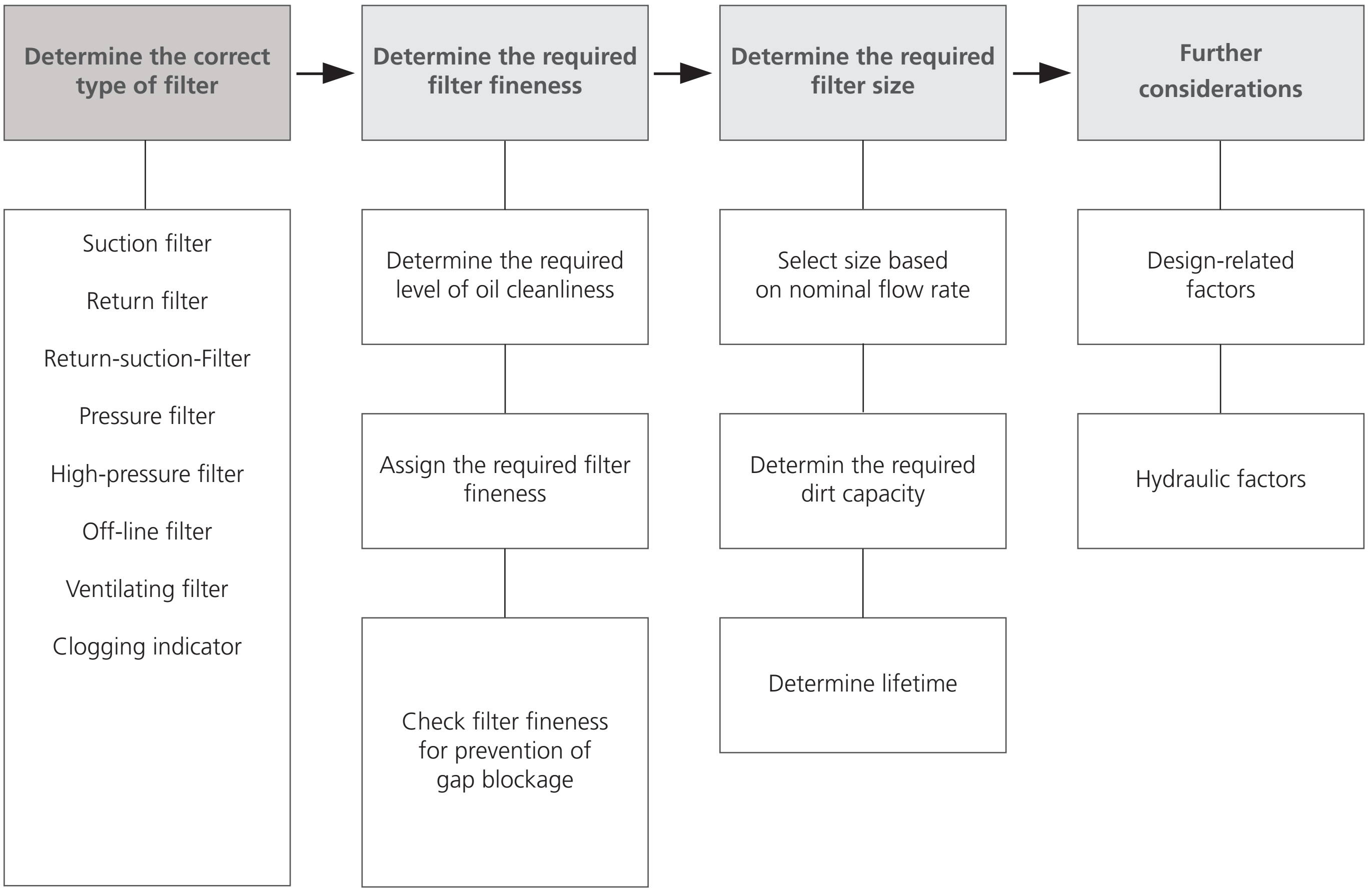


Pressure drop

We are certain that these “Guidelines“ have provided you with some important information and that they will help you to reach a descision.

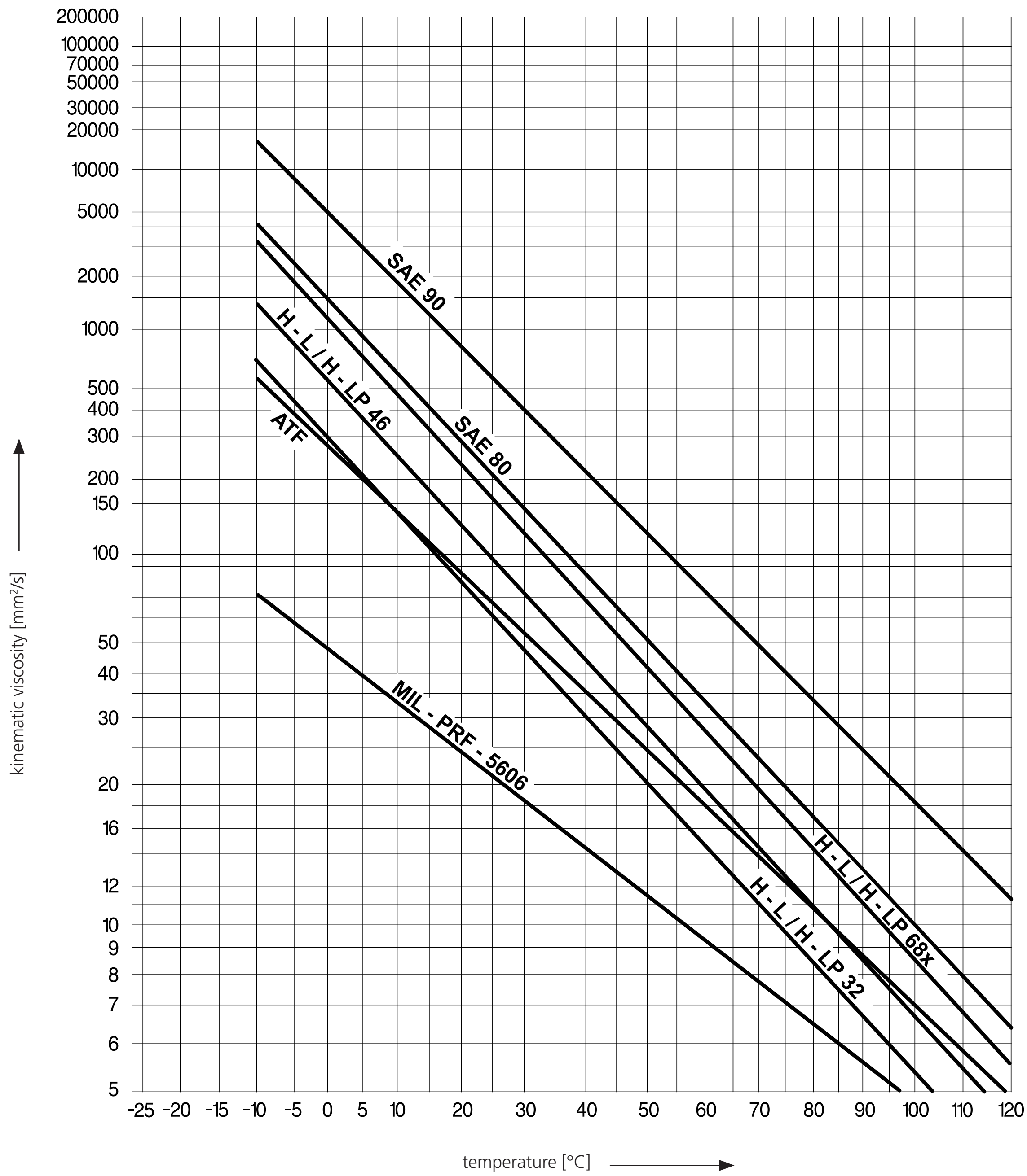
However, the ”Guidelines“ cannot be a substitute for personal advice from our qualified filter specialists, nor are they intended as such.

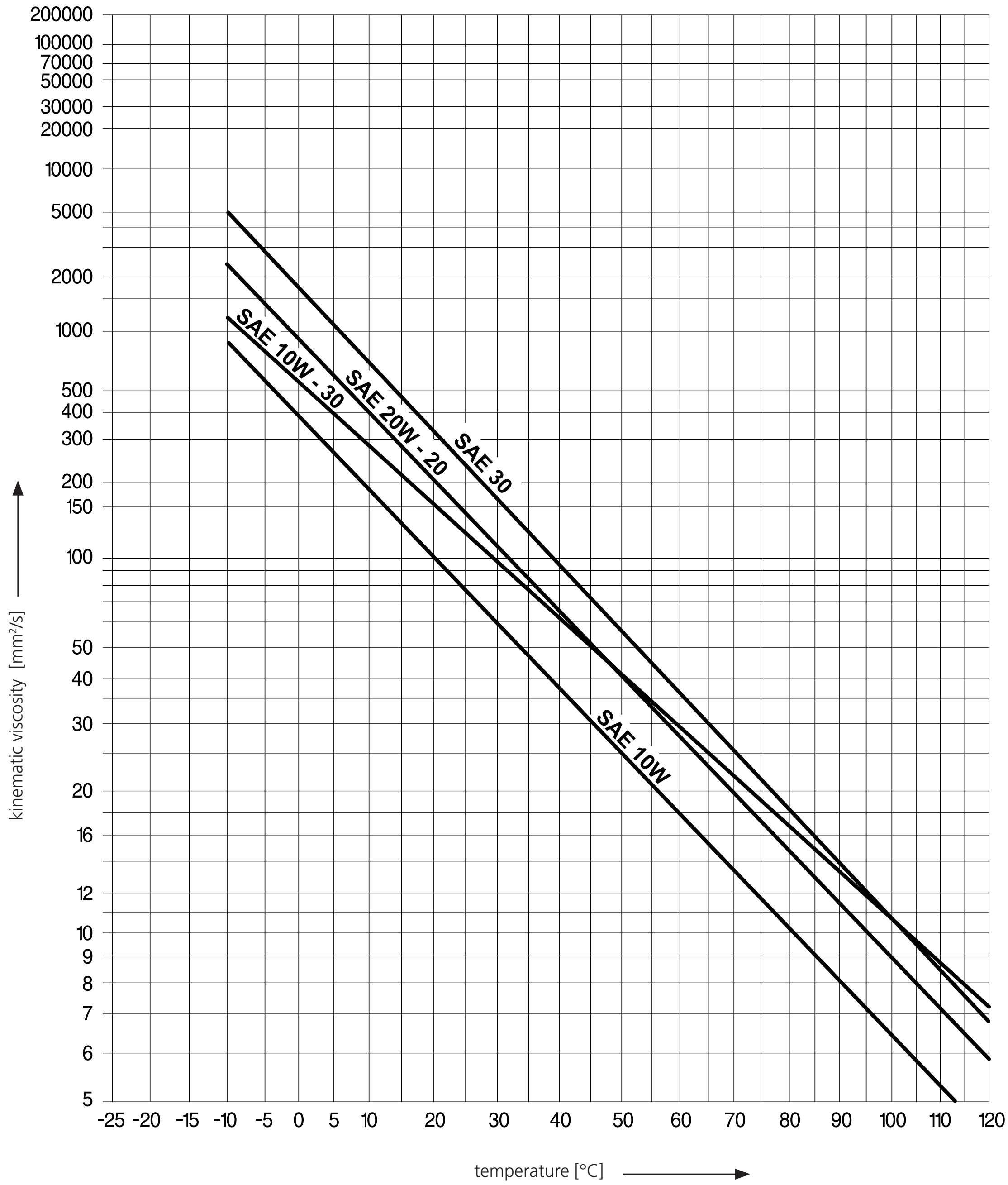
Flow chart filter selection procedure



Viscosity Temperature Diagram

Hydraulic Oils · Vehicle Gear Oils · ATF-Oils · MIL-PRF-5606





Remarks:

› The actual viscosity-temperature behaviour may vary from the characteristic curves for average values which are indicated here. For a precise determination, the information from the respective oil manufacturer should be used.

› On request we will send you a file (MS Excel) with the viscosity curves of common hydraulic media.

Use of Components in Systems

with Environmentally Sound Hydraulic Fluids

Environmentally sound hydraulic fluids

At present, three groups of environmentally sound[1] or environmentally compatible[1] hydraulic fluids are used:

- Native esters (HETG), e.g., rapeseed oil
- Synthetic esters (HEES), e.g., dicarboxylic acid ester
- Polyalkylene glycols (HEPG), e.g., polyethylene glycol

Chemical resistance tests

The chemical resistance of ARGO-HYTOS products is currently tested with typical representatives of the groups native esters (HETG), synthetic esters (HEES) and mineral oils (HL, HLP, HLPV).

Ventilating Filters, Filling and Ventilating Filters, Accessories for Filters and Tanks

Native esters (vegetable oils)

The current level of knowledge shows that the above mentioned components can be used in vegetable oils without any problems, provided that the vegetable oils are kept free of water during operation.

If water is allowed to enter, the sealing materials (as well as metal components) may corrode due to hydrolytic[2] separation of the rapeseed oils.

Synthetic esters

The current level of knowledge shows that the above mentioned components can be used in synthetic esters without any problems.

Hydraulic Filters

Native esters and synthetic esters

The current level of knowledge shows that ARGO-HYTOS filters can be used without any problems in fluids of these groups. For the components no chemical resistance problems occur in case of no other sealing materials than NBR[3] is specified by the fluid manufacturer and provided that the subsequent recommendations are observed.

Polyalkylene glycols

If you intend to use the hydraulic filters for fluids of the polyalkylene glycol type (HEPG), it is essential that you first consult ARGO-HYTOS.

Required Replacement Intervals for ARGO-HYTOS Filter Elements

Initial fill of hydraulic systems

Hydraulic components are normally tested with mineral oil. Rapeseed oil-based hydraulic fluids and synthetic esters can both be mixed with mineral oils.

With native esters (vegetable oils)

- First filter element change after running-in period, but not later than after 50 operating hours.
- Second filter element change after 500 operating hours, together with hydraulic fluid

Subsequent filter element changes every 1000 operating hours and/or always together with hydraulic fluid change, but at least once a year. The hydraulic fluid should be tested by the supplier/manufacturer in all cases after 1000 operating hours, and thereafter at intervals of 300 operating hours, owing to the risk of hydrolysis[2] if water[4] enters.

With synthetic esters

- First filter element change after running-in period, but not later than after 50 operating hours.
- Second filter element change after 500 operating hours, together with hydraulic fluid.

Subsequent filter element changes every 1000 operating hours and/or always together with hydraulic fluid change, but at least once a year.

Changing the oil type of hydraulic systems to native or synthetic esters

After filling with vegetable oil or synthetic ester for the first time, and using new filter elements, the entire hydraulic system should be flushed. All hydraulic functions should be operated several times to ensure that any residue of used oil is flushed out of the entire system. After this first flushing process, a full oil change should be carried out, whereby the filter elements should also be replaced with new ones.

As both vegetable oils and synthetic esters have good dirt-removing[5] properties, the

- first filter element change should be made approx. 10 … 20 operating hours after changing the oil type.

All subsequent filter element changes should be carried out at the same intervals as for initial fill of hydraulic systems (see above).

[1] The terms "environmentally sound" and "environmentally compatible" should be regarded in relation to mineral oil-based hydraulic oils (fluids). The term "environmentally friendly" should not be used in connection with hydraulic fluids.
[2] Separation into glycerine and fatty acid
[3] In oil hydraulics NBR sealing materials are standard. If in the technical datasheet of the used oil a higher quality sealing material than NBR is recommended, ARGO-HYTOS should be consulted.
[4] e.g. condensation water
[5] Deposits which have built up during operation with mineral oil are loosened

Technical Recommendations

Taking Oil Samples from Hydraulic Systems

Basic requirements

Particle counting and oil sample analyzing

Counting the particles contained in an oil sample and analyzing the oil condition is a complex task. The information value of the analysis exclusively depends on whether the particle distribution of the oil sample is representative to the oil situation of the hydraulic system. Therefore we ask you to observe the following instructions and to exercise special care when taking samples.

Sampling points

When selecting sampling points make sure that representative samples are withdrawn from the system (for more information see Adequate Sampling Points).

Sampling time

Samples must be taken at machine operating temperature.

Sampling bottles

The sampling bottles supplied by us are thoroughly cleaned. They may only be taken out of the plastic bag right before sampling.

Sampling conditions

On mobile hydraulic systems preparation of the oil sampling as well as the oil sampling itself should be carried out at locations where external contamination through airborne particles is prevented. Samples taken under windy or rainy conditions cause special problems (water makes any particle counting worthless).

Adequate sampling points

Systems with in-line filters, pressure filters or high-pressure filters
Sampling downstream of the filter

- by means of a special sampling valve or
- by means of a micro port and hose

Systems equipped with tank-mounted return filters
Sampling upstream of the filter

- by means of a special sampling valve or
- by means of a micro port and hose

Systems equipped with suction filters
Sampling

- by means of a special sampling valve or
- by means of a micro port and hose connected to the pressure line or
- from the oil tank, using special equipment, if no other method is possible

Sampling

Before an oil sample has been withdrawn from a hydraulic system (when the operating temperature has been reached) the hydraulic fluid should be re-circulated at maximum flow rate for at least 5 to 10 minutes. All machine movements should be actuated several times.

Sampling by means of a special sampling valve or a micro port and hose

This is the most reliable method for obtaining reproducible results as secondary contamination will effectively be prevented. Furthermore, the sample will be directly taken from the oil flow. On hydraulic systems operated on a fixed location, sampling is possible without shutting down the system.
When taking a sample you are requested to proceed as follows:

- While the pump is operating (max. flow rate) open the sampling valve and drain a sufficient quantity of fluid (approx. 2 l) into a separate container in order to flush the sampling valve and dead volumes in the area of the sampling port. Never take a sample right after opening the sampling valve.
- Open the plastic bag, take the sampling bottle, remove the screw cap and hold it without touching its inner surface.
- Place the bottle directly under the fluid stream and fill it up to at least 50 %, max. up to 80 %.

Please note: Reduce the bottled quantity instantly in case the prescribed maximum has been exceeded.[1]

- Seal the bottle with the screw cap immediately, close the sampling valve afterwards.
- Label one of the self-sticking tags (to be found in the plastic bag) and stick it to the outward-cleaned bottle.
- Operating hours:...........................
- Type: ....
- No.: ....
- Date: ....
- Company: ....

- Fill in the data sheet (00.320). Please answer the questions accurately. Send us the oil samples together with the data sheet.

[1] To prepare the sample in our laboratory (homogenization) a volume of min. 130 ml and max. 200 ml will be required (by using 250 ml sampling bottles provided by ARGO-HYTOS).

Sampling from the tank

This sampling method should only be applied in exceptional cases.
Please contact a staff member of our research department if there is no other possibility to sample. He will advise you.

Remark:

In case the oil sampling will be carried out together with an element change, please label the element and send it to us together with the filled in data sheet (00.320).

Datasheet

Oil sampling ☐ Filter element change ☐

Company ______ Industry ______
Address ______ Phone ______

Machine/Application ______ Manufacturer ______
Type/Model ______ Chassis/Machine No. ______
Operating hours ______ h Year of manufacture ______ Power ______ kW (______ HP)

Oil sampling/element change date ______ by ______ from Company ______

Operating hours of oil ______ h Designation/type of oil ______

Circulation time through filter before sampling ______ ☐min. ☐hrs.
Operating hours of element ______ h Tank volume ______ l Max. operation temperature ______ °C

Filter type ______ Manufacturer ______
Filter identification ______
Element fineness ______ µm ☐nom. ☐abs. Clogging indicator ☐no ☐visual ☐electr. ☐electr./vis.

Sampling location ☐Upstream Filter ☐Downstream Filter ☐Tank
☐Other ______

Sampling through ☐System Valve ☐Minimess ☐Vacuum bottle
☐Other ______

Hydraulic circuit ☐Closed ☐Open ☐Ventilating Filters
Type ______ Manufacturer ______

Hydraulic pump ☐Variable displacement ☐Fixed displacement Design ______
Type ______ Manufacturer ______
Capacity ______ l/min Operating pressure max. ______ bar

Field of application ☐Construction site equipment ☐Machine tool ☐Hydraulic press ☐Injection molding machine
☐Other ______

Maintenance
Last hydraulic fluid change at ______ Operating hours at ______
Recommended fluid change interval ______ Operating hours resp. ______ Months
Last element change/cleaning at ______ Operating hours at ______
Recommended element change interval ______ Operating hours resp. ______ Months

Repairs ☐No
☐Yes, at ______ Operating hours Kind of repair ______

Contact person ______ Phone ______ E-mail ______

Confirmation:
We hereby confirm that the oil sample(s) in question does (do) not contain PCB (polychlorinated biphenyl) nor PCT (polychlorinated terphenyl).

Place ______, Date ______ ______
Stamp and signature

Technical Recommendations

Maintenance of Hydraulic and Ventilating Filters

General

The task of filters is to remove solid particles from hydraulic and lubrication systems. As a result the filter contaminates itself.

Ventilating filters contaminate due to the dusty ambient air.

To avoid malfunctions in the system, the maintenance intervals recommended by the manufacturer should be observed.

In filtration we differentiate between 2 filtration principles:

› Depth filters with chaotically arranged fibres (e.g. glass fibres, polyester fibres)
› Surface filters with geometrically defined gaps (e.g. filter mesh of metal or plastic wires)

With **depth filters** open pores or gaps in the filter material are clogged by different sized dirt particles and thus the differential pressure continuously increases. **Cleaning such a filter is not possible.**

Surface filters hold back all particles which are larger than the mesh size. Particularly strainers with a mesh size smaller 60 µm might be completely clogged at high contamination. **These filters are cleanable.**

Ventilating filters

ARGO-HYTOS ventilating filters are depth filters. These filters cannot be cleaned.
For operational safety reasons and to simplify maintenance, the housings cannot be separated. Changing the filter element is therefore not possible.

ARGO-HYTOS recommends changing the ventilating filters every 1000 operating hours, at least once a year.
This applies to the operation of filters with the nominal volume flow rates specified by ARGO-HYTOS.

Ventilating filters

Hydraulic Filters

Maintaining filters with clogging indicator

By the use of a clogging indicator the pending filter maintenance is indicated and this results in an optimum utilization of the dirt holding capacity.

Clogging of the filter element and thus the differential pressure increase with growing lifetime.

The clogging indicator monitors the differential pressure and generates an electrical and / or optical signal as soon as the preset value is reached.

It should be noted that:
The differential pressure at the filter element increases with the volume flow, the clogging and the kinematic viscosity of the hydraulic fluid.

A filter element is not regarded as contaminated and has to be replaced before the clogging indicator responds at operating temperature of the hydraulic system, causing a continuous signal.

Then the filter element should be changed as soon as possible.

Maintaining filters without clogging indicator

Depth filters
Should the ARGO-HYTOS filters be operated with the volume flow rates indicated in the catalogue with a medium dirt ingress of 0,07 g per l/min, **a maintenance interval of 1000 operating hours, at least once a year** is recommended.

Taking into account the specific operating conditions, the maintenance interval may differ from this indication.

Depth filter (EXAPOR®MAX 2 filter element)

Surface filters

Due to their filter fineness, normally larger than 60 µm, surface filters cannot produce a sufficient oil cleanliness and are therefore used to protect the system.

The robust design allows the use in many applications throughout the entire lifetime, provided that visual inspections are regularly performed and that the filter elements are cleaned if necessary.

For cleaning we recommend:

› Cleaning in ultrasonic bath for a few minutes. As an alternative, put filter in cleaning agent for approx. 15 minutes and remove dirt from the outside using a brush.

› Then flush with fresh cleaning fluid from the inside to the outside.

› Blow out with compressed air from the inside to the outside.

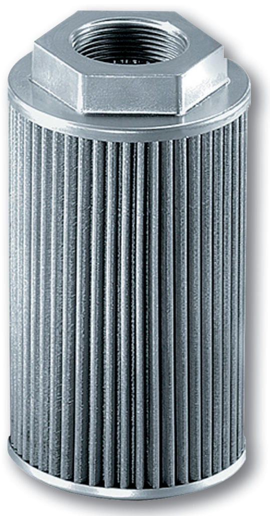
In any case be careful that no dirt enters the inner side (clean oil side) of the suction filter.

This kind of **cleaning can be performed up to 3 times**, then the filter has to be replaced.

Exceptions

Suction filter without sealing point to the surrounding
To guarantee lowest differential pressures in the suction line, a fixed maintenance interval is advisable.

The ARGO-HYTOS suction filters of series AS are surface filters and have a robust design with end caps, inner frame and metal filter mesh, so that **cleaning as above described is possible.**



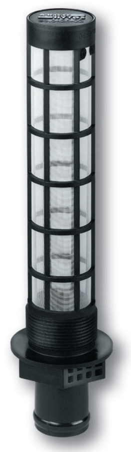
Suction filter
without sealing point to the surrounding

Suction filter with sealing point to the surrounding

The operational reliability of seals reduces with increasing lifetime. Thus suction filters as e.g. products of the ARGO-HYTOS series S0 have to be replaced regularly, preferably in connection with the change of the hydraulic fluid

It is recommended to install a new filter every **2000 operating hours, at least every 2 years.** In this case be careful that no dirt enters the inner side (clean oil side) of the suction filter.

Suction filters with synthetic fabric should not be cleaned but replaced..



Suction filter with sealing point to the surrounding

High pressure safety filter

Due to their design it is not economical to replace filter elements of high pressure safety filters, so that a new filter has to be installed when servicing.
Servicing should always be performed when the system is repaired as a result of a larger damage.

High pressure safety filters

Additional information

ARGO-HYTOS recommends to check the seals with each filter maintenance and replace them if necessary.
Maintenance kits consisting e.g. of filter element, housing seal and maintenance instructions can be put together individually.

All by ARGO-HYTOS announced functionalities of the complete filters as well as the excellent characteristics of the filter element can only be guaranteed when using original ARGO-HYTOS spare parts.

Suction Filter

S0.0426 · S0.0638

In-tank mounting · Hose connection up to DN 60 · Nominal flow rate up to 160 l/min

M

Suction Filter S0.0426

Description

Application

In the suction line of pumps of hydraulic or lubricating circuits.

Performance features

Protection against malfunction:
By full-flow filtration in the suction line, particularly the pumps are protected from coarse dirt particles that have remained in the system after manufacture or repair, or enter the system when it is filled with oil.

Special features

The robust construction with hose fittings, corpus out of reinforced plastics and embedded mesh screen material offers the following advantages:

- high reliability at low dead weight
- enormous shock and vibration resistance
- easy mounting

Construction

Flow direction from outside to centre. By using optimized filter material, pressure drops are kept down.
The suction filters operate without by-pass valves. This guarantees continuous full flow filtration.

Filter maintenance

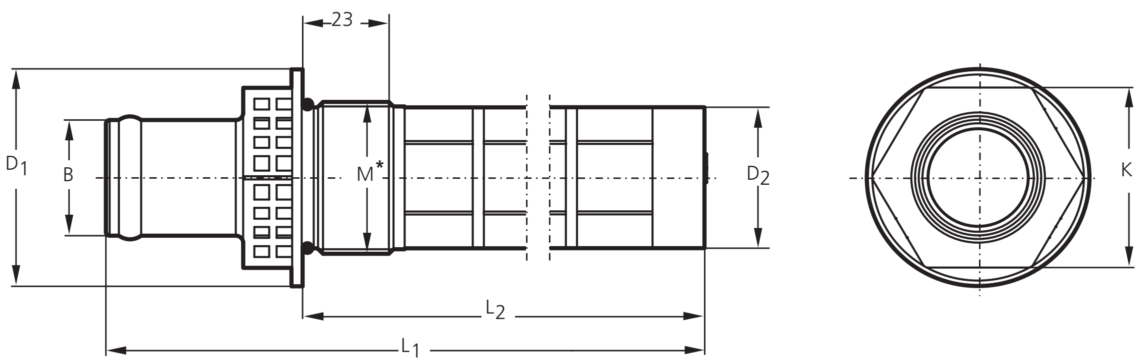
These suction filters have to be replaced on regular basis, e. g. together with the replacement of the hydraulic fluid. It is recommended to change the filter every 2 years or every 2000 operating hours, depending on what occurs first.
When replacing, it is inevitable to prevent any dirt from entering the inner side (clean oil side) of the filter.
Please refrain from cleaning these suction filters.

Selection Chart

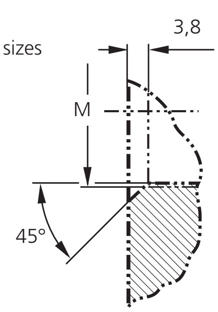
Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness	Filter surface	Connection B	Connection M	Diameter D_1	Diameter D_2	Lenght L_1	Lenght L_2	Dimension K	Symbol	Weight	Remarks
	l/min		µm	cm²	mm		mm	mm	mm	mm	mm		kg	
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
S0.0426-02	30	**D1**/1	135	115	32,0	M42 x 2	60	39	251	198	AF50	1	0,09	-
S0.0426-13	60	**D1**/2	280	115	32,0	M42 x 2	60	39	251	198	AF50	1	0,09	-
S0.0638-01	80	**D1**/3	135	320	60,5	M64 x 2	85	55	370	290	AF65	1	0,17	-
S0.0638-03	160	**D1**/4	280	320	60,5	M64 x 2	85	55	370	290	AF65	1	0,17	-

Remarks:
The filters listed in this chart are standard filters. If modifications are required we kindly ask for your request.

Dimensions



Recommended port sizes

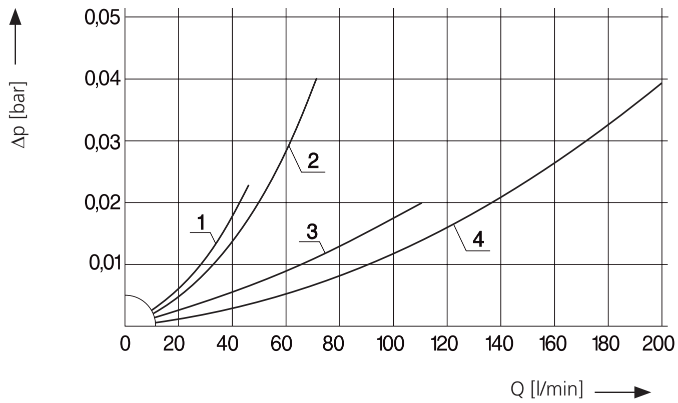


* The thread dimensions do not exactly conform to the DIN ISO standard thread (functioning with the DIN ISO standard thread is guaranteed)

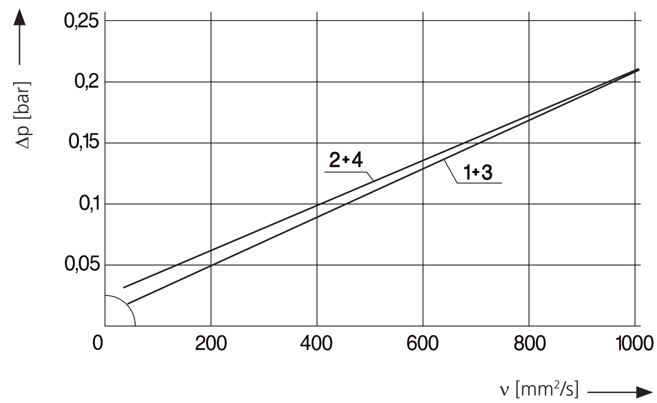
Diagrams

Δp-curves for filters in Selection Chart, column 3

D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s

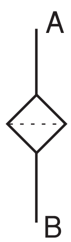


Pressure drop as a function of the **kinematic viscosity** at nominal flow

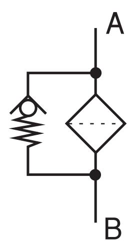


Symbols

1



2



Characteristics

Nominal flow rate

Up to 160 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

› pressure drop $\Delta p < 0{,}035$ bar at $\nu = 35$ mm²/s
› pressure drop $\Delta p \leq 0{,}25$ bar at 1/3 of the nominal flow rate and $\nu = 4000$ mm²/s (~ HLP 46 at -20 °C)
› flow velocity in the connection lines ≤ 1,5 m/s

Connection

Fittings for hoses up to DN 60. Sizes see Selection Chart, column 6 (other port threads on request).

Filter fineness

135 µm, 280 µm

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +80 °C (temporary -40 °C ... +100 °C)

Materials

Corpus:	Polyamid, GF reinforced
Cap:	Polyamid, GF reinforced
Seal:	NBR (FPM on request)
Filter mesh:	Polyester

Viskosity at nominal flow rate

› $\nu < 60$ mm²/s at operating temperature
› as start-up viscosity ν_{max} equivalent to the permitted pump inlet pressure (refer to diagram D), Δp to be determined as a function of the viscosity (take pressure loss in connection lines into account!)

Mounting position

Optional, preferably in horizontal position.
Under all operating conditions (min. oil level, max. inclination) the suction must occur under the oil level.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

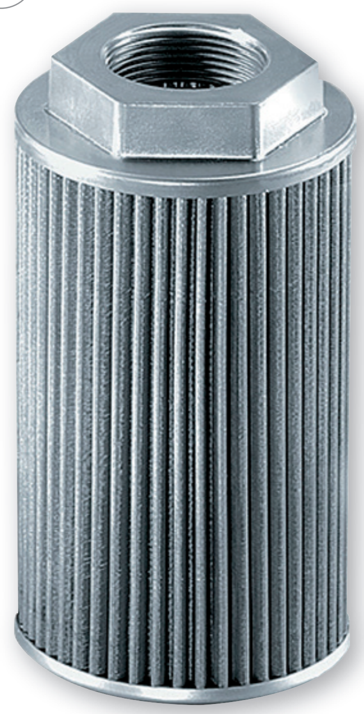
ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high visocity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Suction Filters

AS 010 · AS 025 · AS 040 · AS 060 · AS 080 · AS 100 · AS 150

In-tank mounting · Connection up to G2½ · Nominal flow rate up to 350 l/min



Suction Filter AS 080

Description

Application

In the suction line of pumps of hydraulic or lubricating circuits.

Performance features

Protection against malfunction:
By full-flow filtration in the suction line, particularly the pumps are protected from coarse dirt particles that have remained in the system after manufacture or repair, or enter the system when it is filled with oil.

Special features

The robust construction with end caps, inner core and mesh screen material, all out of metal, offfers the following advantages:

› maximum reliability at increased operating temperatures
› enormous shock and vibration resistance

Construction

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› long service life

Filter maintenance

› Cleaning in ultrasonic bath for a few minutes.
  As an alternative, put suction filter in cleaning agent for approx. 15 minutes and remove dirt from the outside using a brush.
› Then flush with fresh cleaning fluid from the inside to the outside.
› Blow out with compressed air from the inside to the outside.

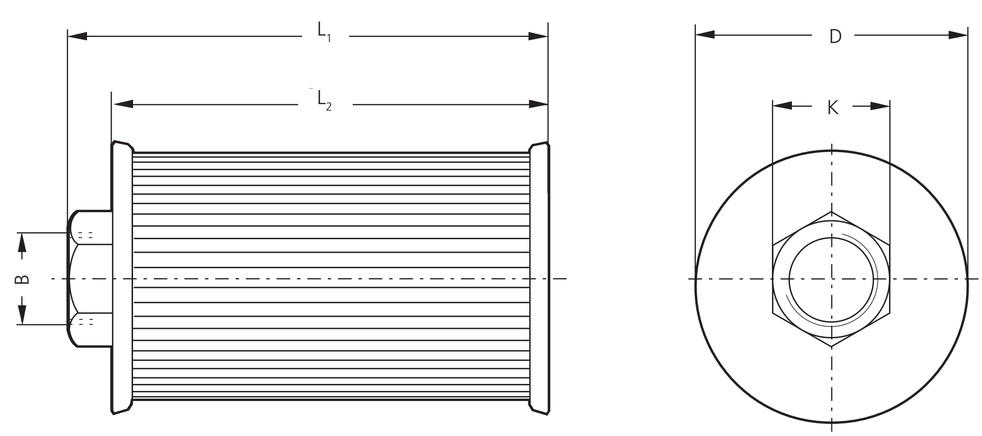
In any case, be careful that no dirt enters the inner side (clean oil side) of the suction filter.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness	Filter surface	Cracking pressure of by-pass	Connection B	Connection D	Length L_1	Length L_2	Dimension K	Symbol	Weight	Remarks
	l/min		µm	cm^2	bar		mm	mm	mm	mm		kg	
1	2	3	4	5	6	7	8	9	10	11	12	13	14
AS 010-00	15	**D1**/1	100	155	-	G½	45	82	60	AF 27	1	0,13	-
AS 025-01	35	**D1**/2	100	420	-	G¾	69,5	91	75	AF 36	1	0,24	-
AS 040-01	60	**D1**/4	100	650	-	G1	69,5	133	117	AF 41	1	0,30	-
AS 040-71	60	**D1**/3	100	650	- 0,3	G1	69,5	133	117	AF 41	2	0,30	-
AS 060-01	90	**D2**/1	100	1030	-	G1¼	70	205	185	AF 50	1	0,42	-
AS 080-01	120	**D2**/2	100	1280	-	G1½	100	182	165	AF 70	1	0,50	-
AS 080-81	120	**D2**/2	100	1400	- 0,3	G1½	100	182	165	AF 70	2	0,50	-
AS 100-01	200	**D2**/4	100	2300	-	G2	100	213	196	AF 70	1	0,60	-
AS 100-81	150	**D2**/3	100	1750	- 0,3	G2	100	213	196	AF 70	2	0,60	-
AS 150-01	350	**D2**/5	100	2300	-	G2½	150	191	165	Ø 82	1	1,40	-

Remarks:
The filters listed in this chart are standard filters. Other designs, e.g. other filter finenesses, available on request.

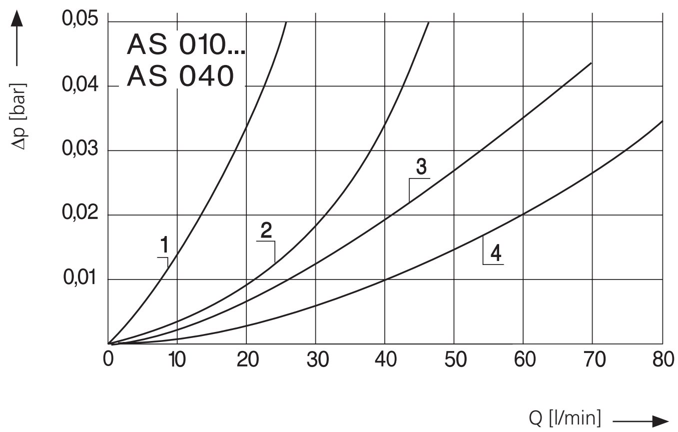
Dimensions



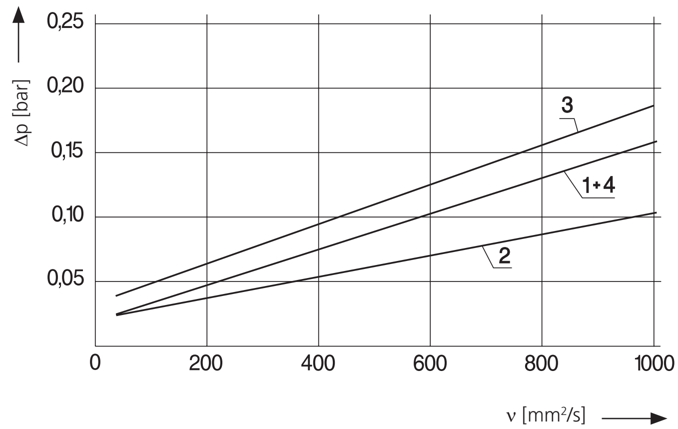
Diagrams

Δp-curves for filters in Selection Chart, column 3

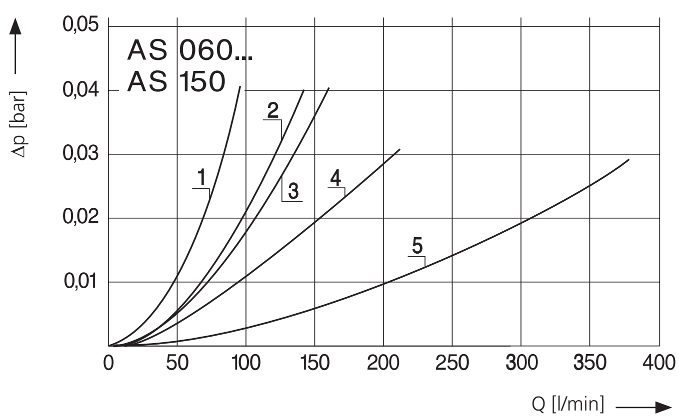
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s



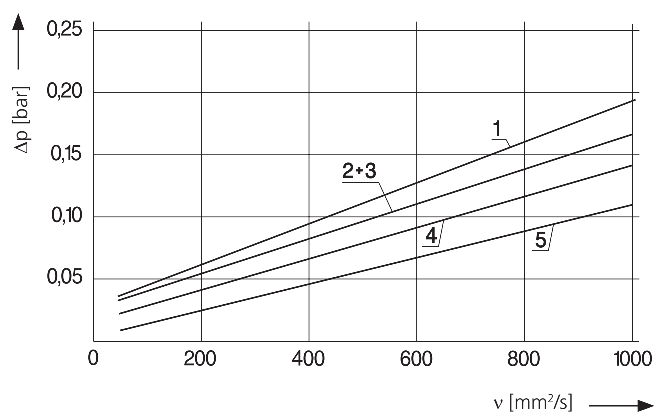
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s

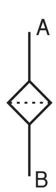


Pressure drop as a function of the **kinematic viscosity** at nominal flow

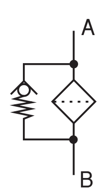


Symbols

1



2



Characteristics

Nominal flow rate

Up to 350 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- pressure drop $\Delta p < 0{,}035$ bar at $\nu = 35$ mm²/s
- closed by-pass valve at $\nu \leq 200$ mm²/s
- flow velocity in the connection lines $\leq 1{,}5$ m/s

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 7 (other port threads on request).

Filter fineness

100 µm

Hydraulic fluids

Mineral oil and biodegradable fluids (HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Materials

- AS 010-00 / AS 025-01 / AS 040-01 / AS 060-01 / AS 150-01
  end caps out of steel, support mesh out of steel, zinc plated, filter mesh out of stainless steel (1.4301)
- AS 080-01 / AS 100-01
  end cap with hexagon out of aluminum, bottom end cap out of steel, support mesh out of steel, zinc plated, filter mesh out of stainless steel (1.4301)
- AS 040-71
  end caps out of steel, filter mesh out of stainless steel (1.4301)
- AS 080-81 / AS 100-81
  end cap with hexagon out of aluminum, bottom end cap out of steel, filter mesh out of stainless steel (1.4301)

Viscosity at nominal flow rate

- $\nu < 60$ mm²/s at operating temperature
- start-up viscosity ν_{max} equivalent to the permitted pump inlet pressure (refer to diagram D), Δp to be determined as a function of the viscosity (take pressure loss in connection lines into account!)

Mounting position

Optional; versions equipped with bypass valve preferably in horizontal position. Under all operating conditions (min. oil level, max. inclination) the suction must occur under the oil level.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high visocity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Suction Filters

LS 025 · LS 035

In-line mounting · Connection up to G¾ · Nominal flow rate up to 33 l/min

M

Suction Filters LS 025

Description

Application

To be installed in the suction line of the pumps of hydraulic systems resp. upstream of the charge pumps of hydrostatic drives.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Filter elements

Flow direction from outside to center. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Aluminium alloy
Filter bowl:	Polyamide, GF reinforced
Seals:	NBR (FPM on request)
Filter media:	Paper-cellulose web, impregnated with resin

Accessories

Electrical and optical clogging indicators are available.
Dimensions and technical data see catalogue sheet 60.20.

Characteristics

Nominal flow rate

Up to 33 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- Closed by-pass valve at $\nu \leq 200$ mm²/s
- Element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- Flow velocity in the connection lines ≤ 1,5 m/s
  If units not equipped with a bypass valve are used in hydrostatic drives, the recommendations regarding their technical application given on catalogue sheet 10.310 should be observed.

Connection

Threaded ports according to ISO 228 or DIN 13. Sizes see Selection Chart, column 6 (other port threads on request)

Filter fineness

50 µm(c)
ß-values according ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- start-up viscosity:
  Determine ν_{max}, observing the permissible pressure at the pump inlet according to diagram D; determine Δp as a function of the viscosity (take into account the pressure loss in the connecting lines!)
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

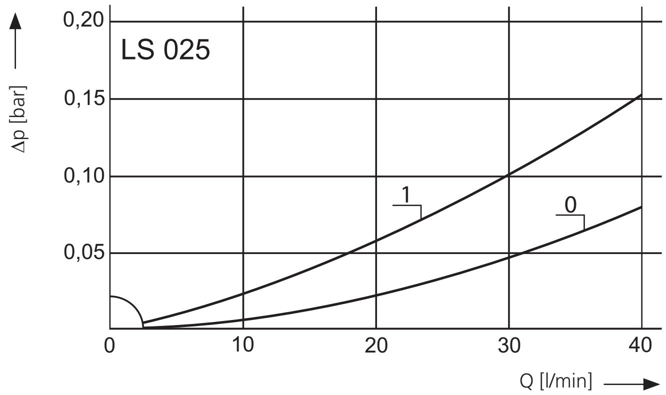
Mounting position

Vertical mounting to be preferred, filter head on top.

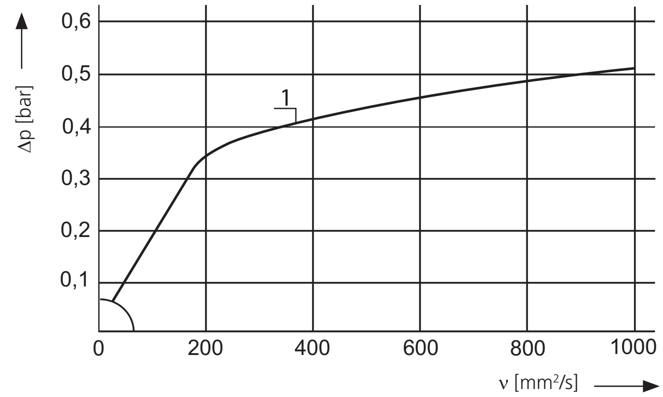
Diagrams

Δp-curves for complete filters in Selection Chart, column 3

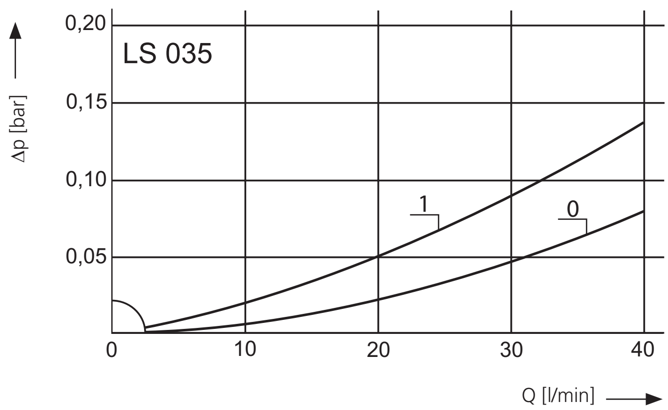
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



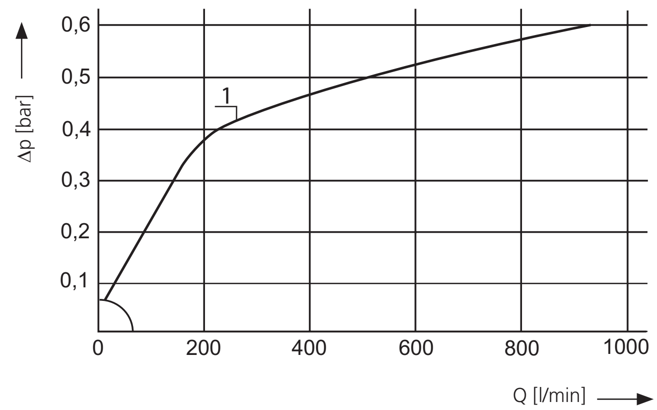
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

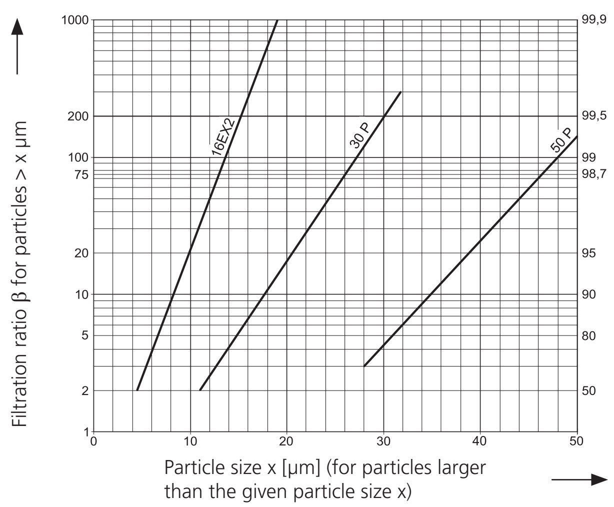


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

16EX2 = $\bar{\beta}_{16\,(c)}$ = 200 EXAPOR®MAX 2
30P = $\bar{\beta}_{30\,(c)}$ = 200 Paper
50P = $\bar{\beta}_{50(c)}$ = 200 Paper

Based on the structure of the filter media of the 30P and 50P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S = screen material with mesh size 40 µm
60S = screen material with mesh size 60 µm
100S = screen material with mesh size 100 µm

Tolerances for mesh size according to DIN 4189.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt holding capacity Filter surface in ( )	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No	Weight	Remarks
	l/min			g		bar			kg	
1	2	3	4	5	6	7	8	9	10	11
LS 025-152	25	**D1**/1	50P	15	G¾	-0,3	2	P3.0714-02	0,9	-
LS 035-152	33	**D2**/1	50P	19	G¾	-0,3	2	P3.0717-02	1,0	-

All filters are delivered with a plugged clogging indicator connection G¼. As clogging indicators either manometers or vacuum switches can be used.

For the appropriate clogging indicator see catalogue sheet 60.20.

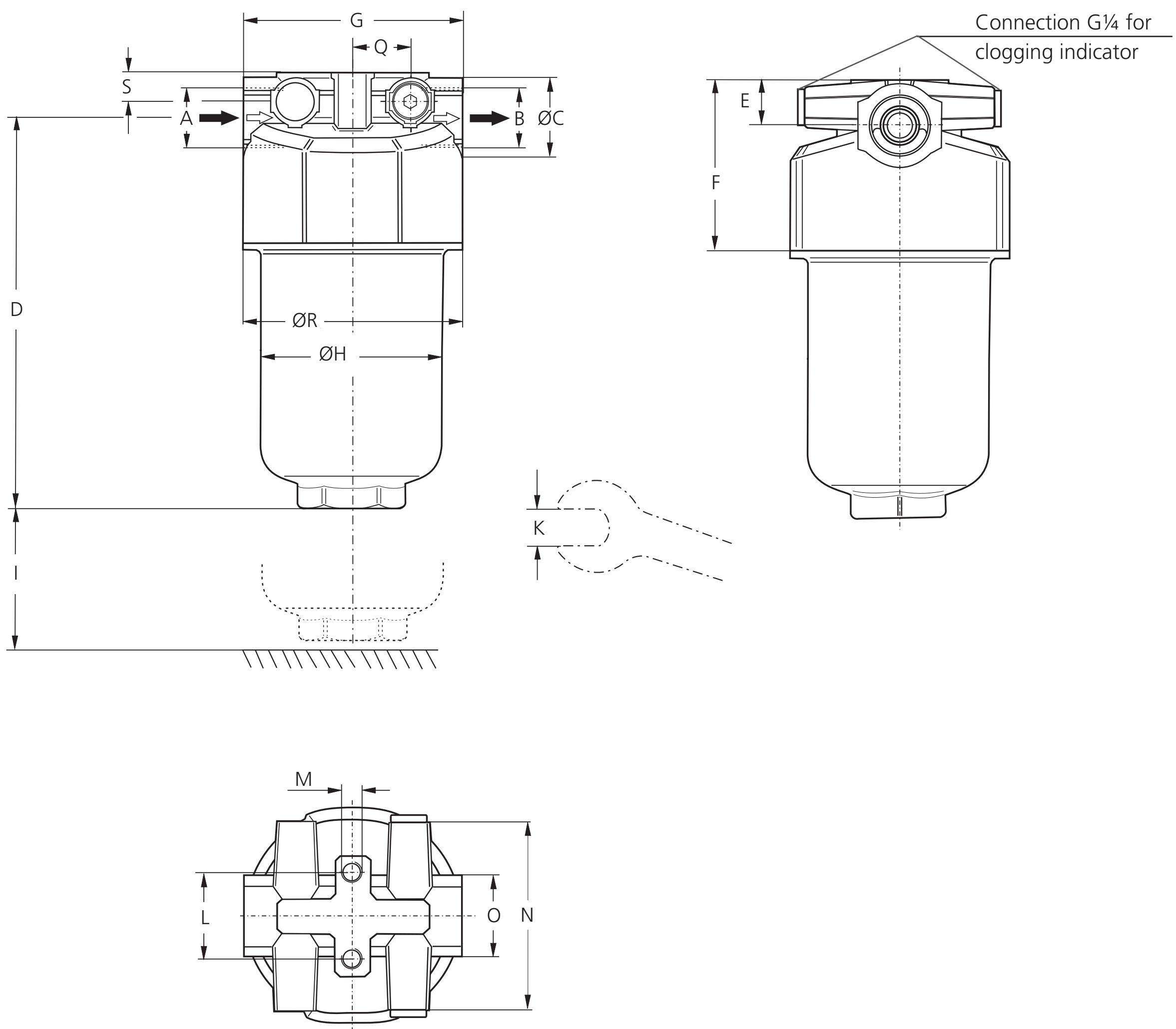
Remarks:

› The start of the red area respectively the actuating pressure of the vacuum switch has always to be higher than the cracking pressure of the by-pass valve (see Selection Chart, column 7).

› Clogging indicators are optional and always delivered detached from the filter.

› The filters listed in this chart are standard filters. Other designs available on request.

Dimensions

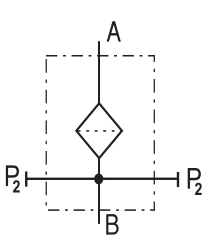


Measurements

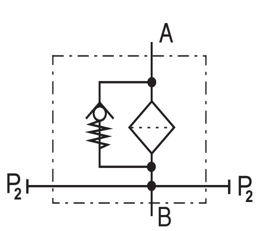
Type	A	B	C	D	E	F	G	H	I	K	L	M Ø/depth	N	O	Q	R	S
LS 025	G¾	G¾	35	178	20	74	95	80	70	AF 41	38,1	M8/15	82	AF 36	25	95	12
LS 035	G¾	G¾	35	212	20	74	95	80	70	AF 41	38,1	M8/15	82	AF 36	25	95	12

Symbols

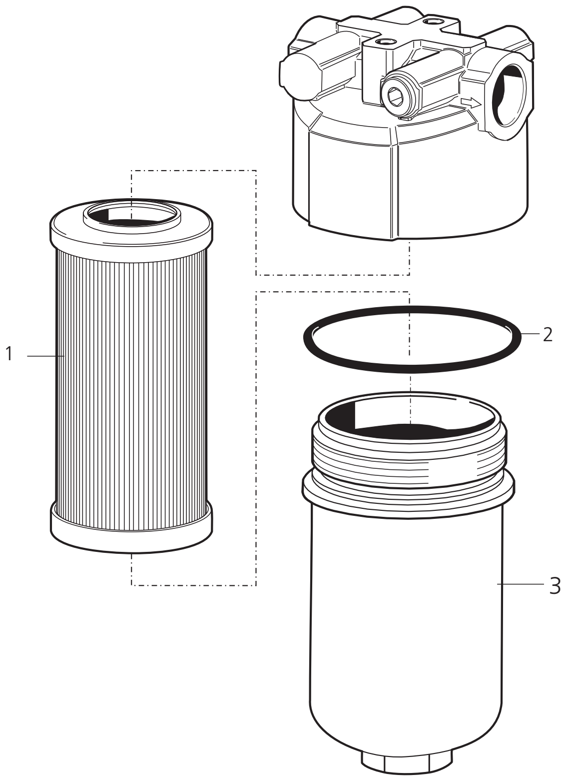
1



2



Spare Parts



Pos.	Designation	Part No.
1	Filter element	s. Chart/col. 9
2	O-ring 82,14 x 3,53	N007.0824
3	Filter bowl LS 025	E 068.0101
3	Filter bowl LS 035	E 068.0102

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

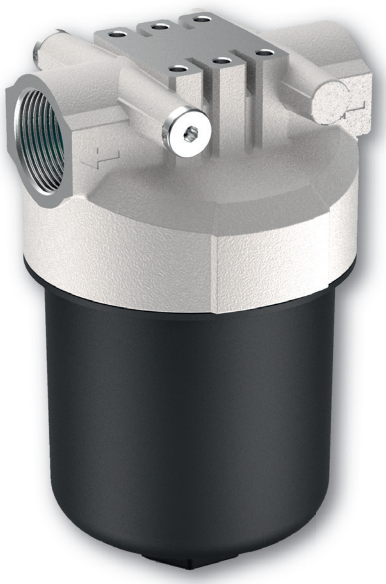
ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Suction Filters

LS 040 · LS 075

In-line mounting · Connection up to G1¼ · Nominal flow rate up to 75 l/min



In-line Suction Filter LS 075

Description

Application

To be installed in the suction line of the pumps of hydraulic systems resp. upstream of the charge pumps of hydrostatic drives.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Filter elements

Flow direction from outside to center. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Aluminium alloy
Filter bowl:	Polyamide, GF reinforced
Seals:	NBR (FPM on request)
Filter media:	Paper-cellulose web, impregnated with resin

Accessories

Electrical and optical clogging indicators are available.
Dimensions and technical data see catalogue sheet 60.20.

Nominal flow rate

Up to 75 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- Closed by-pass valve at $\nu \leq 200$ mm²/s
- Element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- Flow velocity in the connection lines ≤ 1,5 m/s
  If units not equipped with a bypass valve are used in hydrostatic drives, the recommendations regarding their technical application given on catalogue sheet 10.310 should be observed.

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 (other port threads on request)

Filter fineness

50 µm(c)
ß-values according ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperatur range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- start-up viscosity:
  Determine ν_{max}, observing the permissible pressure at the pump inlet according to diagram D; determine Δp as a function of the viscosity (take into account the pressure loss in the connecting lines!)
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

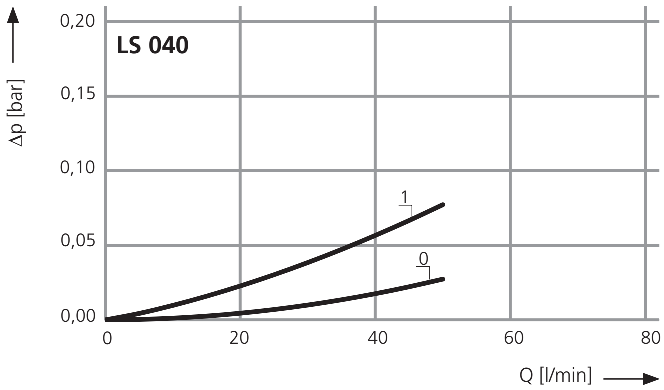
Mounting position

Vertical mounting to be preferred, filter head on top.

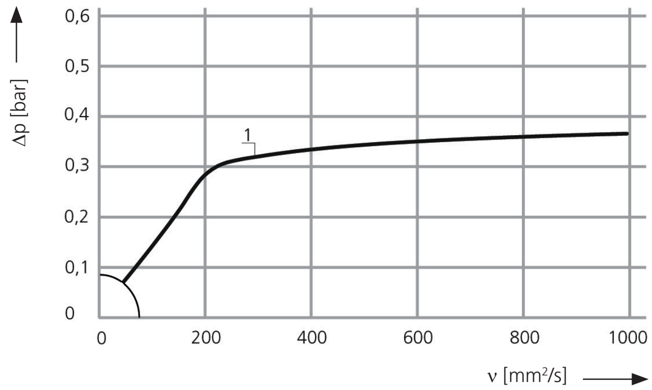
Diagrams

Δp-curves for complete filters in Selection Chart, column 3

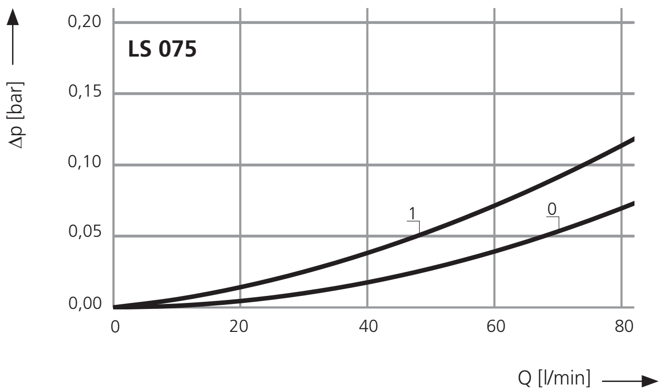
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



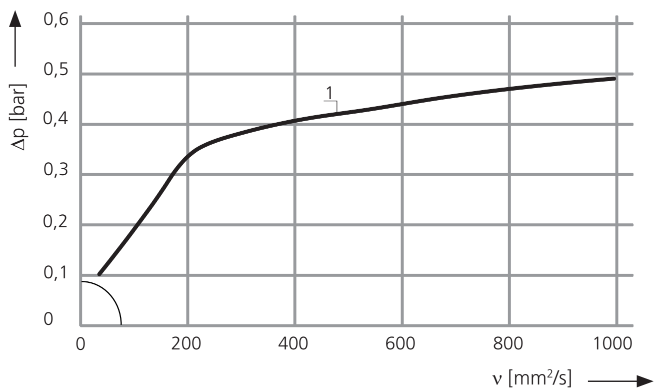
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

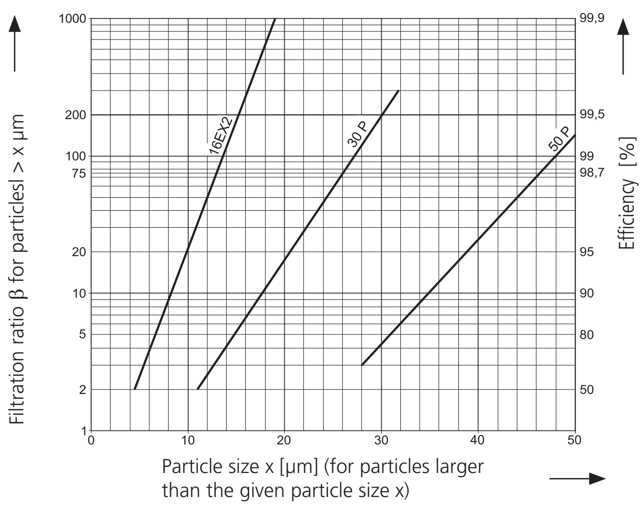


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

16EX2 = $\overline{\beta}_{16(c)}$ = 200 EXAPOR®MAX 2
30P = $\beta_{30\,(c)}$ = 200 Paper
50P = $\beta_{50\,(c)}$ = 200 Paper

Based on the structure of the filter media of the 30P and 50P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S = screen material with mesh size 40 µm
60S = screen material with mesh size 60 µm
100S = screen material with mesh size 100 µm

Tolerances for mesh size according to DIN 4189.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part. No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt -holding capacity Filter surface in ( )	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part. No.	Weight	Remarks
	l/min			g		bar			kg	
1	2	3	4	5	6	7	8	9	10	11
LS 040-152	40	**D1**/1	50P	40	G1¼	-0,3	2	P3.1014-02	1,8	-
LS 075-152	75	**D2**/1	50P	77	G1¼	-0,3	2	P3.1025-02	2,1	-

All filters are delivered with a plugged clogging indicator connection G¼. As clogging indicators either manometers or vacuum switches can be used.

For the appropriate clogging indicator see catalogue sheet 60.20.

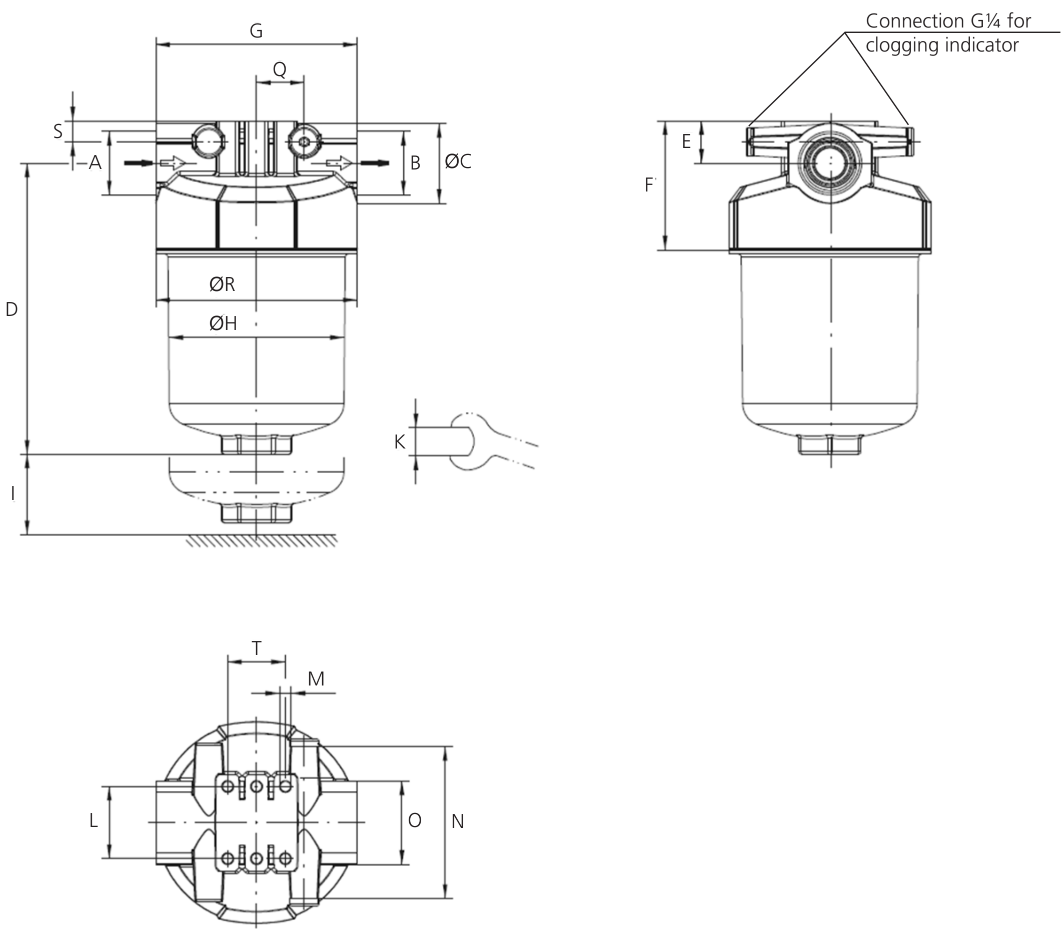
Remarks:

› The start of the red area respectively the actuating pressure of the vacuum switch has always to be higher than the cracking pressure of the by-pass valve (see Selection Chart, column 7).

› Clogging indicators are optional and always delivered detached from the filter.

› The filters listed in this chart are standard filters. Other designs available on request.

Dimensions

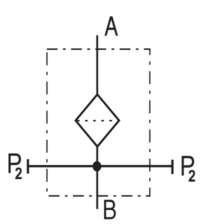


Measurements

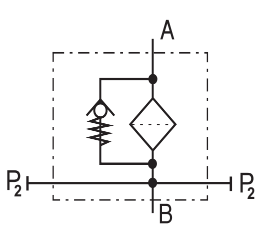
Type	A	B	C	D	E	F	G	H	I	K	L	M Ø/depth	N	O	Q	R	S	T
LS 040	G1¼	G1¼	52	192	28	85	133	117	60	AF41	47,6	M8/15	100	AF55	31,5	133	14	38,1
LS 075	G1¼	G1¼	52	302	28	85	133	117	60	AF41	47,6	M8/15	100	AF55	31,5	133	14	38,1

Symbols

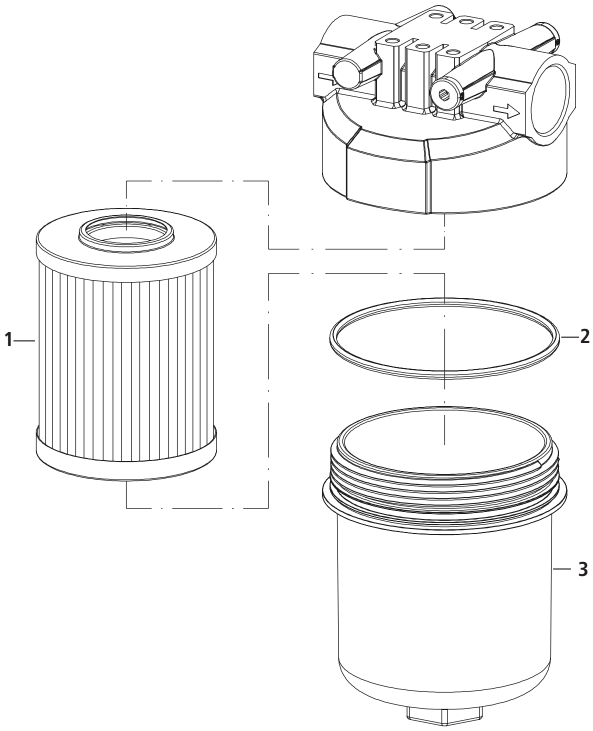
1



2



Spare Parts



Pos.	Designation	Part No.
1	Filter element	see Chart/col. 9
2	O-ring 115,00 x 4,50	N007.1155
3	Filter bowl LS 040	D 230.0102
3	Filter bowl LS 075	D 230.0101

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

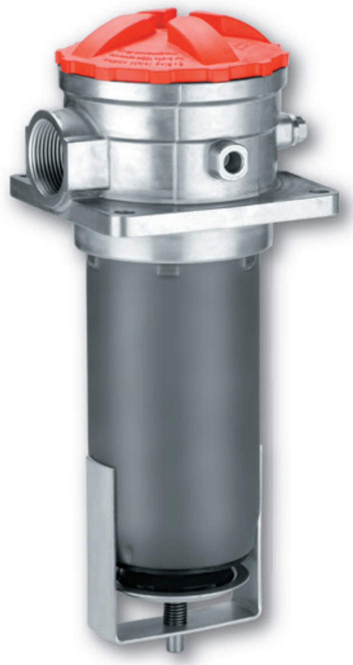
To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

ES 074 · ES 094

Tank top mounting · Connection up G1¼ · Nominal flow rate up to 80 l/min



In-line Suction Filter ES 074

Description

Application

To be installed in the suction line of the pumps of hydraulic systems resp. upstream of the charge pumps of hydrostatic drives.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

› By-pass valve:
The location close to the suction inlet prevents dirt particles retained by the filter element from entering into the clean oil side.

› Filter element locking valve:
Ensures that dirt accumulated in the filter element is removed together with the element and cannot return to the tank.

› Foot valve:
When the screw-on cap is removed for maintenance, the foot valve closes automatically. This makes it possible to service the filter even if it is submerged below the oil level in a full tank.

Filter elements

Flow direction from centre to outside. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

In filters with a magnetic system, the ferromagnetic particles in the fluid pass first through a strong magnetic field and are separated.

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Screw-on cap:	Polyester, GF reinforced
Filter head:	Aluminium alloy
Filter bowl:	Steel
Seals:	NBR (FPM on request)
	EXAPOR®MAX 2 - inorganic microfibre web
Filter media:	Paper – cellulose web, impregnated with resin Stainless steel wire mesh (1.4301)

Accessories

Electrical and optical clogging indicators are available on request. Dimensions and technical data see catalogue sheet 60.20.

Characteristics

Nominal flow rate

Up to 80 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200\ mm^2/s$
- Element service life > 1.000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume.
- Flow velocity in the connection lines ≤ 1,5 m/s. If units not equipped with a bypass valve are used in hydrostatic drives, the recommendations regarding their technical application given on catalogue sheet 10.310 should be observed.

Connection

Threaded ports according to ISO 228 or DIN 13. Sizes see Selection Chart, column 6 (other port threads on request)

Filter fineness

16 µm(c) ... 60 µm(c)
β-values according ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60\ mm^2/s$
- start-up viscosity:
  Determine ν_{max}, observing the permissible pressure at the pump inlet according to diagram D; determine Δp as a function of the viscosity (take pressure loss in connection lines into account!)
- at initial operation of units equipped with a bypass valve:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

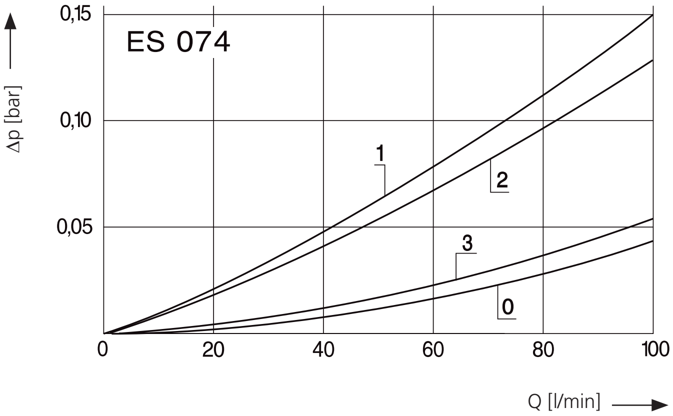
Mounting position

Vertical mounting to be preferred, suction opening pointing downwards, versions equipped with foot valve for horizontal mounting also.

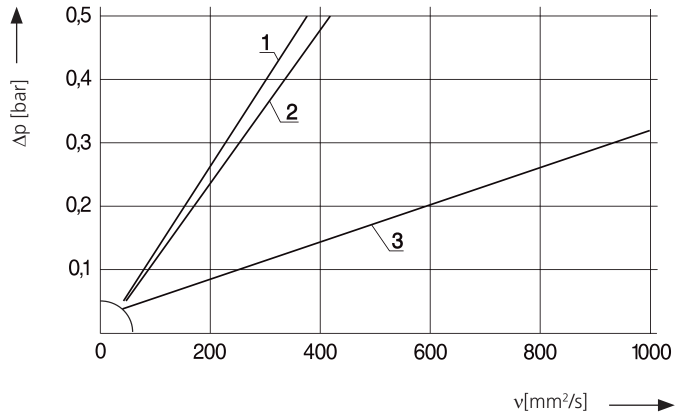
Diagrams

Δp-curves for complete filters in Selection Chart, column 3

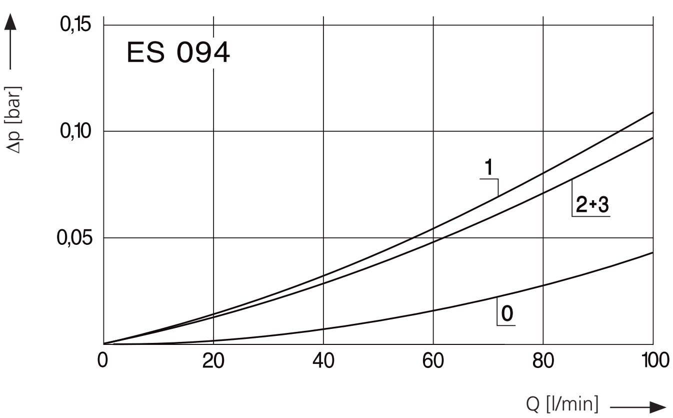
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



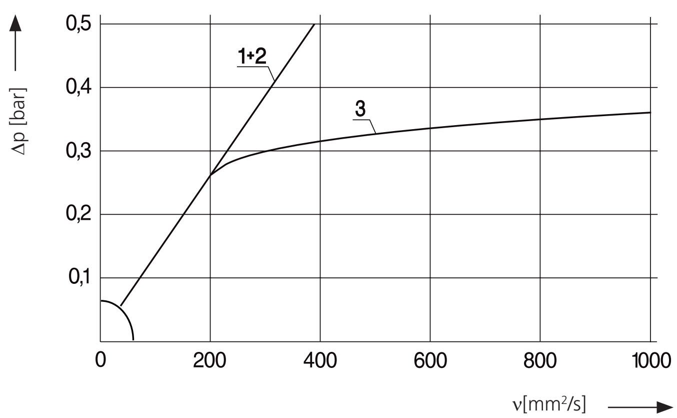
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

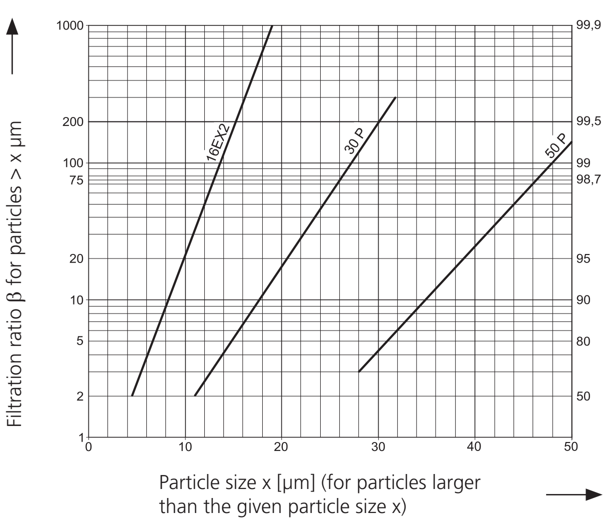


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

16EX2 = $\overline{\beta}_{16(c)}$ = 200 EXAPOR®MAX 2
30P = $\overline{\beta}_{30\,(c)}$ = 200 Paper
50P = $\overline{\beta}_{50\,(c)}$ = 200 Paper

Based on the structure of the filter media of the 30 P and 50 P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S = screen material with mesh size 40 µm
60S = screen material with mesh size 60 µm
100S = screen material with mesh size 100 µm

Tolerances for mesh size according to DIN 4189.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity Filter surface in ( )	Connection B	Cracking pressure of by-pass	Foot valve	Symbol	Replacement filter element Part. No.	Weight	Remarks
	l/min			g		bar				kg	
1	2	3	4	5	6	7	8	9	10	11	12
ES 074-6801	40[1]	**D1**/1	16EX2	26	G1¼	-	•	2	V2.0923-07	2,4	-
ES 074-6110	45[1]	**D1**/2	30P	23	G1	-	-	1	P2.0923-01	2,2	-
ES 074-6120	45[1]	**D1**/2	30P	23	G1¼	-	-	1	P2.0923-01	2,2	-
ES 074-6121	45[1]	**D1**/2	30P	23	G1	-	•	2	P2.0923-01	2,4	-
ES 074-6141	45[1]	**D1**/2	30P	23	G1¼	-	•	2	P2.0923-01	2,4	-
ES 074-0001	80	**D1**/3	60S	(1540 cm^2)	G1¼	-0,25	•	6	S2.0920-10	2,4	with magnetic system
ES 094-6801	60[1]	**D2**/1	16EX2	40	G1¼	-	•	2	V2.0933-08	3,2	-
ES 094-6110	70[1]	**D2**/2	30P	34	G1¼	-	-	1	P2.0933-01	3,0	-
ES 094-6111	70[1]	**D2**/2	30P	34	G1¼	-	•	2	P2.0933-01	3,2	-
ES 094-6121	70	**D2**/3	30P	34	G1¼	-0,25	•	4	P2.0933-01	3,2	-

All filters are delivered with a plugged clogging indicator connection G¼. As clogging indicators either manometers or vacuum switches can be used.
Optional extension pipes adapt the filter length to various tank depths. For ordering of accessories please use the below mentioned codes.

Order example: The filter ES 074-6110 has to be supplied with an extension pipe (EV) for a mounting depth of 400 mm.

Order-description: **ES 074-6110 / EV 400**

Part No. (Basic unit)

Extension pipe[2] (2 lengths are available)

EV = 400 / 500 mm (see dimensions and measurements)

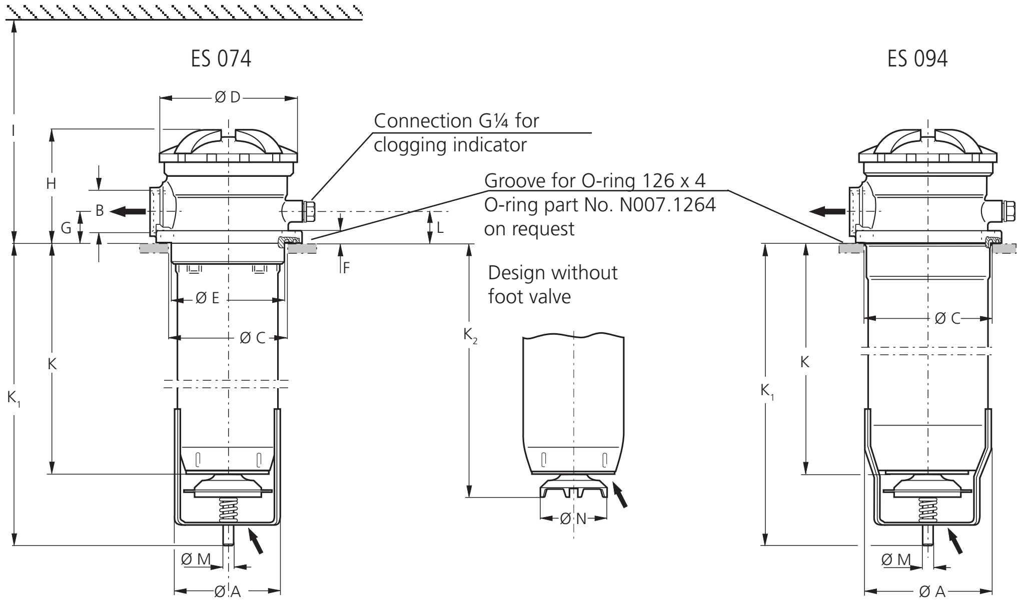
For the appropriate clogging indicator see catalogue sheet 60.20.

Remarks:

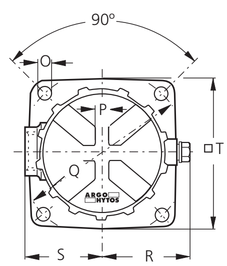
› The start of the red area respectively the actuating pressure of the vacuum switch has always to be higher than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
› Clogging indicators are optional and always delivered detached from the filter.
› The filters listed in this chart are standard filters. Other designs available on request.

[1] Those values apply when used in hydrostatic drives and instructions in catalogue sheet 10.310 have to be observed
[2] For designs without foot valve

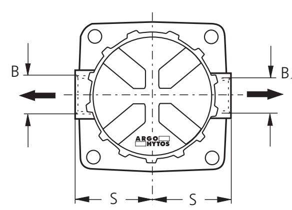
Dimensions



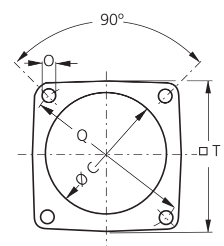
Design with 1 outlet port



Design with 2 outlet ports on request



Required mounting surface



For calculation of dimension EV see selection chart

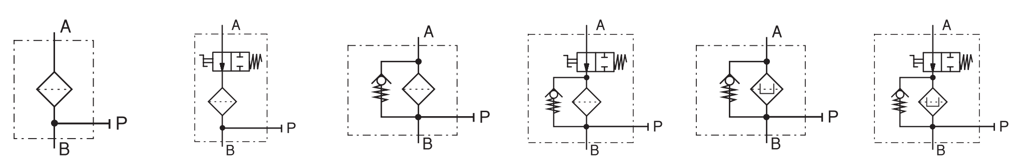
Measurements

Type	A	B	C min./max.	D	E	F	G	H	I	K	K_1	K_2	L	M	N	O	P
ES 074	100	G1, G1¼	111/121	126,5	110	11,5	32	106	400	198	256	218	35	10	62,5	11	13
ES 094	115	G1¼	119/121	126,5	-	11,5	32	106	525	305	364	325	35	10	62,5	11	13

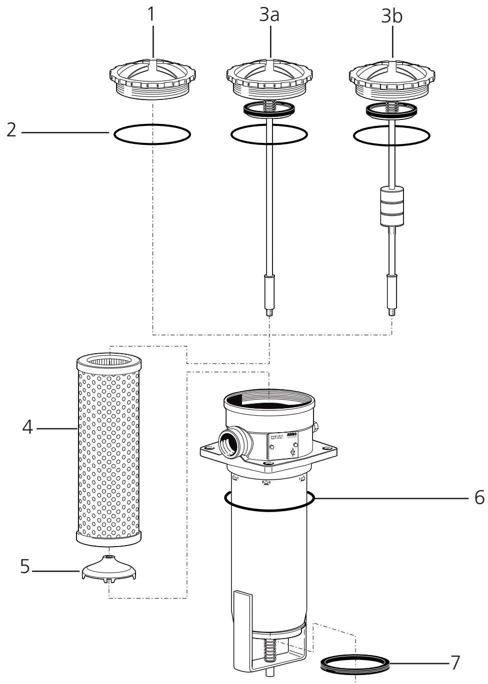
Type	Q	R	S	T
ES 074	165	82,5	76	141
ES 094	165	76,5	76	141

Symbols

1 2 3 4 5 6



Spare Parts



Pos.	Designation	Part No.
1	Screw-on cap with Pos. 2	ES 074.1212
2	O-ring 100 x 4	N007.1004
3a	Screw-on cap with Pos. 2 for ES 074 (without by-pass) for ES 094 (without by-pass) for ES 094 (with by-pass)	 ES 074.1213 ES 094.1212 ES 094.1213
3b	Screw-on cap with Pos. 2 including magnetic system for ES 074 (with by- pass)	 ES 074.1205
4	Filter element	see Chart / col. 10
5	Valve cone	ES 074.0202
6	O-ring 126 x 4 *	N007.1264
7	Rubber ring	N042.7401

* not included in basic equipment

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941 Verification of collapse/burst pressure rating
ISO 2942 Verification of fabrication integrity (Bubble Point Test)
ISO 2943 Verification of material compatibility with fluids
ISO 3968 Evaluation of pressure drop versus flow characteristics
ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Suction Filters

ES 134 · ES 144

Tank top mounting · Connection up to SAE 1½ · Nominal flow rate up to 130 l/min

Suction Filters ES 144

Description

Application

To be installed in the suction line of the pumps of hydraulic systems resp. upstream of the charge pumps of hydrostatic drives.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

- By-pass valve:
  The location close to the suction inlet prevents dirt particles retained by the filter element from entering into the clean oil side.
- Filter element locking valve:
  Ensures that dirt accumulated in the filter element is removed together with the element and cannot return to the tank.
- Foot valve:
  When the screw-on cap is removed for maintenance, the foot valve closes automatically. This makes it possible to service the filter even if it is submerged below the oil level in a full tank.

Filter elements

Flow direction from centre to outside. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

In filters with a magnetic system, the ferromagnetic particles in the fluid pass first through a strong magnetic field and are separated.

Filter maintenance

By using a clogging indicator the correct moment for main-tenance is stated and guarantees the optimum utilization of the filter life.

Materials

Screw-on cap:	Polyester, GF reinforced
Filter head:	Aluminium alloy
Filter bowl:	Steel
Seals:	NBR (FPM on request)
Filter media:	Paper – cellulose web, impregnated with resin Stainless steel wire mesh (1.4301)

Accessories

Electrical and optical clogging indicators are available on request. Dimensions and technical data see catalogue sheet 60.20.

Characteristics

Nominal flow rate

Up to 130 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines ≤ 1,5 m/s
  If units not equipped with a bypass valve are used in hydrostatic drives, the recommendations regarding their technical application given on catalogue sheet 10.310 should be observed.

Connection

Threaded ports according to ISO 228 or DIN 13 or SAE-flanges (3.000 psi).
Sizes see Selection Chart, column 6 (other port threads on request)

Filter fineness

30 µm(c) ... 60 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

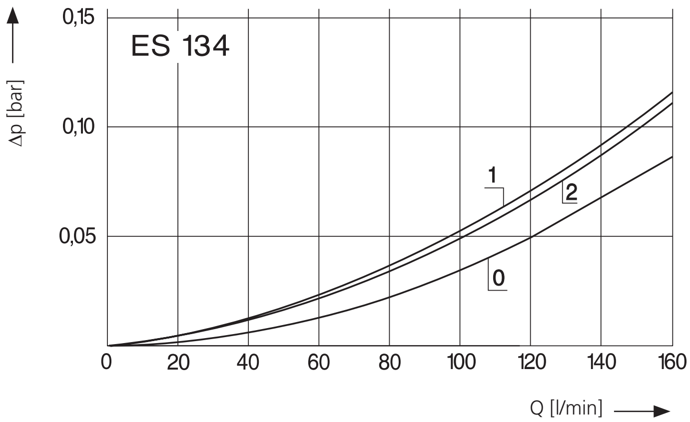
- at operating temperature: $\nu < 60$ mm²/s
- start-up viscosity:
  determine ν_{max}, observing the permissible pressure at the pump inlet according to diagram D; determine Δp as a function of the viscosity (take pressure loss in connection lines into account!)
- at initial operation of units equipped with a bypass valve:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

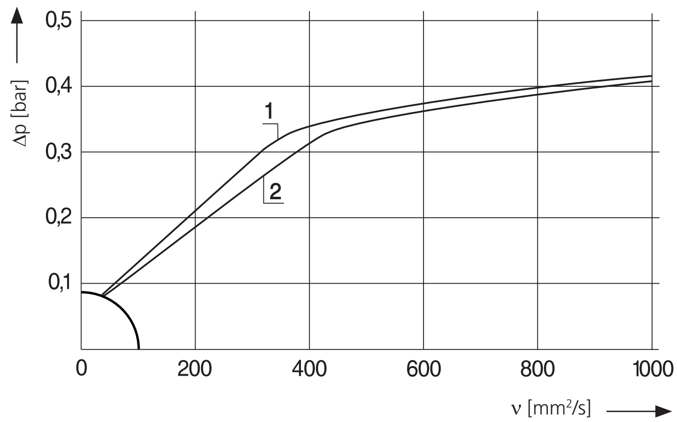
Vertical mounting to be preferred, suction opening pointing downwards, versions equipped with foot valve for horizontal mounting also.

Δp-curves for complete filters in Selection Chart, column 3

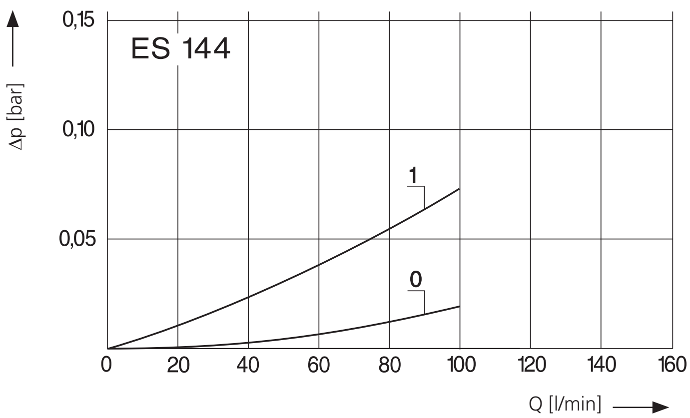
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



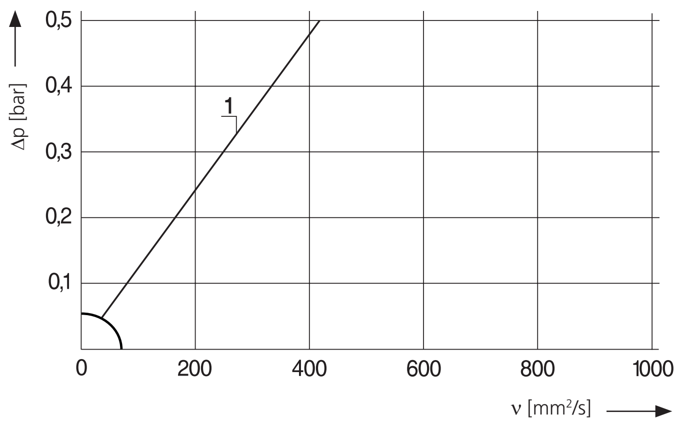
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

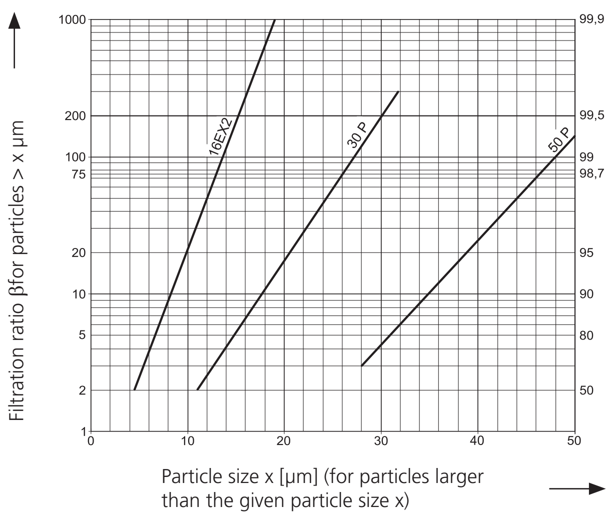


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

16EX2	=	$\overline{\beta}_{16(c)}$	=	200 EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$	=	200 Paper
50P	=	$\overline{\beta}_{50\,(c)}$	=	200 Paper

Based on the structure of the filter media of the 30 P and 50 P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part. No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see Diagr.**Dx**	Dirt-holding capacity Filter surface in ( )	Connection B	Cracking pressure of by-pass	Foot valve	Symbol	Replacement filter element Part No.	Weight	Remarks
	l/min			g		bar				kg	
1	2	3	4	5	6	7	8	9	10	11	12
ES 134-0501	130	**D1**/1	40S	(1540 cm²)	SAE 1½	-0,25	•	6	S2.0920-05	3,0	with magnetic system
ES 134-0001	130	**D1**/2	60S	(1540 cm²)	SAE 1½	-0,25	•	6	S2.0920-10	3,0	with magnetic system
ES 144-6110	70[1]	**D2**/1	30P	34	2 x G1 + G1¼	-	-	1	P2.0933-01	3,5	-

All filters are delivered with a plugged clogging indicator connection G¼. As clogging indicators either manometers or vacuum switches can be used.
Optional extension pipes adapt the filter length to various tank depths. For ordering of accessories please use the below mentioned codes.

Order example: The filter ES 144-6110 has to be supplied with an extension pipe (EV) for a mounting depth of 400 mm.

Order description: **ES 144-6110** / **EV 400**

Part No. (Basic unit)

Extension pipe 2 (2 lengths are available)

EV = 400 / 500 mm (see section dimensions and measurements)

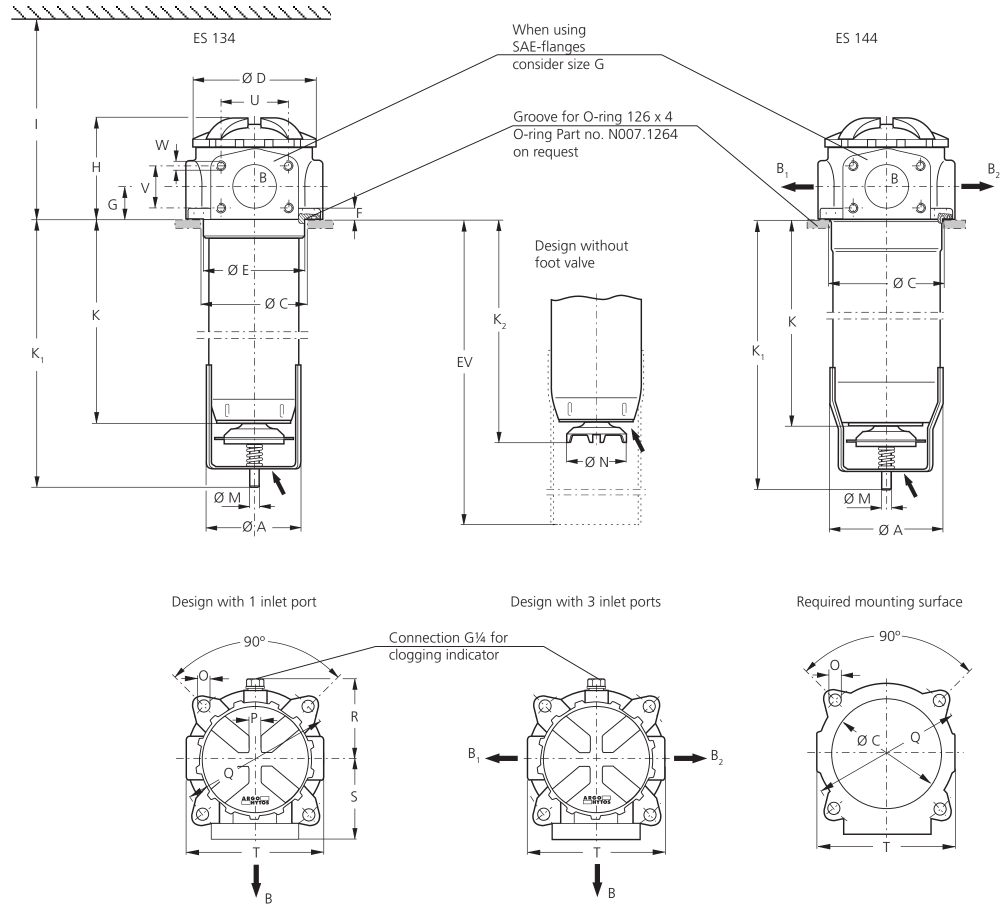
For the appropriate clogging indicator see catalogue sheet 60.20.

Remarks:

- The start of the red area respectively the actuating pressure of the vacuum switch has always to be higher than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. Other designs available on request.

[1] Those values apply when used in hydrostatic drives and instructions in catalogue sheet 10.310 have to be observed.
[2] For designs without foot valve

Dimensions



For calculation of dimension EV see selection chart

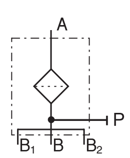
Measurements

Type	A	B	B_1	B_2	C min./max.	D	E	F	G	H	I	K	K_1	K_2	L	M	N
ES 134	100	SAE1½	-	-	111/121	126,5	110	12	32	106	400	198	256	218	-	10	62,5
ES 144	115	G1¼	G1	G1	119/221	126,5	-	12	32	106	525	305	364	325	-	10	62,5

Type	O	P	Q	R	S	T	U	V	W								
ES 134	11,5	13	165	81	82	144	69,8	35,7	M12								
ES 144	11,5	13	165	81	82	144	69,8	35,7	M12								

Symbols

1



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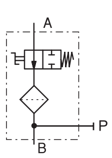

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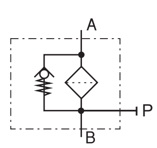

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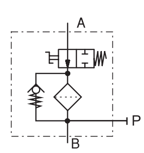

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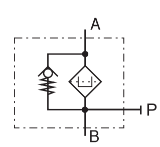

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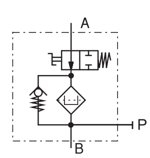
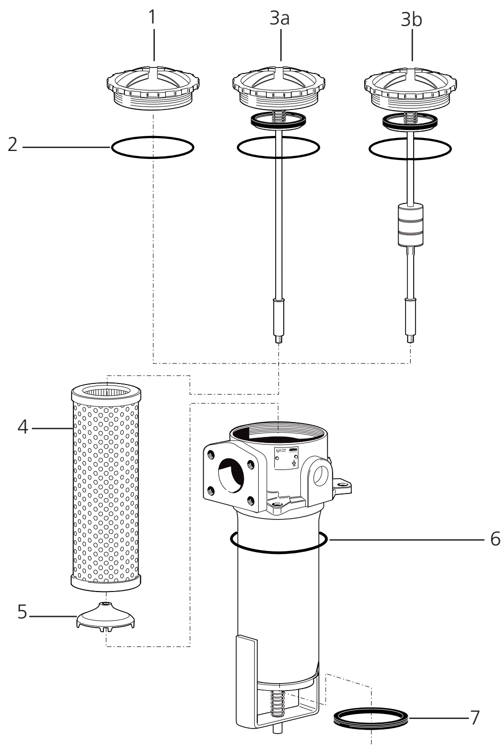


Spare Parts



Pos.	Designation	Part No.
1	Screw-on cap with Pos. 2	ES 074.1212
2	O-ring 100 x 4	N007.1004
3a	Screw-on cap with Pos. 2 for ES 134 (without by-pass) for ES 144 (without by-pass)	 ES 074.1213 ES 094.1212
3b	Screw-on cap with Pos. 2 including magnetic system for ES 134 (with by-pass)	 ES 074.1205
4	Filter element	s. Chart / col. 10
5	Valve cone	ES 074.0202
6	O-ring 126 x 4 *	N007.1264
7	Rubber ring	N042.7401

* not included in basic equipment

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Suction Filters

Type series ES · Application in hydrostatic gears

Suction filter type series ES

Description

Certain versions of our built-in suction filters in the ES series are designed for use in front of filler pumps of hydrostatic gears. Particular attention has been paid to the specific requirements of the manufacturers of these gears regarding filter fineness and pressure drop.
These filters have no bypass-valve, so that unfiltered oil cannot enter the circulation.
Versions without a foot-valve are intended for vertical installation, in which case particular attention must be paid to the oil-level:

› at max. oil-level:
  sufficient safety-clearance below the filter cover must be maintained.

› at min. oil-level:
  sufficient level of oil above the filter inlet must be maintained.

Suction filters designed for installation below the oil-level are fitted with a foot-valve. The oil-feed to the filter casing is cut off automatically when the filter cover is opened.

Some gear manufacturers insist that filters be designed to handle double the maximum output of the filler pump. Our filters already conform to this requirement.
The flow-data for the filters shown in the tables are based on the following assumptions:

1. The use of ATF oils with approx. 26 to 28 mm^2/s at 50 °C or hydraulic oils with a viscosity and viscosity temperature characteristic corresponding to standard ATF oils (also see info-sheet 00.003).

2. Under normal operating conditions an operating viscosity of $\leq$ 35 mm^2/s should be reached within 15 minutes of commencement of operation.

3. Effective oil capacity in litres should be about 0,5 to 1 x the maximum output of the filler pump.

4. A pressure drop Δp between filter outlet and filler pump inlet of $\leq$ 0,05 bar at viscosity of 35 mm^2/s.

Should operating conditions differ from the above, please contact us for further information.

Details of pressure gradients for individual filters are given on the specification sheets of the respective filters, chapter diagrams.

Return Filters

D 090 · D 100

In-line mounting · Connection up to G¾ · Nominal flow rate up to 110 l/min

Return Filter D 090

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Aluminium alloy
Filter bowl:	Polyamide, GF reinforced
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin

Accessories

Electrical and optical clogging indicators are available. Dimensions and technical data see cataologue sheet 60.20.

Nominal flow rate

Up to 110 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average
- fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines ≤ 4,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 (other port threads on request)

Filter fineness

10 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

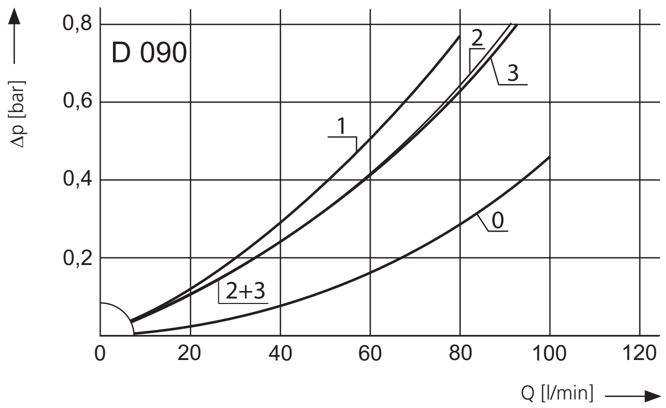
Max. 10 bar

Mounting position

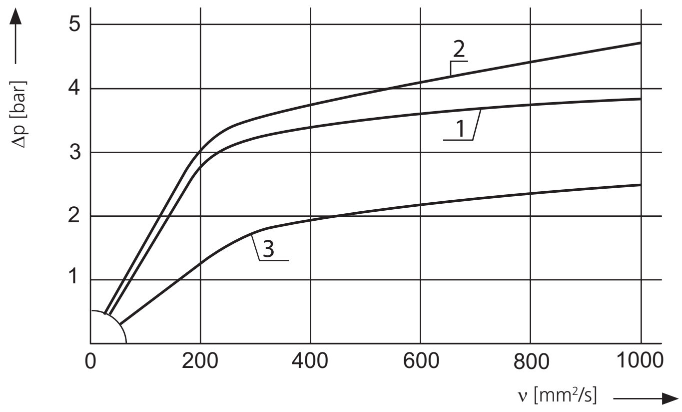
Preferably vertical, filter head on top.

Δp-curves for complete filters in Selection Chart, column 3

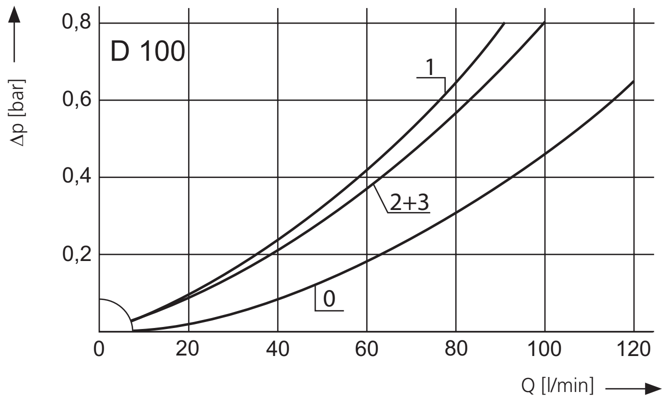
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



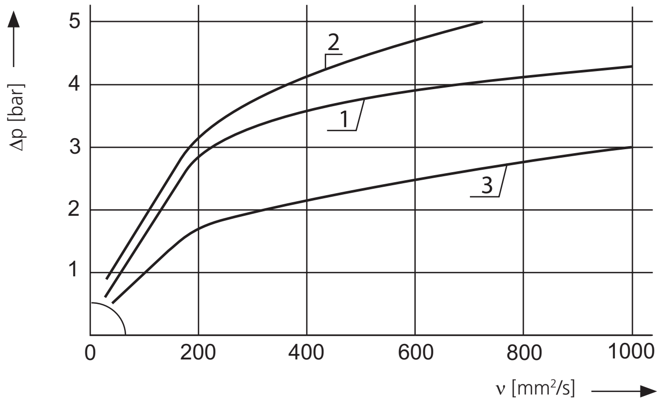
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

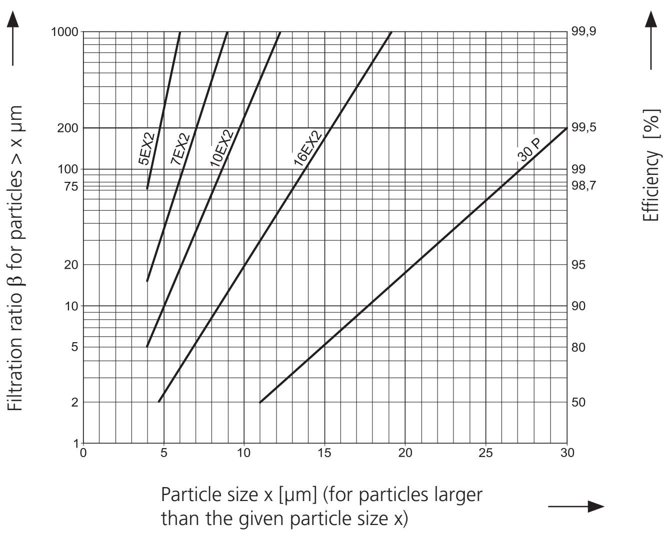


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2 =	$\bar{\beta}_{5\,(c)}$	=	200 EXAPOR®MAX 2
7EX2 =	$\bar{\beta}_{7\,(c)}$	=	200 EXAPOR®MAX 2
10EX2 =	$\bar{\beta}_{10\,(c)}$	=	200 EXAPOR®MAX 2
16EX2 =	$\bar{\beta}_{16\,(c)}$	=	200 EXAPOR®MAX 2
30P =	$\bar{\beta}_{30\,(c)}$	=	200 Paper

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size accordung to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Part No.	Nominal flow rate	Pressure drop see diagramm **D**/Kcurve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement element Part No.	Weight	Remarks
	l/min			g		bar			kg	
1	2	3	4	5	6	7	8	9	10	11
D 090-156	60	**D1**/1	10EX2	17	G¾	2,5	2	V3.0714-06	0,9	-
D 090-158	85	**D1**/2	16EX2	17	G¾	2,5	2	V3.0714-08	0,9	-
D 090-151	50	**D1**/3	30P	7,3	G¾	1,5	2	P3.0714-01	0,9	-
D 100-156	75	**D2**/1	10EX2	22	G¾	2,5	2	V3.0717-06	1,0	-
D 100-158	110	**D2**/2	16EX2	22	G¾	2,5	2	V3.0717-08	1,0	-
D 100-151	70	**D2**/3	30P	9,4	G¾	1,5	2	P3.0717-01	1,0	-

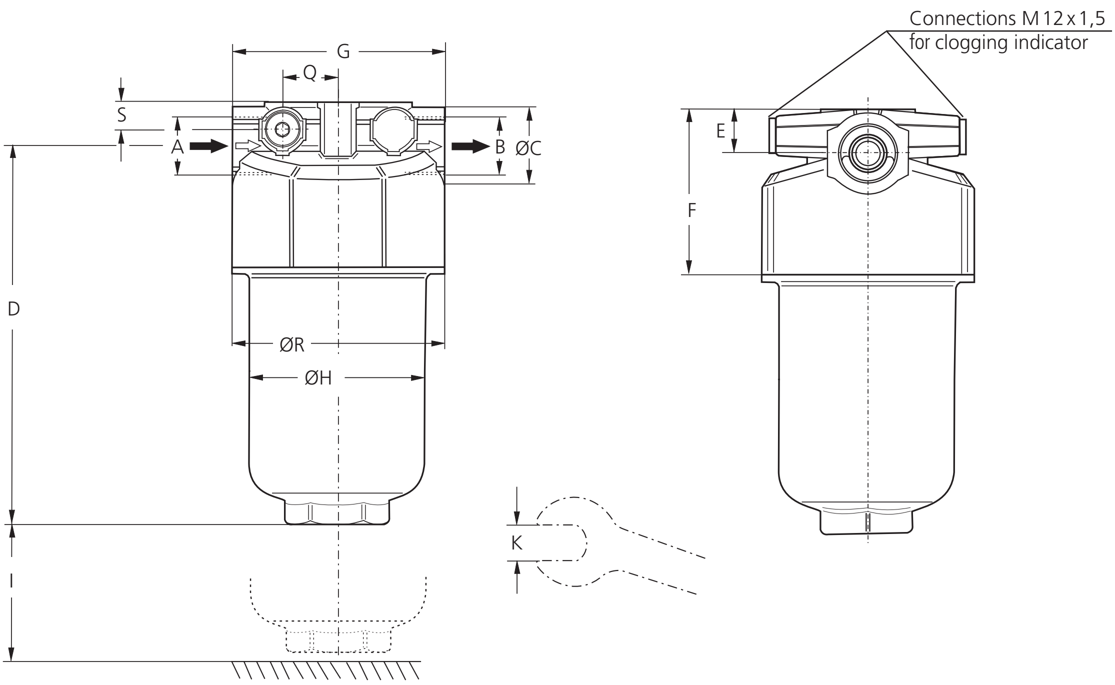
All filters are delivered with a plugged clogging indicator connection M12 x 1,5.
As clogging indicators either manometers or electrical pressure switches can be used.

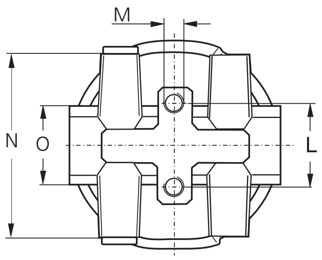
For the appropriate clogging indicator please see catalogue sheet 60.20.

Remarks:

- The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. Other designs available on request.

Dimensions



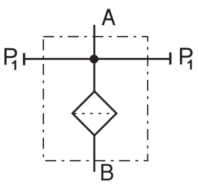


Measurements

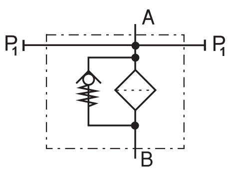
Type	A	B	C	D	E	F	G	H	I	K	L	M Ødepth	N	O	Q	R	S
D 090	G¾	G¾	35	178	20	74	95	80	70	AF41	38,1	M8/15	82	AF36	25	95	12
D 100	G¾	G¾	35	212	20	74	95	80	70	AF41	38,1	M8/15	82	AF36	25	95	12

Symbols

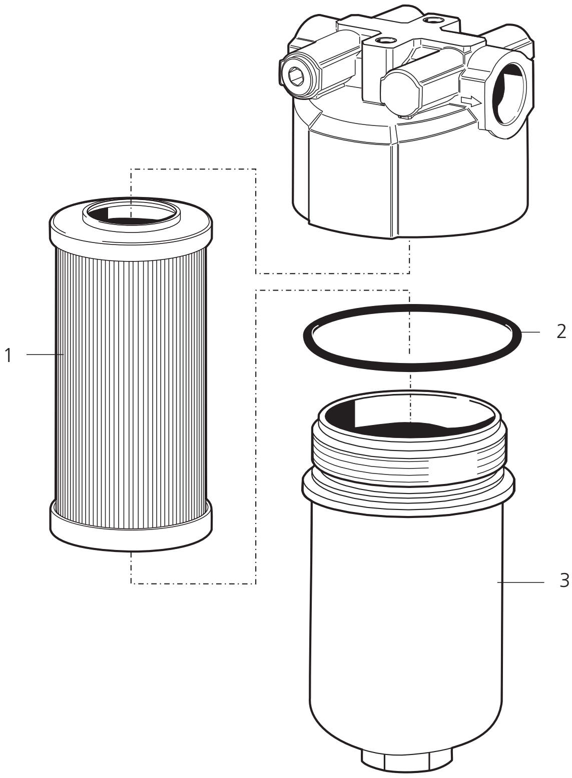
1



2



Spare Parts



Pos.	Designation	Part No.
1	Filter element	see Chart / col. 9
2	O-ring 82,14 x 3,53	N007.0824
3	Filter bowl D 090	E 068.0101
3	Filter bowl D 100	E 068.0102

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941 Verification of collapse/burst pressure rating
ISO 2942 Verification of fabrication integrity (Bubble Point Test)
ISO 2943 Verification of material compatibility with fluids
ISO 3968 Evaluation of pressure drop versus flow characteristics
ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return Filter

D 170 · D 230

In-line mounting · Connection up to G1¼ · Nominal flow rate up to 225 l/min

Return filter D 170

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Aluminium alloy
Filter bowl:	Polyamide, GF reinforced
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin

Accessories

Electrical and optical clogging indicators are available. Dimensions and technical data see cataologue sheet 60.20.

Nominal flow rate

Up to 225 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines ≤ 4,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 (other port threads on request)

Filter fineness

10 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

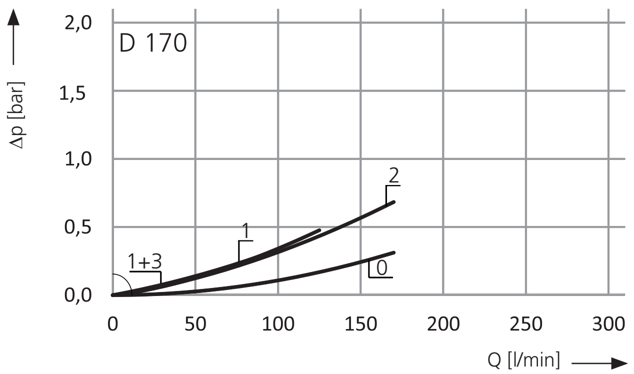
Maximal 10 bar

Mounting position

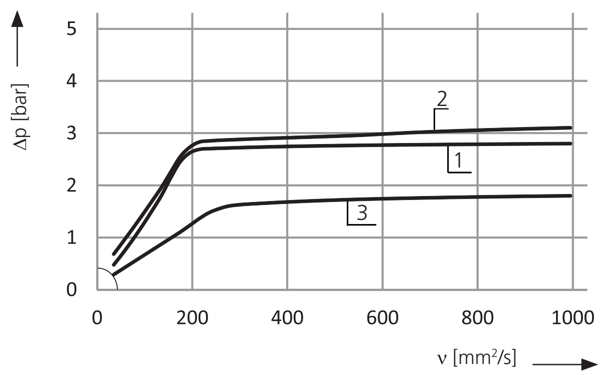
Preferably vertical, filter head on top.

Δp-curves for complete filters in Selection Chart, column 3

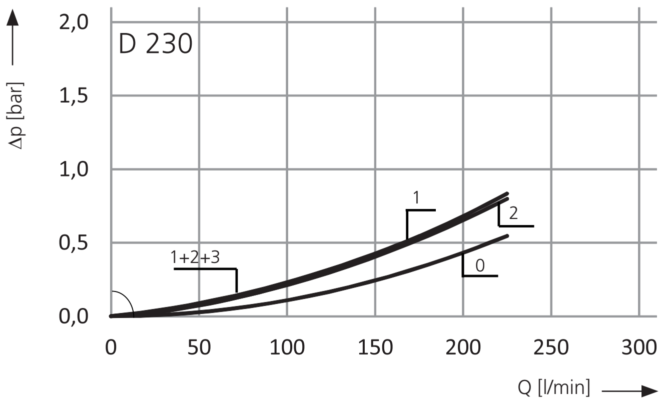
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



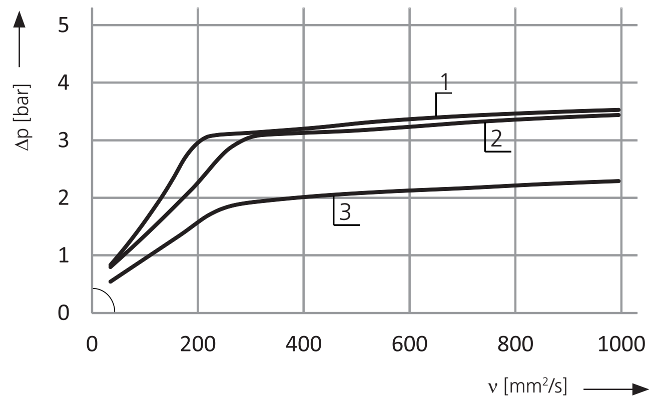
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

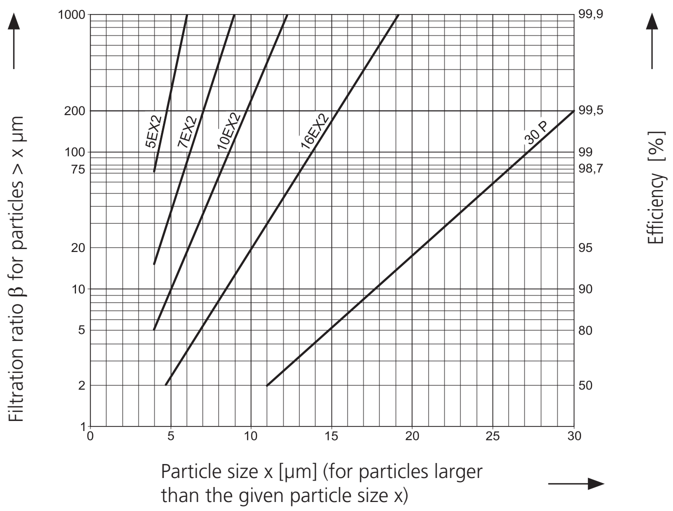


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200 EXAPOR®MAX 2
7EX2	=	$\beta_{7\,(c)}$	= 200 EXAPOR®MAX 2
10EX2	=	$\beta_{10\,(c)}$	= 200 EXAPOR®MAX 2
16EX2	=	$\beta_{16\,(c)}$	= 200 EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200 Paper

For screen elements

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size accordung to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Part No.	Nominal flow rate	Pressure drop see diagramm **D**/curve no..	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement element Part No.	Weight	Remarks
	l/min			g		bar			kg	
1	2	3	4	5	6	7	8	9	10	11
D 170-156	125	**D1**/1	10EX2	41	G1¹/₄	2,5	2	V3.1014-26	1,9	-
D 170-158	170	**D1**/2	16EX2	42	G1¹/₄	2,5	2	V3.1014-28	1,9	-
D 170-151	90	**D1**/3	30P	22	G1¹/₄	1,5	2	P3.1014-01	1,9	-
D 230-156	225	**D2**/1	10EX2	80	G1¹/₄	2,5	2	V3.1025-06	2,4	-
D 230-158	225	**D2**/2	16EX2	82	G1¹/₄	2,5	2	V3.1025-08	2,4	-
D 230-151	175	**D2**/3	30P	42	G1¹/₄	1,5	2	P3.1025-01	2,4	-

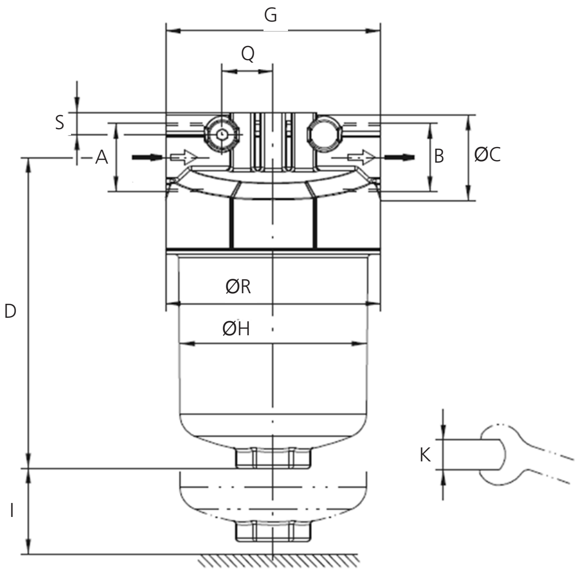
All filters are delivered with a plugged clogging indicator connection M12 x 1,5.
As clogging indicators either manometers or electrical pressure switches can be used.

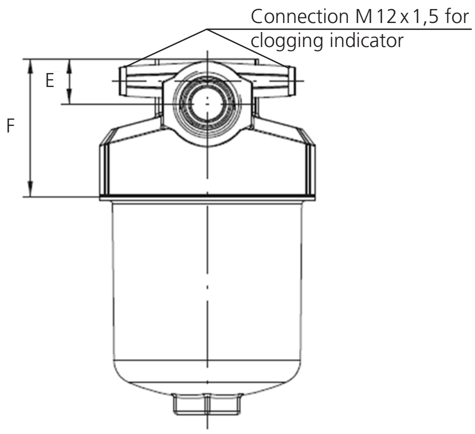
For the appropriate clogging indicator please see catalogue sheet 60.20.

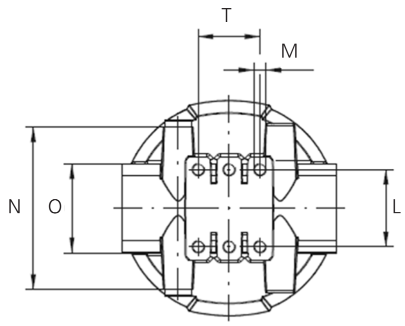
Remarks:

› The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
› Clogging indicators are optional and always delivered detached from the filter.
› The filters listed in this chart are standard filters. Other designs available on request.

Dimensions





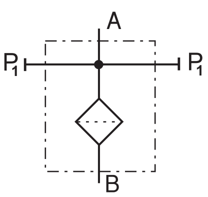


Measurements

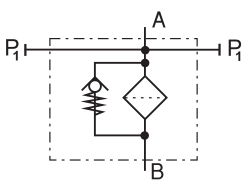
Type	A	B	C	D	E	F	G	H	I	K	L	M Ødepth	N	O	Q	R	S	T
D 170	G1¼	G1¼	52	192	28	85	133	117	60	AF 41	47,6	M8/15	100	AF 55	31,5	133	14	38,1
D 230	G1¼	G1¼	52	302	28	85	133	117	60	AF 41	47,6	M8/15	100	AF 55	31,5	133	14	38,1

Symbols

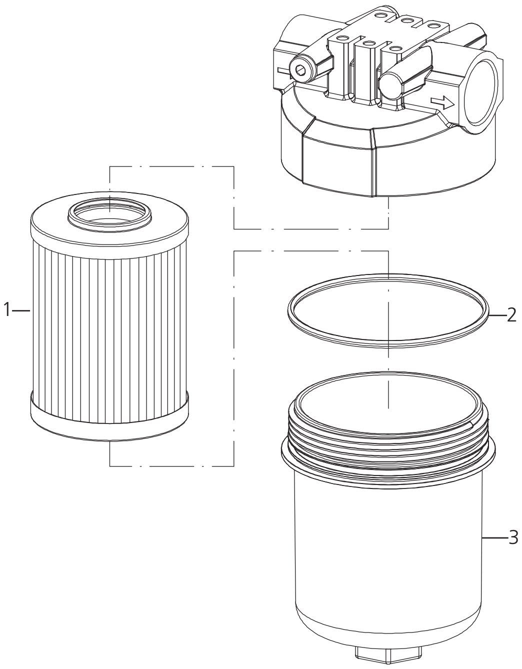
1



2



Spare Parts



Pos.	Designation	Part No.
1	Filter element	see chart./col. 9
2	O-ring 115,00 x 4,50	N007.1155
3	Filter bowl D 170	D 230.0102
3	Filter bowl D 230	D 230.0101

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Illustrations may sometimes differ from the original. ARGO-HYTOS is not responsible for any unintentional mistake in this specification sheet.

Return Filters

E 043 · E 072

Tank top mounting · Connection up to G¾ · Nominal flow rate up to 70 l/min

Return Filter E 072

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

- By-pass valve:
  The location close to the inlet port prevents dirt particles retained by the filter element from entering into the clean oil side.
- Removable bowl:
  In case of maintenance the filter bowl is removed together with the filter element – there fore dirt particles are not flushed back into the tank.
- Extension pipe:
  A correct extension pipe length ensures oil outlet below minimum oil level and prevents foaming.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Ventilating filter

Ventilation of the reservoir by an integral star-shape pleated filter element:

- removable (replace annually!)
- splash-proof
- fineness 2 µm

Filter maintenance

By using a clogging indicator the correct moment for main-tenance is stated and guarantees the optimum utilization of the filter life.

Minerials

Screw-on cap: Polyester, GF-reinforced
Filter head: Aluminium alloy
Filter bowl: Polyamid, CF-reinforced, electrically conducting
Seals: NBR (FPM on request)
Filter media: EXAPOR®MAX 2- organic multi-layer microfibre web
Paper - cellulose web, impregnated with resin

Accessories

Electrical and optical clogging indicators are available on request. Dimensions and technical data see catalogue sheet 60.20.

An optional oil separator (Part No. E 043.1701) is available on request.

Extension pipes on the bowl outlet are available in several lengths on request.
A self-assembly system for installation of extension pipes can be ordered. For detailed information please see catalogue sheet 20.390.

Characteristics

Nominal flow rate

Up to 70 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average
- fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines ≤ 4,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 (other port threads on request)

Filter fineness

5 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).
With high filling conditions we recommend an electrical conductivity >_ 500 pS/m at 20 °C.

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:

The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it inter-sects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

Max. 10 bar

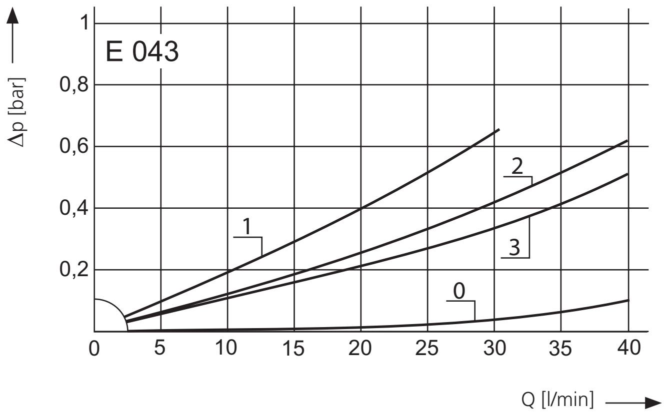
Mounting position

Preferably vertical, outlet downwards

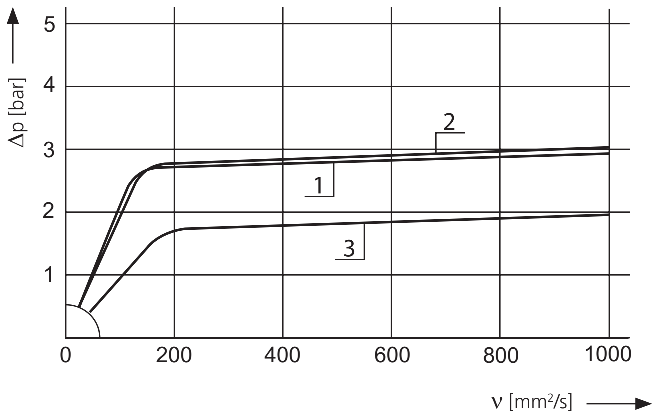
Diagrams

Δp-curves for complete filters in Selection Chart, column 3

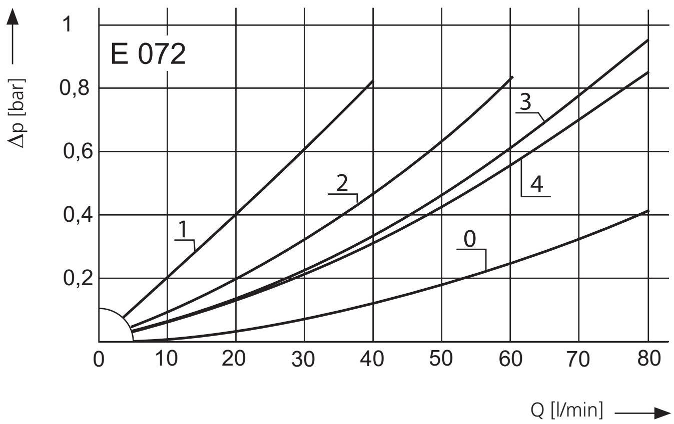
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



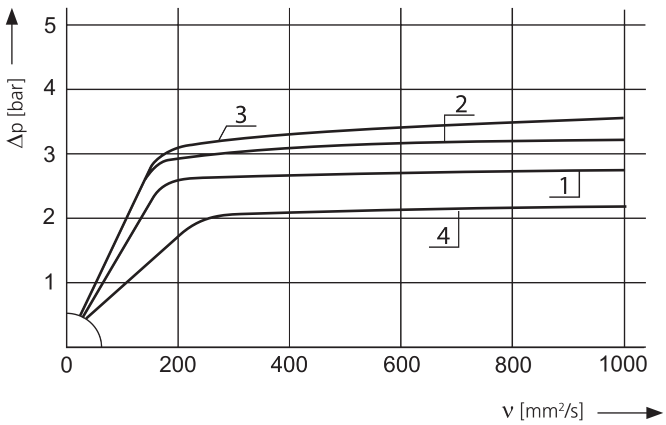
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

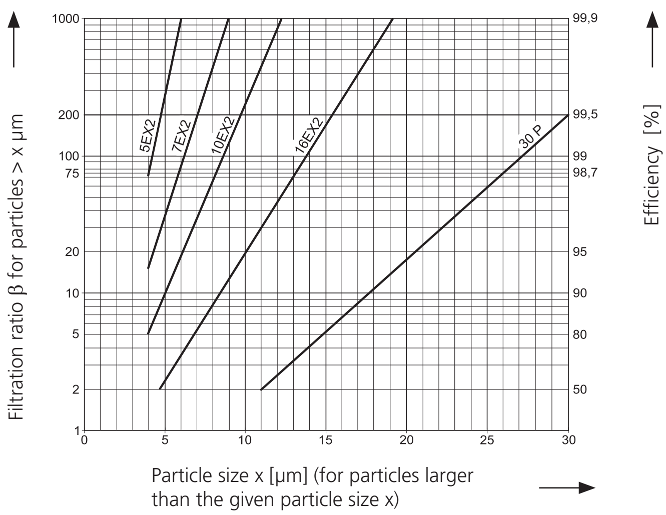


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\bar{\beta}_{5\,(c)}$	= 200 EXAPOR®MAX 2
7EX2	=	$\bar{\beta}_{7\,(c)}$	= 200 EXAPOR®MAX 2
10EX2	=	$\bar{\beta}_{10\,(c)}$	= 200 EXAPOR®MAX 2
16EX2	=	$\bar{\beta}_{16\,(c)}$	= 200 EXAPOR®MAX 2
30P	=	$\bar{\beta}_{30\,(c)}$	= 200 Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For ventilating filter elements:

2CL = 99,5 % efficiency for particles of size 2 µm

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Part No.	Nominal flow rate	Pressure drop see diagram **D**/ curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connection A	Cracking pressure of by-pass	Symbol	Replacement element Part No.	Weight	Replacement ventilating filter Part No. (Filter fineness see diagrams)	Remarks
	l/min			g		bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
E 043-156	25	**D1**/1	10EX2	6,1	$G^{1}/_{2}$	2,5	2	V3.0510-56	0,6	L1.0403-01 (2CL)	-
E 043-166	25	**D1**/1	10EX2	6,1	$G^{1}/_{2}$	2,5	1	V3.0510-56	0,6	-	-
E 043-158	35	**D1**/2	16EX2	6,1	$G^{1}/_{2}$	2,5	2	V3.0510-58	0,6	L1.0403-01 (2CL)	-
E 043-168	35	**D1**/2	16EX2	6,1	$G^{1}/_{2}$	2,5	1	V3.0510-58	0,6	-	-
E 043-151	30	**D1**/3	30P	4,0	$G^{1}/_{2}$	1,5	2	P3.0510-51	0,6	L1.0403-01 (2CL)	-
E 043-161	30	**D1**/3	30P	4,0	$G^{1}/_{2}$	1,5	1	P3.0510-51	0,6	-	-
E 072-153	25	**D2**/1	5EX2	7,7	$G^{3}/_{4}$	2,5	2	V3.0520-53	0,8	L1.0403-01 (2CL)	-
E 072-163	25	**D2**/1	5EX2	7,7	$G^{3}/_{4}$	2,5	1	V3.0520-53	0,8	-	-
E 072-156	50	**D2**/2	10EX2	13	$G^{3}/_{4}$	2,5	2	V3.0520-56	0,8	L1.0403-01 (2CL)	-
E 072-166	50	**D2**/2	10EX2	13	$G^{3}/_{4}$	2,5	1	V3.0520-56	0,8	-	-
E 072-158	70	**D2**/3	16EX2	13	$G^{3}/_{4}$	2,5	2	V3.0520-58	0,8	L1.0403-01 (2CL)	-
E 072-168	70	**D2**/3	16EX2	13	$G^{3}/_{4}$	2,5	1	V3.0520-58	0,8	-	-
E 072-151	50	**D2**/4	30P	6,6	$G^{3}/_{4}$	1,5	2	P3.0520-51*	0,8	L1.0403-01 (2CL)	-
E 072-161	50	**D2**/4	30P	6,6	$G^{3}/_{4}$	1,5	1	P3.0520-51*	0,8	-	-

* Paper media supported with metal gauze

All filters are delivered with a plugged clogging indicator connection M12 x 1,5. As clogging indicators either manometers or electrical pressure switches can be used. Optional extension pipes adapt the filter length to various tank depths. For ordering of accessories please use the below mentioned codes.

Order example: The filter E 072-156 has to be supplied with an extension pipe for a mounting depth of 500 mm.

Order description: **E 072-156 / EV 500**

Part No. (Basic unit)

Mounted extension pipe (5 various lengths are available on request)

E 043: EV 150, EV 200, EV 300, EV 400, EV 500
E 072: EV 250, EV 300, EV 400, EV 500, EV 600

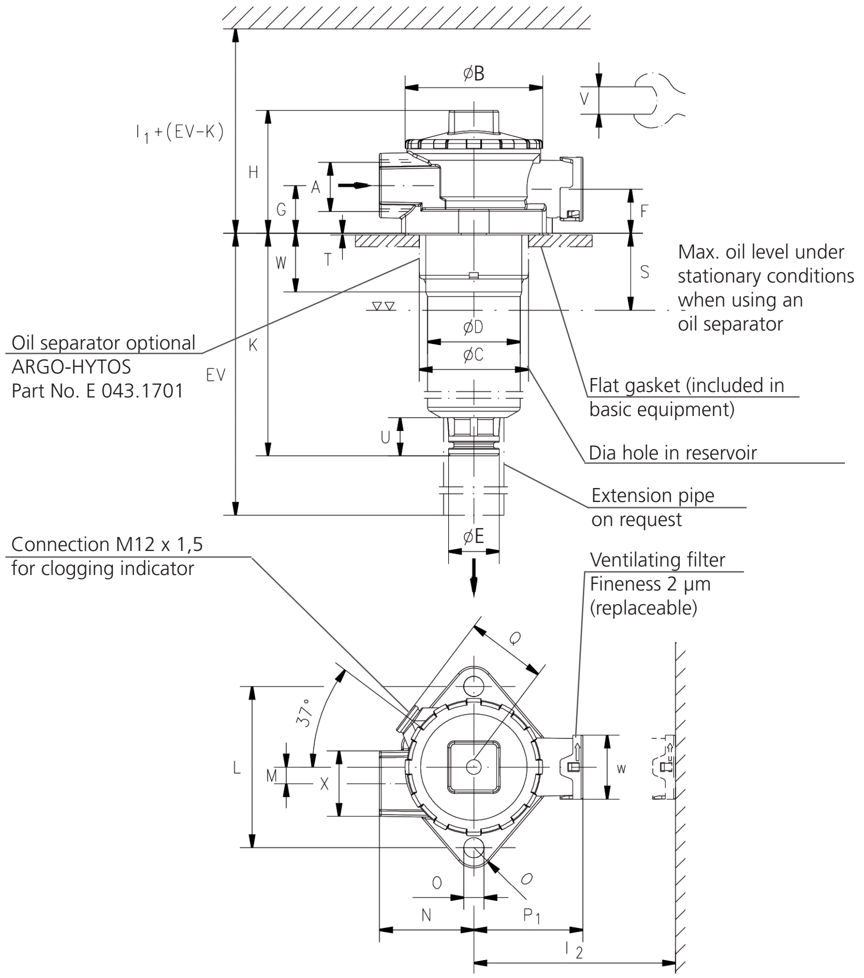
For the appropriate clogging indicators see catalogue sheet 60.20.

Remarks:

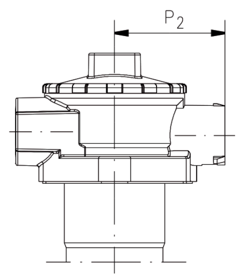
- The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. Other designs available on request.

Dimensions

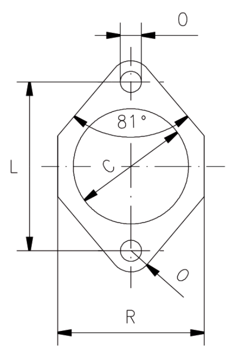
Design with ventilating filter



Design without ventilating filter



Required mounting surface



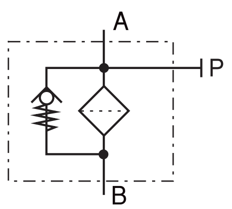
Measurements

Type	A	B	C min/max	D	E	F	G	H	I1	I2	K	L	M	N	O	P1	P2	Q	R	S
E 043	G1/2	75	60/63	51	27,8	24	26	67	175	110	83	88	9	51	11	59,5	57,5	46	79	42
E 072	G3/4	75	60/63	51	27,8	24	26	67	270	110	180	88	9	51	11	59,5	57,5	46	79	42

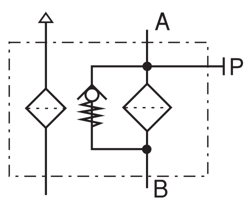
Type	T	U	V	W	X
E 043	2	21	AF 21	35	AF 36
E 043	2	21	AF 21	35	AF 36

Symbols

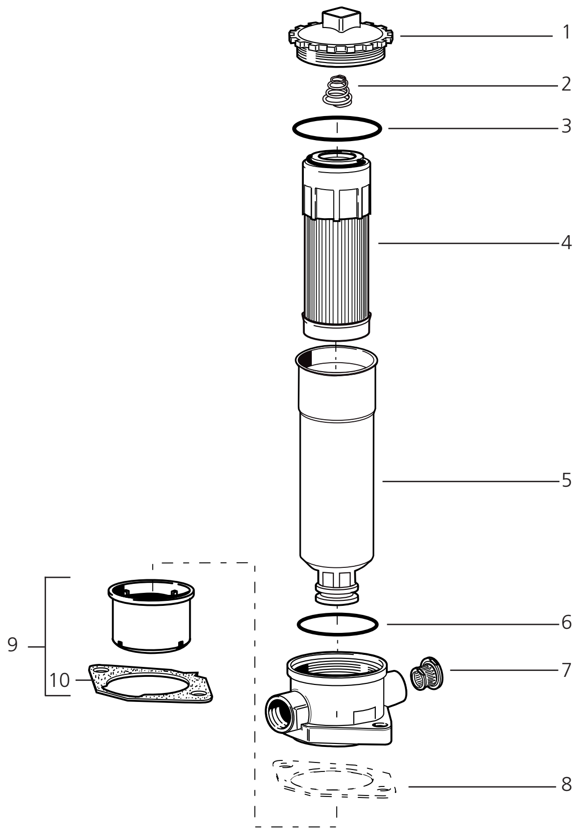
1



2



Spare Parts



Pos.	Designation	Part No.
1	Screw-on cap	FR 043.0201
2	Compression spring	N015.1606
3	O-ring 57 x 3	N007.0573
4	Filter element	see Chart / col. 9
5	Filter bowl E 043 *	FR 043.0107
5	Filter bowl E 072 *	FR 072.0104
6	O-ring 50 x 2	N007.0501
7	Ventilating filter	L1.0403-01
8	Flat gasket (for versions without oil separator)	D 043.0113
9	Oil separator with Pos. 10	E 043.1701
10	Flat gasket (for versions with oil separator)	D 043.0118

* Specify mounting depth (EV) in mm

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return Filter

FR 043 · FR 072

Tank top mounting · Hose connection up to ID 19 mm · Nominal flow rate up to 70 l/min

Return Filter FR 072

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

› Connection: Hose nipple
› By-pass valve:
The location close to the inlet port prevents dirt particles retained by the filter element from entering into the clean oil side.
› Removable bowl:
In case of maintenance the filter bowl is removed together with the filter element - therefore dirt particles are not flushed back into the tank.
› Oil separator:
Prevents oil splashing through the breather on mobile application.
› Extension pipe:
A correct extension pipe length ensures oil outlet below minimum oil level and prevents foaming.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Ventilating Filter

Ventilation of the reservoir by an integral star-shape pleated filter element:

› removable (replace annually!)
› splash-proof
› fineness 2 µm

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Screw-on cap:	Polyester, GF-reinforced
Housing:	Polyamid, CF-reinforced, electrically conducting
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer Microfibre web Paper - cellulose web, impregnated with resin

Accessories

Electrical and optical clogging indicators are available on request. Dimensions and technical data see catalogue sheet 60.20.

Recommended hose clamps according to DIN 3017 Part 2 or equivalent for hose OD 23 mm or 26 mm. For orders use ARGO-HYTOS Part No. 11889400 or 13195600.

Extension pipes on the bowl outlet are available in several lengths on request.

A self-assembly system for installation of extension pipes can be ordered. For detailed information please see catalogue sheet 20.390.

Characteristics

Nominal flow rate

Up to 70 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines ≤ 4,5 m/s

Connection

Hose nipple for hose up to ID 19 mm.
Sizes see Selection Chart, column 6 (other connections on request).

Filter fineness

10 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).
With high filling conditions we recommend an electrical conductivity ≤ 500 pS/m at 20 °C.

Temperature range

-30 °C ... +80 °C (short intervals to +100 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it inter-sects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

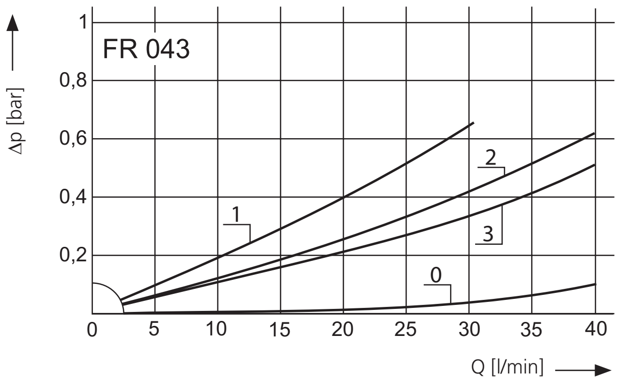
Max. 6 bar

Mounting position

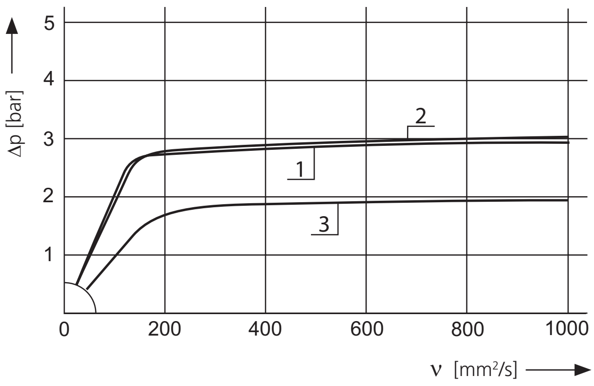
Preferably vertical, outlet downwards

Δp-curves for complete filters in Selection Chart, column 3

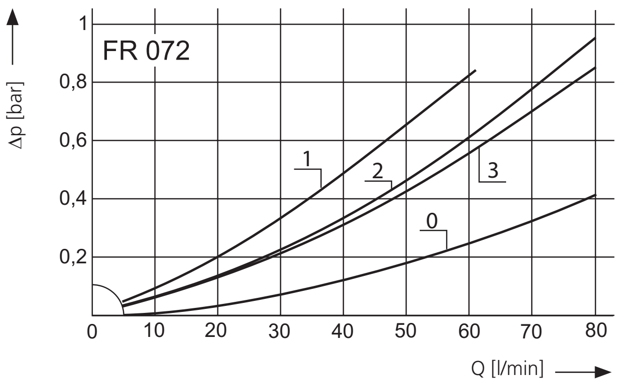
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



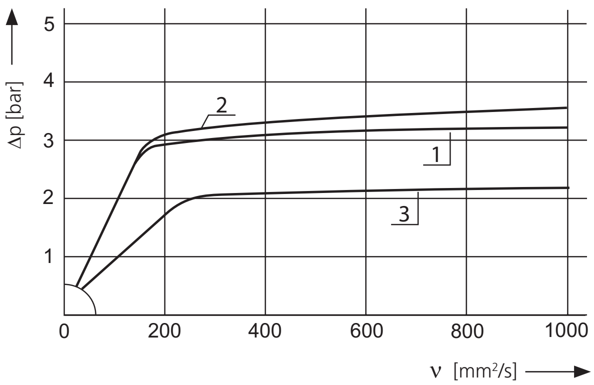
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

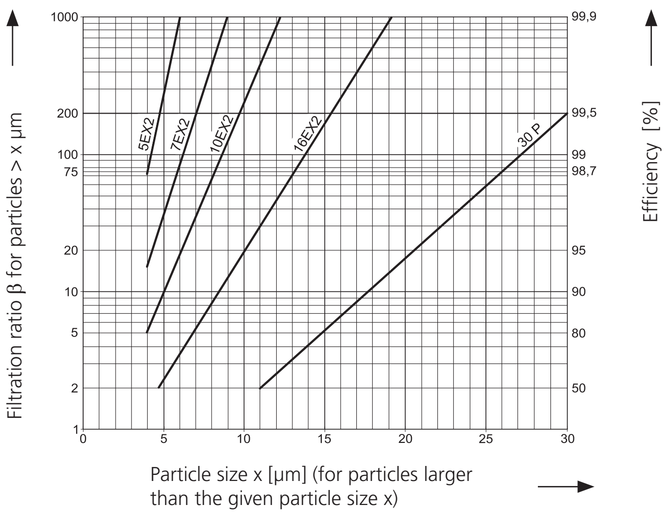


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$ = 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$ = 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$ = 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$ = 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$ = 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For ventilating filter elements:

2CL = 99,5 % filter efficiency for particles of size 2 µm

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see Diagram **D**/curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connection A	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Replacement ventilating filter Part No. (Filter fineness, see diagrams)	Remarks
	l/min			g	mm	bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
FR 043-156	25	**D1**/1	10EX2	6,1	17,5	2,5	1	V3.0510-56	0,42	L1.0403-51 (2CL)	-
FR 043-166	25	**D1**/1	10EX2	6,1	17,5	2,5	2	V3.0510-56	0,42	L1.0403-51 (2CL)	for indicator M12 x 1,5
FR 043-158	35	**D1**/2	16EX2	6,1	17,5	2,5	1	V3.0510-58	0,42	L1.0403-51 (2CL)	-
FR 043-178	35	**D1**/2	16EX2	6,1	17,5	2,5	2	V3.0510-58	0,42	L1.0403-51 (2CL)	for indicator M12 x 1,5
FR 043-151	30	**D1**/3	30P	4,0	17,5	1,5	1	P3.0510-51	0,42	L1.0403-51 (2CL)	-
FR 043-161	30	**D1**/3	30P	4,0	17,5	1,5	2	P3.0510-51	0,42	L1.0403-51 (2CL)	for indicator M12 x 1,5
FR 072-156	50	**D2**/1	10EX2	13	20,5	2,5	1	V3.0520-56	0,58	L1.0403-51 (2CL)	-
FR 072-166	50	**D2**/1	10EX2	13	20,5	2,5	2	V3.0520-56	0,58	L1.0403-51 (2CL)	for indicator M12 x 1,5
FR 072-158	70	**D2**/2	16EX2	13	20,5	2,5	1	V3.0520-58	0,58	L1.0403-51 (2CL)	-
FR 072-168	70	**D2**/2	16EX2	13	20,5	2,5	2	V3.0520-58	0,58	L1.0403-51 (2CL)	for indicator M12 x 1,5
FR 072-151	50	**D2**/3	30P	6,6	20,5	1,5	1	P3.0520-51*	0,58	L1.0403-51 (2CL)	-
FR 072-171	50	**D2**/3	30P	6,6	20,5	1,5	2	P3.0520-51*	0,58	L1.0403-51 (2CL)	for indicator M12 x 1,5

* Paper media supported with metal gauze

As clogging indicators either manometers or electrical pressure switches can be used. Optional extension pipes adapt the filter length to various tank depths. For ordering of accessories please use the below mentioned codes.

Order example: The filter FR 072-156 has to be supplied with an extension pipe for a mounting depth of 500 mm.

Order description: FR 072-156 / EV 500

Part No. (Basic unit)

Extension pipe (5 various lengths are available on request)

FR 043: EV 150, EV 200, EV 300, EV 400, EV 500
FR 072: EV 250, EV 300, EV 400, EV 500, EV 600

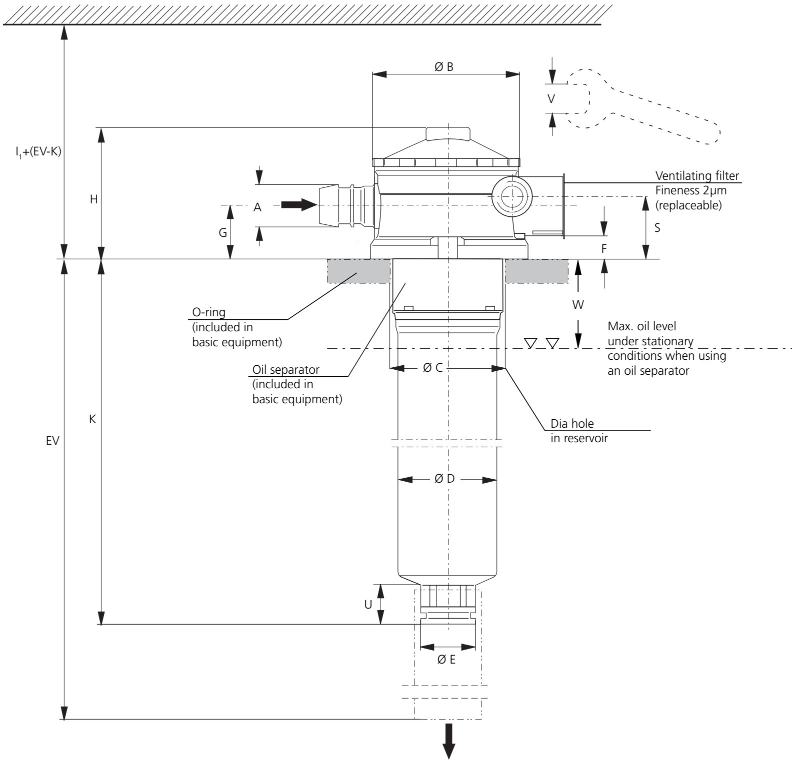
For the appropriate clogging indicator see data sheet 60.20.

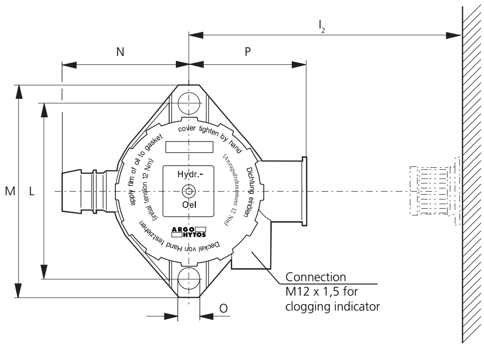
When using pressure switches of series DG 813 sealing by means of an O-ring (order no. N007.0103, to be ordered separately) has to be guaranteed (torque 4 Nm). When using manometers of series DG 200 variants with preformed sealing ring are to be used.

Remarks:

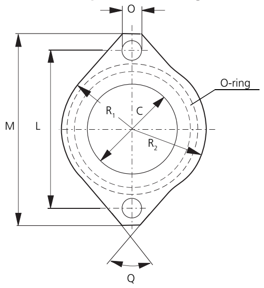
› The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
› Clogging indicators are optional and always delivered detached from the filter.
› For fastening the filter the enclosed spring washers have to be used. Assembly torque 15^{+5} Nm.
› The filters listed in this chart are standard filters. Other designs available on request.

Dimensions





Required mounting surface



For dimension EV see selection chart

Measurements

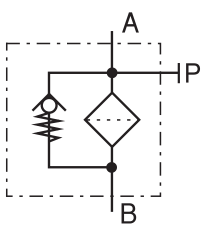
Type	A	B	C (min/max.)	D	E	F*	G	H	l_1	l_2	K	L	M	N	O	P	Q	R_1	R_2
FR 043	17,5	75	60/61	51	27,8	11	22	65	175	110	85	88	108	65	11	59	80°	39	42
FR 072	20,5	75	60/61	51	27,8	11	22	65	270	110	182	88	108	65	11	59	80°	39	42

Type	S	U	V	W
FR 043	27	20	AF 27	40
FR 072	27	20	AF 27	40

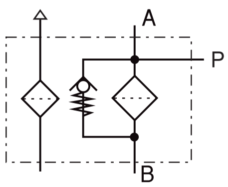
* including the enclosed spring washers Ø10, DIN 137 shape B, corrugated

Symbols

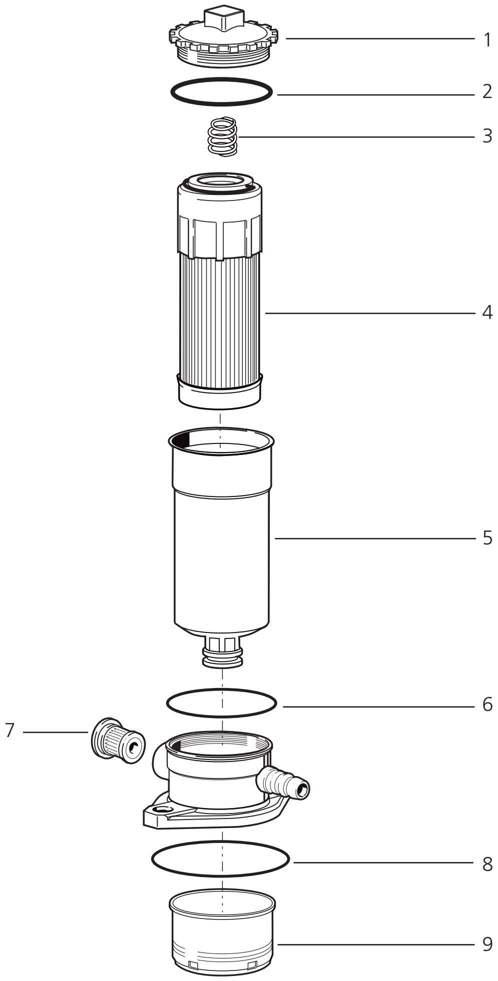
1



2



Spare Parts



Pos.	Designation	Part No.
1	Screw-on cap	FR 043.0201
2	O-ring 57 x 3	N007.0573
3	Compression spring	N015.1606
4	Filter element	s. Chart / col. 9
5	Filter bowl FR 043 *	FR 043.0107
5	Filter bowl FR 072 *	FR 072.0104
6	O-ring 50 x 2	N007.0501
7	Ventilating filter	L1.0403-51
8	O-ring 69 x 4	N007.0704
9	Oil separator	FR 043.0701

* Specify mounting depth (EV) in mm

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters

Return Filters

E 094 · E 103 · E 143

Tank top mounting · Connection up to G1 · Nominal flow rate up to 135 l/min

Return Filter E 103

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

- By-pass valve:
  The location close to the inlet port prevents dirt particles retained by the filter element from entering into the clean oil side.
- Removable bowl:
  In case of maintenance the filter bowl is removed together with the filter element - therefore dirt particles are not flushed back into the tank.
- Extension pipe:
  A correct extension pipe length ensures oil outlet below minimum oil level and prevents foaming.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Ventilating Filter

Ventilation of the reservoir by an integral star-shape pleated filter element:

- removable (replace annually!)
- splash-proof
- fineness 2 µm

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Screw-on cap: Polyamide, GF-reinforced
Filter head: Alluminium alloy
Filter bowl: Polyamide, CF-reinforced, electrically conducting
Seals: NBR (FPM on request)
Filter media: EXAPOR®MAX 2 - inorganic multi-layer microfibre web
Paper - cellulose web, impregnated with resin

Accessories

Electrical and optical clogging indicators are available on request. Dimensions and technical data see cataologue sheet 60.20.

An optional oil separator (Part No. E 103.1702) is available on request.

Extension pipes on the bowl outlet are available in several lengths on request.
A self-assembly system for installation of extension pipes can be ordered. For detailed information please see catalogue sheet 20.390.

Characteristics

Nominal flow rate

Up to 135 l/min (see Selection Chart, column 2). The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

› closed by-pass valve at $\nu \leq 200$ mm²/s
› element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
› flow velocity in the connection lines ≤ 4,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 (other port threads on request)

Filter fineness

5 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).
With high filling conditions we recommend an electrical conductivity >_ 500 pS/m at 20 °C.

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

› at operating temperature: $\nu < 60$ mm²/s
› as starting viscosity: $\nu_{max} = 1200$ mm²/s
› at initial operation:
The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

Max. 10 bar

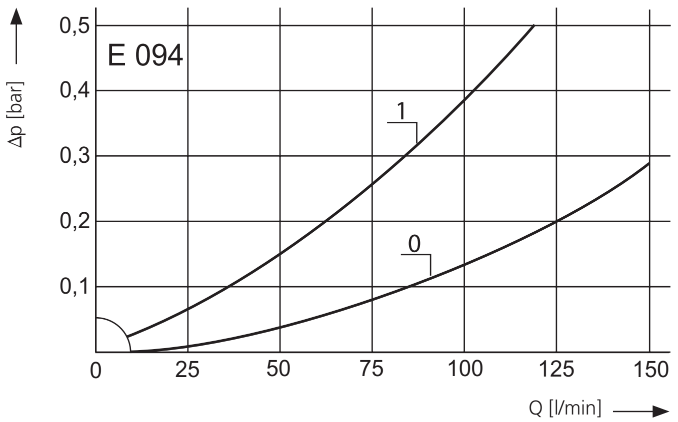
Mounting position

Preferably vertical, outlet downwards

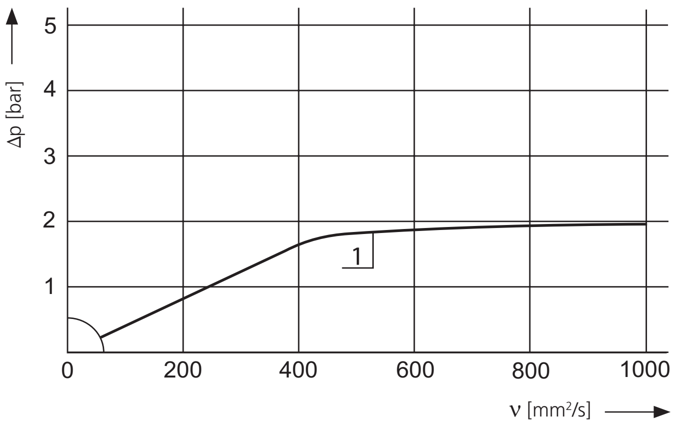
Diagrams

Δp-curves for complete filters in Selection Chart, column 3

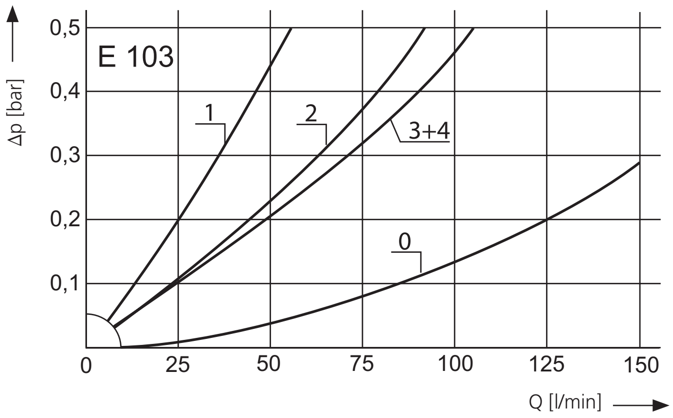
D1 Pressure drop as a function of the **flow volume** at $\nu = 35$ mm²/s (0 = casing empty)



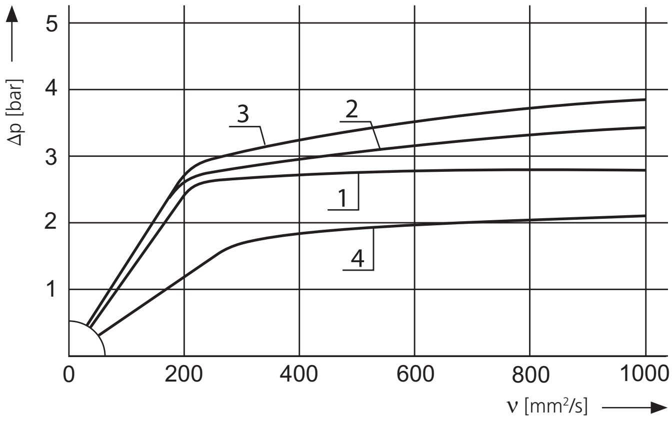
Pressure drop as a function of the **kinematic viscosity** at nominal flow



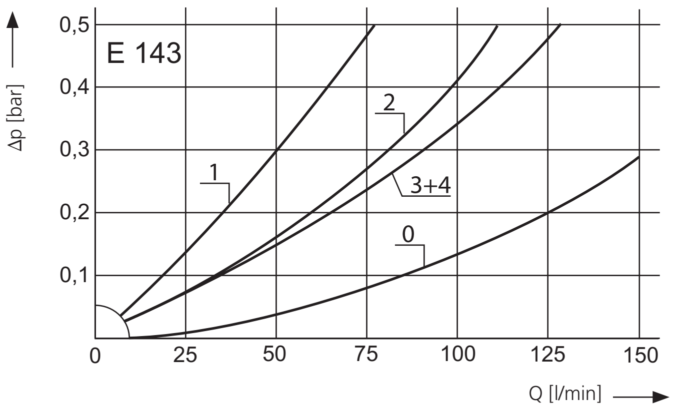
D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



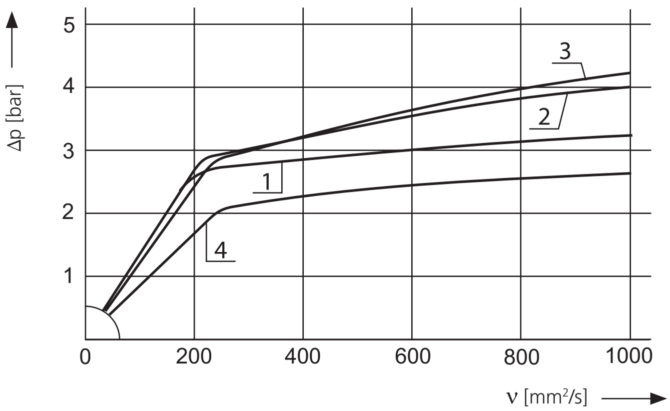
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D3 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

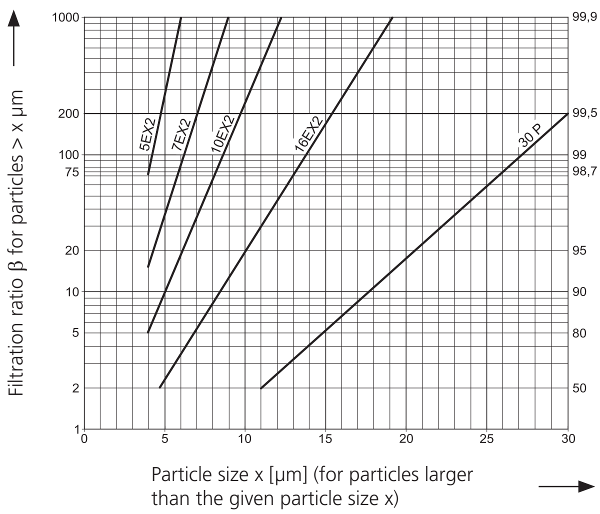


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size accordung to DIN 4189

For ventilating filter elements:

2CL = 99,5 % Abscheidegrad für Partikel der Größe 2 µm

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see Diagr. **DX**	Dirt-holding capacity	Connection A	Cracking pressure of by-pass	Symbol	Replacement element Part No.	Weight	Replacement ventilating filter Part No. (Filter fineness, see diagrams)	Remarks
	l/min			g		bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
E 094-661	50	**D1**/1	30P	11	G$^{3}/_{4}$	1,5	2	P3.0613-51	0,8	L1.0503-03 (2CL)	-
E 094-671	50	**D1**/1	30P	11	G$^{3}/_{4}$	1,5	1	P3.0613-51	0,8	-	-
E 103-657	45	**D2**/1	5EX2	18	G¾	2,5	2	V3.0620-53	1,0	L1.0503-03 (2CL)	-
E 103-677	45	**D2**/1	5EX2	18	G¾	2,5	1	V3.0620-53	1,0	-	-
E 103-676	80	**D2**/2	10EX2	25	G$^{3}/_{4}$	2,5	2	V3.0620-56	1,0	L1.0503-03 (2CL)	-
E 103-686	80	**D2**/2	10EX2	25	G$^{3}/_{4}$	2,5	1	V3.0620-56	1,0	-	-
E 103-898	110	**D2**/3	16EX2	25	G1	2,5	2	V3.0620-58	1,0	L1.0503-03 (2CL)	-
E 103-888	110	**D2**/3	16EX2	25	G1	2,5	1	V3.0620-58	1,0	-	-
E 103-871	70	**D2**/4	30P	11	G$^{3}/_{4}$	1,5	2	P3.0620-51*	1,0	L1.0503-03 (2CL)	-
E 103-861	70	**D2**/4	30P	11	G$^{3}/_{4}$	1,5	1	P3.0620-51*	1,0	-	-
E 143-657	70	**D3**/1	5EX2	28	G$^{3}/_{4}$	2,5	2	V3.0730-53	1,2	L1.0503-03 (2CL)	-
E 143-667	70	**D3**/1	5EX2	28	G$^{3}/_{4}$	2,5	1	V3.0730-53	1,2	-	-
E 143-676	115	**D3**/2	10EX2	38	G1	2,5	2	V3.0730-56	1,2	L1.0503-03 (2CL)	-
E 143-686	115	**D3**/2	10EX2	38	G1	2,5	1	V3.0730-56	1,2	-	-
E 143-888	135	**D3**/3	16EX2	38	G1	2,5	2	V3.0730-58	1,2	L1.0503-03 (2CL)	-
E 143-688	135	**D3**/3	16EX2	38	G1	2,5	1	V3.0730-58	1,2	-	-
E 143-851	120	**D3**/4	30P	17	G1	1,5	2	P3.0730-51*	1,2	L1.0503-03 (2 CL)	-
E 143-861	120	**D3**/4	30P	17	G1	1,5	1	P3.0730-51*	1,2	-	-

* Paper media supported with metal gauze

All filters are delivered with a plugged clogging indicator connection M12 x 1,5. As clogging indicators either manometers or electrical pressure switches can be used. Optional extension pipes adapt the filter length to various tank depths. For ordering of accessories please use the below mentioned codes.

Order example: The filter E 103-676 has to be supplied with an extension pipe for a mounting depth of 500 mm.

Order description: **E 103-676** / **EV 500**

Part No. (Basic unit)

Mounted extension pipe (7 various lengths are available on request)

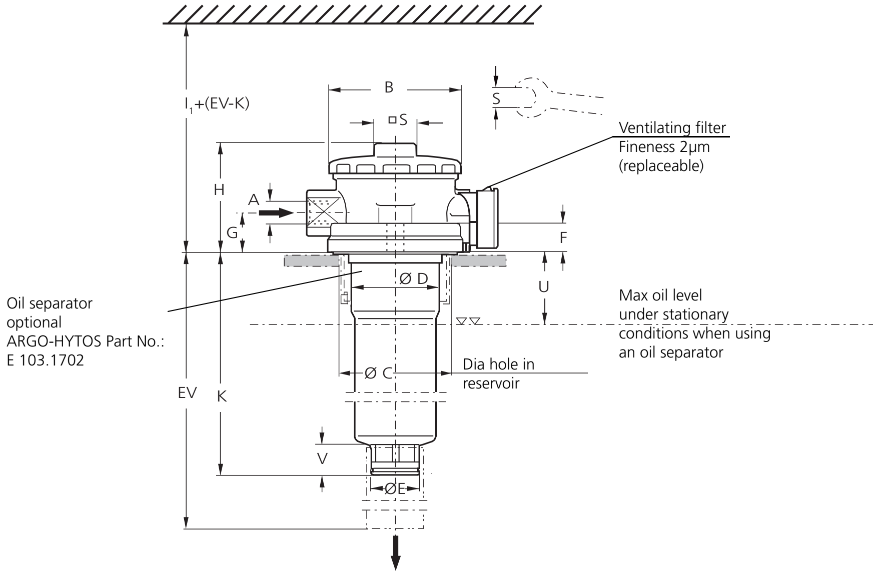
E 094: EV 130, EV 190, EV 234, EV 284, EV 334, EV 434, EV 534
E 103: EV 196, EV 256, EV 300, EV 350, EV 400, EV 500, EV 600
E 143: EV 297, EV 357, EV 400, EV 450, EV 500, EV 600, EV 700

For the suitable clogging indicators please see catalogue sheet 60.20.

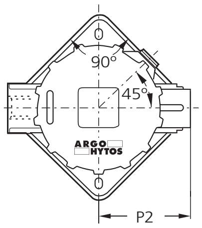
Remarks:

› The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
› Clogging indicators are optional and always delivered detached from the filter.
› The filters listed in this chart are standard filters. Other designs available on request.

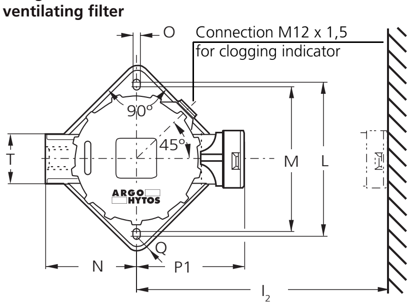
Dimensions



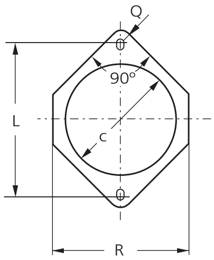
Design without ventilating filter



Design with ventilating filter



Required mounting surface



For dimension EV see selection chart

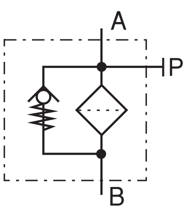
Measurements

Type	A	B	C min/max	D	E	F	G	H	l_1	l_2	K	L	M	N	O	P_1	P_2
E 094	G ¾	105	87/91	73,5	38	20,5	30	88,5	235	125	111	115	110	70	11	82	69
E 103	G¾, G1	105	87/91	73,5	38	20,5	30	88,5	300	125	177	115	110	70	11	82	69
E 143	G¾, G1	105	87/91	73,5	38	20,5	30	88,5	400	125	278	115	110	70	11	82	69

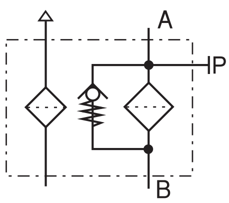
Type	Q	R	S	T	U	V
E 094	13,5	107,5	AF 32	AF 41	50	23
E 103	13,5	107,5	AF 32	AF 41	50	23
E 143	13,5	107,5	AF 32	AF 41	50	23

Symbols

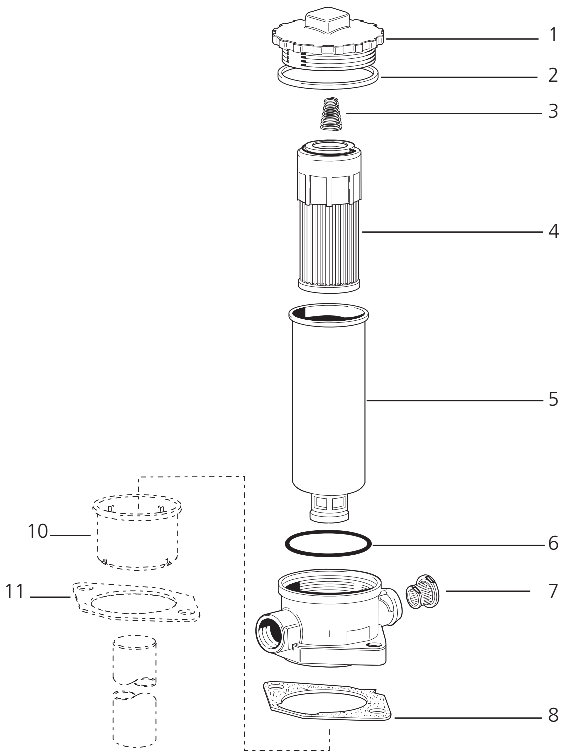
1



2



Spare Parts



Pos.	Designation	Part No.
1	Screw-on cap	E 103.0201
2	Flat gasket	N031.0841
3	Compression spring	N015.3703
4	Filter element	see Chart / Col. 9
5	Filter bowl E094 *	E 094.0903
5	Filter bowl E103 *	E 103.0912
5	Filter bowl E143 *	E 143.0903
6	O-ring 69,5 x 3,5	N007.0703
7	Ventilating filter	L1.0503-03K
8	Housing (for pos. 7)	L1.0503.0801
9	Flat gasket (for versions without oil separator)	E 103.0147
10	Oil separator with Pos. 11	E 103.1702
11	Flat gasket (for versions with oil separator)	E 103.0148

* Specify mounting depth (EV) in mm

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941 Verification of collapse/burst pressure rating
ISO 2942 Verification of fabrication integrity (Bubble Point Test)
ISO 2943 Verification of material compatibility with fluids
ISO 3968 Evaluation of pressure drop versus flow characteristics
ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity
ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

E 212 · E 222

Tank top mounting · Connection up to G1¼ · Nominal flow rate up to 220 l/min

Return Filter E 222

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are proteced from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

- By-pass valve:
  The location close to the inlet port prevents dirt particles retained by the filter element from entering into the clean oil side.
- Removable bowl:
  In case of maintenance the filter bowl is removed together with the filter element - therefore dirt particles are not flushed back into the tank.
- Filling filter/By-pass protection strainer:
  The filling filter is integrated in the filter element and prevents coarse particles from entering during filling or re-filling due to maintenance or repair reasons. Filling can be carried out at the filter. Therefore the cover must be removed. In operation, the filling filter functions as a by-pass protection strainer and prevents dirt from entering into the tank when the by-pass valve is open.
- Port for ventilating filter:
  The ventilating filter thread connection M42 x 2 allows assembly of a ventilating filter, which assumes ventilation of the tank. The ventilating filter has to be ordered separately.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Screw-on cap:	Polyester, GF-reinforced
Filter head:	Aluminium alloy
Filter bowl:	Polyamid, CF-reinforced, electrically conducting
Seals:	NBR (FPM on request)
Filtermaterial:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin
Filling filter:	Polyamide, reinforced; Polyester web

Accessories

Electrical and optical clogging indicators are available on request. Dimensions and technical data see catalogue sheet 60.20.

Ventilating filters with connection thread M42 x 2 have to be ordered separately. Dimensions and technical data see catalogue sheet 50.20 and 50.30.

Extension pipes or diffusors on the bowl outlet are available on request.

- Extension pipe: A correct extension pipe length ensures oil outlet below minimum oil level and prevents foaming.

Characteristics

Nominal flow rate

Return filter:
Up to 220 l/min (see Selection Chart, column 2). The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines ≤ 4,5 m/s

Filling filter:
up to 20 l/min (see Selection Chart, column 3)

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 9 (other port threads on request)

Filter fineness

5 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 5 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 6)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).
With high filling conditions we recommend an electrical conductivity ≤ 500 pS/m at 20 °C.

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

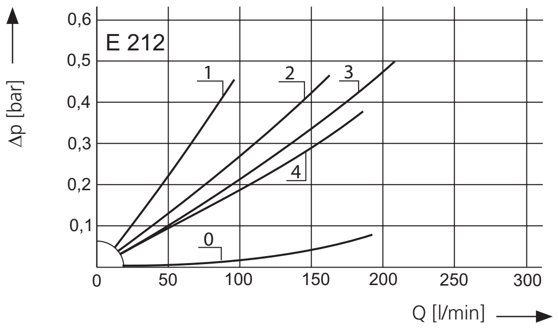
Max. 10 bar

Mounting position

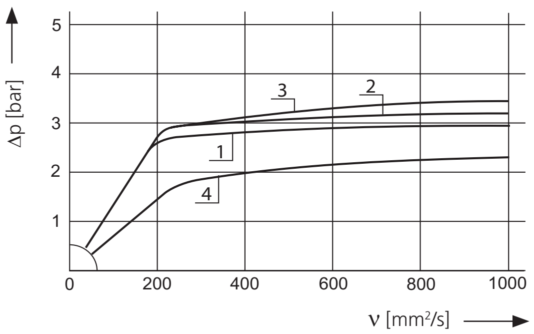
Preferably vertical, outlet downwards

Δp-curves for complete filters in Selection Chart, column 4

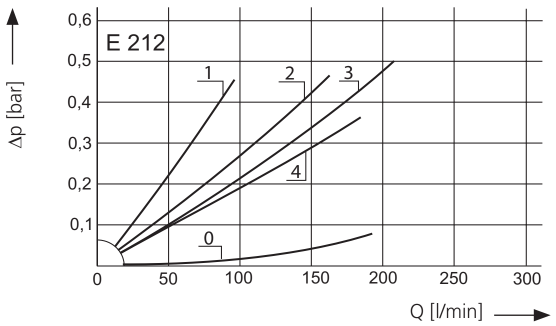
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



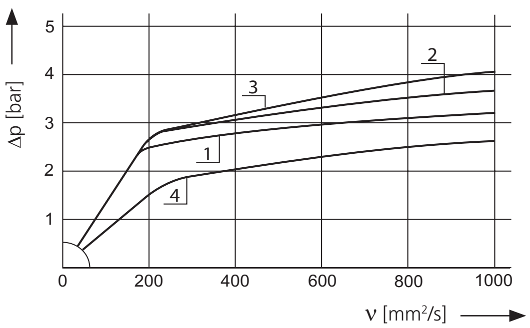
Pressure drop as a function of the **kinematic viscosity** at nominal flow



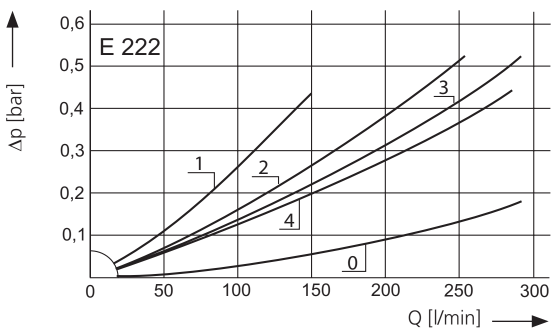
D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



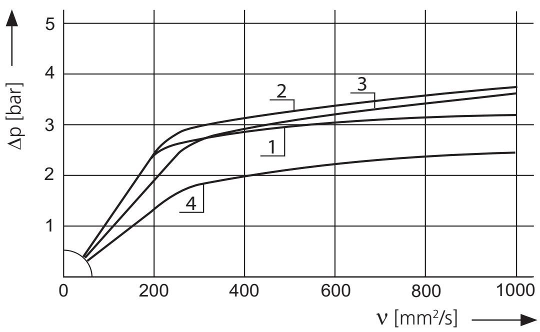
Pressure drop as a function of the **kinematic viscosity** at nominal flow



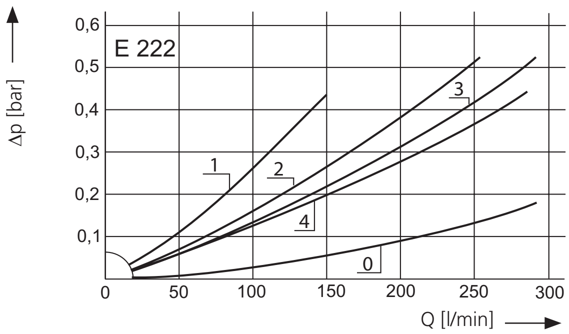
D3 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



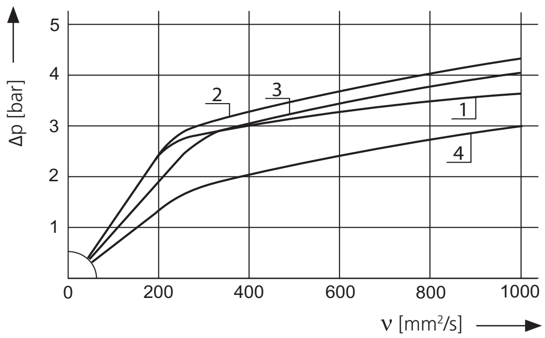
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D4 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

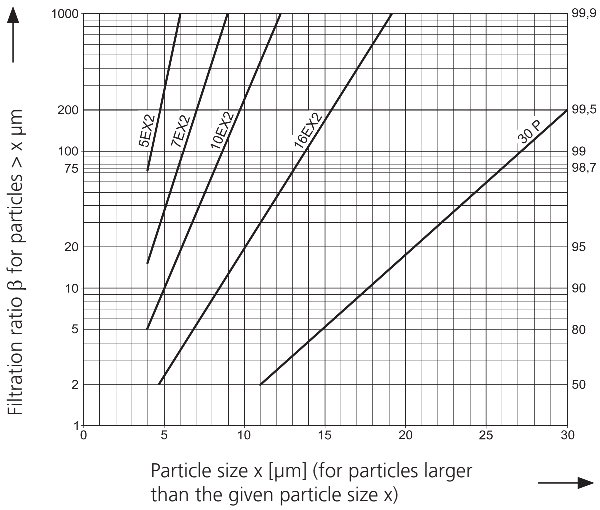


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 5

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following ß-values resp. finenesses:

For EXAPOR®MAX 2- and Paper elements:

5EX2	=	$\bar{\beta}_{5\,(c)}$	= 200 EXAPOR®MAX 2
7EX2	=	$\bar{\beta}_{7\,(c)}$	= 200 EXAPOR®MAX 2
10EX2	=	$\bar{\beta}_{10\,(c)}$	= 200 EXAPOR®MAX 2
16EX2	=	$\bar{\beta}_{16\,(c)}$	= 200 EXAPOR®MAX 2
30P	=	$\bar{\beta}_{30\,(c)}$	= 200 Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189.

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Order Information

All filters are delivered with a plugged clogging indicator connection M12 x 1,5. As clogging indicators either manometers or electrical pressure switches can be used. Optional extension pipes adapt the filter length to various tank depths.
For ordering of accessories please use the below mentioned codes.

Order example: The filter E 222-151 has to be supplied with an extension pipe for a mounting depth of 500 mm.

Order description: **E 222-151** / **EV 500**

Part No. (Basic unit) → E 222-151

Extension pipe (4 various lengths are available on request) → EV 500

E 212: EV 300, EV 366, EV 400, EV 466
E 222: EV 434, EV 500, EV 534, EV 600

For the appropriate ventilating filters with M42x2 thread connection see catalogue sheet 50.20 and 50.30, for the appropriate clogging indicators see catalogue sheet 60.20.

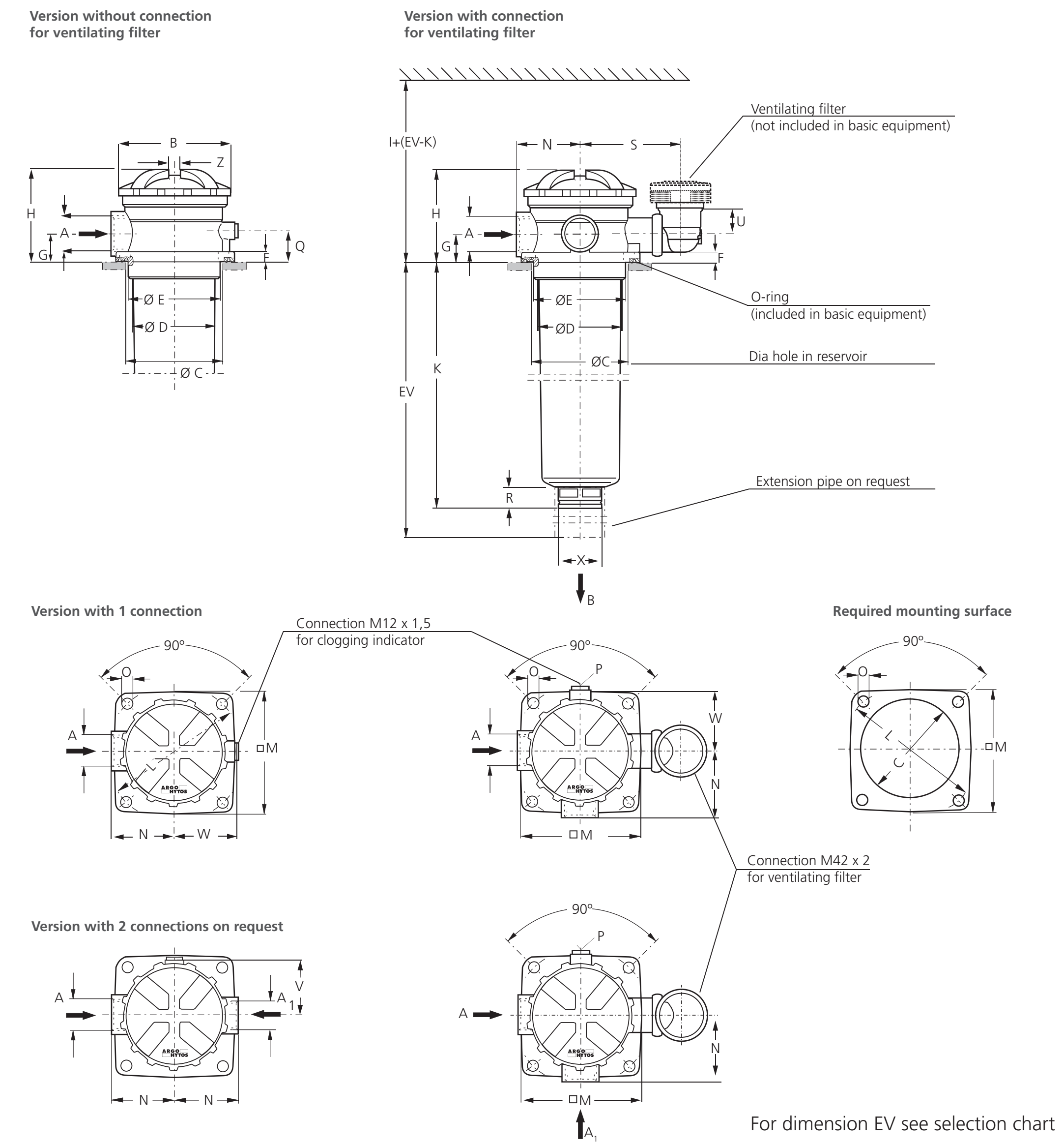
Remarks:

- The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 10).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. Other designs available on request.

Part No.	Nominal flow rate Return filter	Nominal flow rate Filling filter[1]	Pressure drop see Diagram **D**/curve No.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Filter finenes filling filter / by-pass protection strainer	Filter surface filling filter / by-pass protection strainer	Connection A	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Ventilating filter thread connection M42x2	Weight	Remarks
	l/min	l/min			g	µm	cm²		bar				kg	
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15
E 212-159	80	-	**D1**/1	5EX2	29	-	-	G1¼	2,5	1	V7.0820-03	-	1,7	
E 212-156	140	-	**D1**/2	10EX2	43	-	-	G1¼	2,5	1	V7.0820-06	-	1,7	
E 212-158	190	-	**D1**/3	16EX2	43	-	-	G1¼	2,5	1	V7.0820-08	-	1,7	
E 212-151	160	-	**D1**/4	30 P	21	-	-	G1¼	1,5	1	P7.0820-11[2]	-	1,7	
E 212-359	80	20	**D2**/1	5EX2	29	450	85	G1¼	2,5	3	K7.0820-03	•	2,0	[3]
E 212-356	140	20	**D2**/2	10EX2	43	450	85	G1¼	2,5	3	K7.0820-06	•	2,0	[3]
E 212-358	190	20	**D2**/3	16EX2	43	450	85	G1¼	2,5	3	K7.0820-08	•	2,0	[3]
E 212-351	160	20	**D2**/4	30 P	21	450	85	G1¼	1,5	3	K7.0820-11[2]	•	2,0	[3]
E 222-159	130	-	**D3**/1	5EX2	50	-	-	G1¼	2,5	1	V7.0833-03	-	2,1	
E 222-156	220	-	**D3**/2	10EX2	74	-	-	G1¼	2,5	1	V7.0833-06	-	2,1	
E 222-158	220	-	**D3**/3	16EX2	76	-	-	G1¼	2,5	1	V7.0833-08	-	2,1	
E 222-151	220	-	**D3**/4	30 P	35	-	-	G1¼	1,5	1	P7.0833-11[2]	-	2,1	
E 222-359	130	20	**D4**/1	5EX2	50	450	85	G1¼	2,5	3	K7.0833-03	•	2,4	[3]
E 222-356	220	20	**D4**/2	10EX2	74	450	85	G1¼	2,5	3	K7.0833-06	•	2,4	[3]
E 222-358	220	20	**D4**/3	16EX2	76	450	85	G1¼	2,5	3	K7.0833-08	•	2,4	[3]
E 222-351	220	20	**D4**/4	30 P	35	450	85	G1¼	1,5	3	K7.0833-11[2]	•	2,4	[3]

[1] At 200 mm²/s (ISO VG46 at ca. 15°C) [2] Paper media supported with metal qauze
[3] Open connection for ventilating filter. Please assemble ventilating filter before operating.

Dimensions



For dimension EV see selection chart

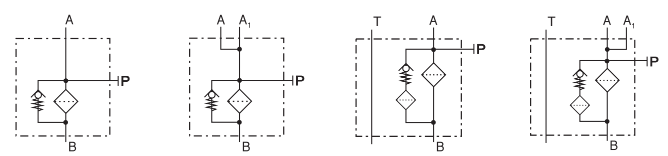
Measurements

Type	A	A1	B	C min/max	D	E	F	G	H	I	K	L	M	N	O	Q	R	S	U
E 212	G1¼	G1	126	118/121	95	110	11,5	32	105	325	213	165	141	76	11	35	23	113	28,5
E 222	G1¼	G1	126	118/121	95	110	11,5	32	105	455	347	165	141	76	11	35	23	113	28,5

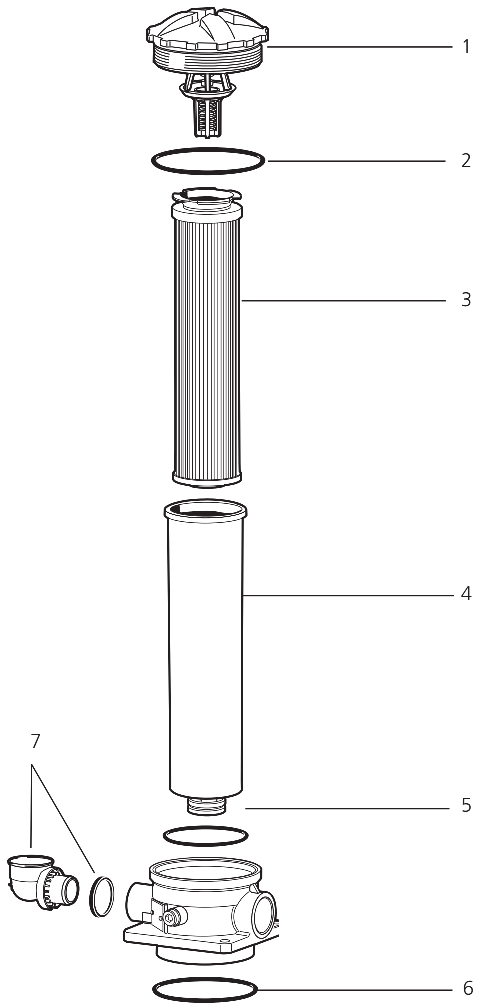
Type	V	W	X	Z
E 212	68	74	44	13
E 222	67	74	44	13

Symbols

1 2 3 4



Spare Parts



Pos.	Designation	Part No.
1	Screw-on cap with valve (2,5 bar) and Pos. 2	E 221.1200
1	Screw-on cap with valve (1,5 bar) and Pos. 2	E 221.1210
2	O-ring 100 x 4	N007.1004
3	Filter element	see Chart / col. 12
4	Filter bowl E 212*	E 212.0901
4	Filter bowl E 222*	E 222.0901
5	O-ring 90 x 4	N007.0904
6	O-ring 126 x 4	N007.1264
7	Connection for ventilating filter O-ring 31 x 4	E 222.1900

*Specify mounting depth (EV) in mm

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return Filters

E 444 · E 454 · E 464 · E 644

Tank top mounting · Connection up to SAE 2 · Nominal flow rate up to 680 l/min

Return Filter E 454

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

- By-pass valve:
  The location close to the inlet port prevents dirt particles retained by the filter element from entering into the clean oil side.
- Removable bowl:
  In case of maintenance the filter bowl is removed together with the filter element - therefore dirt particles are not flushed back into the tank.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

In filters with a magnetic system, the ferromagnetic particles in the fluid pass first through a strong magnetic field and are separated.

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head cover:	Aluminium alloy
Filter head:	Aluminium alloy
Housing:	Steel, phosphated
Housing bottom:	Polyamide, GF reinforced
Seals:	NBR (FPM om request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin, stainless steel wire mesh (1.4301)

Accessories

Extension pipes or diffusers on the bowl outlet are available on request. Even the combination of both options is possible.

- Extension pipe:
  A correct extension pipe length ensures oil outlet below minimum oil level and prevents foaming.
- Diffuser:
  Diffusers reduce oil velocity and direct the oil to 90° outlet flow. This function prevents also oil foaming and whirling up of solid particles settled at the tank bottom. The mesh screen element filters the oil in case of an open by-pass valve.

Electrical and optical clogging indicators are available on request. Dimensions and technical data see catalogue sheet 60.20.

Characteristics

Nominal flow rate

Up to 680 l/min (see Selection Chart, column 2). The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \le 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines ≤ 4,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13 and SAE-flange (3000 psi). Sizes see Selection Chart, column 6 (other port threads on request).

Filter fineness

5 µm(c) ... 60 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

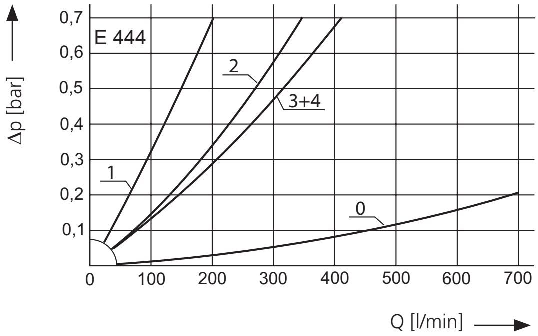
Max. 10 bar

Mounting position

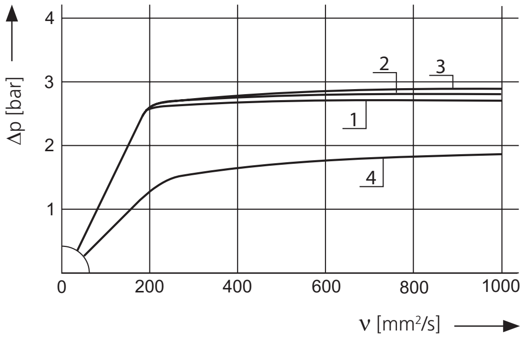
Preferably vertical, outlet downwards

Δp-curves for complete filters in Selection Chart, column 3

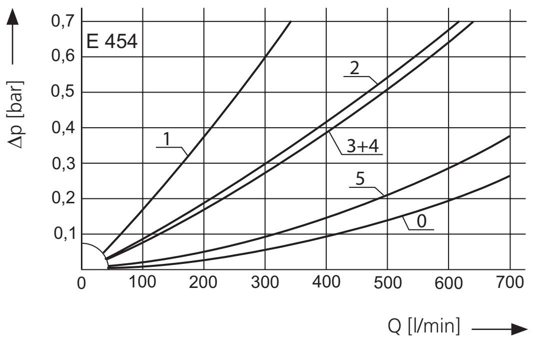
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



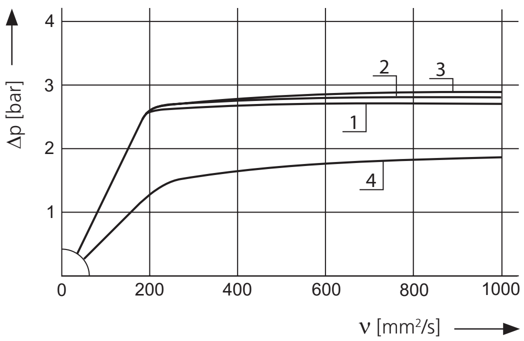
Pressure drop as a function of the **kinematic viscosity** at nominal flow



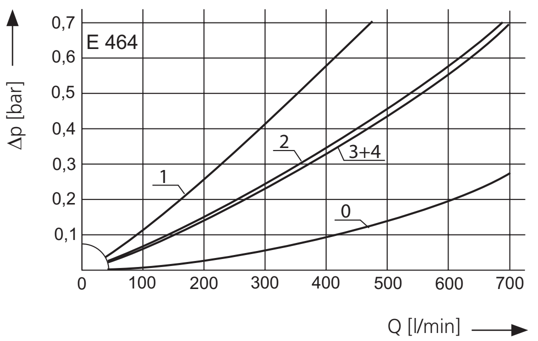
D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



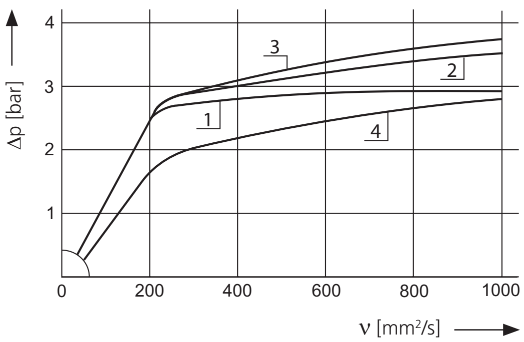
Pressure drop as a function of the **kinematic viscosity** at nominal flow



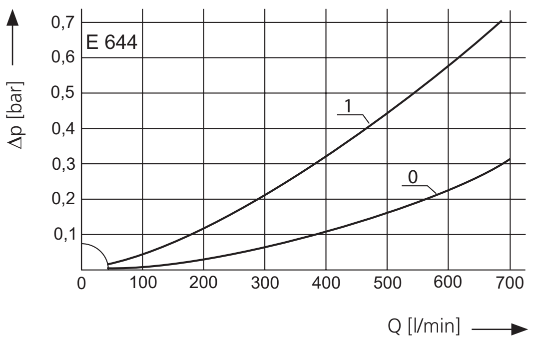
D3 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



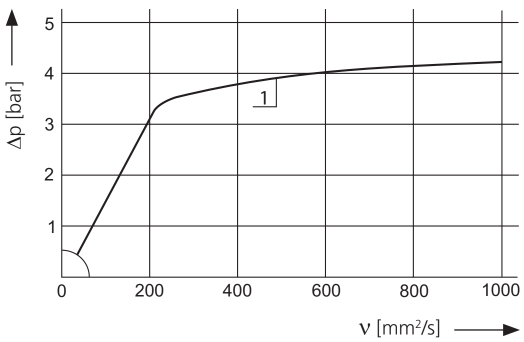
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D4 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

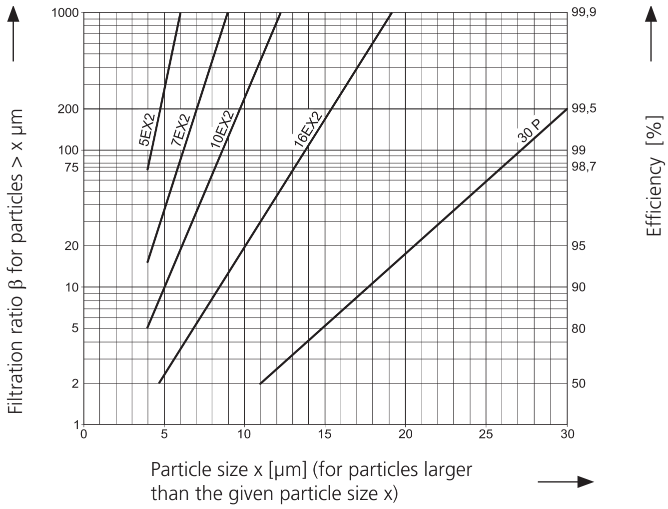


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

Screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Order Information

All filters are delivered with a plugged clogging indicator connection M12 x 1,5. (Mounting holes for differential pressure switches on request). As clogging indicators either manometers or electrical pressure switches can be used. Two different head pieces with three various connecting options are available. All filters can also be supplied with an outlet diffuser. Optional extension pipes adapt the filter length to various tank depths. For ordering of accessories please use the below mentioned codes.

Order example: The filter E 453-456 has to be supplied with 2 connections (A and A3), an outlet diffuser and an extension pipe for 564 mm length.

Order description: **E 454- 256 / VD / EV 564**

Connections:

3 various options are available
one connection (A) - G1½ / SAE 2 — 1
two connections[1] (A und A3) - G1½ / SAE 2 und G¾ — 2
four connections[1] (A1, A2, A3 und A4) - 2 x G1¼ / SAE 1½, G¾ und G1 — 4

Options (bowl outlet):

2 various options are available
VD: Outlet diffuser, RV: Extension pipe

Extension pipe:

7 various lengths are available
EV = K (Bowl length) + 81 / + 136 / + 196 / + 231 / + 356 / + 446 / + 626 mm (see section dimensions and measurements)

For the appropriate clogging indicators see catalogue sheet 60.20.

Remarks:

- The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. Other designs, e.g. with screen elements (mesh size 450 µm) at the bowl outlet, are available on request.

[1] The individual flow rates must match the connections

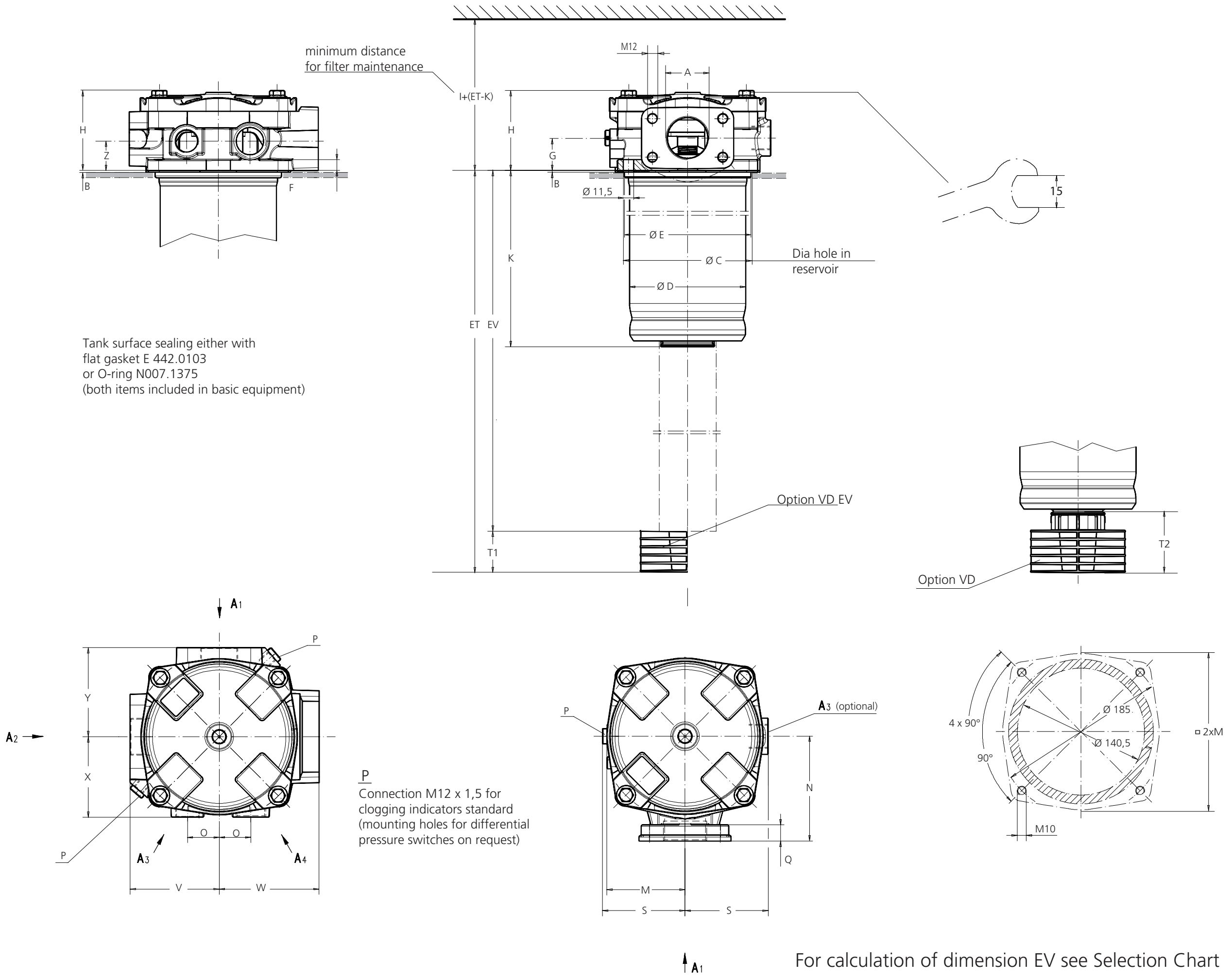
Selection Chart

Part No.	Nominal flow rate[1]	Pressure drop see diagram **D**/curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity Filter surface in ( )	Connection A SAE (3000 psi)	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Remarks
	l/min			g		bar			kg	
1	2	3	4	5	6	7	8	9	10	11
E 444-459	115	**D1**/1	5EX2	45	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1217-53	4,4	-
E 444-456	200	**D1**/2	10EX2	61	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1217-56	4,4	-
E 444-468	270	**D1**/3	16EX2	62	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1217-58	4,4	-
E 444-481	175	**D1**/4	30P	29	2 x G1¼ / SAE1½, G¾ + G1	1,5	3	P2.1217-51[2]	4,4	-
E 454-459	220	**D2**/1	5EX2	93	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1234-23	6,1	-
E 454-456	375	**D2**/2	10EX2	130	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1234-26	6,1	-
E 454-468	480	**D2**/3	16EX2	124	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1234-28	6,1	-
E 454-453	350	**D2**/4	30P	63	2 x G1¼ / SAE1½, G¾ + G1	1,5	3	P2.1234-41[2]	6,1	-
E 454-400	525	**D2**/5	60S	(3600 cm²)	2 x G1¼ / SAE1½, G¾ + G1	1,5	6	S2.1234-00	6,4	with magnetic system
E 464-459	300	**D3**/1	5EX2	140	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1250-03	7,8	-
E 464-456	500	**D3**/2	10EX2	200	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1250-06	7,8	-
E 464-468	600	**D3**/3	16EX2	200	2 x G1¼ / SAE1½, G¾ + G1	2,5	3	V2.1250-08	7,8	-
E 464-453	480	**D3**/4	30P	95	2 x G1¼ / SAE1½, G¾ + G1	1,5	3	P2.1250-11[2]	7,8	-
E 644-476	680	**D4**/1	10EX2	250	2 x G1¼ / SAE1½, G¾ + G1	3,0	3	V2.1260-46	9,5	

[2] Paper media supported with metal gauze

Dimensions

Version with 4 connections **Versions with 1 or 2 connections**



For calculation of dimension EV see Selection Chart

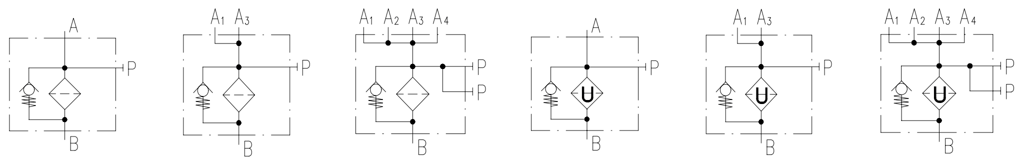
Measurements

Type	A	B	C	D	E	F	G	H	I	K	M	N	O	Q	S	T1	T2	V	W	X	Y	Z
E 444	see	2	141	128,5	139,9	12	36/35*	90	315	195	86,5	116	35	18	92	47,5	64	98,5	110,5	89	98,5	32,5
E 454	Selection	2	141	128,5	139,9	12	36/35*	90	485	362	86,5	116	35	18	92	47,5	64	98,5	110,5	89	98,5	32,5
E 464	Chart	2	141	128,5	139,9	12	36/35*	90	650	530	86,5	116	35	18	92	47,5	64	98,5	110,5	89	98,5	32,5
E 644		2	141	128,5	139,9	12	36/35*	90	750	630	86,5	116	35	18	92	47,5	64	98,5	110,5	89	98,5	32,5

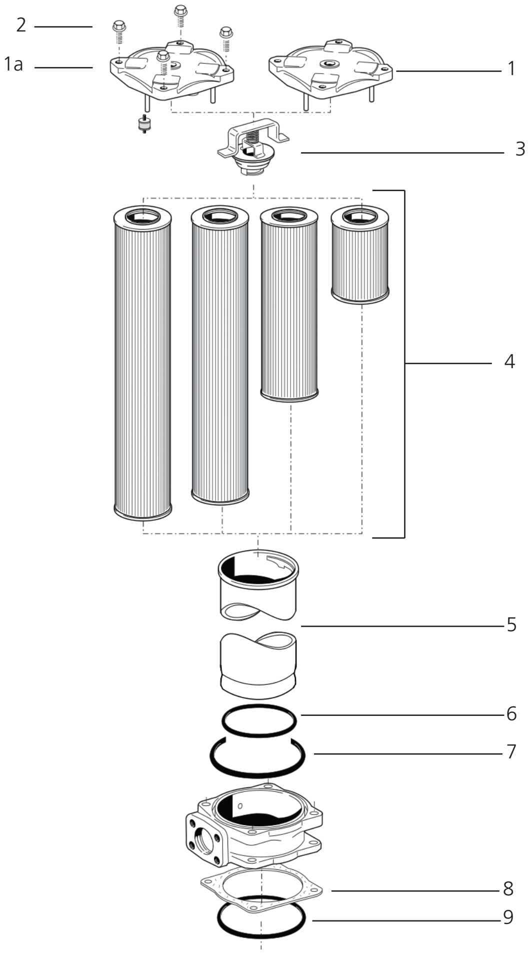
* for design with 4 connections

Symbole

1 2 3 4 5 6



Spare Parts



Pos.	Designation	Part No.
1	Cover	E 443.1200
1a	Cover with magnetic system	E 443.1210
2	Hexagonscrew M10 x 35	28213600
3	By-pass (1,5 bar)	E 440.1500
3	By-pass (2,5 bar)	E 460.1520
3	By-pass (3,0 bar)	E 640.1510
4	Filter elements	s. Chart / col. 9
5	Filter bowl E 444 *	E 441.1900
5	Filter bowl E 454 *	E 451.1900
5	Filter bowl E 464 *	E 461.1900
5	Filter bowl E 644 *	E 641.1900
6	O-ring 125 x 6	N007.1256
7	O-ring 151,76 x 5,33	N007.1525
8	Flat gasket	E 442.0103
9	O-ring 136.5 x 5,34	N007.1375

* Please indicate options (VD, VDEV, resp. RVEV)

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Illustrations may sometimes differ from the original. ARGO-HYTOS is not responsible for any unintentional mistake in this specification sheet.

E 441 · E 451 · E 461 · E 641 · E 700

Tank mounting · Nominal flow rate up to 800 l/min

Return Filter E 461

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protectionagainst wear:
By means of filter elements that, in full-flow filtration meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

› Installation:
Installation directly into a separate tank section for the return oil. This solution allows a number of returnline connections and does not show any restriction by a filter head.

› By-pass valve:
The location close to the inlet port prevents dirt particles retained by the filter element from entering into the clean oil side.

› Removable bowl:
In case of maintenance the filter bowl is removed together with the filter element - therefore dirt particles are not flushed back into the tank.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› high dirt-holding capacities
› low pressure drop
› long service life

Filter maintenance

By using a clogging indicator the correct moment for main-tenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter bowl:	Steel, phosphated
Housing bottom:	Polyamide, GF reinforced
(for E 700:	Steel, phosphated)
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web
	Paper - cellulose web, impregnated with resin

Accessories

Extension pipes or diffusers on the bowl outlet are available on request. Even the combination of both options is possible.

Extension pipe:
A correct extension pipe length ensures oil outlet below minimum oil level and prevents foaming.

Diffusers:
Diffusers reduce oil velocity and direct the oil to 90° outlet flow. This function prevents also oil foaming and whirling up of solid particles settled at the tank bottom.

Electrical and optical clogging indicators are available on request. Dimensions and technical data see catalogue sheet 60.20.

Characteristics

Nominal flow rate

Up to 800 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines $\leq 4{,}5$ m/s

Installation

Tank immersed installation in a separate return oil chamber of the reservoir.

Filter fineness

10 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

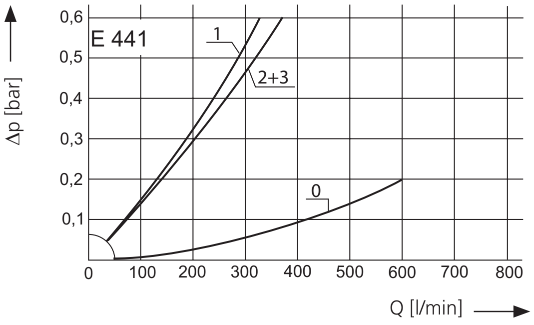
Max. 10 bar

Mounting position

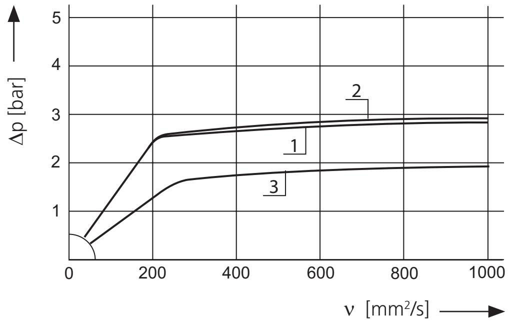
Preferably vertical, outlet downwards

Δp-curves for complete filters in Selection Chart, column 3

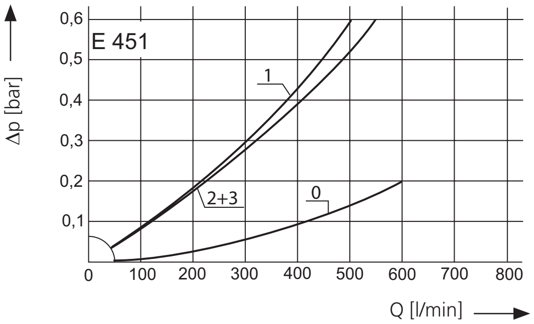
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



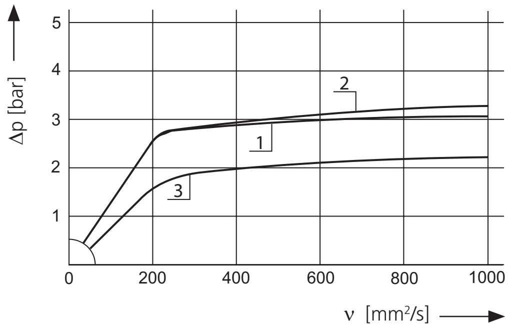
Pressure drop as a function of the **kinematic viscosity** at nominal flow



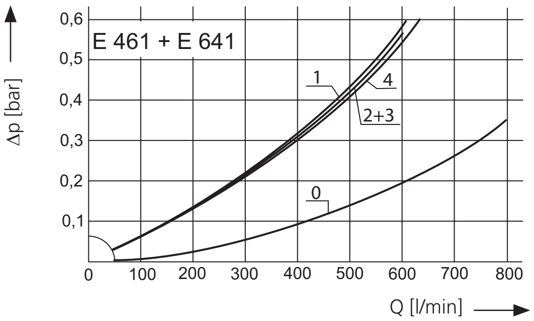
D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



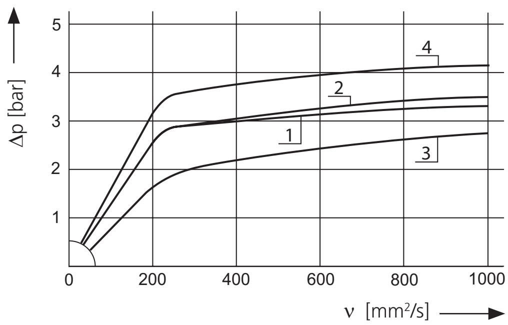
Pressure drop as a function of the **kinematic viscosity** at nominal flow



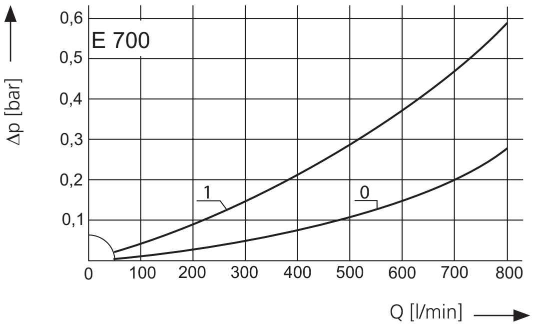
D3 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



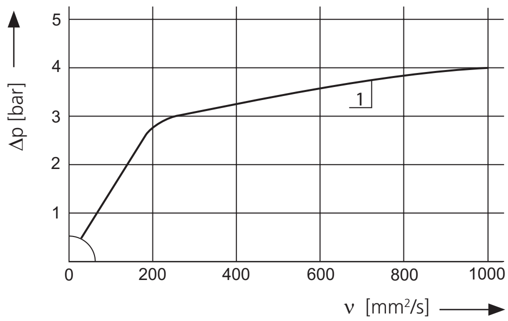
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D4 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

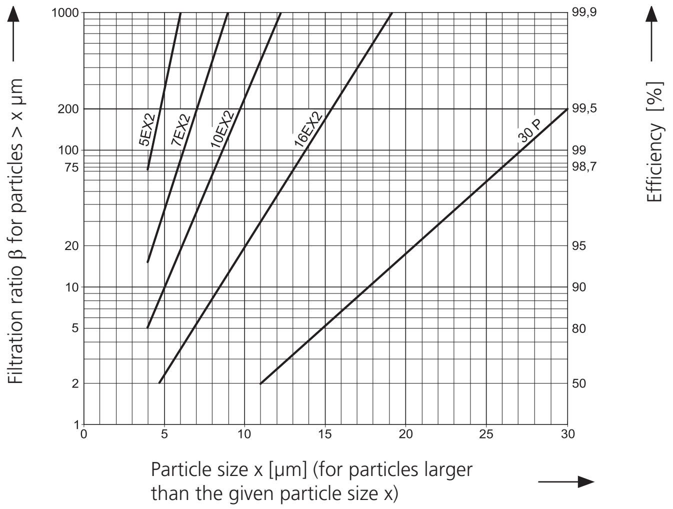


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\beta_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\beta_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\beta_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Order Information

As clogging indicators either manometers or electrical pressure switches can be used. Filters can also be supplied with an outlet diffuser. Optional extension pipes adapt the filter length to various tank depths. For ordering of accessories please use the below mentioned codes.

Order example: The filter E 451-156 has to be supplied with an outlet diffuser and an extension pipe (EV) for 580 mm length.

Order description: **E 451-156 / VD / EV 580**

Part No. (Basic unit)

Options:

Two options are available
VD: Outlet diffuser, RV: Extension pipe

Extension pipes:

7 various lengths are available
E 441 / E 451 / E 461 / E 641:
EV = K + 81 / + 136 / + 196 / + 231 / + 356 / + 446 / + 626 mm (see section dimensions and measurements)
E 700:
EV on request.

For the appropriate clogging indicators see catalogue sheet 60.20.

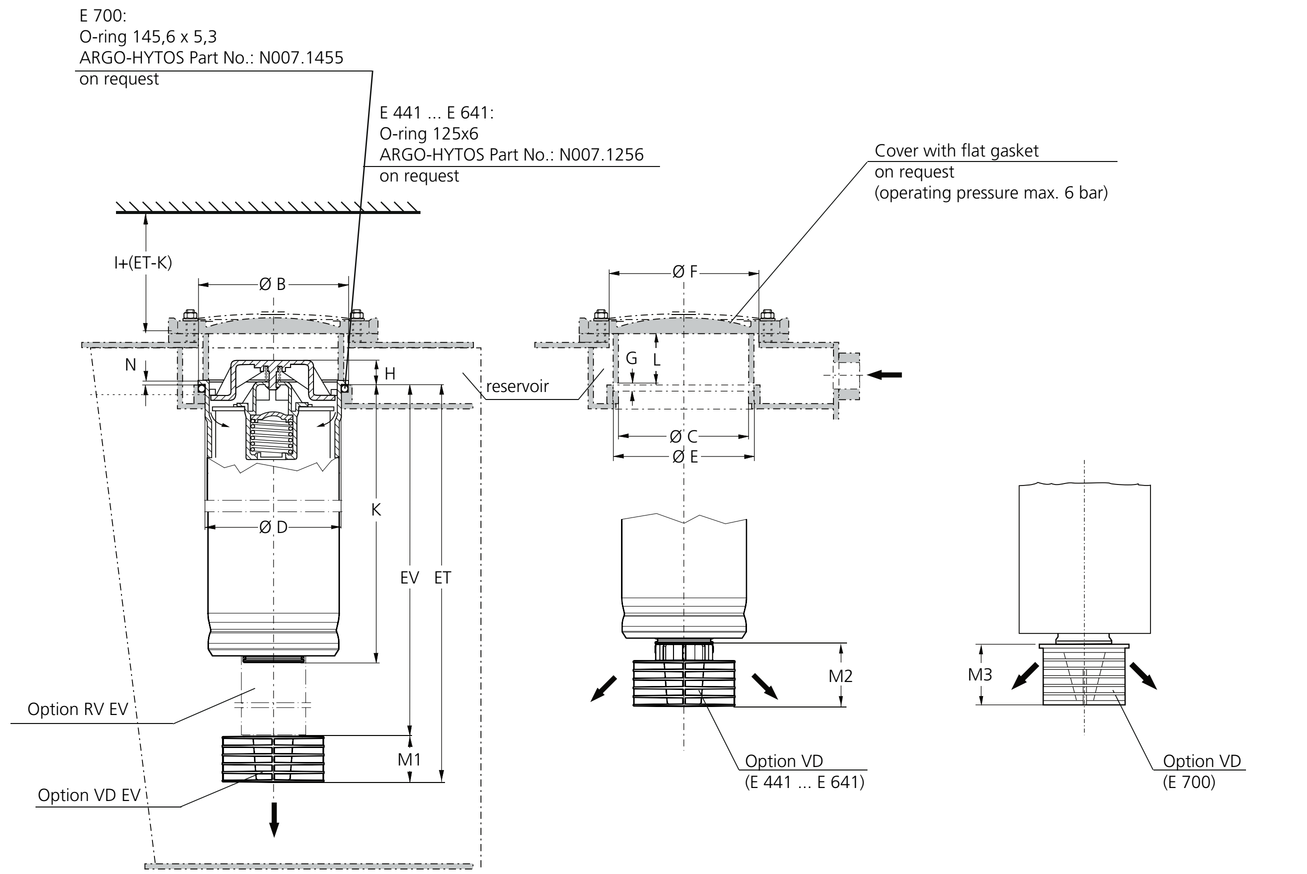
Remarks:

- The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. Other designs are available on request.

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connection A	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Remarks
	l/min			g		bar			kg	
1	2	3	4	5	6	7	8	9	10	11
E 441-156	200	**D1**/1	10EX2	61	-	2,5	1	V2.1217-56	2,4	-
E 441-168	270	**D1**/2	16EX2	62	-	2,5	1	V2.1217-58	2,4	-
E 441-153	175	**D1**/3	30P	29	-	1,5	1	P2.1217-51*	2,4	-
E 451-156	375	**D2**/1	10EX2	130	-	2,5	1	V2.1234-26	4,1	-
E 451-168	480	**D2**/2	16EX2	124	-	2,5	1	V2.1234-28	4,1	-
E 451-153	350	**D2**/3	30P	63	-	1,5	1	P2.1234-41*	4,1	-
E 461-156	500	**D3**/1	10EX2	200	-	2,5	1	V2.1250-06	5,8	-
E 461-168	600	**D3**/2	16EX2	200	-	2,5	1	V2.1250-08	5,8	-
E 461-153	480	**D3**/3	30P	95	-	1,5	1	P2.1250-11*	5,8	-
E 641-76	680	**D3**/4	10EX2	250	-	3,0	1	V2.1260-46	7,5	-
E 700-156	800	**D4**/1	10EX2	300	-	2,5	1	V2.1460-26	12,4	-

* Paper media supported with metal gauze

Dimensions



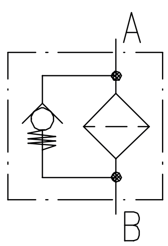
For calculation of dimension EV see data in Selection Chart

Measurements

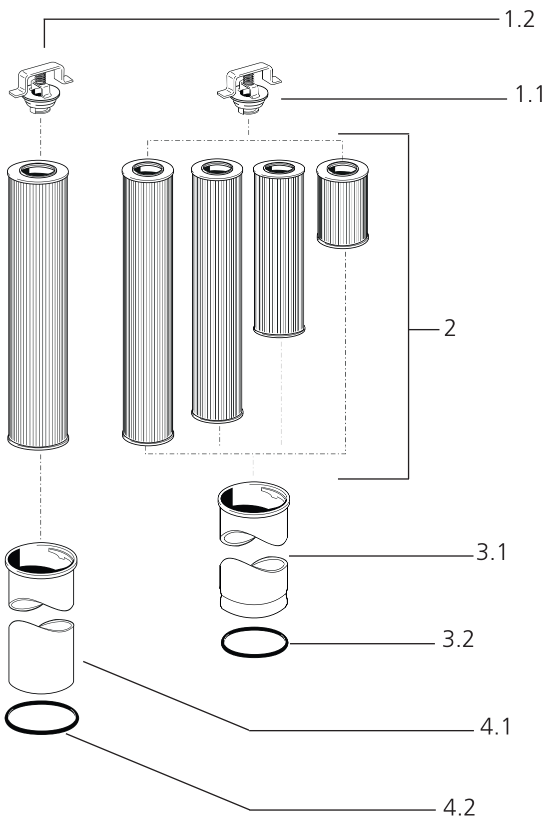
Type	A	B	C	D	E	F	G	H	I	K	L	M1	M2	M3	N
E 441	-	$142^{+2/-0,5}$	132	131	145	>145	6,5	26	250	211	48	47,5	62	-	1,5
E 451	-	$142^{+2/-0,5}$	132	131	145	>145	6,5	26	410	378	48	47,5	62	-	1,5
E 461	-	$142^{+2/-0,5}$	132	131	145	>145	6,5	26	580	546	48	47,5	62	-	1,5
E 641	-	$142^{+2/-0,5}$	132	131	145	>145	6,5	26	680	644	48	47,5	62	-	1,5
E 700	-	167^{+2}	155	155	170	>170	6,5	27	700	651	82	-	-	58	1,5

Symbols

1



Spare Parts



Pos.	Designation	Part No.
1.1	By-pass (1,5 bar)	E 440.1500
1.1	By-pass (2,5 bar)	E 460.1520
1.1	By-pass (3,0 bar)	E 640.1510
1.2	By-pass (2,5 bar) for E 700	E 703.1510
2	Filter elements	s. Chart / col. 9
3.1	Filter bowl E 441 [1]	E 441.1900
3.1	Filter bowl E 451 [1]	E 451.1900
3.1	Filter bowl E 461 [1]	E 461.1900
3.1	Filter bowl E 641 [1]	E 641.1900
3.2	O-ring 125 x 6 [2]	N007.1256
4.1	Filter bowl E 700	E 700.1900
4.2	O-ring 145,4 x 5,3 (for E 700) [2]	N007.1455

[1] Please indicate options (VD, VDEV and RVEV respectively)
[2] Not included in basic equipment

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return Filters

E 303 · E 503 · E 703

Tank top mounting · Connection up to SAE 2½ · Nominal flow rate up to 900 l/min

Return Filters E 503

Description

Application

In the return line circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Special features

› By-pass valve:
  The location close to the inlet port prevents dirt particles retained by the filter element from entering into the clean oil side.
› Removable bowl:
  In case of maintenance the filter bowl is removed together with the filter element - therefore dirt particles are not flushed back into the tank.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head cover:	Steel
Filter head:	Aluminium alloy
Filter bowl:	Steel
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

Accessories

Extension pipes and diffusers on the bowl outlet are available on request.

Extension pipe:
A correct extension pipe length ensures oil outlet below minimum oil level and prevents foaming.

Diffuser:
Diffusers reduce oil velocity and direct the oil to 90° outlet flow. This function prevents also oil foaming and whirling up of solid particles settled at the tank bottom.

Electrical and optical clogging indicators are available on request.
Dimensions and technical data see catalogue sheet 60.20

Characteristics

Nominal flow

Up to 900 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200\ mm^2/s$
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines $\leq 4{,}5$ m/s

Connection

SAE-flange (3.000 psi). Sizes see Selection Chart, column 6
(other port threads on request)

Filter fineness

5 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60\ mm^2/s$
- as starting viscosity: $\nu_{max} = 1200\ mm^2/s$
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

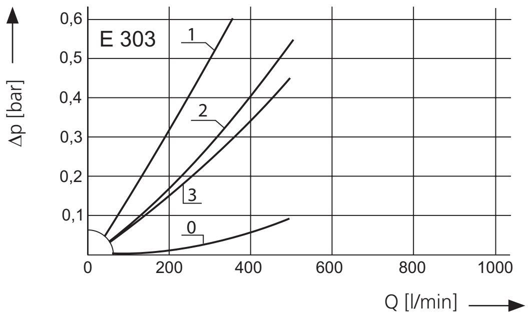
Max. 10 bar

Mounting position

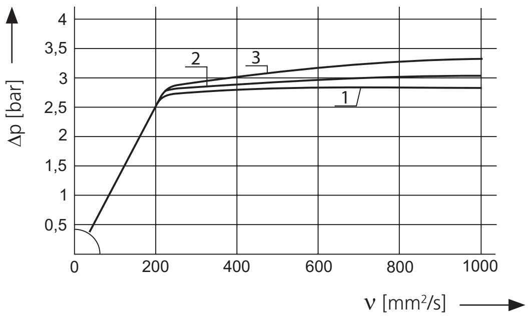
Preferably vertical, outlet downwards

Δp-curves for complete filters in Selection Chart, column 3

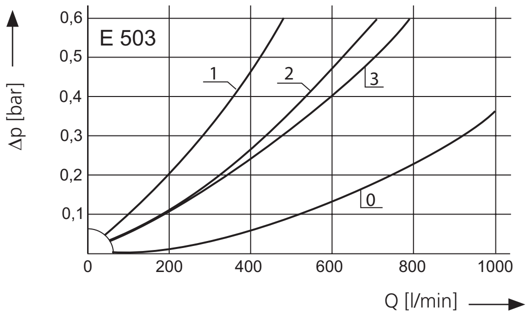
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



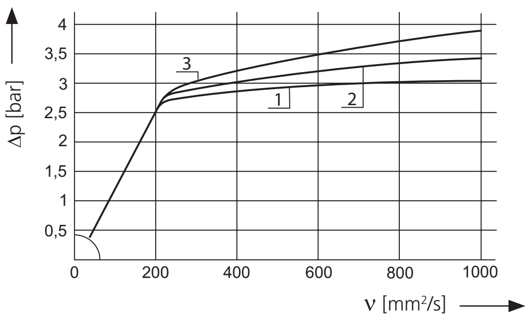
Pressure drop as a function of the **kinematic viscosity** at nominal flow



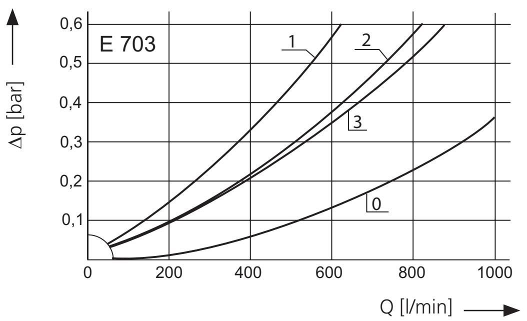
D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



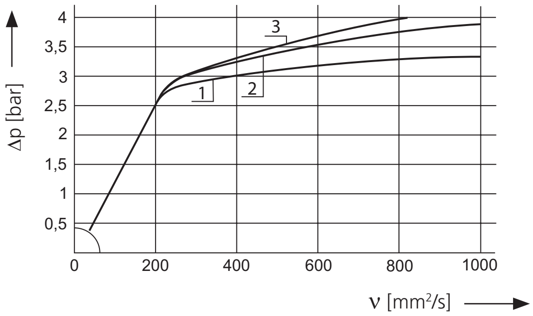
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D3 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

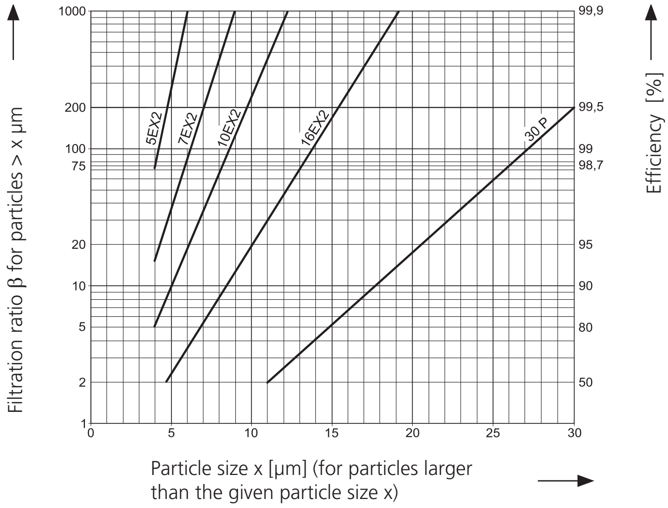


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$ = 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$ = 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$ = 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$ = 200	EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$ = 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 μm
60S	=	screen material with mesh size	60 μm
100S	=	screen material with mesh size	100 μm

Tolerances for mesh size according to DIN 4189.

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

Part No.	Nominal flow rate	Pressure drop diagram **D**/curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connection A SAE (3000 psi)	Cracking Pressure of by-pass	Symbol	Replacement filter element Part no.	Weight	Remarks
	l/min			g		bar			kg	
1	2	3	4	5	6	7	8	9	10	11
E 303-453	220	**D1**/1	5EX2	91	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1425-23	8,9	-
E 303-456	350	**D1**/2	10EX2	120	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1425-26	8,9	-
E 303-458	500	**D1**/3	16EX2	130	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1425-28	8,9	-
E 503-453	350	**D2**/1	5EX2	150	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1440-23	11,7	-
E 503-456	540	**D2**/2	10EX2	200	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1440-26	11,7	-
E 503-458	750	**D2**/3	16EX2	200	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1440-28	11,7	-
E 703-453	500	**D3**/1	5EX2	230	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1460-23	15,4	-
E 703-456	740	**D3**/2	10EX2	300	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1460-26	15,4	-
E 703-458	900	**D3**/3	16EX2	310	2 x G1¼ / SAE1½, G¾ + G1	2,5	2	V2.1460-28	15,4	-

All filters are delivered with a plugged clogging indicator connection M12 x 1,5. (Mounting holes for differential pressure switches on request). As clogging indicators either manometers or electrical pressure switches can be used. Two different head pieces with three various connecting options are available. All filters can also be supplied with an outlet diffuser. Optional extension pipes adapt the filter length to various tank depths. For ordering of accessories please use the below mentioned codes.

Order example: The filter E 703-256 has to be supplied with 2 connections (A and A4) and an extension pipe for 800 mm length.

Order description: **E 703- 256 / RV / EV 800**

Connections:

two various options are available
two connections[1] (A und A4)[2] - SAE2½ und G1 — 2
four connections[1] (A1, A2, A3 und A4) - 2 x G1¼ / SAE1½, G¾ und G1 — 4

Bowl outlet[2]:

two various options are available
VD - Outlet diffuser, RV - extension pipe

Extension pipe[3]:

four various lengths are available
EV = K + 64 / + 164 / + 264 / + 454 mm (see section dimensions and measurements)

For the appropriate clogging indicators see catalogue sheet 60.20.

Remarks:

› The switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).

› Clogging indicators are optional and always delivered detached from the filter.

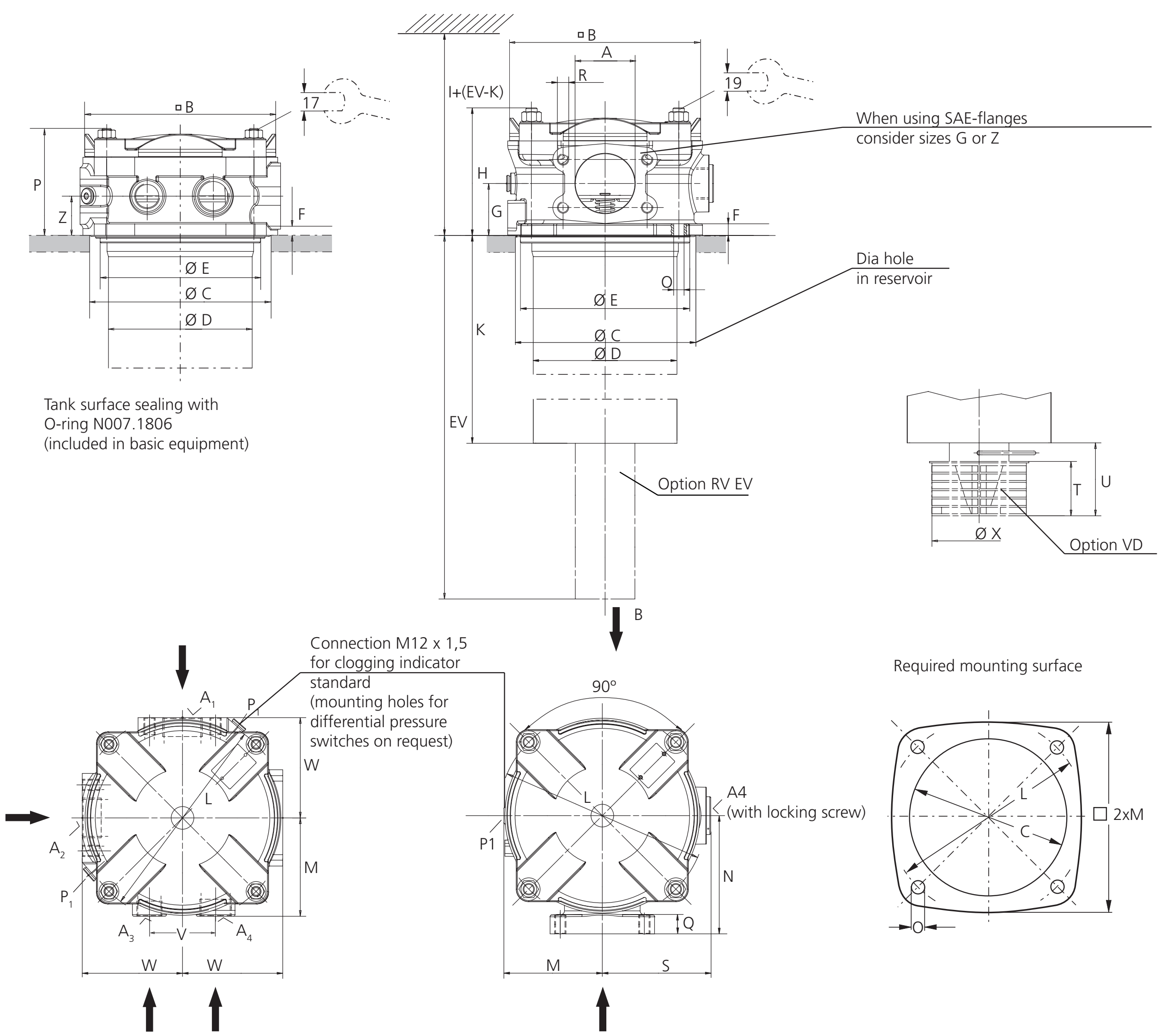
› The filters listed in this chart are standard filters. Other designs available on request.

[1] The individual flow rates must be matched to the connections
[2] Connection G1 (A4) with locking screw
[3] On request an outlet diffuser can be combined with an extension pipe

Dimensions

Version with 4 connections

Version with 2 connections



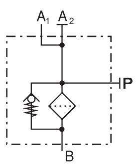
Measurements

Type	A	B	C	D	E	F	G	H	I	K	L	M	N	O	P	Q	R	S	T	U	V	W	X	Z
E 303	see	182	180	152	179	12	55	133	400	276	220	104	125	11,5*	113	20	M12	115	58	79	70	106	100	41,5
E 503	Selec-	182	180	152	179	12	55	133	550	430	220	104	125	11,5*	113	20	M12	115	58	79	70	106	100	41,5
E 703	tion Chart	182	180	152	179	12	55	133	810	636	220	104	125	11,5*	113	20	M12	115	58	79	70	106	100	41,5

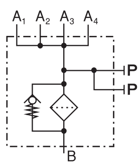
* for M10

Symbols

1



2



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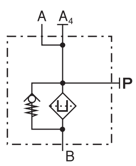

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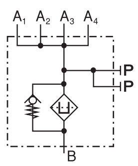
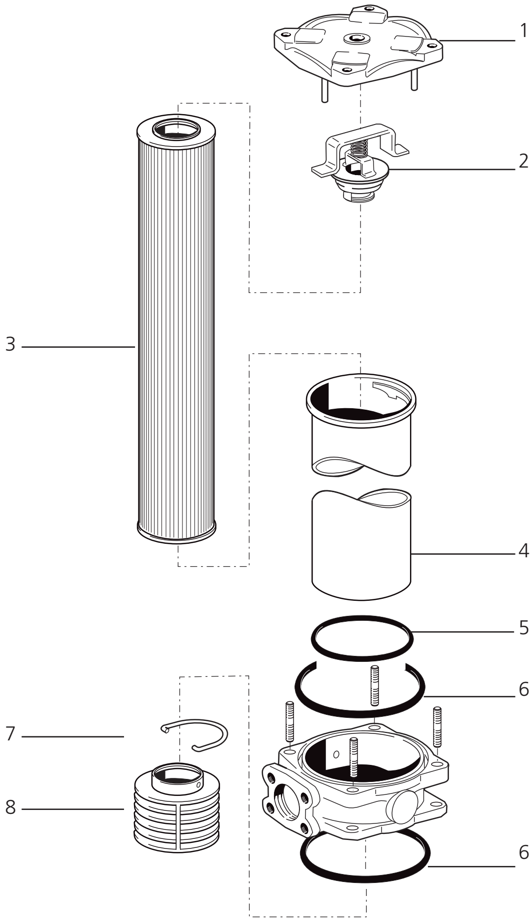


Spare Parts



Pos.	Designation	Part No.
1	Cover assy (2 connections)	E 303.1200
1	Cover assy (4 connections)	E 703.2202
2	By-pass (2,5 bar)	E 703.1510
3	Filter elements	see Chart. / col. 9
4	Filter bowl E 303*	E 303.1900
4	Filter bowl E 503*	E 503.1910
4	Filter bowl E 703*	E 703.1900
5	O-ring 145,42 x 5,33	N007.1455
6	O-ring 180 x 6	N007.1806
7	Clip (only option VD)	N026.0311
8	Diffuser (only option VD)	E 703.0701

* Please indicate options (VD, VDEV and RVEV respectively)

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return-Suction Filters

E 068 · E 088

In-line mounting · Connection up to G¾ · Nominal flow rate up to 100 l/min

M

Return-Suction Filter E 088

Description

Application

For operation in units with hydrostatic drives, when the return flow is under all operating conditions higher than the oil flow of the feed pump.

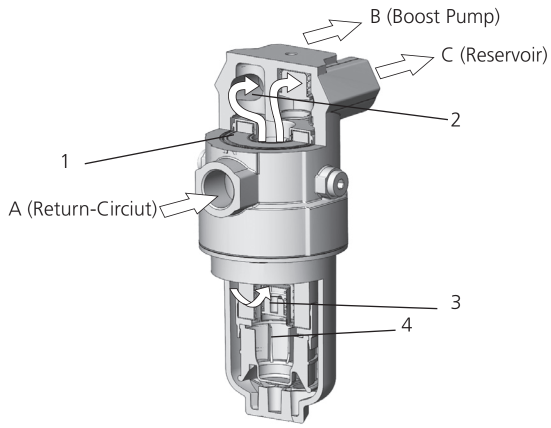
Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

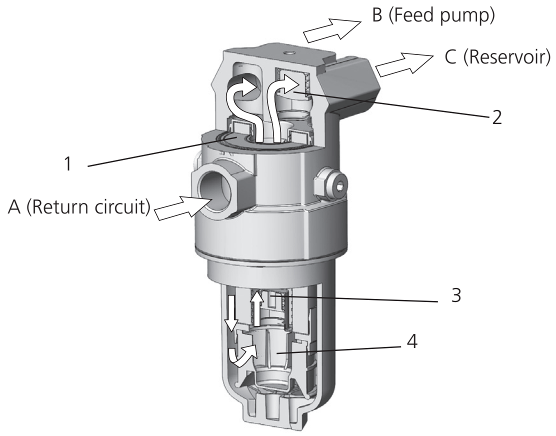
Suction filter function:
Because of the 100 %-filtration of the suction flow, no dirt can get into the feed pump.

Return filter function:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remainning in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Function (normal operation):



Function with response of the bypass valve (3):



Functional characteristics

The hydraulic oil returning from the circuit (A) passes the filter element (1), is pressurized by a 0,5 bar check valve (2) and supplied to the feed pump (B). The surplus oil flows filtered over the integral check valve into the reservoir (C).
As the feed pump is always fed with pressurized oil, the risk of cavitation is minimized and full performance is available even during the critical cold start phase.

An integral bypass valve (3) in the filter element (1) prevents too high back pressure (cold start, element contaminates).
A bypass valve with a 125 µm protection strainer (4) guarantees that only filtered oil can get into the feed pump.

Start up / Deaeration

Deaerating instructions published by the manufacturers of hydraulic drives must be observed.

Filter elements

Flow direction from outside to the center. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is indicated and guarantees therefore the optimum utilization of the filter elements.
In case of maintenance the filter bowl is removed together with the filter element – therefore dirt particles are not flushed back into the tank.

Accessories

Electrical and optical clogging indicators are available. Dimensions and technical data see catalogue sheet 60.20

General

In machines with a hydrostatic drive and combined working hydraulic system, return-suction filters replace the suction or pressure filters previously required for the feed pump of the closed-loop hydrostatic drive circuit as well as the return filter for the open-loop working hydraulic circuit.
While each circuit operates independently with separate filters, the combination of the two circuits via the return-suction filter causes interaction between the circuits.
If the design criteria described below are taken into account, you can take full advantage of the benefits provided by the return-suction filter concept, thus making sure that your system performs reliably even under extreme operating conditions.

Required return flow in the system

In order to maintain a precharging pressure of approx. 0,5 bar at the intake of the feed pump, the return flow must exceed the suction flow under any operating condition.

Permitted feed pump flow rate

- at operating temperature (ν < 60 mm²/s, rpm=max):
  feed pump flow rate < 0,8 x rated return flow according to column 2 of selection table
- at cold start-up (ν < 1000 mm²/s, rpm = 1000 min^{-1}):
  feed pump flow rate < 0,8 x rated return flow

Please contact us if your system operates with higher flow rates than stated above.

Flow velocity in the connecting lines

- Flow velocity in the return lines ≤ 4,5 m/s
- Flow velocity in the suction lines ≤ 1,5 m/s

Permitted pressure in the suction lines

At cold start up (ν < 1000 mm²/s, rpm = 1000 min^{-1}):
feed pump flow rate < 0,8 x rated return flow. The pressure loss in the suction lines must not exceed 0,4 bar.

Backpressures in system return lines

If drain oil from the hydrostatic drive is routed across the filter in addition to the flow of the open-loop circuit, the following has to be observed in order to protect the shaft seals:

- permitted leakage oil pressure for a given viscosity and speed (manufacturer's specifications!)
- pressure loss caused by the leakage oil pipes
- pressure loss caused by the oil cooler used
- backpressure of the filter for a given flow rate or kinematic viscosity (refer to pressure loss diagrams)

Depending on the application, the use of a cooler bypass valve is recommended.
Generously sized drain oil pipes are also of advantage.

Filter fineness grades

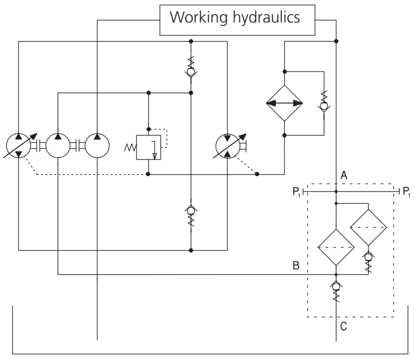
With the filter fineness grades available, the following oil cleanliness according to ISO 4406 can be achieved:

- 10EX2: 18/15/11 ... 14/11/7
- 16EX2: 20/17/12 ... 17/14/10

Even with the 16EX2 filter fineness grade, the requirements specified by manufacturers of hydrostatic drives are sometimes exceeded significantly. If components requiring a still better oil purity are used, we recommend the 10EX2 filter fineness grade.

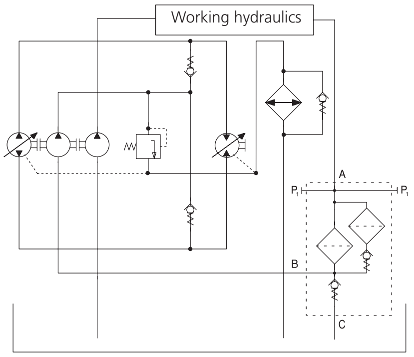
Suggested circuit layouts

A) The leakage oil of the hydrostatic drive is routed across the filter.



The entire dirt produced in the hydrostatic drive by abrasion is filtered out immediately and is thus not taken in by the pump of the open-loop circuit.
This circuit layout is always recommended if the return flow only slightly exceeds the suction flow, i.e. if there is a risk that the 0,5 bar precharging pressure cannot be maintained.

B) The drain oil of the hydrostatic drive is not routed across the filter but is discharged directly into the tank.



This circuit layout has the advantage that drain oil pressures are comparatively low.

Nominal flow rate

Up to 100 l/min in return line (see Selection Chart, column 2)
Up to 80 l/min feed pump flow rate (see Layout)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the return lines ≤ 4,5 m/s
- flow velocity in the suction lines ≤ 1,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 and 7
(other port threads on request)

Filter fineness

10 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-service 00.20).

Temperature range

-30 ° C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1000$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

Max. 10 bar

Materials

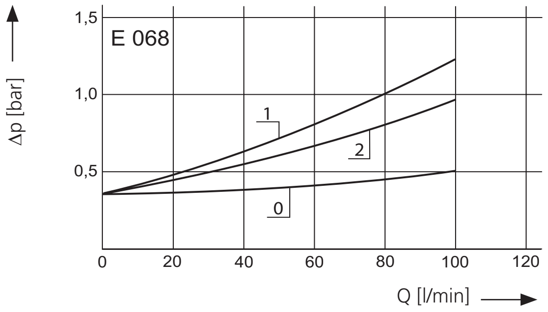
Filter head:	Aluminium alloy
Filter bowl:	Polyamide, GF-reinforced
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

Fitting position

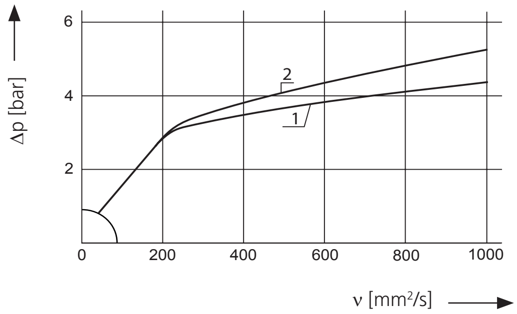
Preferably vertical, filter head on top.

Δp-curves for complete filters in Selection Chart, column 3 (80% of the nominal flow volume via connection B)

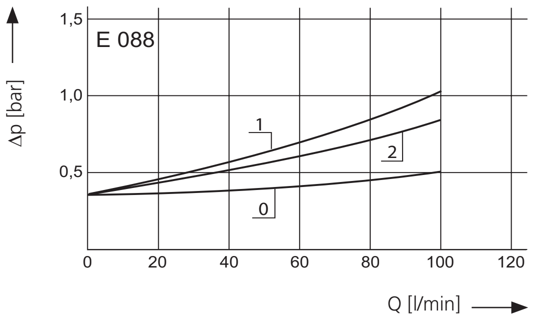
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



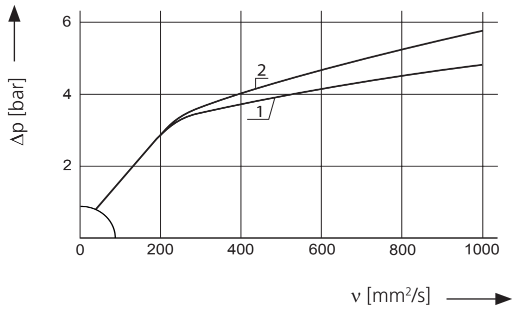
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

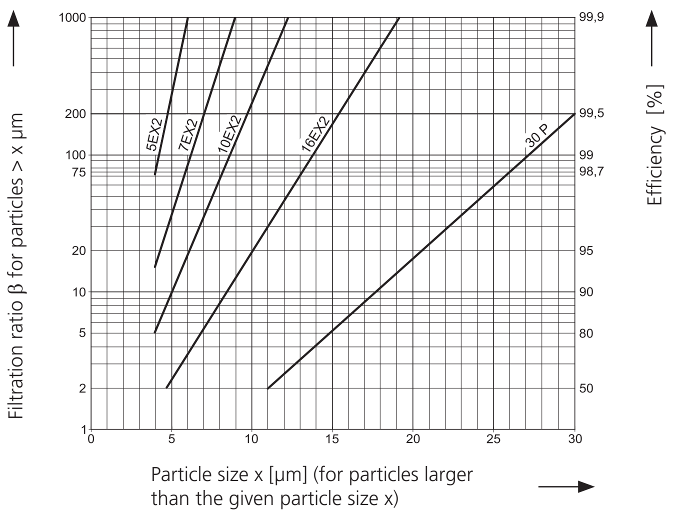


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2 = $\overline{\beta}_{5\,(c)}$ = 200 EXAPOR®MAX 2
7EX2 = $\overline{\beta}_{7\,(c)}$ = 200 EXAPOR®MAX 2
10EX2 = $\overline{\beta}_{10\,(c)}$ = 200 EXAPOR®MAX 2
16EX2 = $\overline{\beta}_{16\,(c)}$ = 200 EXAPOR®MAX 2
30P = $\beta_{30\,(c)}$ = 200 Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Part No.	Nominal return flow	Pressure drop see diagram **D**/curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connection A	Connection B/C	Cracking Pressure of CV[1]	Cracking Pressure of PRV[2]	Symbol	Replacement filter element Part No.	Weight	Remarks
	l/min			g			bar	bar			kg	
1	2	3	4	5	6	7	8	9	10	11	12	13
E 068-156	50	**D1**/1	10EX2	15	G¾	G¾	0,5	2,5	1	K3.0718-56	1,3	-
E 068-158	80	**D1**/2	16EX2	15	G¾	G¾	0,5	2,5	1	K3.0718-58	1,3	-
E 088-156	65	**D2**/1	10EX2	20	G¾	G¾	0,5	2,5	1	K3.0721-56	1,4	-
E 088-158	100	**D2**/2	16EX2	20	G¾	G¾	0,5	2,5	1	K3.0721-58	1,4	-

[1] Cracking pressure of check valve
[2] Cracking pressure of pressure relief valve

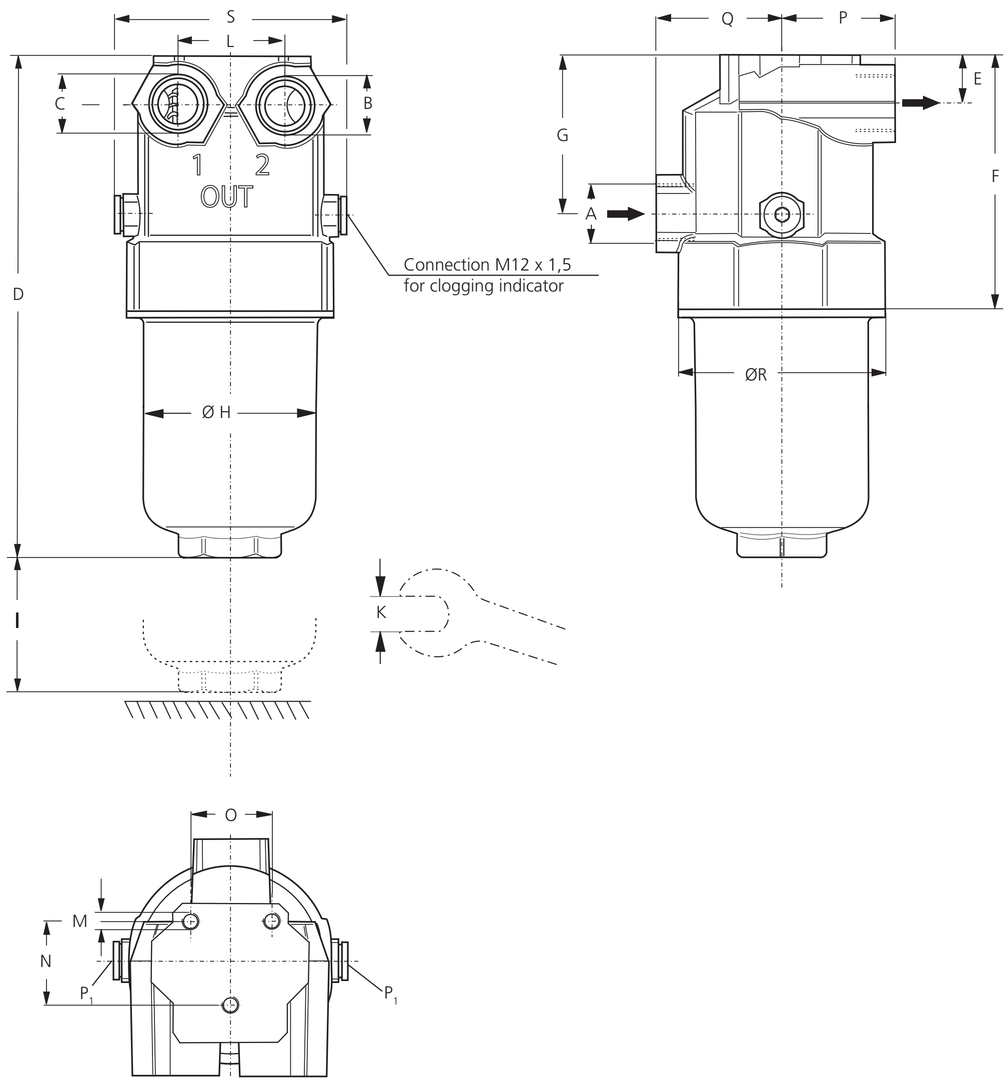
All filters are delivered with two plugged clogging indicator connections M12 x 1,5. As clogging indicators on the return side (P_1) either manometers or electrical pressure switches can be used.

For the appropriate clogging indicators see catalogue sheet 60.20.

Remarks:

› The start of the red area respectively the switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the pressure relief valve (see Selection Chart, column 9).
› Clogging indicators are optional and always delivered detached from the filter.
› The filters listed in this chart are standard filters. If modifications are required, we kindly ask for your request.
› For deaeration a bleed screw (for connection P_1) with Part No. SV 0112.15 is available.

Dimensions

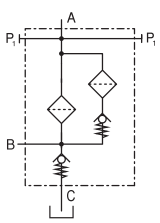


Measurements

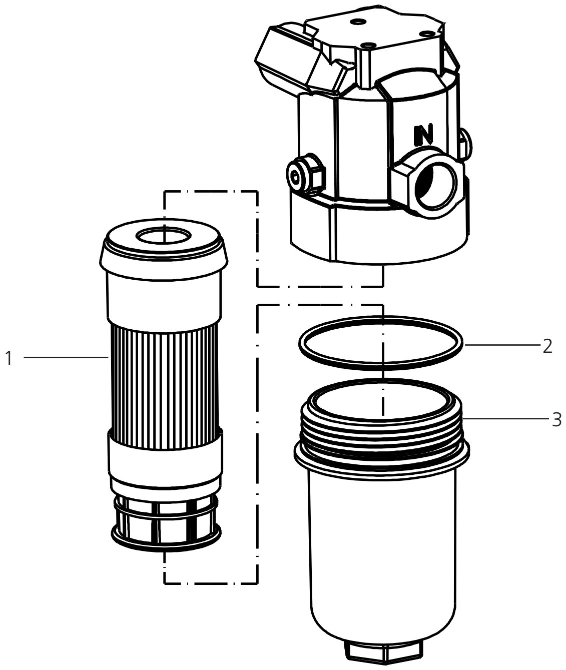
Type	A	B	C	D	E	F	G	H	I	K	L	M Ø / depth	N	O	P	Q	R	S
E 068	G¾	G¾	G¾	234	23,3	119	74,2	80	75	AF41	50	M8/15	40	38,1	53,5	57,5	95	108
E 088	G¾	G¾	G¾	268	23,3	119	74,2	80	75	AF41	50	M8/15	40	38,1	53,5	57,5	95	108

Symbols

1



Spare Parts



Pos.	Designation	Part No.
1	Filter element	see Chart / col. 11
2	O-ring 82,14 x 3,53	N007.0824
3	Filter bowl E 068	E 068.0101
3	Filter bowl E 088	E 068.0102

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return-Suction Filters

E 178 · E 258

In-line mounting · Connection G1· Nominal flow rate up to 250 l/min

Return-Suction Filter E 178

Description

Application

For operation in units with hydrostatic drives, when the return flow is under all operating conditions higher than the oil flow of the feed pump.

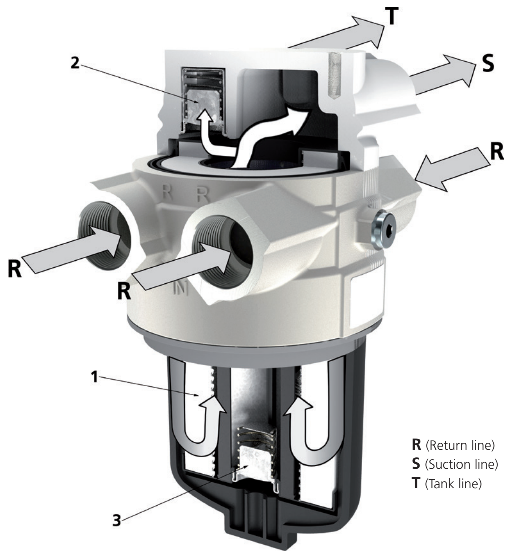
Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Suction filter function:
Because of the 100 %-filtration of the suction flow, no dirt can get into the feed pump.

Return filter function:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remainning in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Function (normal operation):



Functional characteristics

The hydraulic oil returning from the circuit (R) passes the filter element (1), is pressurized by a 0,5 bar check valve (2) and supplied to the feed pump (S). The surplus oil flows filtered over the integral check valve into the reservoir (T).
As the feed pump is always fed with pressurized oil, the risk of cavitation is minimized and full performance is available even during the critical cold start phase.

An integral bypass valve (3) in the filter element (1) prevents too high back pressure (cold start, element contaminates).
A bypass valve with a 200 μm protection strainer guarantees that only filtered oil can get into the feed pump.

Start up / Deaeration

Deaerating instructions published by the manufacturers of hydraulic drives must be observed.

Filter elements

Flow direction from outside to the center. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is indicated and guarantees therefore the optimum utilization of the filter elements.
In case of maintenance the filter bowl is removed together with the filter element – therefore dirt particles are not flushed back into the tank.

Accessories

Electrical and optical clogging indicators are available.
Dimensions and technical data see catalogue sheet 60.20.

General

In machines with a hydrostatic drive and combined working hydraulic system, return-suction filters replace the suction or pressure filters previously required for the feed pump of the closed-loop hydrostatic drive circuit as well as the return filter for the open-loop working hydraulic circuit.
While each circuit operates independently with separate filters, the combination of the two circuits via the return-suction filter causes interaction between the circuits.
If the design criteria described below are taken into account, you can take full advantage of the benefits provided by the return-suction filter concept, thus making sure that your system performs reliably even under extreme operating conditions.

Required return flow in the system

In order to maintain a precharging pressure of approx. 0,5 bar at the intake of the feed pump, the return flow must exceed the suction flow under any operating condition.

Permitted feed pump flow rate

› at operating temperature (ν < 60 mm²/s, rpm=max):
  feed pump flow rate < 0,8 x rated return flow according to column 2 of selection table
› at cold start-up (ν < 1000 mm²/s, rpm = 1000 min^{-1}):
  feed pump flow rate < 0,8 x rated return flow

Please contact us if your system operates with higher flow rates than stated above.

Flow velocity in the connecting lines

› Flow velocity in the return lines ≤ 4,5 m/s
› Flow velocity in the suction lines ≤ 1,5 m/s

Permitted pressure in the suction lines

At cold start up (ν < 1000 mm²/s, rpm = 1000 min^{-1}):
feed pump flow rate < 0,8 x rated return flow. The pressure loss in the suction lines must not exceed 0,4 bar.

Backpressures in system return lines

If drain oil from the hydrostatic drive is routed across the filter in addition to the flow of the open-loop circuit, the following has to be observed in order to protect the shaft seals:

› permitted leakage oil pressure for a given viscosity and speed (manufacturer's specifications!)
› pressure loss caused by the leakage oil pipes
› pressure loss caused by the oil cooler used
› backpressure of the filter for a given flow rate or kinematic viscosity (refer to pressure loss diagrams)

Depending on the application, the use of a cooler bypass valve is recommended.
Generously sized drain oil pipes are also of advantage.

Filter fineness grades

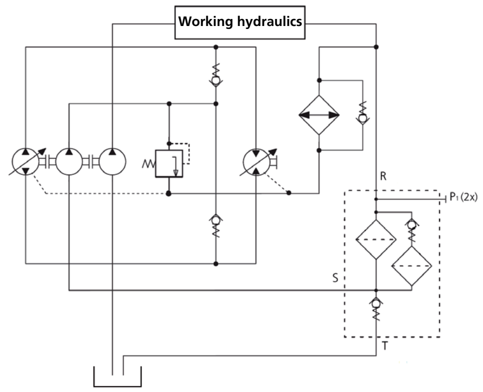
With the filter fineness grades available, the following oil cleanliness according to ISO 4406 can be achieved:

› 10EX2: 18/15/11 ... 14/11/7
› 16EX2: 20/17/12 ... 17/14/10

Even with the 16EX2 filter fineness grade, the requirements specified by manufacturers of hydrostatic drives are sometimes exceeded significantly. If components requiring a still better oil purity are used, we recommend the 10EX2 filter fineness grade.

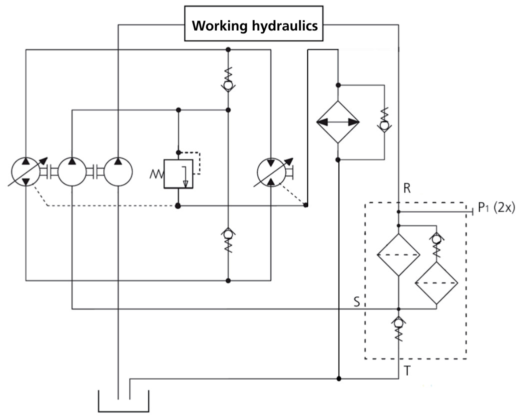
Suggested circuit layouts

A) The leakage oil of the hydrostatic drive is routed across the filter.



The entire dirt produced in the hydrostatic drive by abrasion is filtered out immediately and is thus not taken in by the pump of the open-loop circuit.
This circuit layout is always recommended if the return flow only slightly exceeds the suction flow, i.e. if there is a risk that the 0,5 bar precharging pressure cannot be maintained.

B) The drain oil of the hydrostatic drive is not routed across the filter but is discharged directly into the tank.



This circuit layout has the advantage that drain oil pressures are comparatively low.

Nominal flow rate

Up to 250 l/min in return line (see Selection Chart, column 2)
Up to 200 l/min feed pump flow rate (see Layout)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the return lines ≤ 4,5 m/s
- flow velocity in the suction lines ≤ 1,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 and 7
(other port threads on request)

Filter fineness

10 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-service 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1000$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

Max. 10 bar

Materials

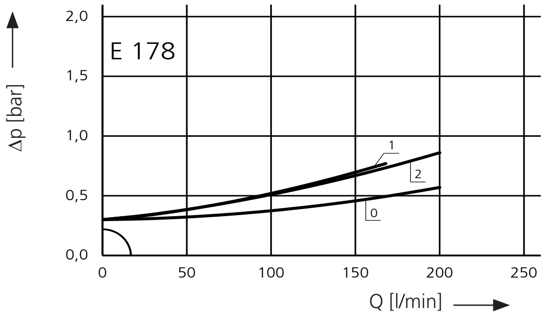
Filter head:	Aluminium alloy
Filter bowl:	Polyamide, GF-reinforced
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

Fitting position

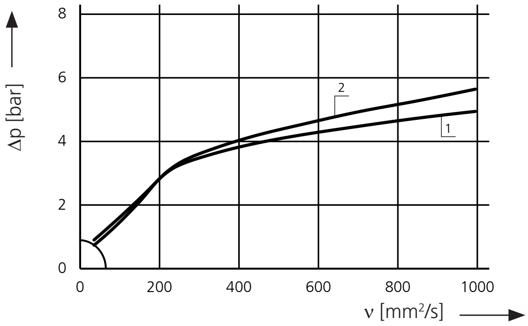
Preferably vertical, filter head on top.

Δp-curves for complete filters in Selection Chart, column 3 (80% of the nominal flow volume via connection B)

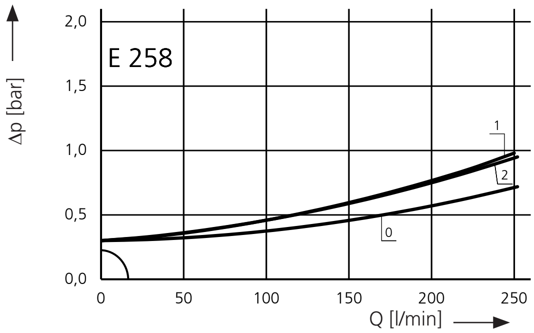
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



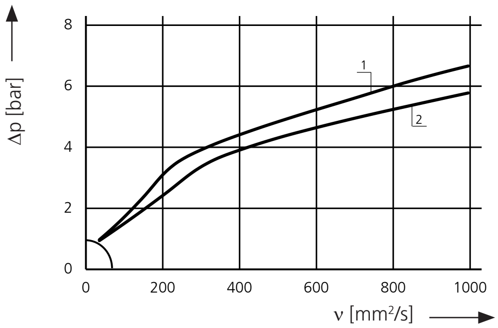
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

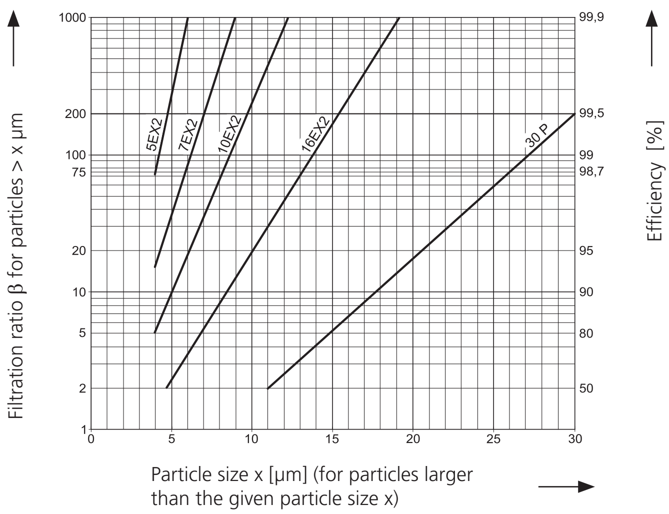


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2 =	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2 =	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2 =	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2 =	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P =	$\overline{\beta}_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Part No.	Nominal return flow	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection R	Connections S/T	Cracking pressure of CV[1]	Cracking pressure of PRV[2]	Symbol	Replacement filter element Part no.	Weight	Remarks
	l/min			g			bar	bar			kg	
1	2	3	4	5	6	7	8	9	10	11	12	13
E 178-166	160	**D1**/1	10EX2	60	G1	G1	0,5	2,5	1	K3.1019-56	3,0	-
E 178-168	210	**D1**/2	16EX2	59	G1	G1	0,5	2,5	1	K3.1019-58	3,0	-
E 258-166	250	**D2**/1	10EX2	95	G1	G1	0,5	2,5	1	K3.1030-56	3,5	-
E 258-168	250	**D2**/2	16EX2	94	G1	G1	0,5	2,5	1	K3.1030-58	3,5	-

[1] Cracking pressure of check valve
[2] Cracking pressure of pressure relief valve

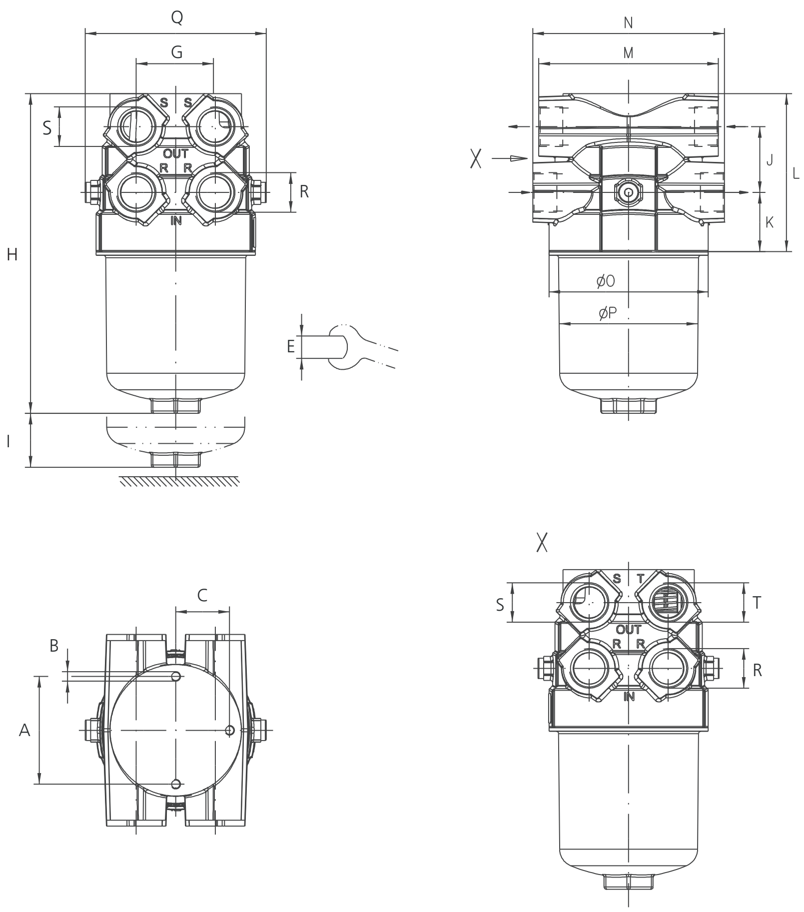
All filters are delivered with two plugged clogging indicator connections M12 x 1,5. As clogging indicators on the return side (P_1) either manometers or electrical pressure switches can be used.

For the appropriate clogging indicators see catalogue sheet 60.20.

Remarks:

› The start of the red area respectively the switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the pressure relief valve (see Selection Chart, column 9).
› Clogging indicators are optional and always delivered detached from the filter.
› The filters listed in this chart are standard filters. If modifications are required, we kindly ask for your request.
› For deaeration a bleed screw (for connection P_1) with Part No. SV 0112.15 is available.

Dimensions

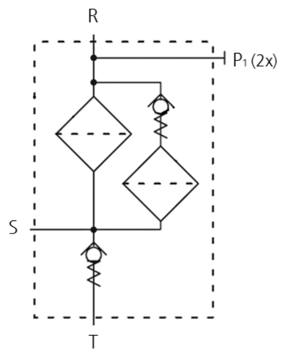


Measurement

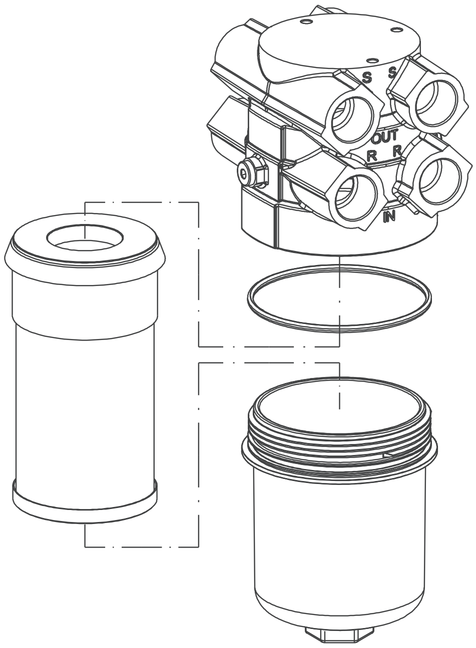
Type	A	B	C	E	G	H	I	J	K	L	M	N	O	P	Q
E 178	90	M8x18	45	AF41	66	268	95	55	49,5	132	150	160	Ø133	Ø117	151
E 258	90	M8x18	45	AF41	66	378	95	55	49,5	132	150	160	Ø133	Ø117	151
Type	R	S	T												
E 178	G1	G1	G1												
E 258	G1	G1	G1												

Symbols

1



Spare Parts



Pos.	Designation	Part No.
1	Filter element	see Chart / col. 11
2	O-ring 115,00 x 4,5	N007.1155
3	Filter bowl E 178	D 230.0102
3	Filter bowl E 258	D 230.0101

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return-Suction Filters

E 084

Tank top mounting · Connection up to G1 · Nominal flow rate up to 80 l/min

M

Return-Suction-Filter E 084

Description

Application

For operation in units with hydrostatic drives, when the return flow is under all operating conditions higher than the oil flow of the feed pump.

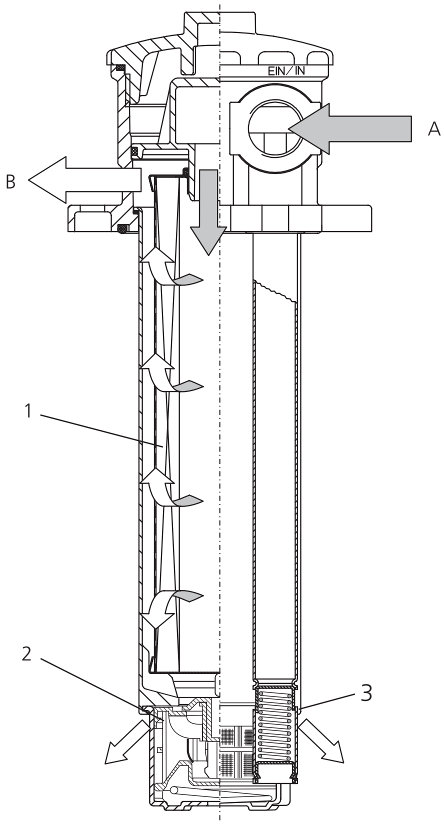
Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

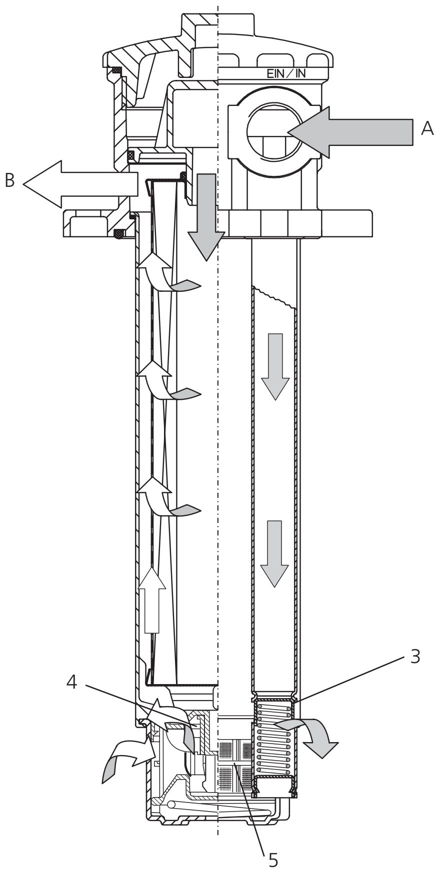
Suction filter function:
Because of the 100%-filtration of the suction flow, no dirt can get into the feed pump.

Return filter function:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Function (schematic):



Emergency-suction (schematic)



Functional characteristics

The hydraulic oil returning from the circuit (A) passes the filter element (1), is pressurized by a 0,5 bar check valve (2) and supplied to the feed pump (B). The surplus oil flows filtered over the integral check valve into the reservoir.
As the feed pump is always fed with pressurized oil, the risk of cavitation is minimized and full performance is available even during the critical cold start phase.
An integral pressure relief valve (3) prevents too high back pressure and protects the shaft seals against damages. As this valve leads the oil directly into the tank there is no direct connection between the return line (A) and the connection of the feed pump (B) (no bypass valve function).

The emergency-suction valve (4) with 125 µm protection strainer (5) supplies the feed pump in case of a short term of lack of oil. During normal operation, a lack of oil may definitely not occur (refer to „Design" section).

Start up / Deaeration

For units with emergency-suction valve and protection strainer the start up set E 084.1710 can be used to de-aerate the hydraulic system at first start up or at start up after repair; hereby the immediate supply of the feed pump with hydraulic oil is guaranteed.
For all other types, deaerating instructions published by the manufacturers of hydraulic drives must be observed.

Filter maintenance

By using a clogging indicator the correct moment for maintenance is indicated and guarantees therefore the optimum utilization of the filter elements.

Filter elements

Flow direction from centre to the outside. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Dirt deposits are entirely removed when the element is changed and cannot re-enter the tank.

Accessories

Electrical and optical clogging indicators are available.
Dimensions and technical data see catalogue sheet 60.20.

General

In machines with a hydrostatic drive and combined working hydraulic system, return-suction filters replace the suction or pressure filters previously required for the feed pump of the closed-loop hydrostatic drive circuit as well as the return filter for the open-loop working hydraulic circuit.
While each circuit operates independently with separate filters, the combination of the two circuits via the return-suction filter causes interaction between the circuits.
If the design criteria described below are taken into account, you can take full advantage of the benefits provided by the return-suction filter concept, thus making sure that your system performs reliably even under extreme operating conditions.

Required return flow in the system

In order to maintain a precharging pressure of approx. 0,5 bar at the intake of the feed pump, the return flow must exceed the suction flow under any operating condition:

Special feature:

- Versions with hole (Ø 4 mm) in the pressurizing valve: at least 10 l/min of excess flow

Permitted feed pump flow rate

- at operating temperature (ν < 60 mm²/s, rpm=max): feed pump flow rate < 0,5 x rated return flow according to column 2 of selection table
- at cold start-up (ν < 1000 mm²/s, rpm = 1000 min^{-1}): feed pump flow rate < 0,2 x rated return flow according to column of selection table

Please contact us if your system operates with higher flow rates than stated above.

Flow velocity in the connecting lines

- Flow velocity in the return lines ≤ 4,5 m/s
- Flow velocity in the suction lines ≤ 1,5 m/s

Permitted pressure in the suction lines

At cold start up (ν < 1000 mm²/s, rpm = 1.000 min^{-1}):
feed pump flow rate ≤ 0,2 x rated return flow. The pressure loss in the suction lines must not exceed 0,4 bar.

Backpressures in system return lines

If drain oil from the hydrostatic drive is routed across the filter in addition to the flow of the open-loop circuit, the following has to be observed in order to protect the shaft seals:

- permitted leakage oil pressure for a given viscosity and speed (manufacturer's specifications!)
- pressure loss caused by the leakage oil pipes
- pressure loss caused by the oil cooler used
- backpressure of the filter for a given flow rate or kinematic viscosity (refer to pressure loss diagrams)

Depending on the application, the use of a cooler bypass valve is recommended.
Generously sized drain oil pipes are also of advantage.

Filter fineness grades

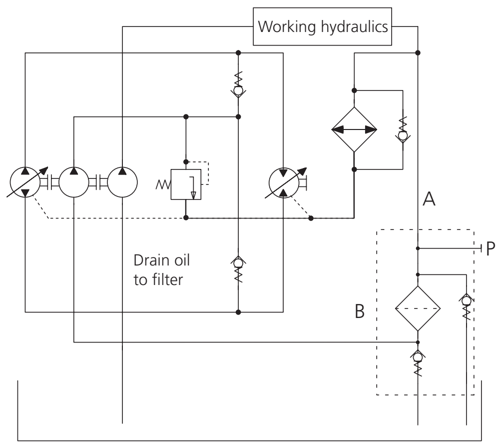
With the filter fineness grades available, the following oil cleanliness according to ISO 4406 can be achieved:

- 10EX2: 18/15/11 ... 14/11/7
- 16EX2: 20/17/12 ... 17/14/10

Even with the 16EX2 fineness grade, the requirements specified by manufacturers of hydrostatic drives are sometimes exceeded significantly.
If components requiring a still better oil purity are used, we recommend the 10EX2 filter fineness grade.

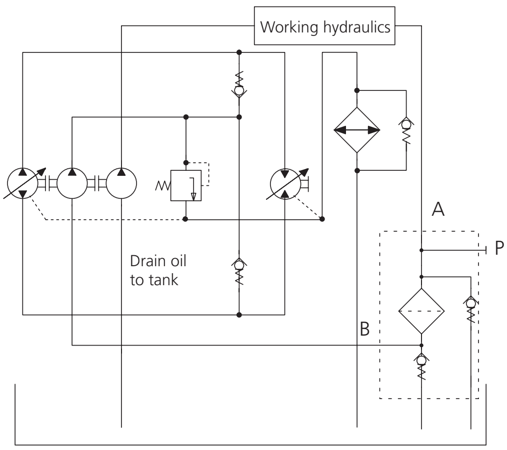
Suggested circuit layouts

A) The leakage oil of the hydrostatic drive is routed across the filter.



The entire dirt produced in the hydrostatic drive by abrasion is filtered out immediately and is thus not taken in by the pump of the open-loop circuit.
This circuit layout is always recommended if the return flow only slightly exceeds the suction flow, i.e. if there is a risk that the 0,5 bar precharging pressure cannot be maintained.

B) The drain oil of the hydrostatic drive is not routed across the filter but is discharged directly into the tank.



This circuit layout has the advantage that drain oil pressures are comparatively low.

Nominal flow rate

Up to 80 l/min in return line (see Selection Chart, column 2)
Up to 40 l/min feed pump flow rate (see Layout)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200\ mm^2/s$
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the return lines ≤ 4,5 m/s
- flow velocity in the suction lines ≤ 1,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 and 7
(other port threads on request)

Filter fineness

10 µm(c) ... 16 µm(c)
b-Werte nach ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-service 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60\ mm^2/s$
- as starting viscosity: $\nu_{max} = 1000\ mm^2/s$
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

Max. 10 bar

Materials

Screw-on cap:	Polyamide, GF-reinforced
Filter head:	Aluminium alloy
Filter bowl:	Aluminium alloy
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

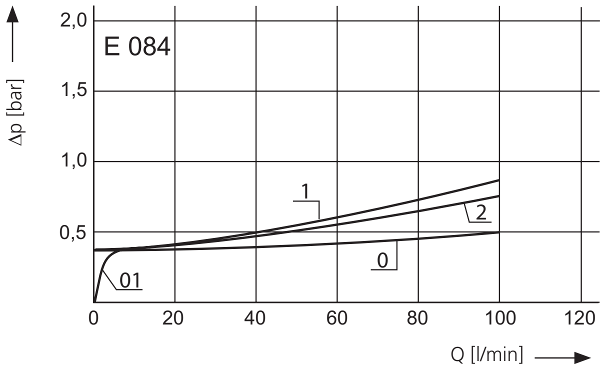
Fitting position

- Standard type no restriction, preferably vertical
- Models with emergency-suction valve can vary up to 15° from the vertical
- Models with hole ∅ 4 mm in the check valve can vary up to 45° from the vertical

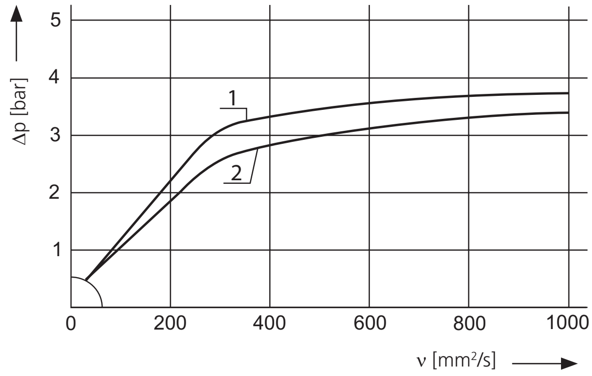
Even under unfavourable operating conditions (min. oil level, max. sloping) the oil outlet resp. emergency suction has to be below the oil level.
Special designs are available for horizontal assembly.

Δp-curves for complete filters in Selection Chart, column 3
(50 % of the nominal flow volume via connection B)

D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (00/01 = casing empty without/with hole Ø 4 mm)

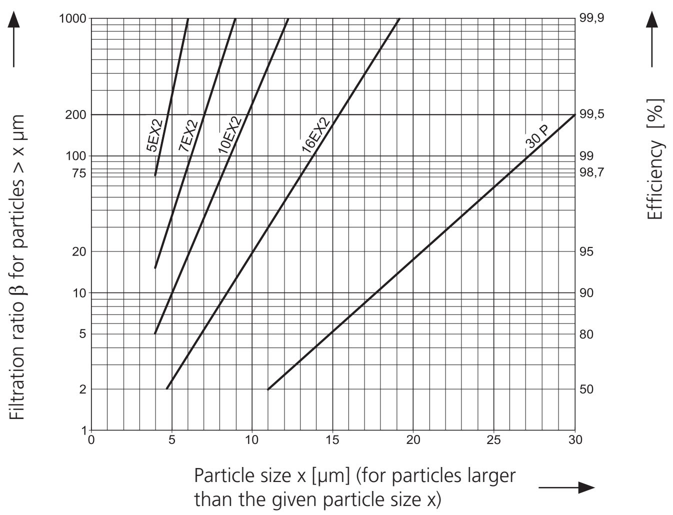


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following ß-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$ = 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$ = 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$ = 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$ = 200	EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$ = 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part No.	Nominal return flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connection A	Connection B	Cracking pressure of CV[1]	Cracking pressure of PRV[2]	Symbol	Suction valve	Replacement filter element Part No.	Weight	Remarks
	l/min			g			bar	bar				kg	
1	2	3	4	5	6	7	8	9	10	11	12	13	14
E 084-56	75	**D1**/1	10EX2	32	G1	G¾	0,5	3,0	2		V3.0724-06	1,7	[3]
E 084-77	80	**D1**/2	16EX2	31	G1	G¾	0,5	2,5	2		V3.0724-08	1,7	[3]
E 084-88	80	**D1**/2	16EX2	31	G¾	G¾	0,5	2,5	2		V3.0724-08	1,7	[3]
E 084-78	80	**D1**/2	16EX2	31	G1	G¾	0,5	2,5	1		V3.0724-08	1,7	-
E 084-87	80	**D1**/2	16EX2	31	G¾	G¾	0,5	2,5	1		V3.0724-08	1,7	-
E 084-277	80	**D1**/2	16EX2	31	G1	G¾	0,5	2,5	4	•	V3.0724-08	1,8	[4]
E 084-288	80	**D1**/2	16EX2	31	G¾	G¾	0,5	2,5	4	•	V3.0724-08	1,8	[4]
E 084-287	80	**D1**/2	16EX2	31	G1	G¾	0,5	2,5	3	•	V3.0724-08	1,8	[4+5]

[1] Cracking pressure of check valve
[2] Cracking pressure of pressure relief valve
[3] With hole Ø 4 mm in the check valve for oil drain when opening the filter cover
[4] With emergency-suction valve and protection strainer (mesh size 125 µm) [5] Suitable for horizontal assembly

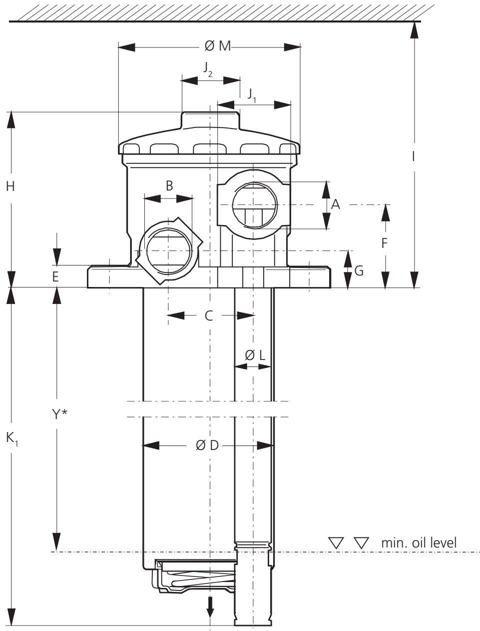
All filters are delivered with a plugged clogging indicator connection M12 x 1,5 (connection P_1).
As clogging indicators either manometers or electrical pressure switches can be used.

For the appropriate clogging indicators see catalogue sheet 60.20.

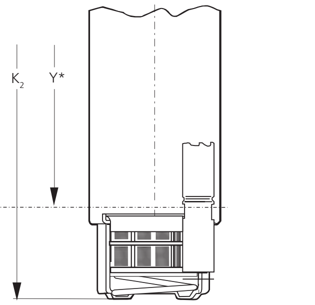
Remarks:

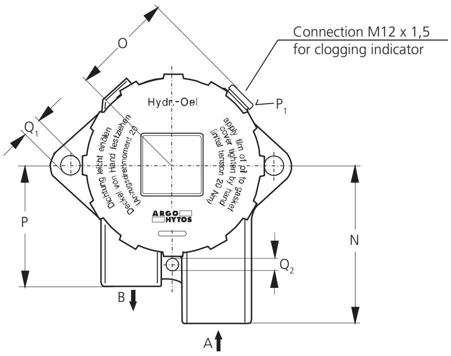
- The start of the red area respectively the switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the pressure relief valve (see Selection Chart, column 9).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. If modifications are required, e.g. for horizontal assembly or with integrated suction valve integrated into the pressure relief valve (see section symbols, symbol no. 5) to guarantee the emergency steering feature for vehicles with official road use, we kindly ask for your request.
- For deaeration a bleed screw (for connection P_1) with Part No. SV 0112.15 is available.

Dimensions

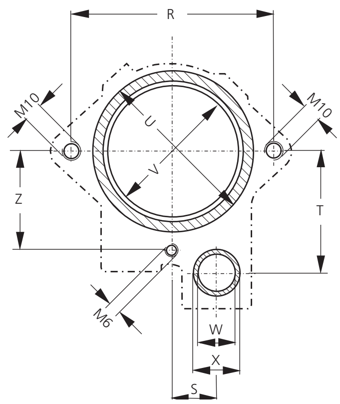


Versions with emergency-suction valve and protection strainer





Port sizes and mounting face



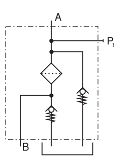
Measurements

Type	A	B	C	D	E	F	G	H	I	J_1	J_2	K_1	K_2	L	M	N	O	P	Q_1	Q_2
E 084	G¾,G1	G¾	48	73,5	12	47	21	102	315	AF41	AF32	254	268	20,5	104,5	90	60	69	11	6,6
Type	R	S	T	U	V	W	X	Y*	Z											
E 084	115	25	65	100	79	21	38	224	55											

* Oil outlet resp. emergency suction has to be under all operating cond. below min. oil level (given by Y)

Symbols

1



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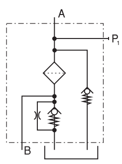

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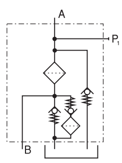

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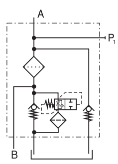
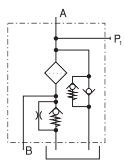
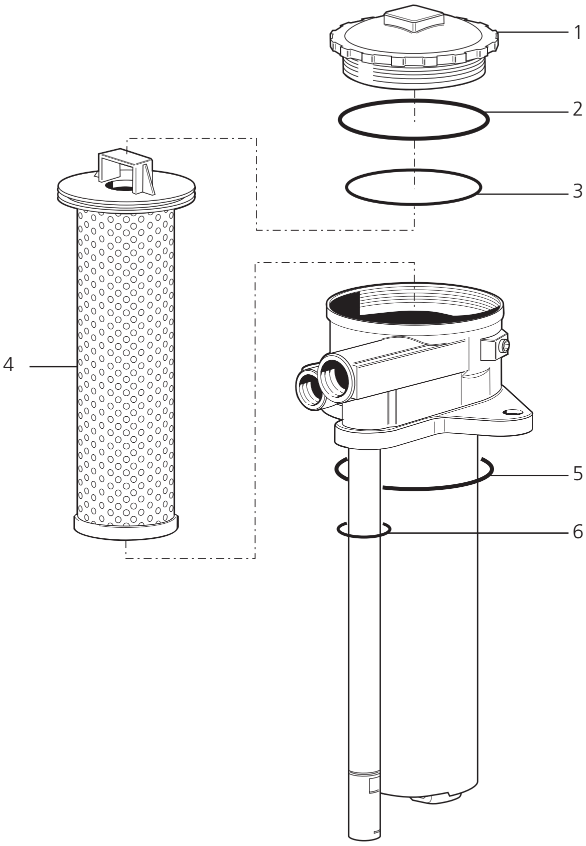


5



Spare Parts



Pos.	Designation	Part No.
1	Screw-on cap	E 103.0201
2	Flat gasket	N031.0841
3	O-ring 72 x 3	N007.0723
4	Filter element	see Chart. / col. 11
5	O-ring 84 x 4	N007.0844
6	O-ring 23 x 4	N007.0231

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941 Verification of collapse/burst pressure rating
ISO 2942 Verification of fabrication integrity (Bubble Point Test)
ISO 2943 Verification of material compatibility with fluids
ISO 3968 Evaluation of pressure drop versus flow characteristics
ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return-Suction Filters

E 158 · E 198 · E 248

Tank top mounting · Connection up to G1¼ · Nominal flow rate up to 250 l/min

Return-Suction Filter E 198

Description

Application

For operation in units with hydrostatic drives, when the return flow is under all operating conditions higher than the oil flow of the feed pump.

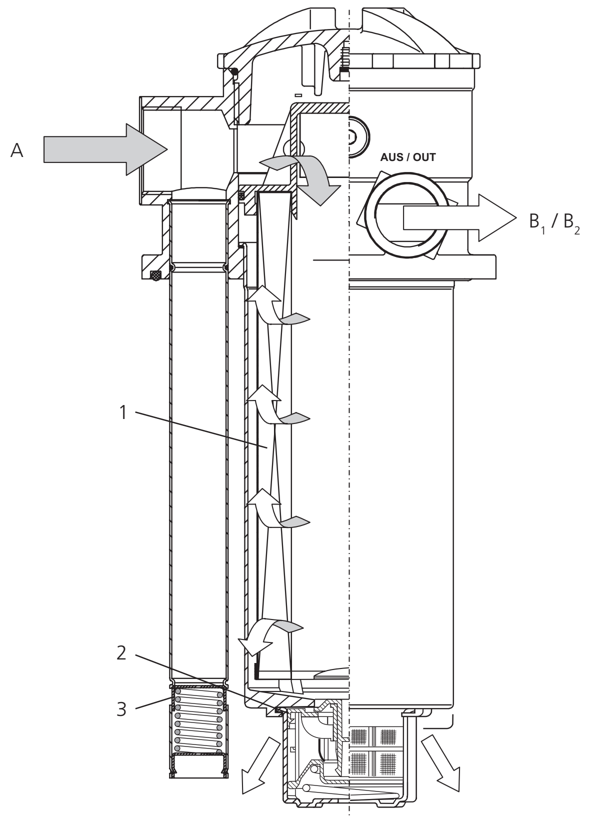
Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

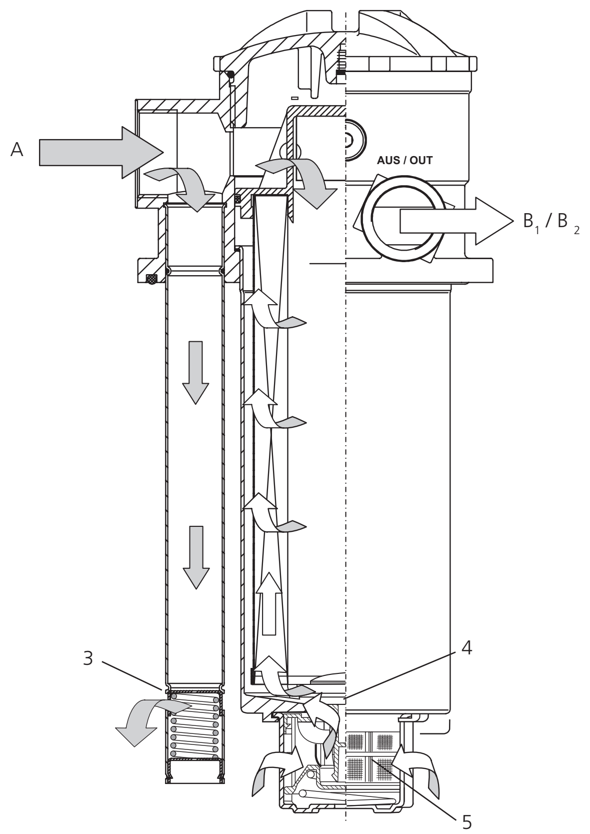
Suction filter function:
Because of the 100 %-filtration of the suction flow, no dirt can get into the feed pump.

Return filter function:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remainning in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Function (schematic):



Emergency-suction (schematic):



Functional characteristics

The hydraulic oil returning from the circuit (A) passes the filter element (1), is pressurized by a 0,5 bar check valve (2) and supplied to the feed pump (B). The surplus oil flows filtered over the integral check valve into the reservoir.
As the feed pump is always fed with pressurized oil, the risk of cavitation is minimized and full performance is available even during the critical cold start phase.
An integral pressure relief valve (3) prevents too high back pressure and protects the shaft seals against damages. As this valve leads the oil directly into the tank there is no direct connection between the return line (A) and the connection of the feed pump (B) (no bypass valve function).

The emergency-suction valve (4) with 125 µm protection strainer (5) supplies the feed pump in case of a short term of lack of oil. During normal operation, a lack of oil may definitely not occur (refer to „Design“ section).

Start up / Deaeration

For units with emergency-suction valve and protection strainer the start up set E 198.1710 can be used to de-aerate the hydraulic system at first start up or at start up after repair; hereby the immediate supply of the feed pump with hydraulic oil is guaranteed.
For all other types, deaerating instructions published by the manufacturers of hydraulic drives must be observed.

Filter maintenance

By using a clogging indicator the correct moment for maintenance is indicated and guarantees therefore the optimum utilization of the filter elements

Filter elements

Flow direction from centre to the outside. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Dirt deposits are entirely removed when the element is changed and cannot re-enter the tank.

Accessories

Electrical and optical clogging indicators are available.
Dimensions and technical data see catalogue sheet 60.20.

General

In machines with a hydrostatic drive and combined working hydraulic system, return-suction filters replace the suction or pressure filters previously required for the feed pump of the closed-loop hydrostatic drive circuit as well as the return filter for the open-loop working hydraulic circuit.
While each circuit operates independently with separate filters, the combination of the two circuits via the return-suction filter causes interaction between the circuits.
If the design criteria described below are taken into account, you can take full advantage of the benefits provided by the return-suction filter concept, thus making sure that your system performs reliably even under extreme operating conditions.

Required return flow in the system

In order to maintain a precharging pressure of approx. 0,5 bar at the intake of the feed pump, the return flow must exceed the suction flow under any operating condition:
Special feature:

› Versions with hole (Ø 4 mm) in the pressurizing valve: at least 20 l/min of excess flow

Permitted feed pump flow rate

› at operating temperature (ν < 60 mm²/s, rpm=max): feed pump flow rate < 0,5 x rated return flow according to column 2 of selection table
› at cold start-up (ν < 1000 mm²/s, rpm = 1000 min^{-1}): feed pump flow rate < 0,2 x rated return flow according to column of selection table

Please contact us if your system operates with higher flow rates than stated above.

Flow velocity in the connecting lines

› Flow velocity in the return lines $\leq$ 4,5 m/s
› Flow velocity in the suction lines $\leq$ 1,5 m/s

Permitted pressure in the suction lines

At cold start up (ν < 1000 mm²/s, rpm = 1000 min^{-1}):
feed pump flow rate < 0,2 x rated return flow. The pressure loss in the suction lines must not exceed 0,4 bar.

Backpressures in system return lines

If drain oil from the hydrostatic drive is routed across the filter in addition to the flow of the open-loop circuit, the following has to be observed in order to protect the shaft seals:

› permitted leakage oil pressure for a given viscosity and speed (manufacturer's specifications!)
› pressure loss caused by the leakage oil pipes
› pressure loss caused by the oil cooler used
› backpressure of the filter for a given flow rate or kinematic viscosity (refer to pressure loss diagrams)

Depending on the application, the use of a cooler bypass valve is recommended.
Generously sized drain oil pipes are also of advantage.

Filter fineness grades

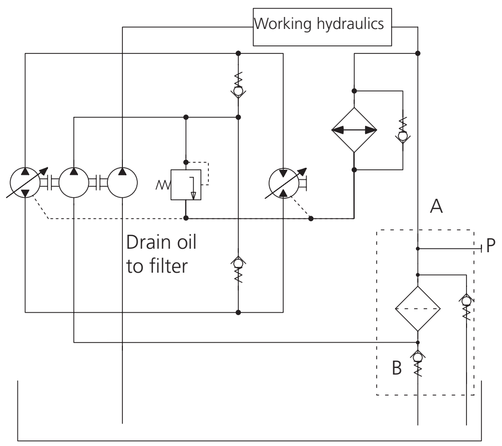
With the filter fineness grades available, the following oil cleanliness according to ISO 4406 can be achieved:

› 10EX2: 18/15/11 ... 14/11/7
› 16EX2: 20/17/12 ... 17/14/10

Even with the 16EX2 filter fineness grade, the requirements specified by manufacturers of hydrostatic drives are sometimes exceeded significantly. If components requiring a still better oil purity are used, we recommend the 10EX2 filter fineness grade.

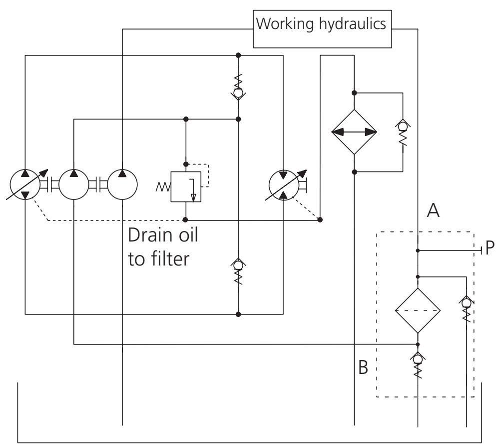
Suggested circuit layouts

A) The leakage oil of the hydrostatic drive is routed across the filter.



The entire dirt produced in the hydrostatic drive by abrasion is filtered out immediately and is thus not taken in by the pump of the open-loop circuit.
This circuit layout is always recommended if the return flow only slightly exceeds the suction flow, i.e. if there is a risk that the 0,5 bar precharging pressure cannot be maintained.

B) The drain oil of the hydrostatic drive is not routed across the filter but is discharged directly into the tank.



This circuit layout has the advantage that drain oil pressures are comparatively low.

Nominal flow rate

- Up to 250 l/min in return line (see Selection Chart, column 2)
- Up to 125 l/min feed pump flow rate (see Layout)

The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the return lines ≤ 4,5 m/s
- flow velocity in the suction lines ≤ 1,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13. Sizes see Selection Chart, column 6 and 7
(other port threads on request)

Filter fineness

10 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-service 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1000$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 %Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

Max. 10 bar

Materials

Screw-on cap:	Polyester, GF-reinforced
Filter head:	Aluminium alloy
Filter bowl:	Aluminium alloy
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

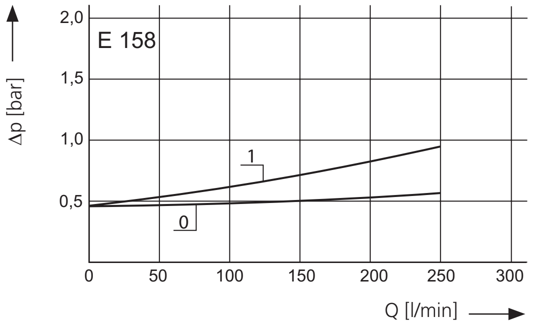
Fitting position

- Standard type no restriction, preferably vertical
- Models with emergency-suction valve can vary up to 15° from the vertical
- Models with hole Ø 4 mm in the check valve can vary up to 45° from the vertical

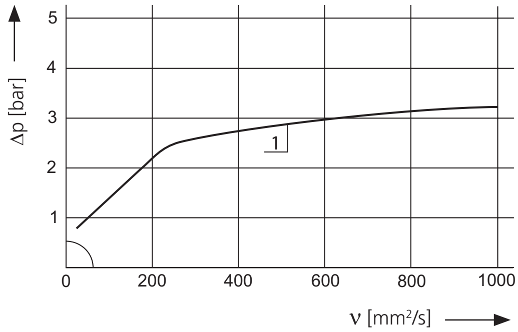
Even under unfavourable operating conditions (min. oil level, max. sloping) the oil outlet resp. emergency suction has to be below the oil level.
Special designs are available for horizontal assembly.

Δp-curves for complete filters in Selection Chart, column 3
(50 % of the nominal flow volume via connection B)

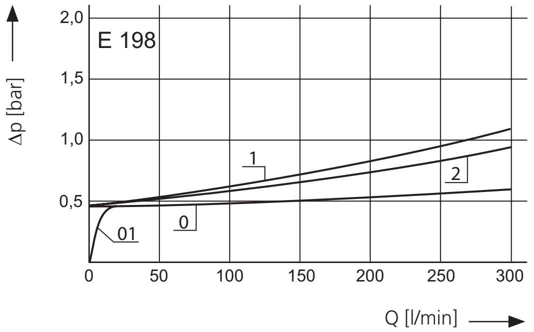
D1 Pressure drop as a function of the **flow volume**
at ν = 35 mm²/s (0 = casing empty with hole Ø 4 mm)



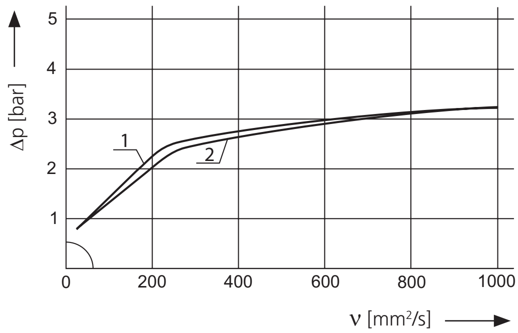
Pressure drop as a function of the
kinematic viscosity at nominal flow



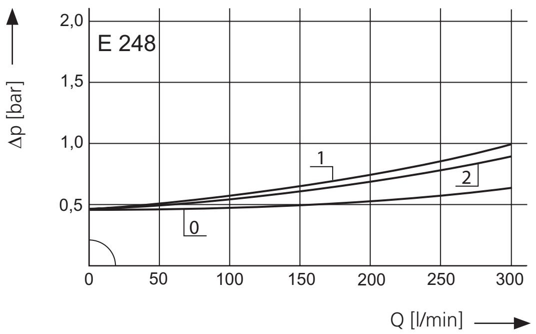
D2 Pressure drop as a function of the **flow volume**
at ν = 35 mm²/s (0 = casing empty with hole Ø 4 mm)



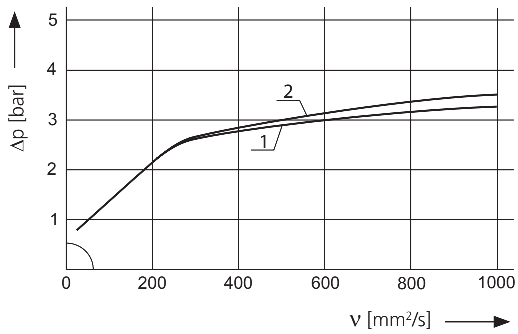
Pressure drop as a function of the
kinematic viscosity at nominal flow



D3 Pressure drop as a function of the **flow volume**
at ν = 35 mm²/s (0 = casing empty with hole Ø 4 mm)

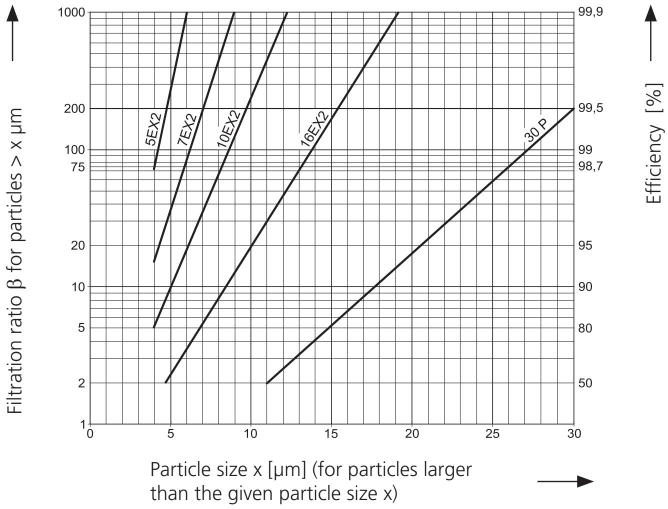


Pressure drop as a function of the
kinematic viscosity at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following ß-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part No.	Nominal return flow rate	Pressure dop see diagram **D**/curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connection A	Connection B_1 / B_2	Cracking pressure of CV [1]	Cracking pressure of PRV [2]	Symbol	Suction valve	Replacement filter element Part No.	Weight	Remarks
	l/min			g			bar	bar				kg	
1	2	3	4	5	6	7	8	9	10	11	12	13	14
E 158-168	180	**D1**/1	16EX2	53	G1¼	G1	0,5	2,5	4	•	V3.0924-08	3,0	4
E198-156	180	**D2**/1	10EX2	73	G1¼	G1	0,5	2,5	1		V3.0934-06	3,7	-
E 198-186	180	**D2**/1	10EX2	73	G1¼	G1	0,5	2,5	4	•	V3.0934-06	3,8	4
E 198-158	200	**D2**/2	16EX2	73	G1¼	G1	0,5	2,5	1		V3.0924-08	3,7	-
E 198-168	200	**D2**/2	16EX2	73	G1¼	G1	0,5	2,5	2		V3.0934-08	3,7	3
E 198-188	200	**D2**/2	16EX2	73	G1¼	G1	0,5	2,5	4	•	V3-0934-08	3,8	4
E 198-468	200	**D2**/2	16EX2	73	G1¼	G1	0,5	2,5	3	•	V3.0934-08	3,8	4+5
E 248-156	190	**D3**/1	10EX2	89	G1¼	G1	0,5	2,5	4	•	V3.0941-06	4,3	4
E 248-158	250	**D3**/2	16EX2	90	G1¼	G1	0,5	2,5	4	•	V3.0941-08	4,3	4
E 248-258	250	**D3**/2	16EX2	90	G1¼	G1	0,5	2,5	1		V3.0941-08	4,2	-

[1] Cracking pressure of check valve
[2] Cracking pressure of pressure relief valve
[3] With hole Ø 4 mm in the check valve for oil drain when opening the filter cover
[4] With emergency-suction valve and protection strainer (mesh size 125 µm)
[5] Suitable for horizontal assembly

All filters are delivered with three plugged clogging indicator connections M12 x 1,5. As clogging indicators on the return side (P_1) either manometers or electrical pressure switches can be used. The monitoring of the vacuum on the suction side (P_2) is additionally possible.
A second return port A_2 can be opened on request.

For the appropriate clogging indicators see catalogue sheet 60.20.

Remarks:

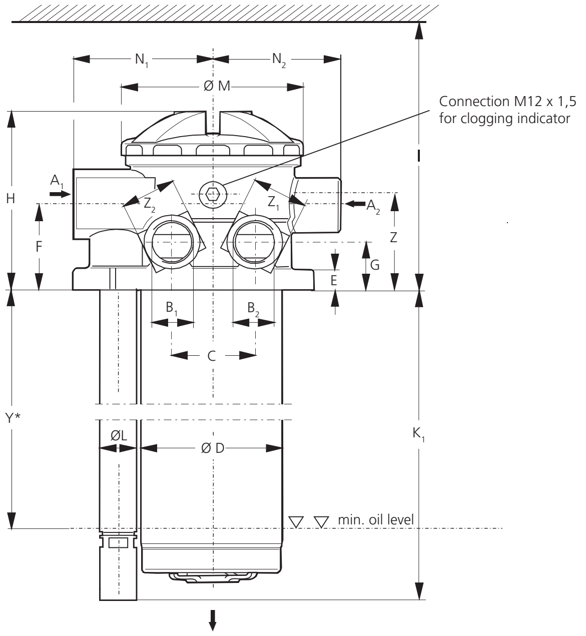
› The start of the red area respectively the switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the pressure relief valve (see Selection Chart, column 9).

› Clogging indicators are optional and always delivered detached from the filter.

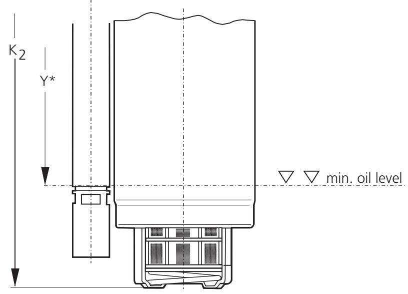
› The filters listed in this chart are standard filters. If modifications are required, e.g. with integrated suction valve (integrated into the pressure relief valve) to guarantee the emergency steering feature for vehicles with official road use, we kindly ask for your request.

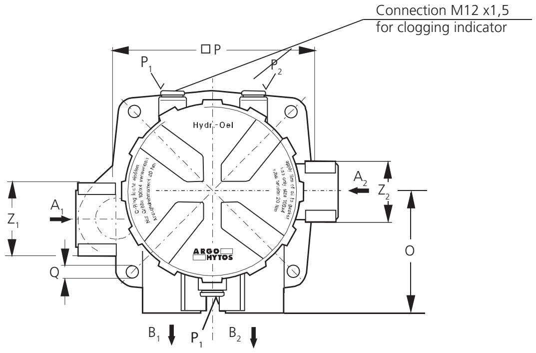
› For deaeration a bleed screw (for connection P_1) with Part No. SV 0112.15 is available.

Dimensions

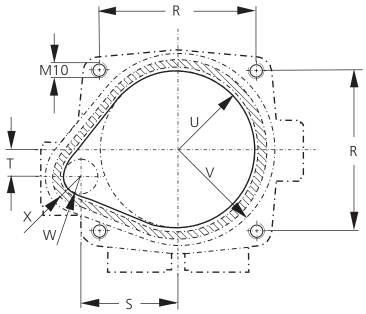


Versions with emergency-suction valve and protection strainer





Port sizes and mounting face



Measurements

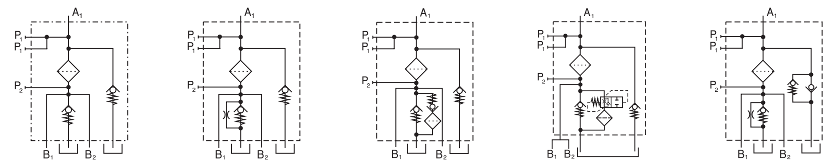
Type	A_1	A_2	$B_{1/2}$	C	D	E	F	G	H	I	K_1	K_2	L	M	N_1	N_2
E 158	G1¼	–	G1	56	100	11,5	61,5	30,5	130	430	238	250	28,5	126,5	97	81,5
E 198	G1¼	–	G1	56	100	11,5	61,5	30,5	130	530	338	354	28,5	126,5	97	81,5
E 248	G1¼	–	G1	56	100	11,5	61,5	30,5	130	600	404	417	28,5	126,5	97	81,5

Type	O	P	Q	R	S	T	U	V	W	X	Y*	Z	Z_1	Z_2		
E 158	85,5	141	11	116,5	68	19,5	51	64	14,5	27	185	68	AF 55	AF 41		
E 198	85,5	141	11	116,5	68	19,5	51	64	14,5	27	285	68	AF 55	AF 41		
E 248	85,5	141	11	116,5	68	19,5	51	64	14,5	27	350	68	AF 55	AF 41		

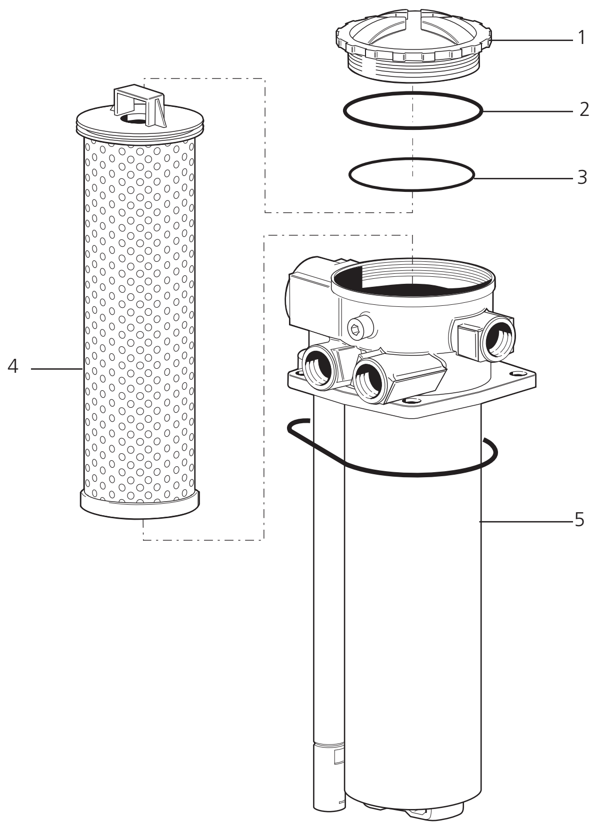
* Oil outlet resp. emergency suction has to be under all operating cond. below min. oil level (given by Y)

Symbols

1 2 3 4 5



Spare Parts



Pos.	Designation	Part No.
1	Screw-on cap	ES 074.0206
2	O-ring 100 x 4	N007.1004
3	O-ring 98 x 3	N007.0983
4	Filter element	see Chart / col. 11
5	O-ring 124 x 4,5	N007.1245

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ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return-Suction Filters

E 328 · E 498

Tank top mounting · Connection up to G1½ and SAE 2 · Nominal flow rate up to 600 l/min

M

Return Suction Filter E 498

Description

Application

For operation in units with hydrostatic drives, when the return flow is under all operating conditions higher than the oil flow of the feed pump.

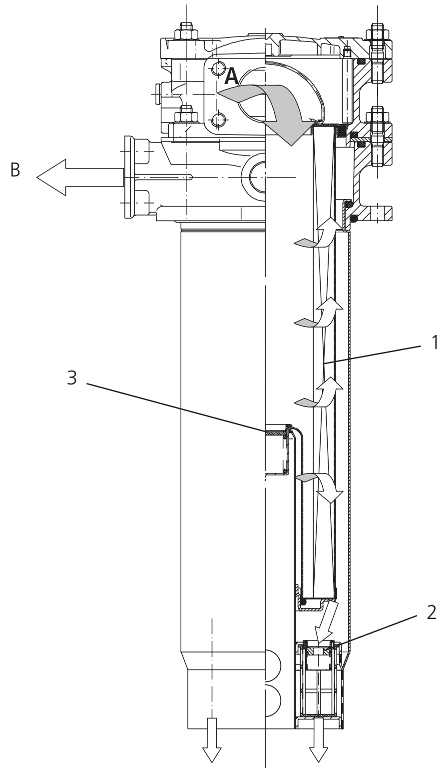
Performance features

Protection against wear:
By means of filter elements that, in fullflow filtration, meet even the highest demands regarding cleanliness classes.

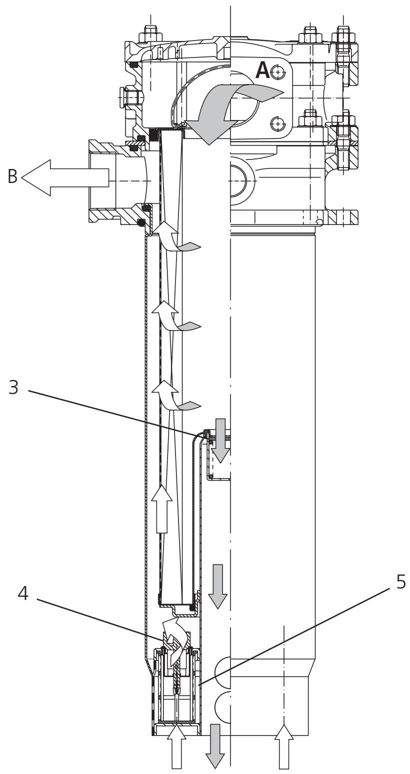
Suction filter function:
Because of the 100%-filtration of the suction flow, no dirt can get into the feed pump.

Return filter function:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Function (schematic):



Emergency-suction (schematic):



Functional characteristics

The hydraulic oil returning from the circuit (A) passes the filter element (1), is pressurized by three 0,5 bar check valves (2) and supplied to the feed pump (B). The surplus oil flows filtered over the integral check valve into the reservoir.
As the feed pump is always fed with pressurized oil, the risk of cavitation is minimized and full performance is available even during the critical cold start phase.
An integral pressure relief valve (3) prevents too high back pressure and protects the shaft seals against damages. As this valve leads the oil directly into the tank there is no direct connection between the return line (A) and the connection of the feed pump (B) (no bypass valve function).

Two emergency-suction valves (4) with 300 µm protection strainer (5) supply the feed pump in case of a short term of lack of oil.
During normal operation, a lack of oil may definitely not occur (refer to „Design“ section).

Start up / Deaeration

For units with emergency-suction valve and protection strainer the start up set E 328.1700 can be used to de-aerate the hydraulic system at first start up or at start up after repair; hereby the immediate supply of the feed pump with hydraulic oil is guaranteed.
For all other types, deaerating instructions published by the manufacturers of hydraulic drives must be observed.

Filter maintenance

By using a clogging indicator the correct moment for maintenance is indicated and guarantees therefore the optimum utilization of the filter elements.

Filter elements

Flow direction from centre to the outside. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Accessories

Electrical and optical clogging indicators are available.
Dimensions and technical data see catalogue sheet 60.20.

General

In machines with a hydrostatic drive and combined working hydraulic system, return-suction filters replace the suction or pressure filters previously required for the feed pump of the closed-loop hydrostatic drive circuit as well as the return filter for the open-loop working hydraulic circuit.
While each circuit operates independently with separate filters, the combi-nation of the two circuits via the return-suction filter causes interaction between the circuits. If the design criteria described below are taken into account, you can take full advantage of the benefits provided by the return-suction filter concept, thus making sure that your system performs reliably even under extreme operating conditions.

Required return flow in the system

In order to maintain a precharging pressure of approx. 0,5 bar at the intake of the feed pump, the return flow must exceed the suction flow under any operating conditions:

› Versions with hole (Ø 8 mm) in the pressurizing valve: at least 30 l/min of excess flow

Permitted feed pump flow rate

› at operating temperature (ν < 60 mm²/s, rpm = max): feed pump flow rate < 0,5 x rated return flow according to column 2 of selection table
› at cold start-up (ν < 1000 mm²/s, rpm=1000 min^{-1}): feed pump flow rate < 0,2 x rated return flow according to column 2 of selection table

Please contact us if your system operates with higher flow rates than stated above.

Flow velocity in the connecting lines

› Flow velocity in the return lines ≤ 4,5 m/s
› Flow velocity in the suction lines ≤ 1,5 m/s

Permitted pressure in the suction lines

At cold start up (ν < 1000 mm²/s, rpm = 1000 min^{-1}):
feed pump flow rate ≤ 0,2 x rated return flow. The pressure loss in the suction lines must not exceed 0,4 bar.

Backpressures in system return lines

If drain oil from the hydrostatic drive is routed across the filter in addition to the flow of the open-loop circuit, the following has to be observed in order to protect the shaft seals:

› permitted leakage oil pressure for a given viscosity and speed (manufacturer's specifications!)
› pressure loss caused by the leakage oil pipes
› pressure loss caused by the oil cooler used
› backpressure of the filter for a given flow rate or kinematic viscosity (refer to pressure loss diagrams)

Depending on the application, the use of a cooler bypass valve is recommended.
Generously sized drain oil pipes are also of advantage.

Filter fineness grades

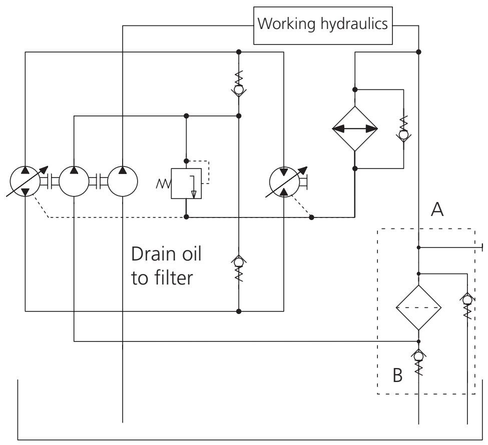
With the filter fineness grades available, the following oil cleanliness according to ISO 4406 can be achieved:

› 10EX2: 18/15/11 ... 14/11/7
› 16EX2: 20/17/12 ... 17/14/10

Even with the 16EX2 filter fineness grade, the requirements specified by manufacturers of hydrostatic drives are sometimes exceeded significantly.
If components requiring a still better oil purity are used, we recommend the 10EX2 filter fineness grade.

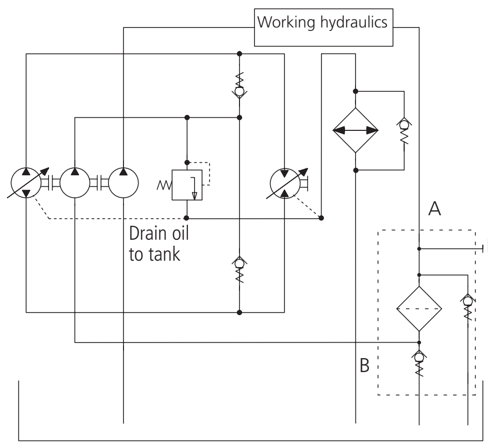
Suggested circuit layouts

A) The leakage oil of the hydrostatic drive is routed across the filter.



The entire dirt produced in the hydrostatic drive by abrasion is filtered out immediately and is thus not taken in by the pump of the open-loop circuit.
This circuit layout is always recommended if the return flow only slightly exceeds the suction flow, i.e. if there is a risk that the 0,5 bar precharging pressure cannot be maintained.

B) The drain oil of the hydrostatic drive is not routed across the filter but is discharged directly into the tank



This circuit layout has the advantage that drain oil pressures are comparatively low.

Nominal flow rate

Up to 600 l/min in return line (see Selection Chart, column 2)
Up to 300 l/min feed pump flow rate (see Layout)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the return lines ≤ 4,5 m/s
- flow velocity in the suction lines ≤ 1,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13 and SAE flange (3000 psi). Sizes see Selection Chart, column 6 (other port threads on request).
Please consider the connection size regarding max. flow volumes.

Filter fineness

10 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

Max. 10 bar

Materials

Screw-on cap:	Aluminium alloy
Filter head:	Aluminium alloy
Filter bowl:	Steel
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

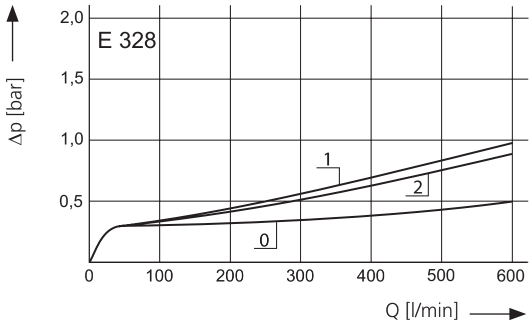
Fitting position

Up to 15° from the vertical, preferably vertical

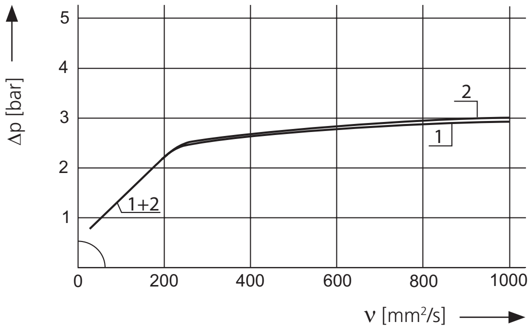
Even under unfavourable operating conditions (min. oil level, max. sloping) the oil outlet resp. emergency suction has to be below the oil level.

Δp-curves for complete filters in Selection Chart, column 3
(50 % of the nominal flow volume via connection B)

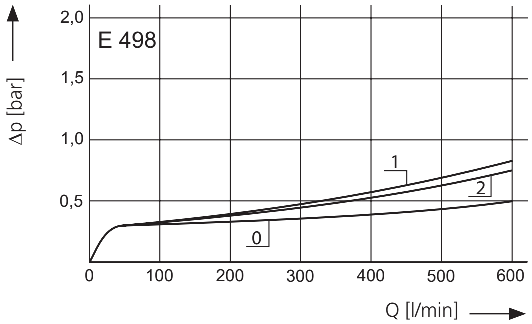
D1 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)



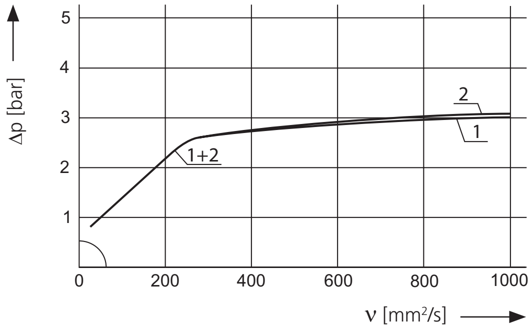
Pressure drop as a function of the
kinematic viscosity at nominal flow



D2 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)

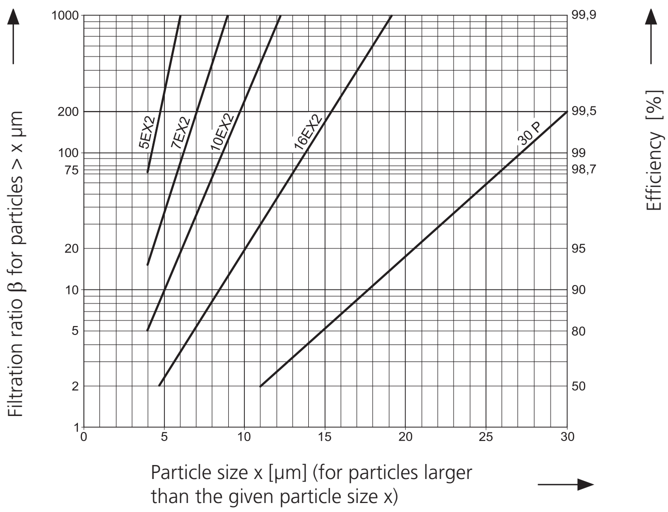


Pressure drop as a function of the
kinematic viscosity at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2 =	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2 =	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2 =	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2 =	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P =	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite propable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Part No.	Nominal return flow rate[1]	Pressure drop see diagram **D**/curve no.	FFilter fineness see Diagr. **DX**	Dirt-holding capacity	Connection A/B SAE (3000 psi)	Cracking pressure of CV [1]	Cracking pressure of PRV [2]	Symbol	Suction valve	Replacement filter element Part No.	Weight	Remarks
	l/min			g		bar	bar				kg	
1	2	3	4	5	6	7	8	9	10	11	12	13
E 328-156	360	**D1**/1	10EX2	140	G1½ / SAE2 + G1	0,5	2,5	1	•	V5.1240-06	8,6	[4+5]
E 328-158	470	**D1**/2	16EX2	140	G1½ / SAE2 + G1	0,5	2,5	1	•	V5.1240-07	8,6	[4+5]
E 498-156	480	**D2**/1	10EX2	200	G1½ / SAE2 + G1	0,5	2,5	1	•	V5.1260-06	10,4	[4+5]
E 498-158	600	**D2**/2	16EX2	200	G1½ / SAE2 + G1	0,5	2,5	1	•	V5.1260-07	10,4	[4+5]

[1] The individual flow rates must be matched to the connections
[2] Cracking pressure of check valve
[3] Cracking pressure of pressure relief valve
[4] With hole Ø 8 mm in the check valve for oil drain when opening the filter cover
[5] With emergency-suction valves and protection strainers (mesh size 300 µm)

All filters are delivered with plugged clogging indicator connections M12 x 1,5.
As clogging indicators on the return side ($P_{1)}$ either manometers or electrical pressure switches can be used.
The monitoring of the vacuum on the suction side (P_2) is additionally possible.

Order example: The filter E 328-156 has to be supplied with 2 x 4 connections (A_1 ... A_4, B_1 ... B_4).

Order description: **E 328-256**

Connections:

2 various options are available:

2 x 2 connections (A und A_4, B und B_4) - G1½ / SAE 2 + G1 (with locking screw) — 1
2 x 4 connections (A_1 ... A_4, B_1 ... B_4) - 2 x G1¼ / SAE 1½, G¾ + G1 — 2
(SAE 2 on request)

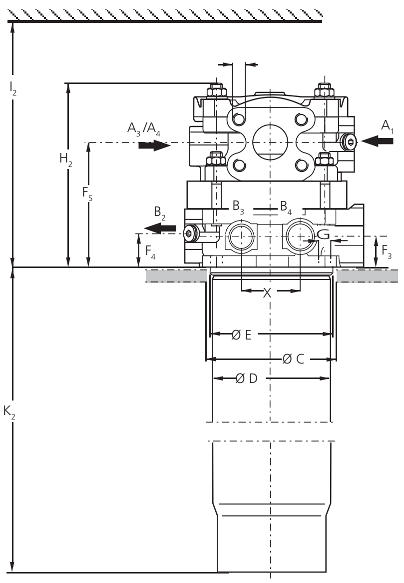
For the appropriate clogging indicator see catalogue sheet 60.20.

Remarks:

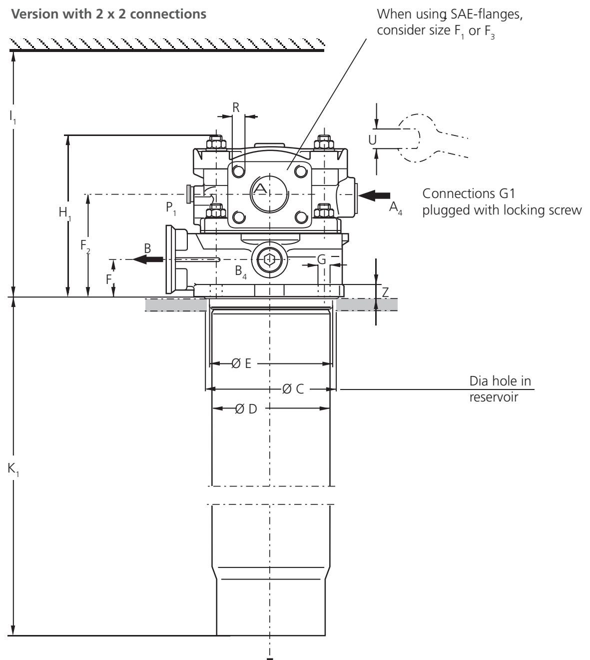
- The start of the red area respectively the switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the pressure relief valve (see Selection Chart, column 9).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. If modifications are required, we kindly ask for your request.
- For deaeration a bleed screw (for connecting P_1) with Part No. SV 0112.15 is available.

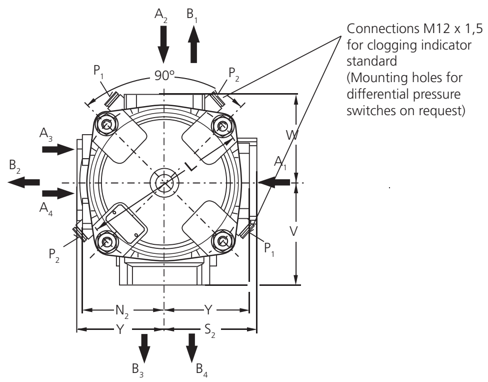
Dimensions

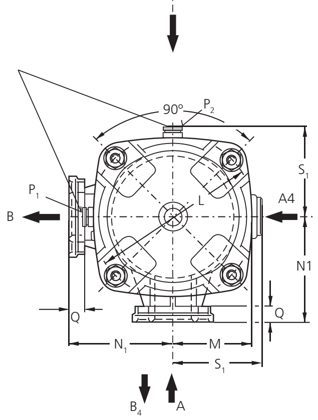
Version with 2 x 4 connections



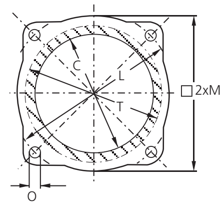
Version with 2 x 2 connections







Port sizes and mounting face
(O-ring area of support hatched)



Tank surface sealing with
O-ring N007.1375
(included in basic equipment)

Measurements

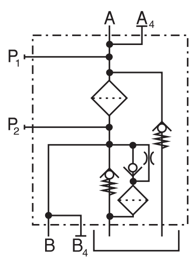
Type	A	B	C	D	E	F_1*	F_2*	F_3*	F_4	F_5	G	H_1	H_2	I_1	I_2
E 328	s. Selection Chart	s. Selection Chart	140,5	138	139,9	36	104,5	32	35	126	11,5	165	185	540	565
E 498	s. Selection Chart	s. Selection Chart	140,5	138	139,9	36	104,5	32	35	126	11,5	165	185	750	780

Type	K_1	K_2	L	M	N_1	N_2	O	Q	R	S_1	S_2	T	U	V	W	X	Y	Z	
E 328	425	403	185	86,5	116	89	M10	18	M12	99	109	160	17	106	102	70	98	12	
E 498	630	605	185	86,5	116	89	M10	18	M12	99	109	160	17	106	102	70	98	12	

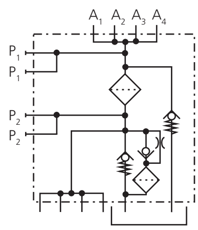
*For use of SAE-flanges see this measurement

Symbols

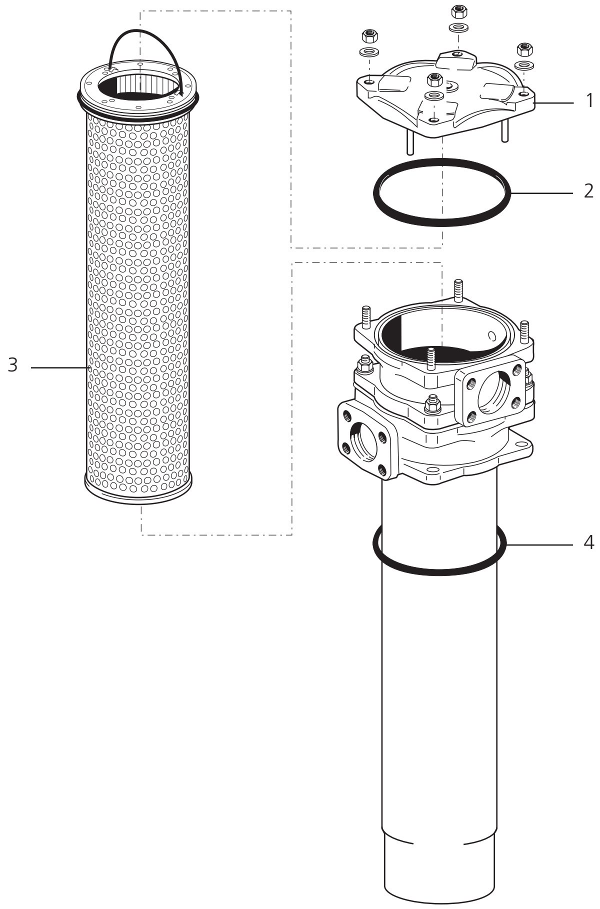
1



2



Spare Parts



Pos.	Designation	Part. No.
1	Cover	E 443.1225
2	O-ring 151,76 x 5,33	N007.1525
3	Filter element	see Chart / col. 10
4	O-ring 136,5 x 5,34	N007.1375

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Return-Suction Filters

E 598 · E 998

Tank top mounting · Connection up to G1½ and SAE 2½ · Nominal flow rate up to 850 l/min

M

Return Suction Filter E 998

Description

Application

For operation in units with hydrostatic drives, when the return flow is under all operating conditions higher than the oil flow of the boost pump.

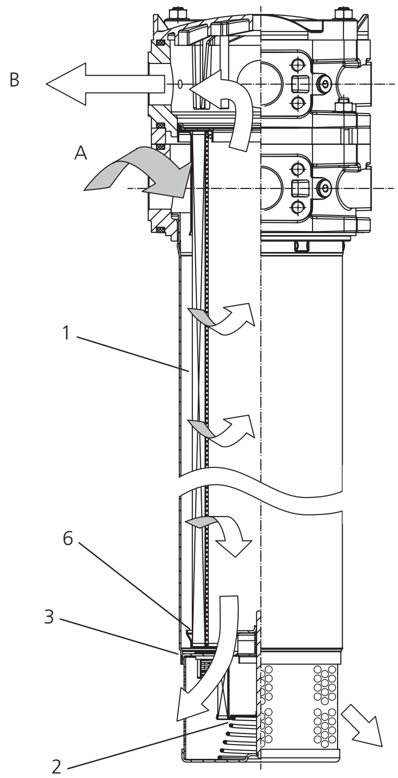
Performance features

Protection against wear:
By means of filter elements that, in fullflow filtration, meet even the highest demands regarding cleanliness classes.

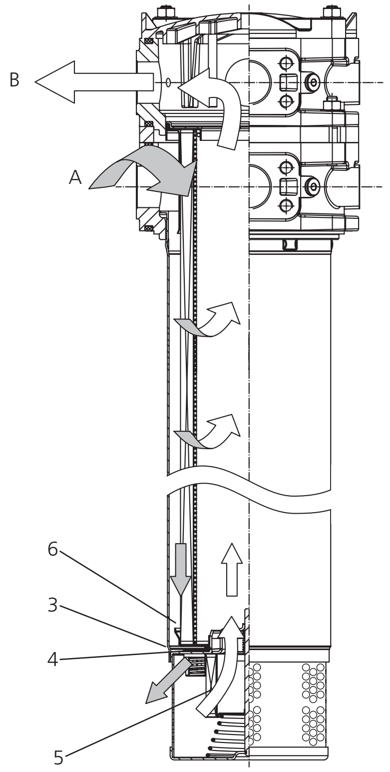
Suction filter function:
Because of the 100%-filtration of the suction flow, no dirt can get into the boost pump.

Return filter function:
By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

Function (schematic):



Emergency-suction (schematic):



Functional characteristics

The hydraulic oil returning from the circuit (A) passes the filter element (1), is pressurized by a 0,5 bar check valve (2) and supplied to the boost pump (B). The surplus oil flows filtered over the integral check valve into the reservoir.
As the boost pump is always fed with pressurized oil, the risk of cavitation is minimized and full performance is available even during the critical cold start phase.
Six integral pressure relief valves (3) prevent too high back pressure and protects the shaft seals against damages. As this valves lead the oil directly into the tank there is no direct connection between the return line (A) and the connection of the boost pump (B) (no bypass valve function).

The emergency-suction valve (4) with 200 µm protection strainer (5) supplies the boost pump in case of a short term of lack of oil. During normal operation, a lack of oil may definitely not occur (refer to „Design" section).

Start up / Deaeration

At first start up or at start up after repair, deaerating instructions published by the manufacturers of hydraulic drives must be observed.

Filter maintenance

By using a clogging indicator the correct moment for maintenance is indicated and guarantees therefore the optimum utilization of the filter elements.

Filter elements

Flow direction from outside to the centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

The dirt collection bowl (6) prevents dirt particles accumulated at the filter element from entering into the tank during maintenance.

Accessories

Electrical and optical clogging indicators are available.
Dimensions and technical data see catalogue sheet 60.20.

General

In machines with a hydrostatic drive and combined working hydraulic system, return-suction filters replace the suction or pressure filters previously required for the feed pump of the closed-loop hydrostatic drive circuit as well as the return filter for the open-loop working hydraulic circuit.
While each circuit operates independently with separate filters, the combi-nation of the two circuits via the return-suction filter causes interaction between the circuits. If the design criteria described below are taken into account, you can take full advantage of the benefits provided by the return-suction filter concept, thus making sure that your system performs reliably even under extreme operating conditions.

Required return flow in the system

- In order to maintain a precharging pressure of approx. 0,5 bar at the intake of the feed pump, the return flow must exceed the suction flow under any operating conditions:
- Versions with hole (Ø 8 mm) in the pressurizing valve: at least 30 l/min of excess flow

Permitted feed pump flow rate

- at operating temperature (ν < 60 mm²/s, rpm = max):
  feed pump flow rate < 0,5 x rated return flow according to column 2 of selection table
- at cold start-up (ν < 1000 mm²/s, rpm = 1.000 min^{-1}):
  feed pump flow rate < 0,2 x rated return flow according to column 2 of selection table.

Please contact us if your system operates with higher flow rates than stated above.

Flow velocity in the connecting lines

- Flow velocity in the return lines ≤ 4,5 m/s
- Flow velocity in the suction lines ≤ 1,5 m/s

Permitted pressure in the suction lines

At cold start up (ν < 1000 mm²/s, rpm = 1.000 min^{-1}):
feed pump flow rate ≤ 0,2 x rated return flow. The pressure loss in the suction lines must not exceed 0,4 bar.

Backpressures in system return lines

If drain oil from the hydrostatic drive is routed across the filter in addition to the flow of the open-loop circuit, the following has to be observed in order to protect the shaft seals:

- permitted leakage oil pressure for a given viscosity and speed (manufacturer's specifications!)
- pressure loss caused by the leakage oil pipes
- pressure loss caused by the oil cooler used
- backpressure of the filter for a given flow rate or kinematic viscosity (refer to pressure loss diagrams)

Depending on the application, the use of a cooler bypass valve is recommended.
Generously sized drain oil pipes are also of advantage.

Filter fineness grades

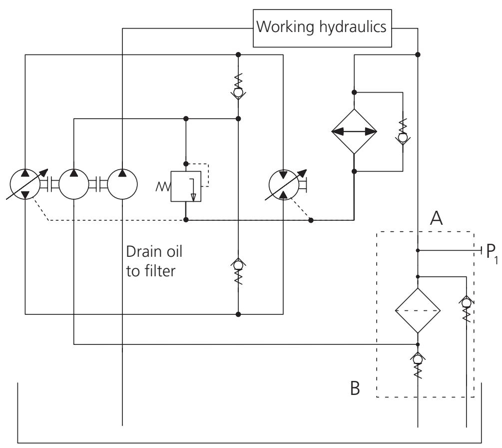
With the filter fineness grades available, the following oil cleanliness according to ISO 4406 can be achieved:

- 10EX2: 18/15/11 ... 14/11/7
- 16EX2: 20/17/12 ... 17/14/10

Even with the 16EX2 filter fineness grade, the requirements specified by manufacturers of hydrostatic drives are sometimes exceeded significantly.
If components requiring a still better oil purity are used, we recommend the 10EX2 filter fineness grade.

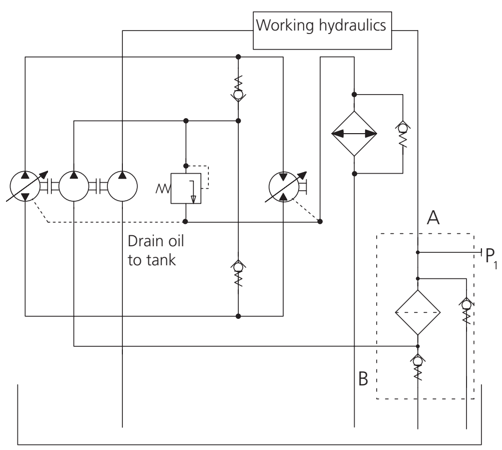
Suggested circuit layouts

A) The leakage oil of the hydrostatic drive is routed across the filter.



The entire dirt produced in the hydrostatic drive by abrasion is filtered out immediately and is thus not taken in by the pump of the open-loop circuit.
This circuit layout is always recommended if the return flow only slightly exceeds the suction flow, i.e. if there is a risk that the 0,5 bar precharging pressure cannot be maintained.

B) The drain oil of the hydrostatic drive is not routed across the filter but is discharged directly into the tank.



This circuit layout has the advantage that drain oil pressures are comparatively low.

Nominal flow rate

Up to 850 l/min in return line (see Selection Chart, column 2)
Up to 425 l/min feed pump flow rate (see Layout)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the return lines ≤ 4,5 m/s
- flow velocity in the suction lines ≤ 1,5 m/s

Connection

Threaded ports according to ISO 228 or DIN 13 and SAE flange (3.000 psi). Sizes see Selection Chart, column 6 (other port threads on request).
Please consider the connection size regarding max. flow volumes.

Filter fineness

10 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Operating pressure

Max. 10 bar

Materials

Screw-on cap:	Aluminium alloy
Filter head:	Aluminium alloy
Filter bowl:	Steel
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 – inorganic multi-layer microfibre web

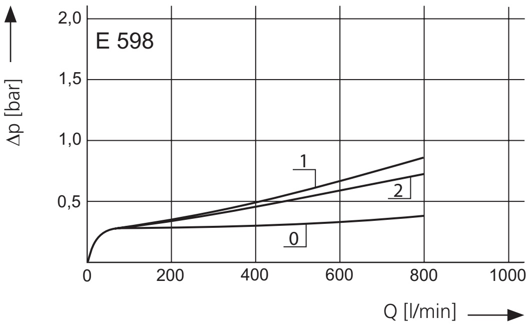
Fitting position

Up to 15° from the vertical, preferably vertical

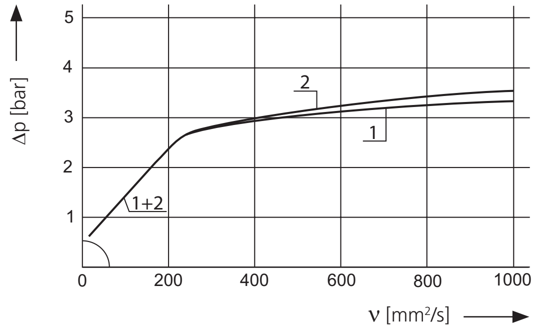
Even under unfavourable operating conditions (min. oil level, max. sloping) the oil outlet resp. emergency suction has to be below the oil level.

Δp-curves for complete filters in Selection Chart, column 3
(50 % of the nominal flow volume via connection B)

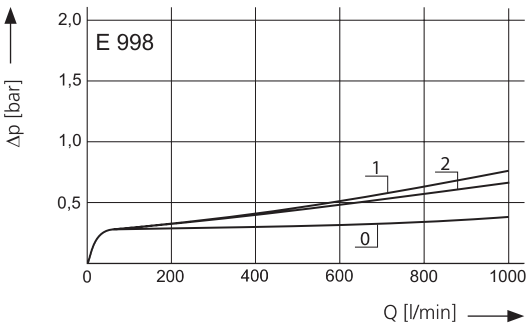
D1 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)



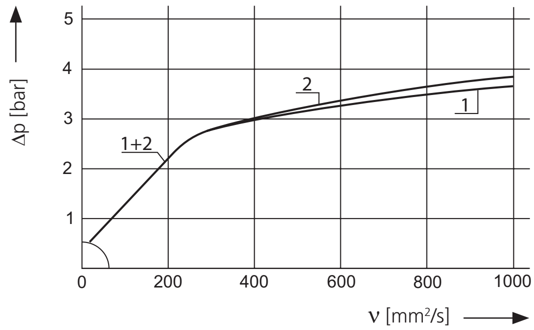
Pressure drop as a function of the
kinematic viscosity at nominal flow



D2 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)

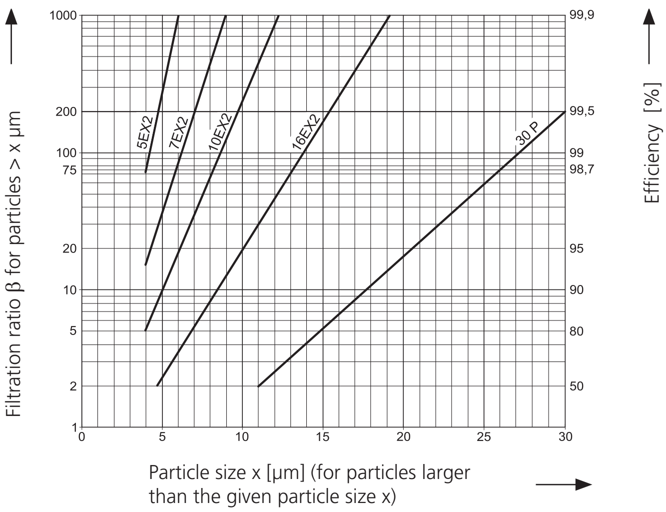


Pressure drop as a function of the
kinematic viscosity at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX 2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$ = 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$ = 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$ = 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$ = 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$ = 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite propable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part No.	Nominal return flow rate[1]	Pressure drop see diagram **D**/curve no.	Filter fineness see Diagr. **Dx**	Dirt-holding capacity	Connections SAE (3000 psi)	Cracking pressure of CV[2]	Cracking pressure of PRV[3]	Symbol	Suction valve	Replacement filter element Part No.	Weight	Remarks
	l/min			g		bar	bar				kg	
1	2	3	4	5	6	7	8	9	10	11	12	13
E 598-256	470	**D1**/1	10EX2	170	2 + 5 connections	0,5	2,5	1	•	V7.1440-06	11,5	4+5
E 598-257	630	**D1**/2	16EX2	180	2 + 5 connections	0,5	2,5	1	•	V7.1440-07	11,5	4+5
E 998-256	680	**D2**/1	10EX2	270	2 + 5 connections	0,5	2,5	1	•	V7.1460-06	13,8	4+5
E 998-257	850	**D2**/2	16EX2	280	2 + 5 connections	0,5	2,5	1	•	V7.1460-07	13,8	4+5

All filters are delivered with plugged clogging indicator connections M12 x 1,5.
As clogging indicators on the return side (P_1) either manometers or electrical pressure switches can be used.
The monitoring of the vacuum on the suction side (P_2) is additionally possible.

Order example: The filter E 598-256 has to be supplied with 5 + 5 connections (A_1 ... A_5, B_1 ... B_5).

Order description: **E 598-556**

Connections:
2 various options are available:

Option	A_1	A_2	A_3	A_4	A_5	B_1	B_2	B_3	B_4	B_5	
2 + 5 connections	SAE 2½	G1[6]	-	-	-	G1¼ / SAE 1½		G1	G¾	G1½ / SAE 2	2
5 + 5 connections	G1¼ / SAE 1½		G1	G¾	G1½ / SAE 2	G1¼ / SAE 1½		G1	G¾	G1½ / SAE 2	5

For the appropriate clogging indicator see catalogue sheet 60.20.

Remarks:

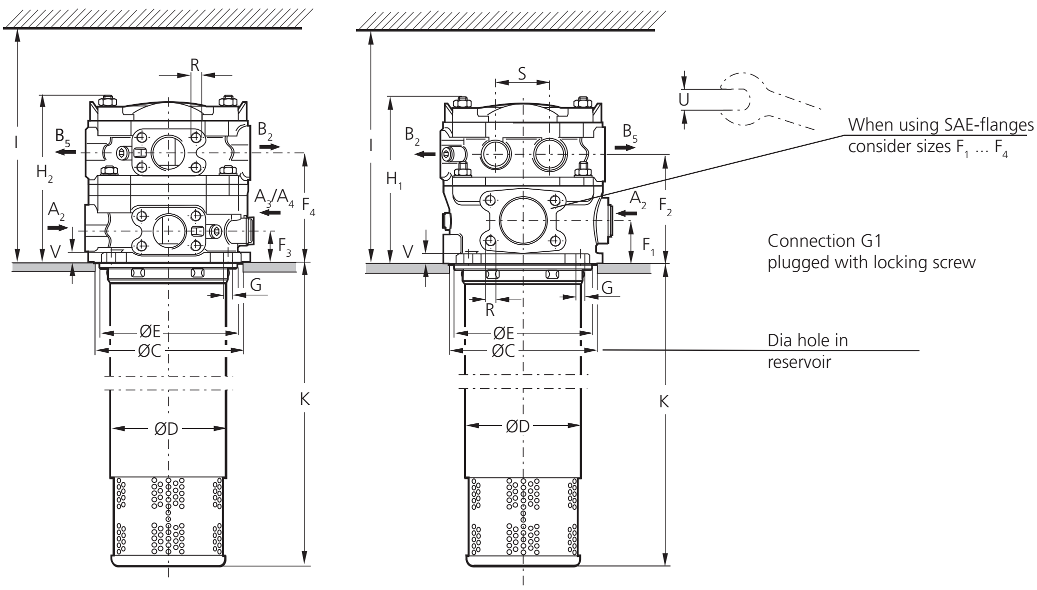
- The start of the red area of the manometer respectively the switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the pressure relief valve (see Selection Chart, column 8).
- Clogging indicators are optional and always delivered detached from the filter.
- The filters listed in this chart are standard filters. If modifications are required, we kindly ask for your request.
- For deaeration a bleed valve (for connection P1) with Part No. SV 0112.15 is available.

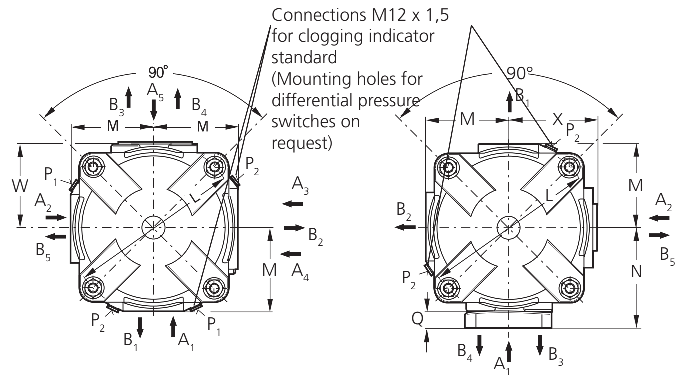
[1] The individual flow rates must be matched to the connections
[2] Cracking pressure of check valve
[3] Cracking pressure of pressure relief valve
[4] With hole Ø 8 mm in the check valve for oil drain when opening the filter cover
[5] With emergency-suction valve and protection strainer (mesh size 200 µm)
[6] Connection G1 (A_2) with locking screw

Dimensions

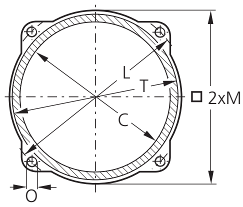
Version with 5 + 5 connections

Version with 2 + 5 connections





Port sizes and mounting surface
(O-ring area of support hatched)



Tank surface sealing with
O-ring N007.1806
(included in basic equipment)

Measurements

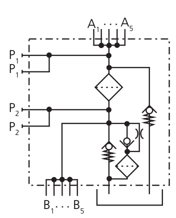
Type	A	B	C	D	E	F_1*	F_2*	F_3*	F_4*	G	H_1	H_2	I
E 598	s. Selec-	s. Selec-	180	152	179	55	141,5	41,5	139,5	11,5	216	214	660
E 998	tion	tion	180	152	179	55	141,5	41,5	139,5	11,5	216	214	860

Type	K	L	M	N	O	Q	R	S	T	U	V	W	X
E 598	406	220	106	125	M10	20	M12	70	200	AF 17	12	104	115
E 998	612	220	106	125	M10	20	M12	70	200	AF 17	12	104	115

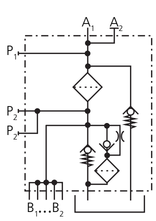
* For use of SAE-flanges see this measurement

Symbols

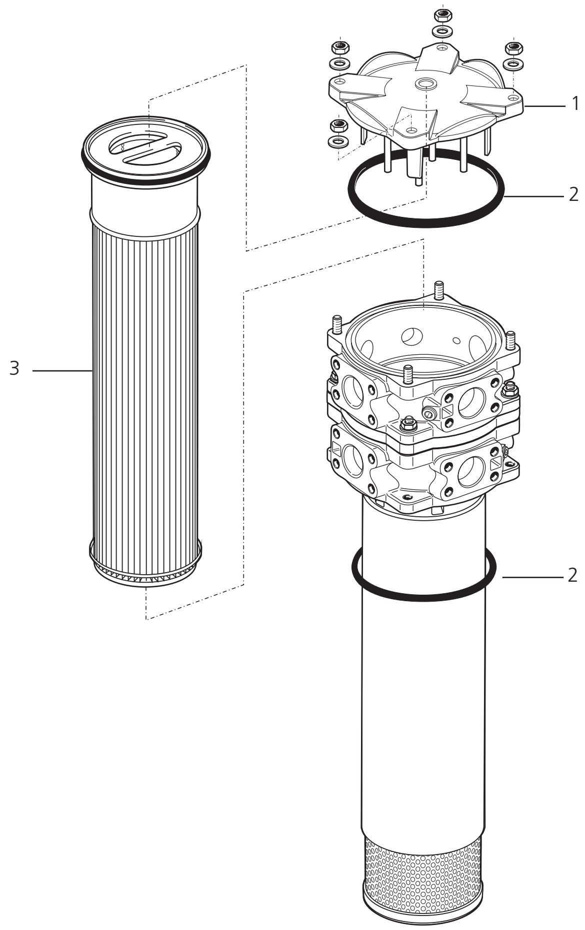
1



2



Spare Parts



Pos.	Designation	Part No.
1	Cover assy	E 998.1200
2	O-ring 180 x 6	N007.1806
3	Filter element	see Chart. / col. 10

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

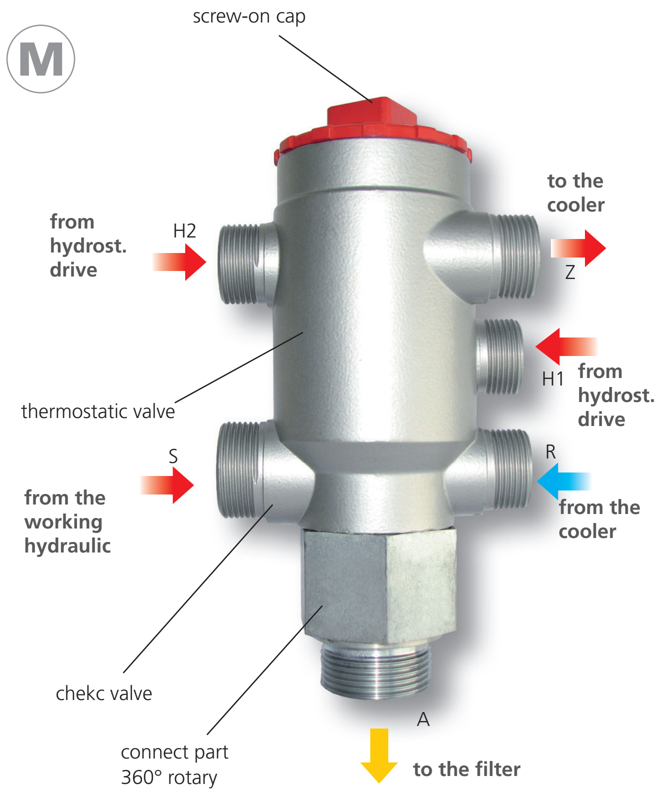
ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Multifunctional Unit

MFE 200

Filter mounting · Connection up G1¼ · Nominal flow rate up to 200 l/min



Description

Application

In particular for mobile machines with hydrostatic drives (closed circuit) and working hydraulic (open circuit), equipped with an oil cooler.

The multifunction unit can be used as collector with integrated check valve and thermostatic valve in combination with ARGO-HYTOS return-suction filters of the series E 084 / E 198 / E 498 / E 998.

Also separate drain oil-/cooler-circuits can be realised by the help of suitable return filters.

Function

Drain oil (H1, H2) from the hydrostatic drive (pump and drive motor) is routed either through a thermostatic cooler-by-pass directly to the filter (A), or at higher operating temperatures, through the cooler (Z ⟶ R), then the filter, and then into the tank.

Bypassing the cooler at cold start-up maintains the back pressure of the drain lines within the permitted range, and allowing the operating temperature of the hydraulic system to be reached more quickly.

The return oil from the working hydraulic (S) flows, optionally pressurised by a check valve, through the filter (A) and into the tank.

Characteristics

Nominal flow rate

Up to 200 l/min (total supply)
Splitting: H1+H2 = 80 l/min, S = 120 l/min

Connection

All connections for drain oil, return oil, cooler and filter are equipped with external threaded ports (direct installation of hose- / pipelines with union nut).

H1, H2, R, Z	M30 x 2 (DKOL* Ø 22)
S	M36 x 2 (DKOL* Ø 28)
A	G1¼ or G1 (see dimensions)

* acc. to ISO 8433-1 (24° cutting ring)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES or HETG, see info-sheet 00.20)

Temperature range

-20 °C … +100 °C (short intervals -30 °C … +120 °C)

Operating pressure

Max. 10 bar

Thermostatic valve

Operating range +50 °C … +70 °C

Check valve

Opening pressure 1 bar

Materials

Screw-on cap:	Polyester, GF-reinforced
Housing:	Aluminium alloy
Connection:	Steel
Seals:	NBR (FPM on request)
Thermostatic valve:	Polyamide, GF-reinforced

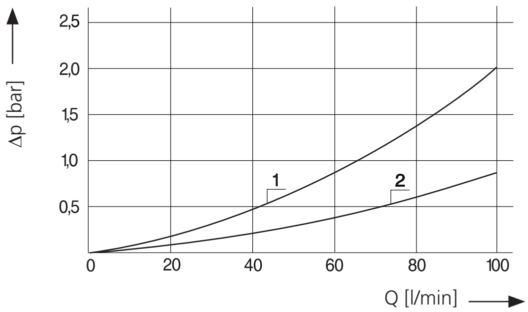
Mounting position

As desired, directly screwed into the filter

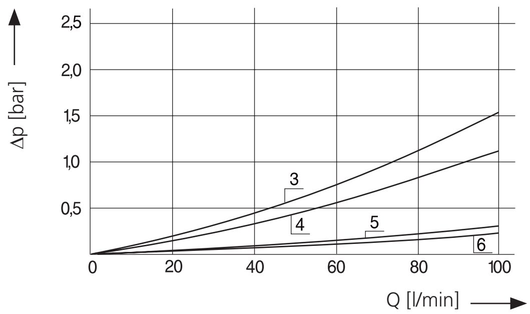
Diagrame

Δp-curves for complete multifunctional units MFE 200-01 (1, 2, 4 and 6) and MFE 200-02 (1, 2, 3 and 5)
Pressure measurement at connection H2 (supply through H1 und H2, S closed, Z hot wired after R)

D1 Pressure drop as a function of the **volume flow**
at ν= 40 mm²/s (1) and ν = 20 mm²/s (2)
Thermostatic valve open



Pressure drop as a function of the **volume flow**
at ν = 1000 mm²/s (3 and 4) and ν = 200 mm²/s (5 and 6)
Thermostatic valve closed



Note

The pressure drop produced by the pipelines, cooler and filter must be added to those of the multifunctional unit.

Order no.

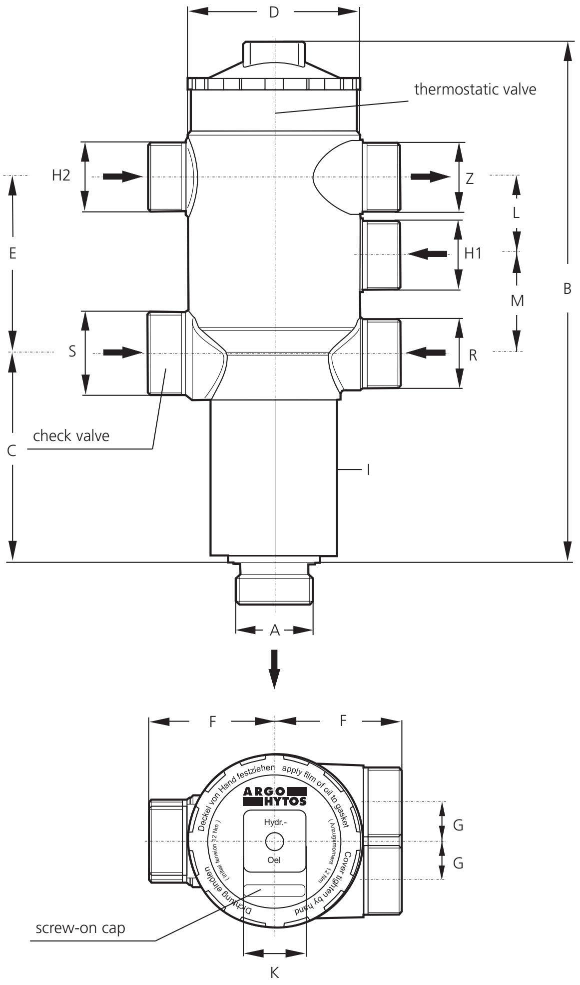
MFE 200-01
with G1¼ (connection A)

MFE 200-02
with G1 (connection A)

Note

Other types e.g. with alternative temperature range or without check valve, on request.

Dimensions

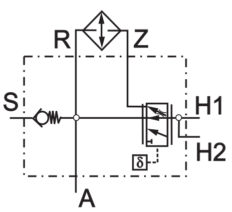


Measurements

Type	A	B	C	D	E	F	G	H_1	H_2	I	K	L	M	R	S	Z
MFE 200-01	G1¼	200	62	75	77	56	17	M30 x 2	M30 x 2	AF55	AF27	34	43	M30 x 2	M36 x 2	M30 x2
MFE 200-02	G1	230	92	75	77	56	17	M30 x 2	M30 x 2	AF55	AF27	34	43	M30 x 2	M36 x 2	M30 x2

Symbols

1



FNK 050 · FNK 100

Operating pressure up to 10 bar · Nominal flow rate up to 125 l/min · Cooling capacity up to 45 kW

Filter-Cooling-Unit FNK 050

Description

Application

Return-flow or off-line filter in hydraulic systems with water cooling.

General

High power densities in modern hydraulic systems require on one hand excellent cleanliness classes of the oil and on the other hand powerful cooling systems. The ARGO-HYTOS filter cooling unit FNK meets both demands on smallest installation space.

Performance features

Protection against wear:
By means of filter elements that meet even the highest demands regarding cleanliness classes.

Cooling:
Efficient discharge of large heat flow volumes by means of a powerful cooler.

Assembly and operating mode

Oil that has to be cooled is first cleaned over a fine filter element and then flows – through a check-valve and the high-performance tubular cooler – in cooled-down condition into the tank. Monitoring of filter clogging is effected by an optionally available differential pressure indicator. The integrated by-pass valve protects the filter element in cold start against increasing differential pressures.

Special design features

By combination of fine filter and cooler in one unit the necessary space is considerably reduced compared to conventional solutions. This also results in less assembling and piping.
The filter element is hooked to the cover and is pulled upwards when it has to be changed. Because of the cover design the filter element can be changed almost without losing any oil.
An integrated check valve prevents draining of oil from the tank when assembling the filter cooling unit below the oil level.
With maintenance work at the cooler it simply can be removed from the housing after removing the water connections.

For in-line mounting, standalone versions are available.
These are also suitable for retrofitting existing hydraulic systems.
If you are interested, please send us your request.

Filter elements

Flow direction from outside to centre.
The star-shaped pleating of the filter results in:

- large filter surfaces
- low pressure drop
- high dirt holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter.
The cooler is maintenance-free up to a large extent. Unfavourable water qualities (e.g. high water hardness and PH-value) and high temperatures may lead to sediments in the water pipes and/or the cooler surface. The water quality therefore has to be controlled regularly and if necessary improved.
For cleaning of the water pipes the cover of the cooler can be removed.
The maintenance instructions give detailed information on the maintenance of the cooler.

Materials

Filter housing FNK 050:	GG, Filter head: Steel
Filter housing FNK 100:	Aluminium alloy
Filter cover:	GG
Cooler cover:	GG
Cooler catalyst tube:	Steel
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 – inorganic multi-layer microfibre web

Accessories

Electrical and optical clogging indicators are available. Dimensions and technical data see catalogue sheet 60.30.

Characteristics

Operating pressure

Max. 10 bar

Cooling capacity

Up to 45 kW
(see Selection Chart, column 2)

Nominal flow rate

Up to 125 l/min
(see Selection Chart, column 3)

Filter fineness

5 µm (c)
β-values according to ISO 16889
(see Selection Chart, column 5 and Diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 6)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range of fluids

-30 °C … +100 °C (temporary -40 °C ... +120 °C)

Mounting position

Filter preferably vertical and/or cooler horizontal.

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 7.

In principle, the selection of the filter cooling unit requires the following steps:

1. Selection of the filter cooling unit according to the cooling performance chart

The displayed performance curves are based on:

› Ratio flow rate water/oil 2:1
› Water inlet temperature 25 °C
› Oil discharge temperature 50 °C
› Oil viscosity 35 mm²/s

For differing viscosity the correction factor A can be read off from the viscosity correction chart on the right hand.

With deviating oil discharge and/or oil entry temperatures and viscosities please calculate as shown in the following example:

Given

Heat to be discharged (AW)	=	17 kW
Oil flow (Q)	=	80 l/min
Oil discharge temperature ($T_{oil\ out}$)	=	45 °C
Water entry temperature ($T_{water\ in}$)	=	25 °C
Oil species	=	ISO VG 32

Procedure

Calculation of the temperature difference ΔT
Temperature difference ΔT (°C) = (AW x 34,1) / Q = 7,2

Calculation of the middle oil temperature
(2 x $T_{oil\ out}$ + ΔT) / 2 ≅ 49 °C

Calculation of the viscosity with middle oil temperature ν_{actual}
ν_{ist} from the oil manufacturer chart
for ISO VG 32 at 49 °C: 21 mm²/s

Viscosity factor „A"
From the viscosity correction chart „A" at 21 mm²/s: 0,88

Determination of the necessary cooling performance
Heat to be discharged
$AW_{eff.}$ = (AW x 27,5 x A) / ($T_{oil\ out}$ - $T_{water\ in}$)
= (17 x 27,5 x 0,88) / 20 = 20,6 kW

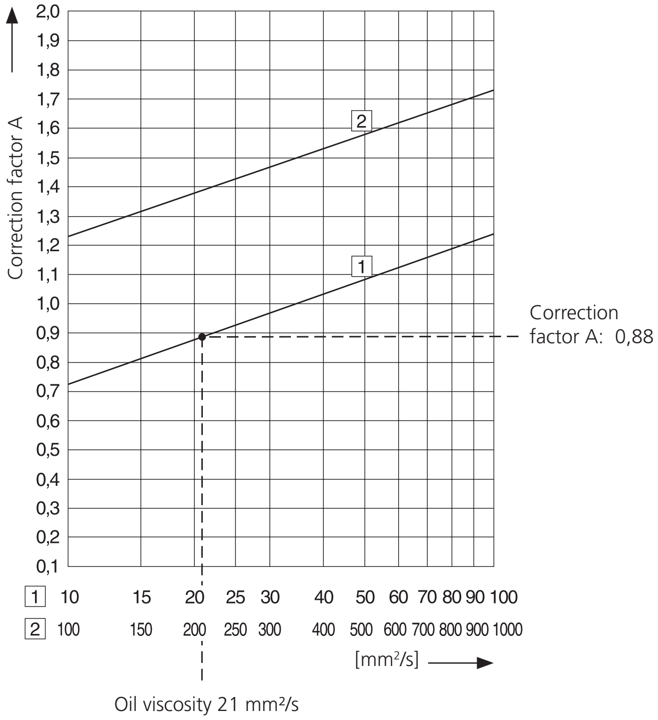
Selection of the filter cooling unit
The cooler performance chart shows
Q = 80 l/min and
$AW_{eff.}$ 20,6 kW the filter cooling unit: FNK 100-3153

2. Controlling pressure drop

To determine the pressure drop it is possible to interpolate within the given set of curves in the diagrams D1.1-D2.3 between 35 mm²/s and 300 mm²/s.
Finally it has to be checked, if there is enough operating pressure for the determined pressure drop of the filter cooling units.
In case the pressure drop of the selected filter cooling unit should be too high, on the basis of the pressure drop curves an adequate version has to be chosen. If necessary the cooling performance has to be verified again.
With volume flows over 100 l/min and operating viscosities from 200 mm²/s on (e.g. at cold start) the by-pass valve can be open with a partially contam-inated filter element (temporary poor filtration performance).

Viscosity correction chart

For determination of the correction factor "A" with oil viscosities differing from 35 mm²/s (in the displayed calculation example 21 mm²/s).

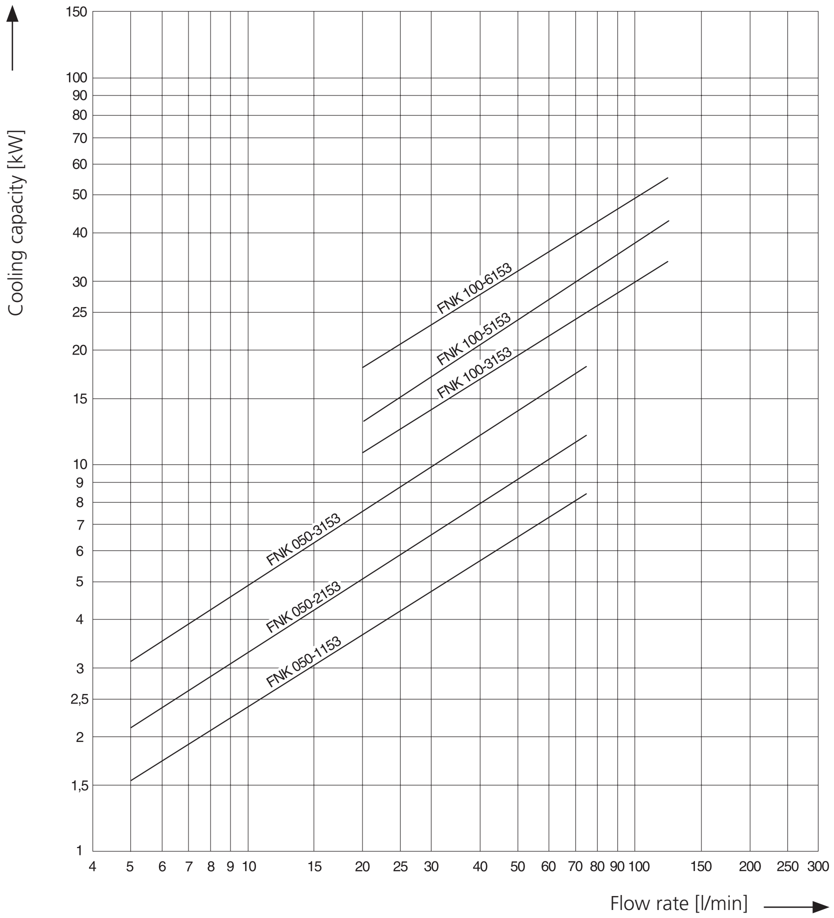


Characteristic curves cooling capacity

Dk The displayed performance curves are based on:

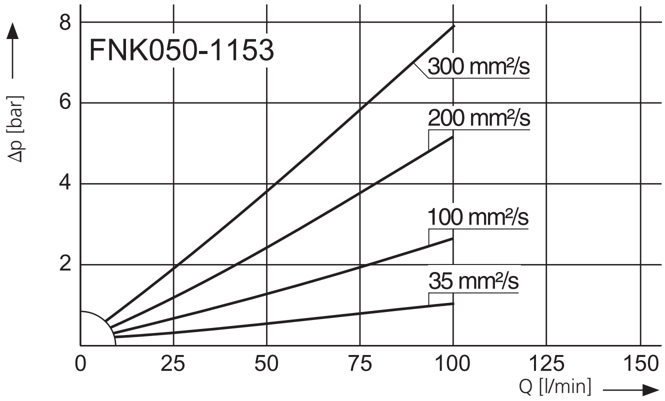
- › Water inlet temperature 25 °C
- › Oil discharge temperature 50 °C
- › Oil viscosity 35 mm²/s

For differing viscosities the correction factor A can be read off from the viscosity correction chart.

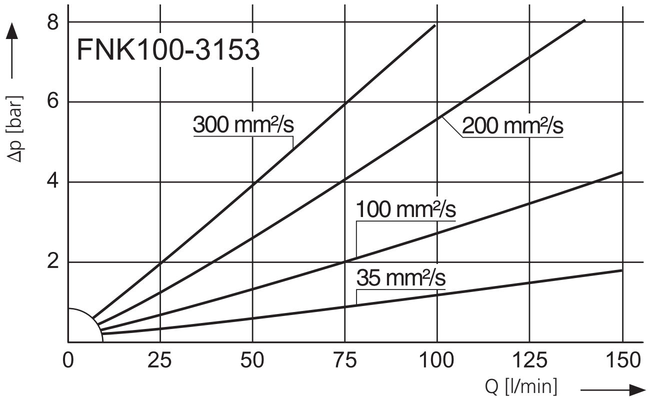


Δp-curves for complete filters in Selection Chart, column 4

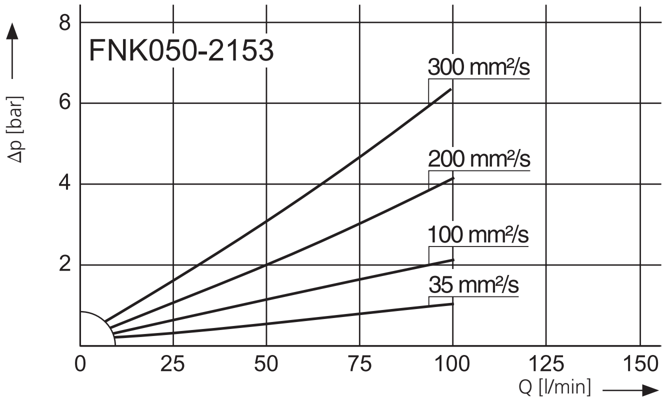
D1.1 Pressure drop as a function of the **flow volume**



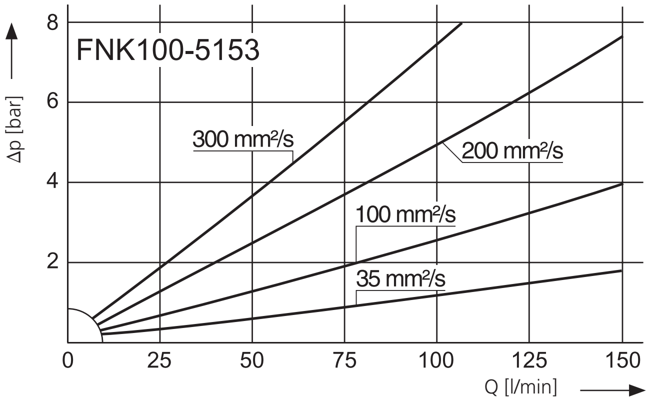
D2.1 Pressure drop as a function of the **flow volume**



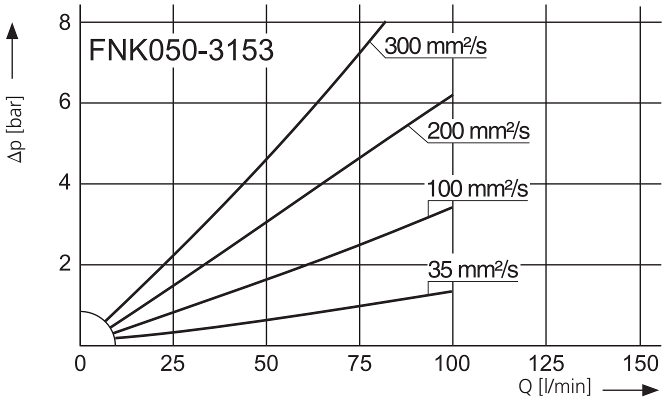
D1.2 Pressure drop as a function of the **flow volume**



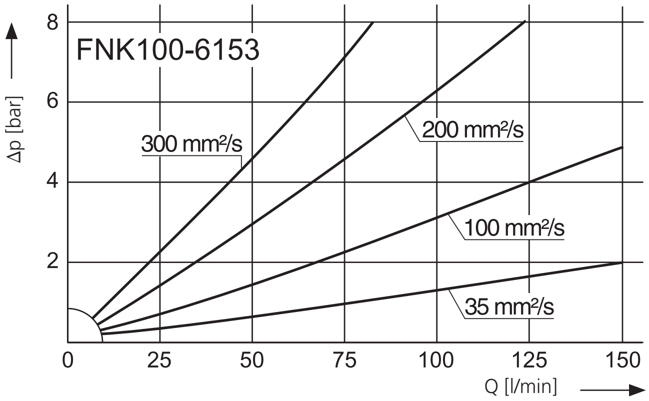
D2.2 Pressure drop as a function of the **flow volume**



D1.3 Pressure drop as a function of the **flow volume**



D2.3 Pressure drop as a function of the **flow volume**



In general the pressure drop increases in line with a larger cooler length.

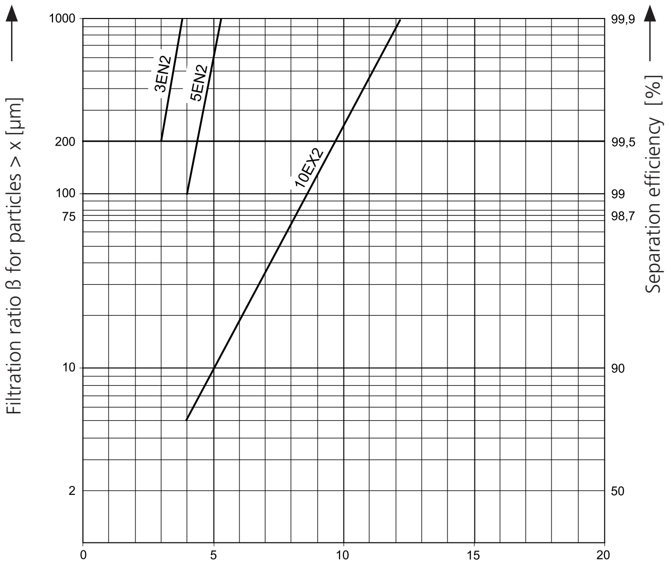
Exception:

Due to lower distances of the disk sheets in the cooler the pressure drop of the FNK 050-1153 is higher than the one of the larger FNK 050-2153.

Due to lower distances of the disk sheets in the cooler the pressure drop of the FNK 100-3153 is higher than the one of the larger FNK 100-5153.

Filter fineness curves in Selection Chart, column 5

Dx Filtration ratio ß as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



Particle size x [μm] (for particles larger than the given particle size x)

The abbreviations represent the following ß-values resp. finenesses:

For EXAPOR®MAX 2-Elements:

3EN2	=	$\overline{\beta}_{3\,(c)} = 200$	EXAPOR®MAX 2
5EN2	=	$\overline{\beta}_{5\,(c)} = 200$	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)} = 200$	EXAPOR®MAX 2

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

Part No.	Nominal cooling capacity	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **DX**	Dirt-holding capacity	Connection A_1 / A_2 inlet	Cracking pressure of by-pass	Replacement filter element Part No.	Clogging indicator	Weight	Cooler element
	kW	l/min			g		bar			kg	
1	2	3	4	5	6	7	8	9	10	11	12
FNK 050-1153	5	75	**D1.1**	5EN2	190	G 1¼	3,5	V7.1235-53	optional	23	FNK 050.1700
FNK 050-2153	8	75	**D1.2**	5EN2	190	G 1¼	3,5	V7.1235-53	optional	24	FNK 050.1710
FNK 050-3153	13	75	**D1.3**	5EN2	190	G 1¼	3,5	V7.1235-53	optional	26	FNK 050.1720
FNK 100-3153	33	125	**D2.1**	5EN2	150	G 1¼	3,5	V7.1235-53	optional	15	FNK 100.0703
FNK 100-5153	40	125	**D2.2**	5EN2	150	G 1¼	3,5	V7.1235-53	optional	16	FNK 100.0705
FNK 100-6153	45	125	**D2.3**	5EN2	150	G 1¼	3,5	V7.1235-53	optional	17	FNK 100.0706

Optical or electrical clogging indicators are available to monitor the clogging condition of the element. If the indicator should be already mounted use the abbreviation "M" behind the part number of the indicator. The printed order acknowledgements show both items separately. For optimal element utilization we recommend clogging indicators with a start-up pressure of 2,5 bar.

Order example: The filter FNK 100-3153 has to be supplied with electrical clogging indicator - response pressure 2,5 bar.

Order description: FNK 100-3153 / DG 041-32 M

Part No. (Basic unit) — FNK 100-3153

Clogging indicator — DG 041-32

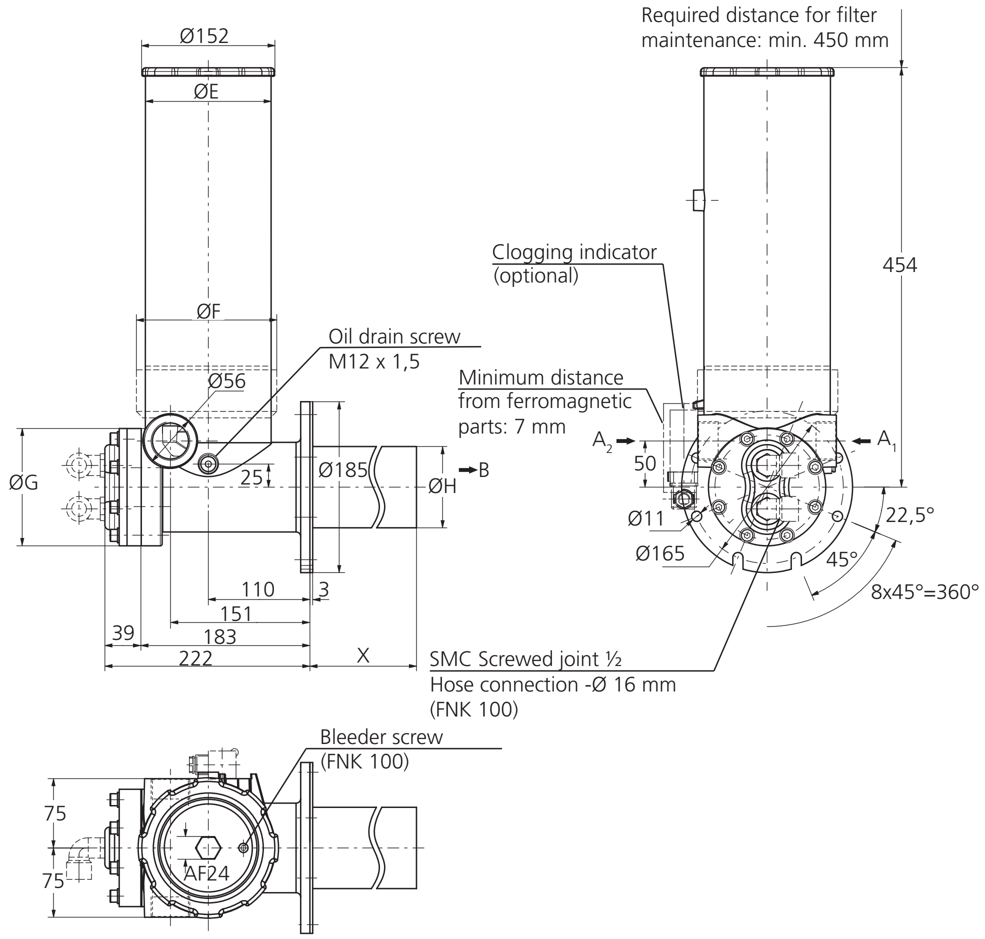
M — **Mounted**

For the appropriate clogging indicator see catalogue sheet 60.30.

Remarks:

- The response/switching pressure of the clogging indicator used must be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 10).
- The filter units listed in this chart are standard units. If modifications are required, we kindly ask for your request.

Dimensions

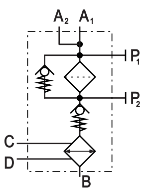


Measurements

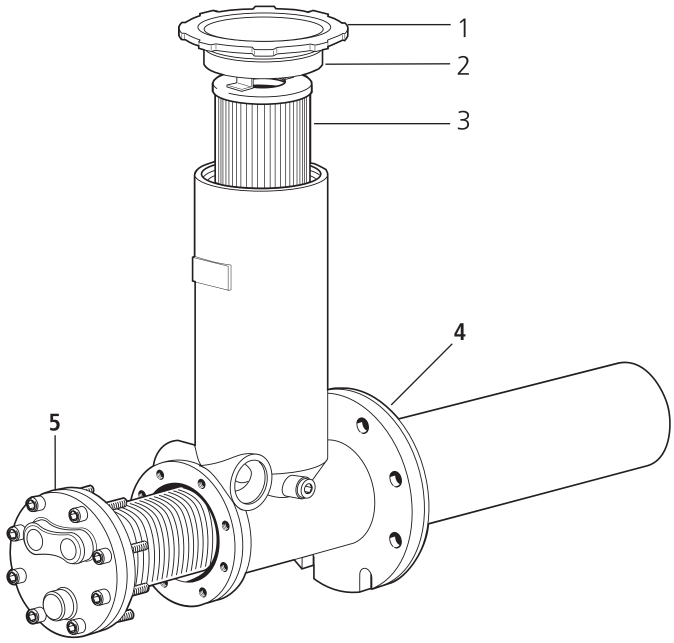
Type	A_1 / A_2	E	F	G	H	X				
FNK 050-1153	G 1¼	133	152	105	65	203				
FNK 050-2153	G 1¼	133	152	105	65	203				
FNK 050-3153	G 1¼	133	152	105	65	457				
FNK 100-3153	G 1¼	145	-	127	88	330				
FNK 100-5153	G 1¼	145	-	127	88	480				
FNK 100-6153	G 1¼	145	-	127	88	785				

Symbols

1



Spare Parts



Pos.	Designation	Part No.
1	Cover complete (with pos. 2)	FNK 100.1210
2	O-ring	N007.1245
3	Filter element	V7.1253-53 K27
4	Flat seal	FNK 100.0113
5	Cooler (with water supply cover and seal)	s. chart/column 12

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941 Verification of collapse/burst pressure rating
ISO 2942 Verification of fabrication integrity (Bubble Point Test)
ISO 2943 Verification of material compatibility with fluids
ISO 3968 Evaluation of pressure drop versus flow characteristics
ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

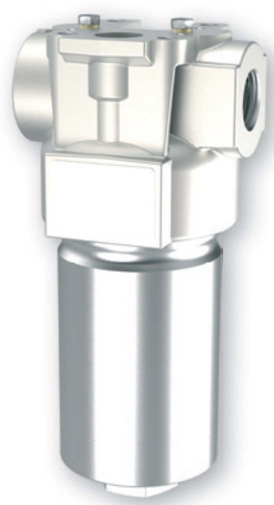
Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Illustrations may sometimes differ from the original. ARGO-HYTOS is not responsible for any unintentional mistake in this specification sheet.

Pressure Filters

D 042 · D 062

In-line mounting · Operating pressure up to 100 bar · Nominal flow rate up to 90 l/min



Pressure Filter D 042

Description

Application

In the pressure circuits of hydraulic and lubrication systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Aluminium alloy
Filter bowl:	Aluminium alloy
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin

Accessories

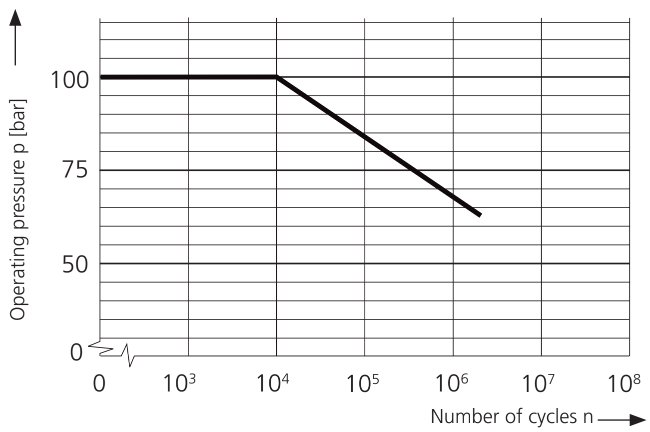
Electrical and/or optical clogging indicators are available - optionally with one or two switching points resp. temperature suppression.
Dimensions and technical data see catalogue sheet 60.30.

Operating pressure

0 ... 63 bar, min. 3 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 100 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 90 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid
- contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines:
  up to 100 bar ≤ 6 m/s

Filter fineness

5 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

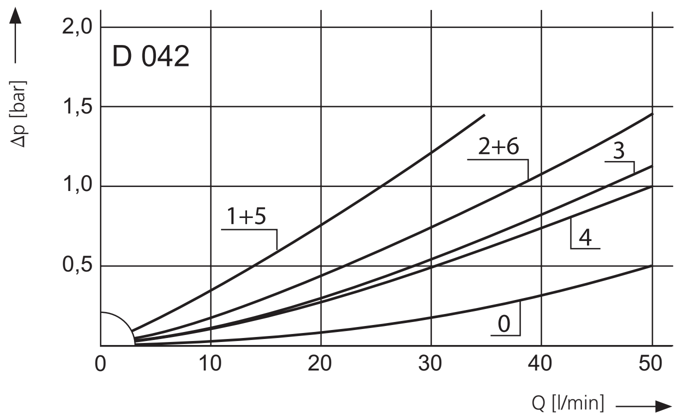
Preferably vertical, filter head on top

Connection

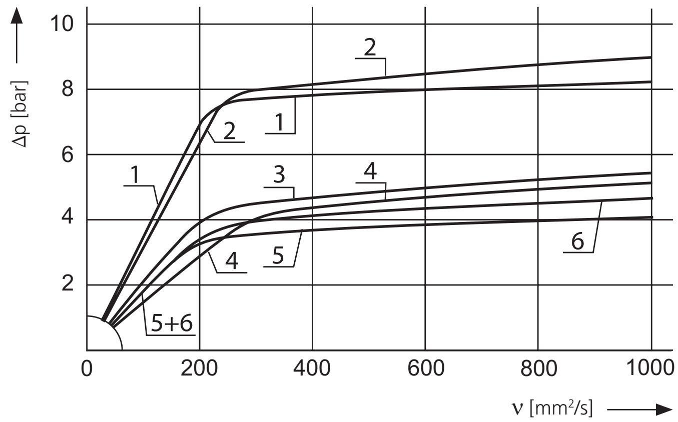
Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 (other port threads on request).

Δp-curves for complete filters in Selection Chart, column 3

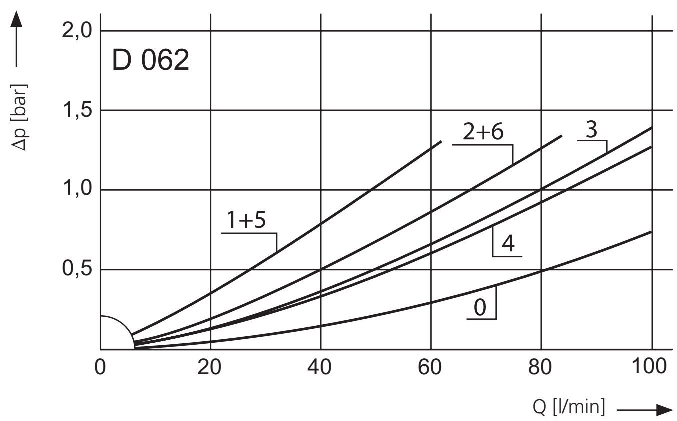
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



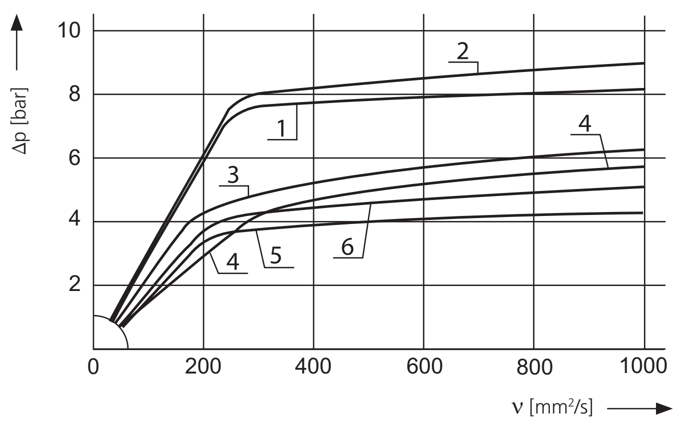
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

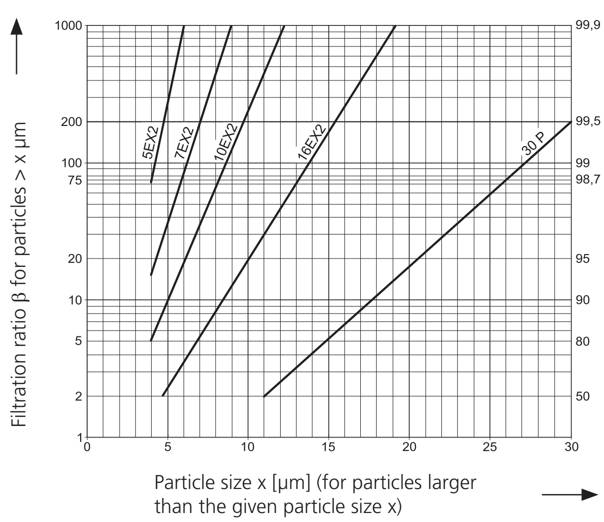


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **DX**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator	Remarks
	l/min			g		bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
D 042-153	16	**D1**/1	5EX2	4,9	G½	3,5	4	V3.0510-03	0,8	optional	-
D 042-156	27	**D1**/2	10EX2	6,8	G½	3,5	4	V3.0510-06	0,8	optional	-
D 042-158	44	**D1**/3	16EX2	6,9	G½	3,5	4	V3.0510-08	0,8	optional	-
D 042-151	40	**D1**/4	30P	3,6	G½	3,5	4	P3.0510-11*	0,8	optional	-
D 042-183	30	**D1**/5	5EX2	4,9	G½	7	4	V3.0510-03	0,8	optional	-
D 042-186	44	**D1**/6	10EX2	6,8	G½	7	4	V3.0510-06	0,8	optional	-
D 062-153	32	**D2**/1	5EX2	10	G½	3,5	4	V3.0520-03	1,1	optional	-
D 062-156	57	**D2**/2	10EX2	14	G¾	3,5	4	V3.0520-06	1,1	optional	-
D 062-158	90	**D2**/3	16EX2	15	G¾	3,5	4	V3.0520-08	1,1	optional	-
D 062-151	80	**D2**/4	30P	7,1	G¾	3,5	4	P3.0520-01*	1,1	optional	-
D 062-183	48	**D2**/5	5EX2	10	G½	7	4	V3.0520-03	1,1	optional	-
D 062-196	80	**D2**/6	10EX2	14	G¾	7	4	V3.0520-06	1,1	optional	-

* Paper media supported with metal gauze

Optical or electrical indicators are available to monitor the clogging condition of the element. If the indicator should be already mounted onto the filter head use the abbreviation "M" behind the part number of the indicator. The printed order acknowledgements show both items separately.

Order example: The filter D 042-156 has to be supplied with optical clogging indicator - response pressure 2,0 bar

Order description: **D 042-156 / DG 042-01 M**

Part No. (Basic unit) — D 042-156

Clogging indicator — DG 042-01

Mounted — M

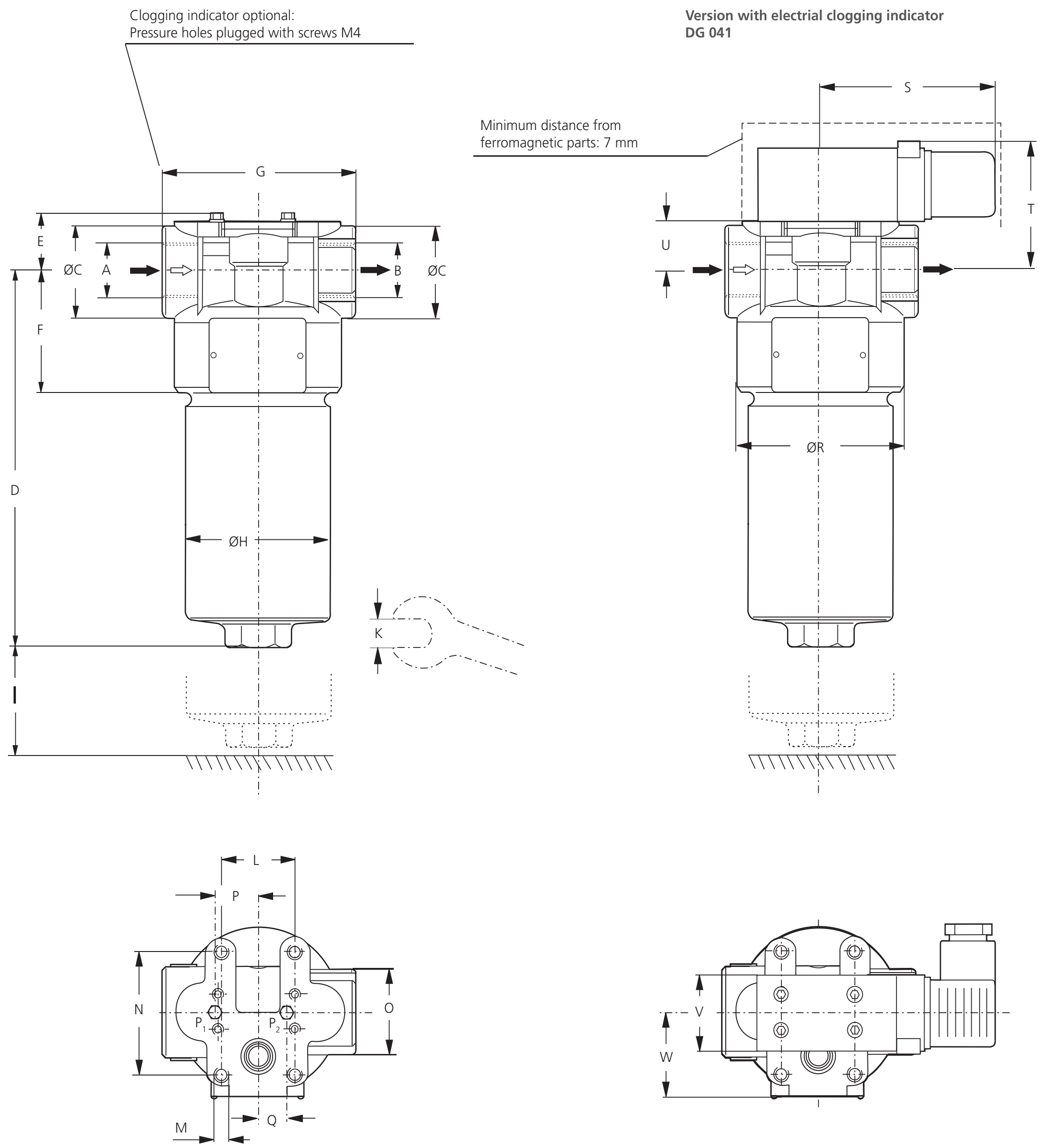
For the appropriate clogging indicators see catalogue sheet 60.30

Remarks:

› The switching pressure of the clogging indicator has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).

› The filters listed in this chart are standard filters. Other designs available on request.

Dimensions

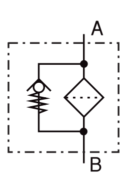


Measurements

Type	A/B	C	D	E	F	G	H	I	K	L	M Ø/depth	N	O	P	Q	R	S	T	U	V	W
D 042	G½	39	148	27	45,5	80	58,5	55	27	35	M6/8	44	AF36	19	15	70	81	55	23	30	35,5
D 062	G½, G¾	39	244	27	45,5	80	58,5	55	27	35	M6/8	44	AF36	19	15	70	81	55	23	30	35,5

Symbols

1



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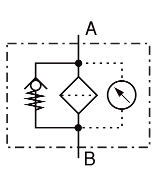

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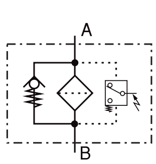

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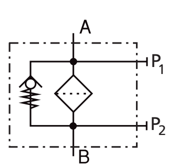

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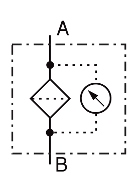

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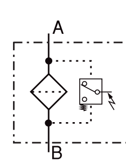
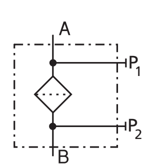
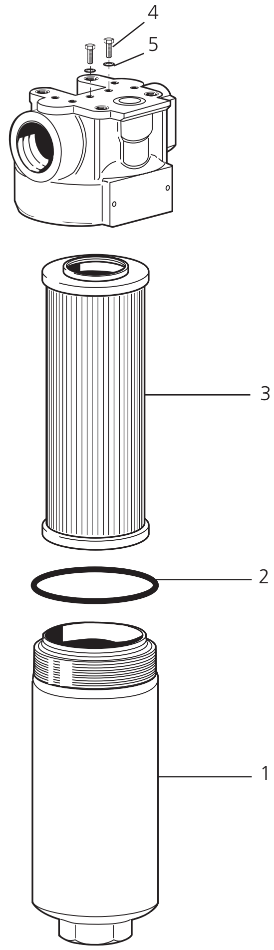


7



Spare Parts



Pos.	Designation	Part No.
1	Filter bowl D 042	D 044.0101
1	Filter bowl D 062	D 064.0101
2	O-ring 50 x 2	N007.0501
3	Filter element (with seal)	s. Chart / col. 9
4	Hexagonal head screw M4 x 8 DIN 933-8.8	11385800
5	Bonded Seal 4,1 x 7,2 x 1	12504600

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

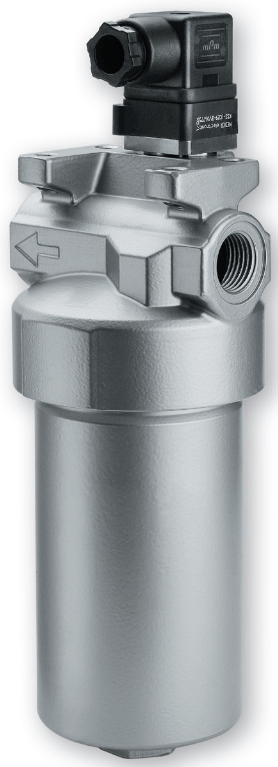
ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Pressure Filters

D 072 · D 112 · D 152

In-line mounting · Operating pressure up to 100 bar · Nominal flow rate up to 170 l/min



Pressure Filters D 072

Description

Application

In the pressure circuits of hydraulic and lubrication systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start conditi-on).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for main-tenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Aluminium alloy
Filter bowl:	Aluminium alloy
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2- inorganic multi-layer microfibre web

Accessories

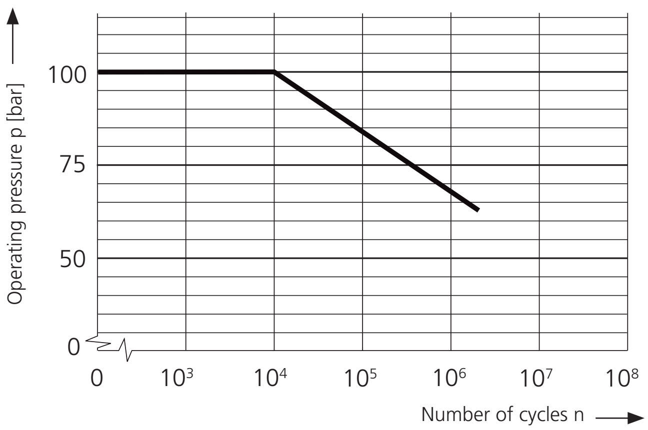
If an electrical indicator is used a transparent socket with LED for optical indication is also available with Part No. DG 041.1200.

Operating pressure

0 ... 63 bar, min. 3 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 100 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 170 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines: up to 100 bar ≤ 6 m/s

Filter fineness

5 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

Preferably vertical, filter head on top

Connection

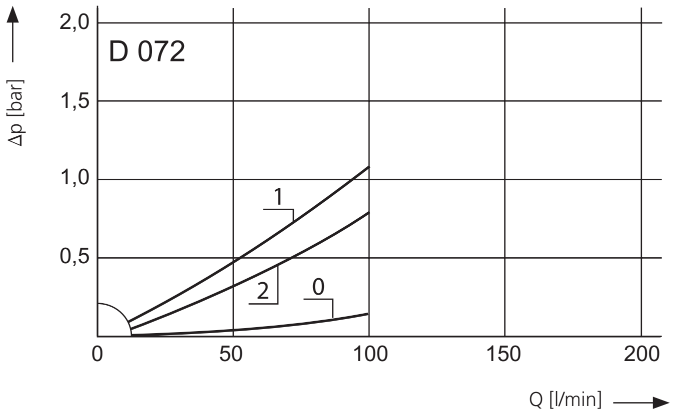
Threaded ports according to ISO 228 or DIN 13. Sizes see Selection Chart, column 6 (other port threads on request).

Electrical clogging indicator

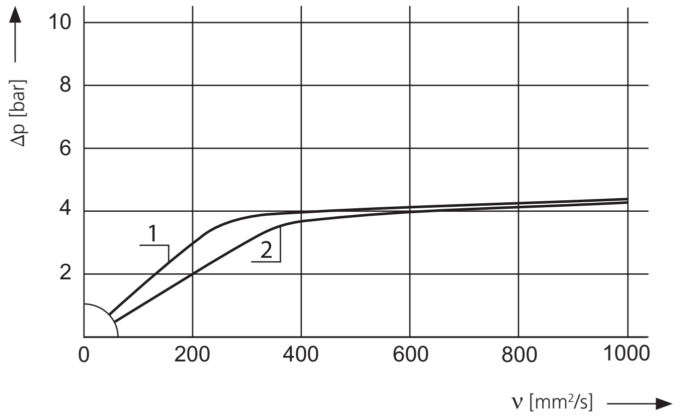
- Switching voltage: max. 120 V AC / 175 V DC
- Switching current: max. 0,17 A AC / 0,25 A DC
- Switching power: max. 3,5 VA AC / 5 W DC
- Type of contact: change over
- Electrical protection: IP 65 (with mounted and secured socket)

Δp-curves for complete filters in Selection Chart, column 3

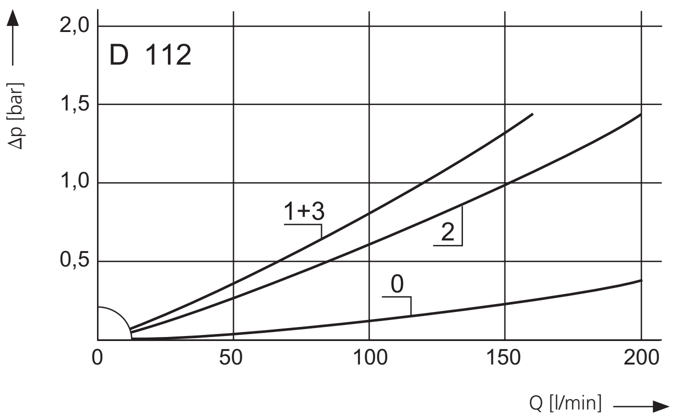
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



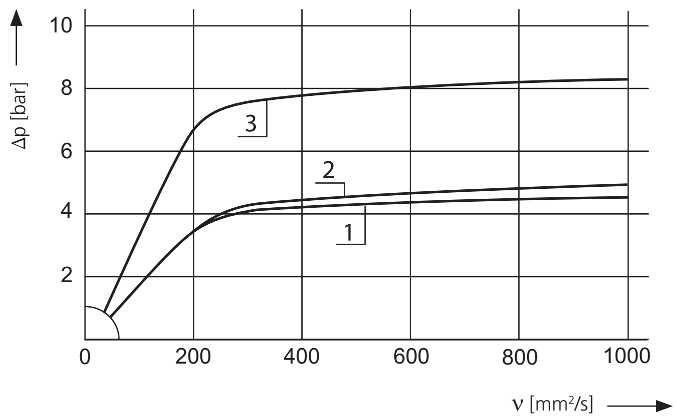
Pressure drop as a function of the **kinematic viscosity** at nominal flow



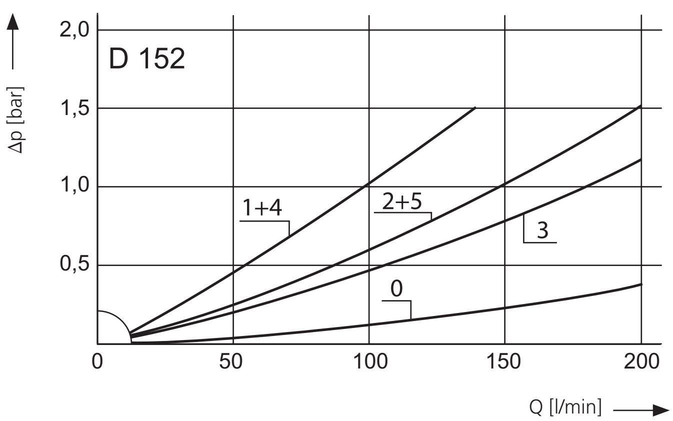
D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



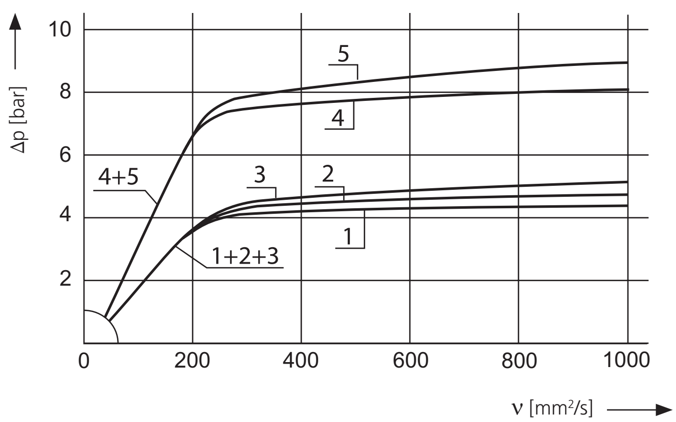
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D3 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

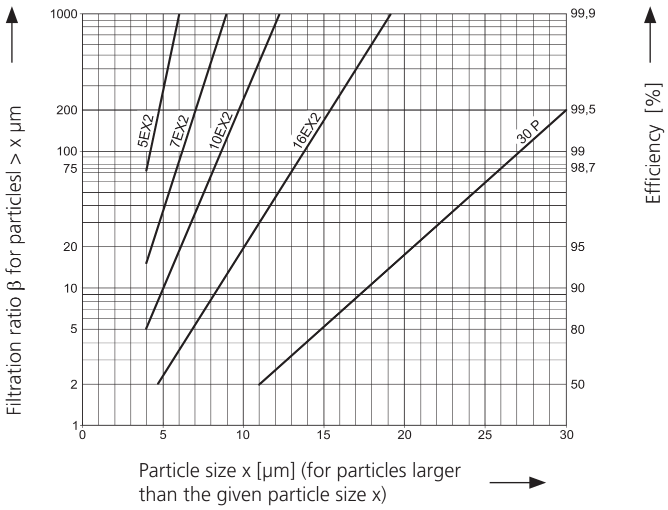


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\bar{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\beta_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\beta_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\beta_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

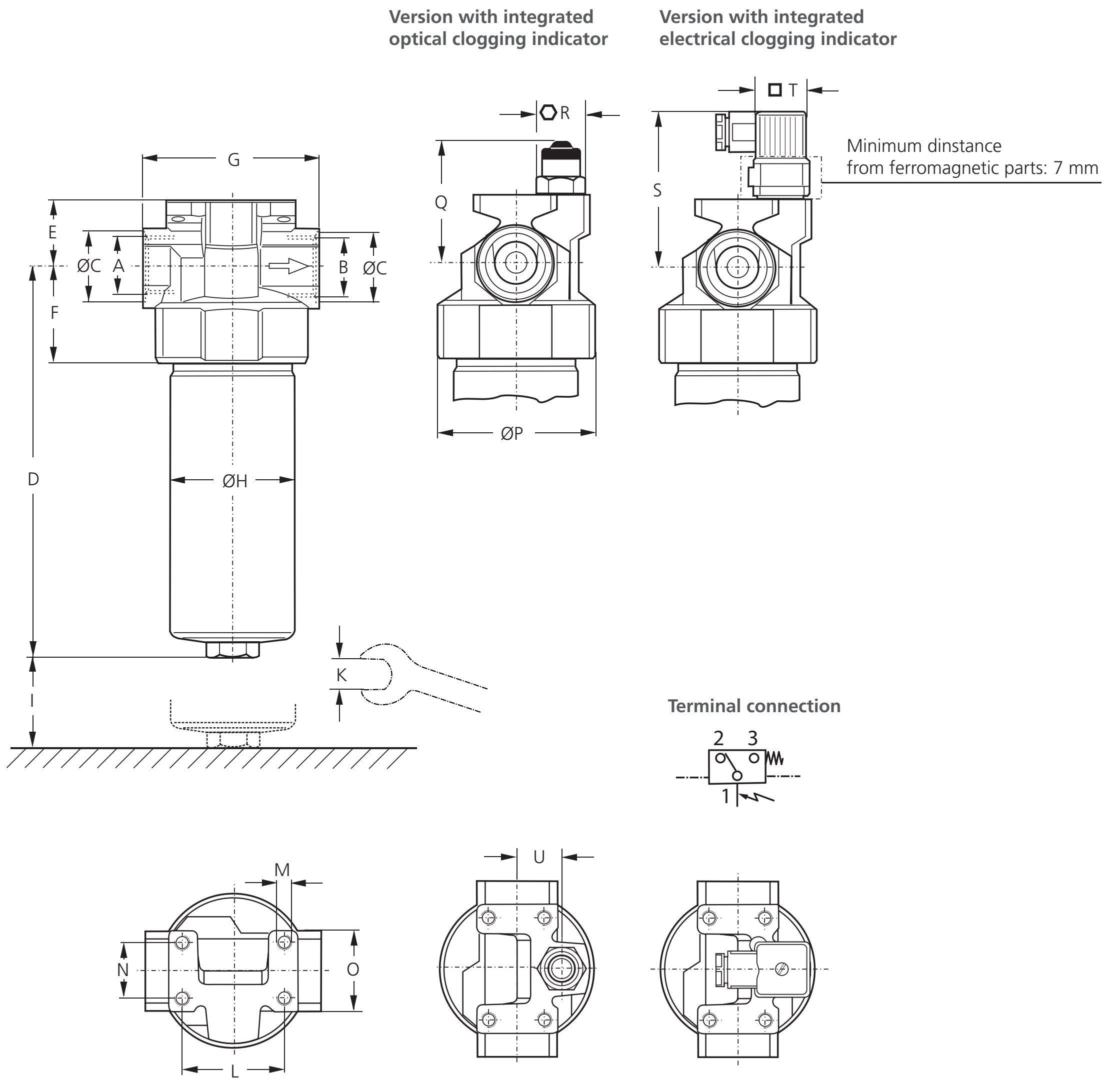
Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator cracking pressure ( )		Remarks
	l/min			g		bar			kg		bar	
1	2	3	4	5	6	7	8	9	10	11		12
D 072-156	48	**D1**/1	10EX2	12	G½	3,5	1	V3.0613-06	1,1	-		-
D 072-176	48	**D1**/1	10EX2	12	G½	3,5	2	V3.0613-06	1,2	optical	(2)	-
D 072-166	48	**D1**/1	10EX2	12	G½	3,5	3	V3.0613-06	1,2	electrical	(2)	change-over
D 072-158	48	**D1**/2	16EX2	12	G½	3,5	1	V3.0613-08	1,1	-		-
D 072-178	48	**D1**/2	16EX2	12	G½	3,5	2	V3.0613-08	1,2	optical	(2)	-
D 072-168	48	**D1**/2	16EX2	12	G½	3,5	3	V3.0613-08	1,2	electrical	(2)	change-over
D 112-156	70	**D2**/1	10EX2	17	G¾	3,5	1	V3.0617-06	1,4	-		-
D 112-176	70	**D2**/1	10EX2	17	G¾	3,5	2	V3.0617-06	1,5	optical	(2)	-
D 112-166	70	**D2**/1	10EX2	17	G¾	3,5	3	V3.0617-06	1,5	electrical	(2)	change-over
D 112-158	105	**D2**/2	16EX2	17	G1	3,5	1	V3.0617-08	1,4	-		-
D 112-178	105	**D2**/2	16EX2	17	G1	3,5	2	V3.0617-08	1,5	optical	(2)	-
D 112-168	105	**D2**/2	16EX2	17	G1	3,5	3	V3.0617-08	1,5	electrical	(2)	change-over
D 112-186	130	**D2**/3	10EX2	17	G1	7,0	1	V3.0617-06	1,4	-		-
D 112-189	130	**D2**/3	10EX2	17	G1	7,0	2	V3.0617-06	1,5	optical	(5)	-
D 112-196	130	**D2**/3	10EX2	17	G1	7,0	3	V3.0617-06	1,5	electrical	(5)	change-over
D 152-153	60	**D3**/1	5EX2	17	G¾	3,5	1	V3.0623-03	1,7	-		-
D 152-173	60	**D3**/1	5EX2	17	G¾	3,5	2	V3.0623-03	1,8	optical	(2)	-
D 152-163	60	**D3**/1	5EX2	17	G¾	3,5	3	V3.0623-03	1,8	electrical	(2)	change-over
D 152-156	100	**D3**/2	10EX2	23	G¾	3,5	1	V3.0623-06	1,7	-		-
D 152-176	100	**D3**/2	10EX2	23	G¾	3,5	2	V3.0623-06	1,8	optical	(2)	-
D 152-166	100	**D3**/2	10EX2	23	G¾	3,5	3	V3.0623-06	1,8	electrical	(2)	change-over
D 152-158	135	**D3**/3	16EX2	25	G1	3,5	1	V3.0623-08	1,7	-		-
D 152-178	135	**D3**/3	16EX2	25	G1	3,5	2	V3.0623-08	1,8	optical	(2)	-
D 152-168	135	**D3**/3	16EX2	25	G1	3,5	3	V3.0623-08	1,8	electrical	(2)	change-over
D 152-183	110	**D3**/4	5EX2	17	G1	7,0	1	V3.0623-03	1,7	-		-
D 152-185	110	**D3**/4	5EX2	17	G1	7,0	2	V3.0623-03	1,8	optical	(5)	-
D 152-193	110	**D3**/4	5EX2	17	G1	7,0	3	V3.0623-03	1,8	electrical	(5)	change-over
D 152-186	170	**D3**/5	10EX2	23	G1	7,0	1	V3.0623-06	1,7	-		-
D 152-189	170	**D3**/5	10EX2	23	G1	7,0	2	V3.0623-06	1,8	optical	(5)	-
D 152-196	170	**D3**/5	10EX2	23	G1	7,0	3	V3.0623-06	1,8	electrical	(5)	change-over

Remarks:

› The filters listed in this chart are standard filters. Other designs available on request.

› If an electrical indicator is used a transparent socket with LED for optical indication is also available with Part No. DG 041.1200.

Dimensions

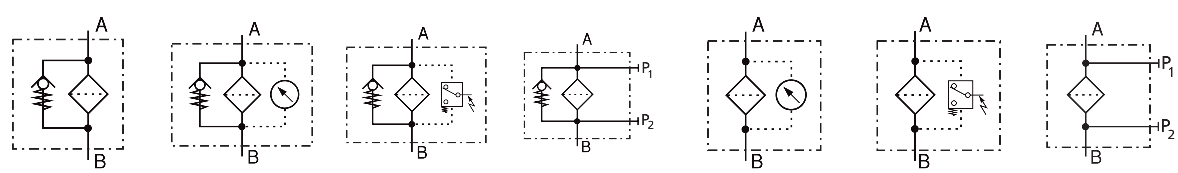


Measurements

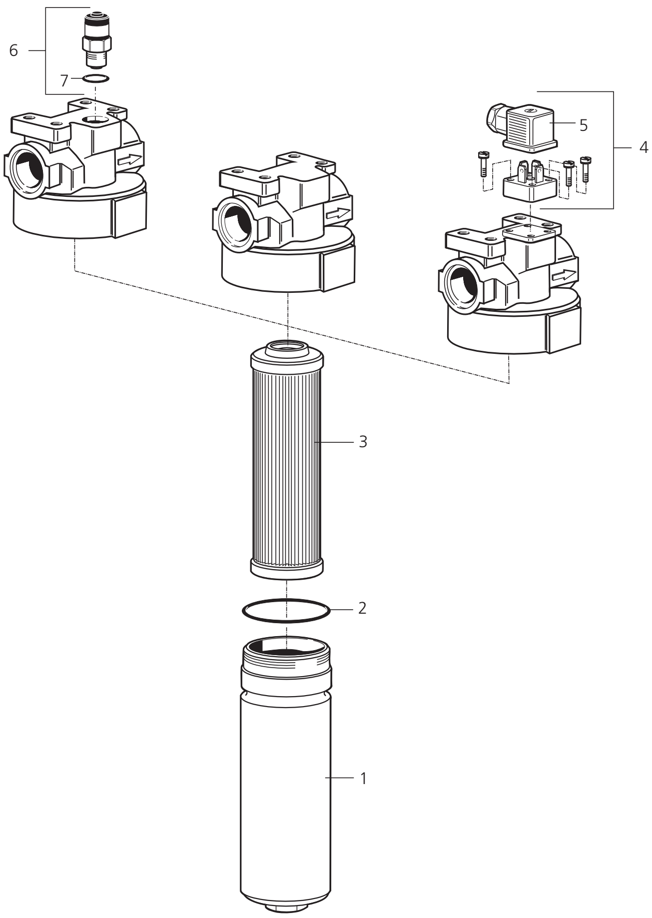
Type	A/B	C	D	E	F	G	H	I	K	L	M	N	O	P	Q	R	S	T	U
D 072	G½	27	178	31	46,5	84	70,5	60	AF27	56	M8x12	30	AF36	85	61	AF24	80	AF30	21,5
D 112	G¾ , G1	34	219	37	51	95	70,5	60	AF27	56	M8x12	30	AF44	85	67	AF24	86	AF30	24,5
D 152	G¾ , G1	40	283	37	51	95	70,5	60	AF27	56	M8x12	30	AF44	85	67	AF24	86	AF30	24,5

Symbols

1 2 3 4 5 6 7



Spare Parts



Pos.	Designation	Part No.
1	Filter bowl D 072	D 072.0101
1	Filter bowl D 112	D 112.0101
1	Filter bowl D 152	D 152.0101
2	O-ring 62 x 2	N007.0622
3	Filter element (with seal)	see Chart / col. 9
4	Reed switch with screws and socket (Pos.5)	HD 049.1410
5	Socket DIN 43650-AF3	DG 041.1220
6	Optical clogging indicator (mit Pos. 7)	D 232.1400
7	O-ring 12,3 x 2,4	N007.0124

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Pressure Filters

D 162 · D 232 · D 332

In-line mounting · Operating pressure up to 63 bar · Nominal flow rate up to 350 l/min

Pressure Filter D 232

Description

Application

In the pressure circuits of hydraulic and lubrication systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Aluminium alloy
Filter bowl:	Aluminium alloy
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin

Accessories

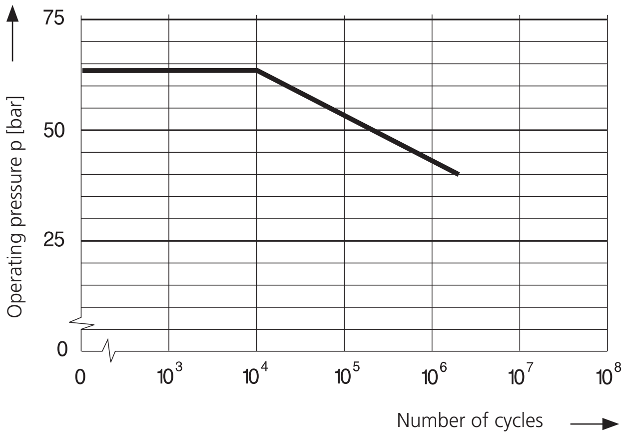
Electrical and/or optical clogging indicators are available - optionally with one or two switching points resp. temperature suppression.
Dimensions and technical data see catalogue sheet 60.30.

Operating pressure

0 ... 40 bar, min. 3 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 63 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 350 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

› closed by-pass valve at $\nu \leq 200$ mm²/s
› element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
› flow velocity in the connection lines:
up to 100 bar ≤ 6 m/s

Filter fineness

5 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEEs and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

› at operating temperature: $\nu < 60$ mm²/s
› as starting viscosity: $\nu_{max} = 1200$ mm²/s
› at initial operation:
The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

Preferably vertical, filter head on top

Connection

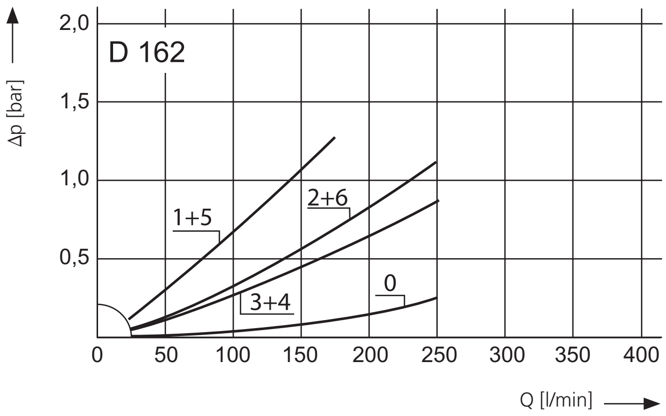
Threaded ports according to ISO 228 or DIN 13. Sizes see Selection Chart, column 6 (other port threads on request).

Electrical clogging indicator

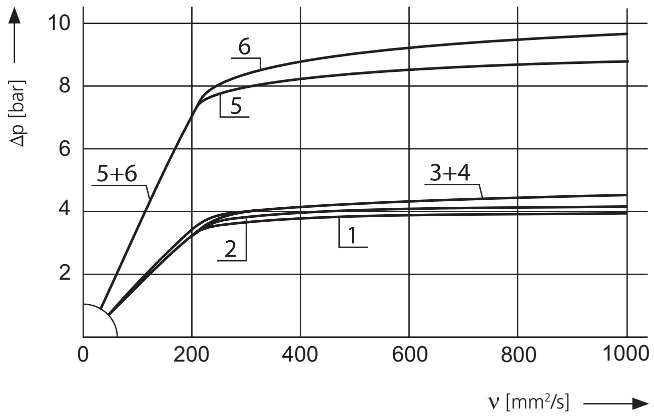
› Switching voltage: max. 120 V AC / 175 V DC
› Switching current: max. 0,17 A AC / 0,25 A DC
› Switching power: max. 3,5 VA AC / 5 W DC
› Type of contact: Change-over
› Electrical protection: IP 65 (with mounted and secured socket)

Δp-curves for complete filters in Selection Chart, column 3

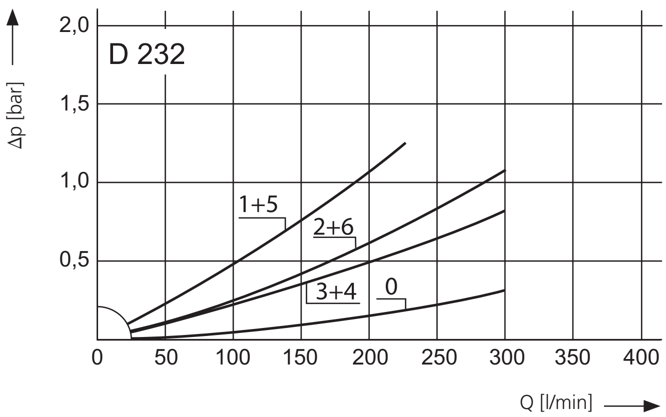
D1 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)



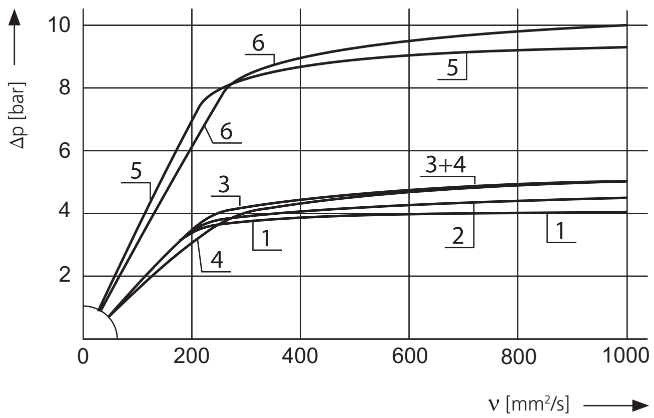
Pressure drop as a function of the
kinematic viscosity at nominal flow



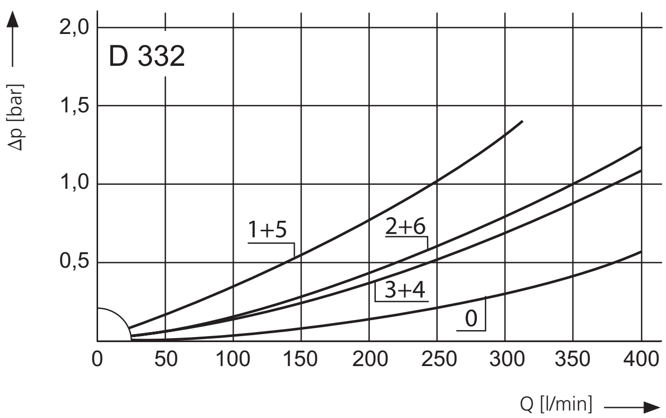
D2 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)



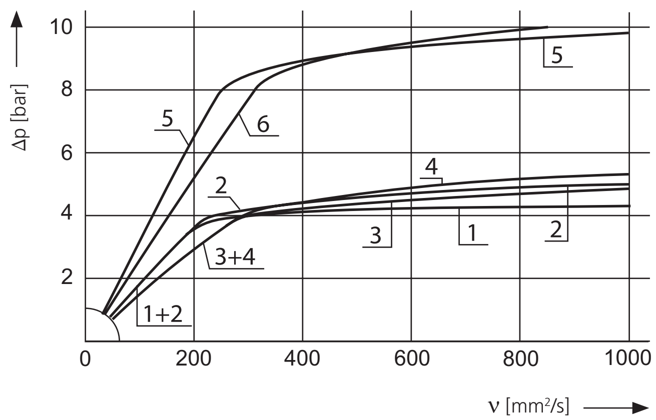
Pressure drop as a function of the
kinematic viscosity at nominal flow



D3 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)

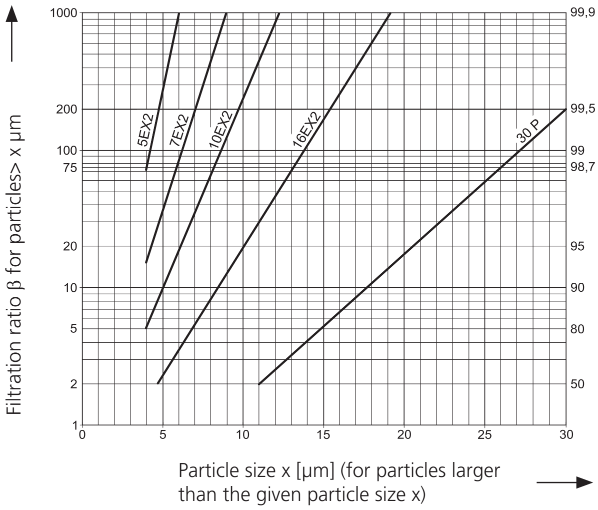


Pressure drop as a function of the
kinematic viscosity at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\beta_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\beta_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\beta_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\beta_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Order Information

Optical or electrical indicators are available to monitor the clogging condition of the element. If the indicator should be already mounted onto the filter head use the abbreviation "M" behind the part number of the indicator. The printed order acknowledgements show both items separately.

Order example: The Filter D 232-256 has to be supplied with optical clogging indicator - response pressure 2,0 bar.

Order description: **D 232-256** / **DG 042-01** **M**

Part No. (basic unit) → D 232-256

Clogging indicator → DG 042-01

M → **Mounted**

For the appropriate clogging indicator see catalogue sheet 60.30.

Besides these mounted clogging indicators we also offer - with a certain order quantity - clogging indicators integrated in the filter head (as listed under „dimensions").

Order examples:

D 232-256 ED (electrical differential pressure switch)
D 232-256 OD (optical differential pressure indicator)
} the switching pressure matches the cracking pressure of the by-pass valve

Remarks:

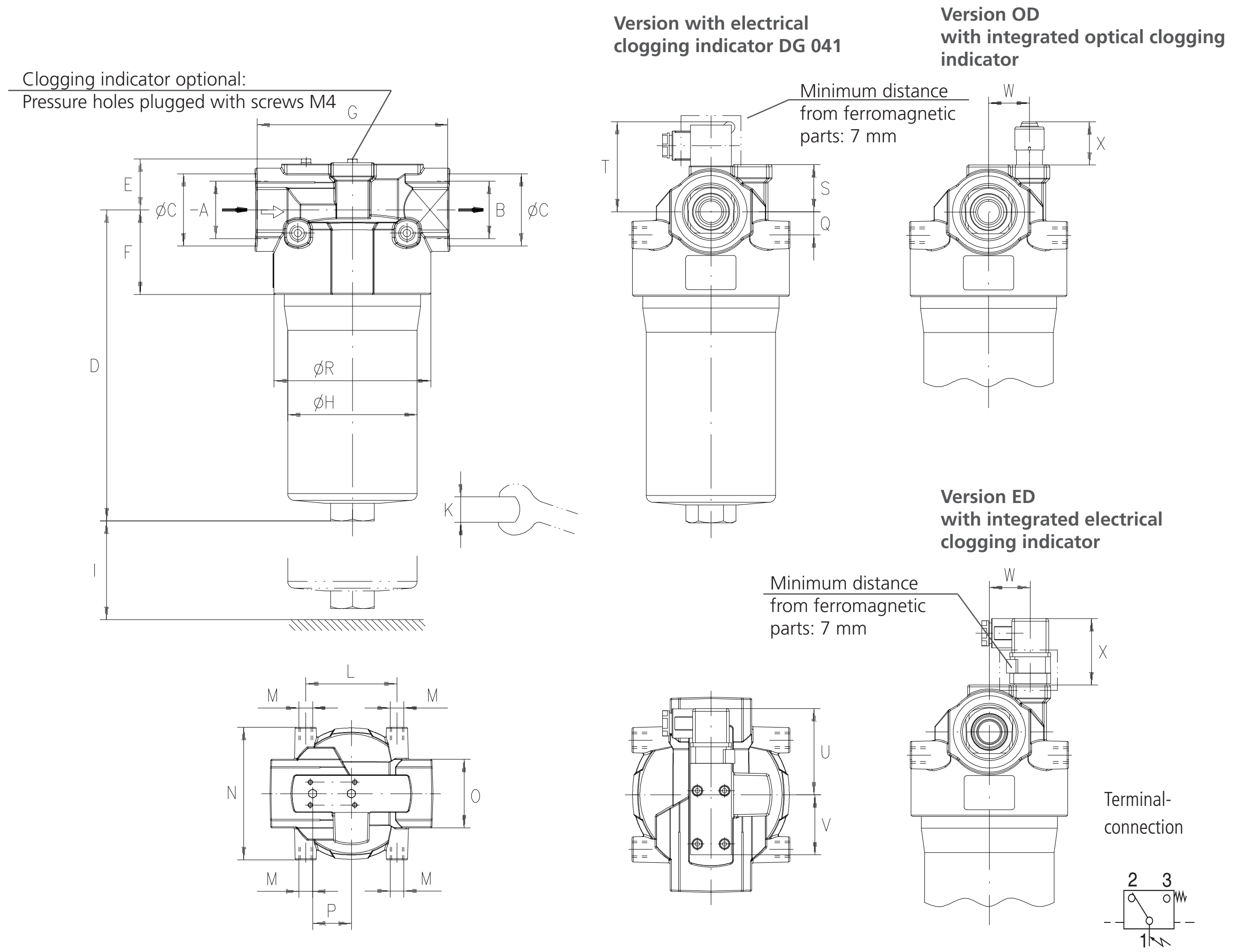
› The switching pressure of the clogging indicator has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
› The filters listed in this chart are standard filters. Other designs available on request.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator	Remarks
	l/min			g		bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
D 162-253	85	**D1**/1	5EX2	24	G1¼	3,5	4	V3.0817-03	2,4	optional	-
D 162-256	140	**D1**/2	10EX2	33	G1¼	3,5	4	V3.0817-06	2,4	optional	-
D 162-258	200	**D1**/3	16EX2	33	G1¼	3,5	4	V3.0817-08	2,4	optional	-
D 162-251	220	**D1**/4	30P	18	G1¼	3,5	4	P3.0817-01*	2,4	optional	-
D 162-283	160	**D1**/5	5EX2	24	G1¼	7	4	V3.0817-03	2,4	optional	-
D 162-286	250	**D1**/6	10EX2	33	G1¼	7	4	V3.0817-06	2,4	optional	-
D 232-253	120	**D2**/1	5EX2	33	G1¼	3,5	4	V3.0823-03	3,4	optional	-
D 232-256	195	**D2**/2	10EX2	47	G1¼	3,5	4	V3.0823-06	3,4	optional	-
D 232-258	275	**D2**/3	16EX2	48	G1¼	3,5	4	V3.0823-08	3,4	optional	-
D 232-251	280	**D2**/4	30P	26	G1¼	3,5	4	P3.0823-01*	3,4	optional	-
D 232-283	220	**D2**/5	5EX2	33	G1¼	7	4	V3.0823-03	3,4	optional	-
D 232-286	300	**D2**/6	10EX2	47	G1½	7	4	V3.0823-06	3,4	optional	-
D 332-253	170	**D3**/1	5EX2	49	G1¼	3,5	4	V3.0833-03	4,0	optional	-
D 332-256	275	**D3**/2	10EX2	67	G1¼	3,5	4	V3.0833-06	4,0	optional	-
D 332-258	280	**D3**/3	16EX2	68	G1¼	3,5	4	V3.0833-08	4,0	optional	-
D 332-251	350	**D3**/4	30P	34	G1½	3,5	4	P3.0833-01*	4,0	optional	-
D 332-283	280	**D3**/5	5EX2	49	G1¼	7	4	V3.0833-03	4,0	optional	-
D 332-286	350	**D3**/6	10EX2	67	G1½	7	4	V3.0833-06	4,0	optional	-

* Paper media supported with metal gauze

Dimensions

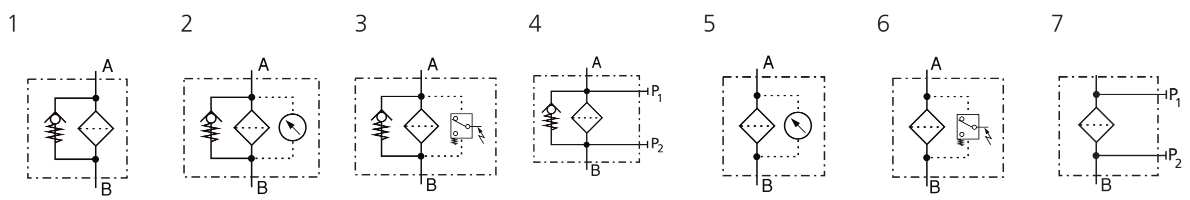


Measurements

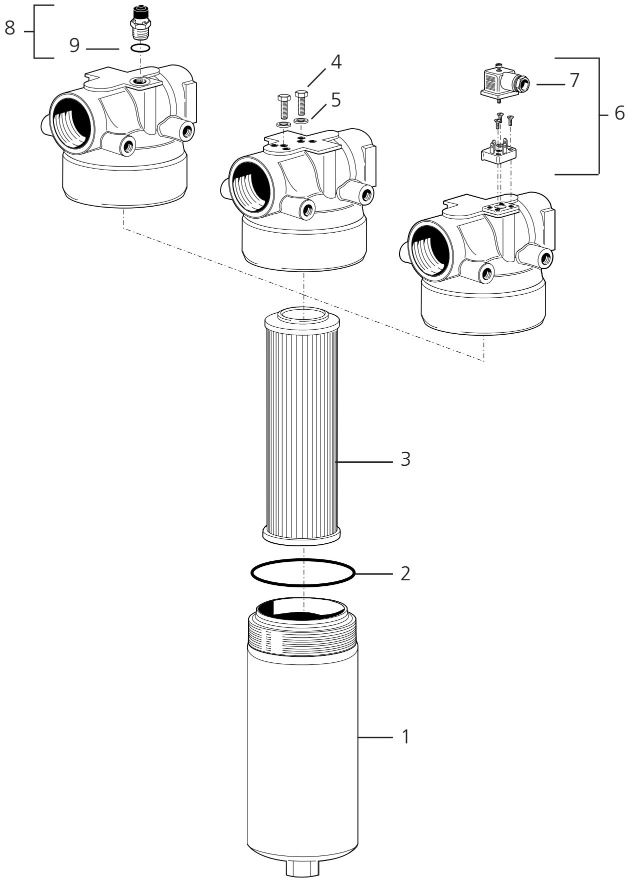
Type	A/B	C	D	E	F	G	H	I	K AF	L	M Ø/depth	N	O	P	Q	R	S	T
D 162	G1¼	61	232	38	62	140	95	80	32	80	M12/18	116	AF60	34	17	115	34	66
D 232	G1¼, G1½	61	296	38	62	140	95	80	32	80	M12/18	116	AF60	34	17	115	34	66
D 332	G1¼, G1½	61	396	38	62	140	101	80	32	80	M12/18	116	AF60	34	17	115	34	66

Type	U	V	W	X	
				ED	OD
D 162	66	44	30	49	30
D 232	66	44	30	49	30
D 332	66	44	30	49	30

Symbols



Spare Parts



Pos.	Designation	Part No.
1	Filter bowl D 162	D 162.0102
1	Filter bowl D 232	D 232.0102
1	Filter bowl D 332	D 332.0102
2	O-ring 88,57 x 2,62	N007.0886
3	Filter element (with seal)	see Chart / col. 9
4	Hexagonal head screw M4 x 8 DIN 933-8.8	11385800
5	Bonded seal 4,1 x 7,2 x 1	12504600
6	Reed switch with screws and socket (Pos. 7)	HD 049.1410
7	Socket DIN 43650 - AF3	DG 041.1220
8	Optical clogging indicator (with Pos. 9)	D 232.1400
9	O-ring 12,3 x 2,4	N007.0124

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Low-Pressure In-Line Filters

FNL 1000 · FNL 2000

In-line mounting · Operating pressure up to 40 bar · Nominal flow rate up to 1450 l/min

Low-Pressure In-Line Filters FNL 1000

Description

Application

In the pressure circuits of hydraulic and lubrication systems.

Performance features

Protection against wear:
By means of filter elements that meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Cover:	Aluminium alloy
Filter housing:	Aluminium alloy
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web
	Paper - cellulose web, impregnated with resin

Accessories

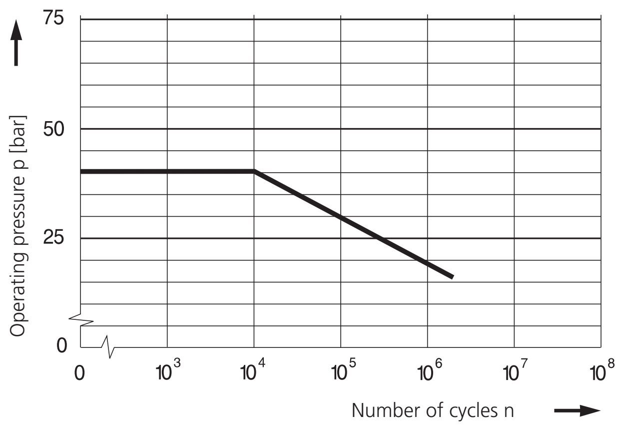
Electrical and/or optical clogging indicators are available - optionally with one or two switching points resp. temperature suppression.
Dimensions and technical data see catalogue sheet 60.30.

Operating pressure

0 ... 16 bar, min. 3 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 40 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 1450 l/min (see Selection Chart, column 2).
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

› closed by-pass valve at $\nu \leq 200$ mm²/s
› element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
› flow velocity in the connection lines:
up to 25 bar ≤ 4,5 m/s

Filter fineness

5 µm(c) ... 10 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEEs and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

› at operating temperature: $\nu < 60$ mm²/s
› as starting viscosity: $\nu_{max} = 1200$ mm²/s
› at initial operation:
The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

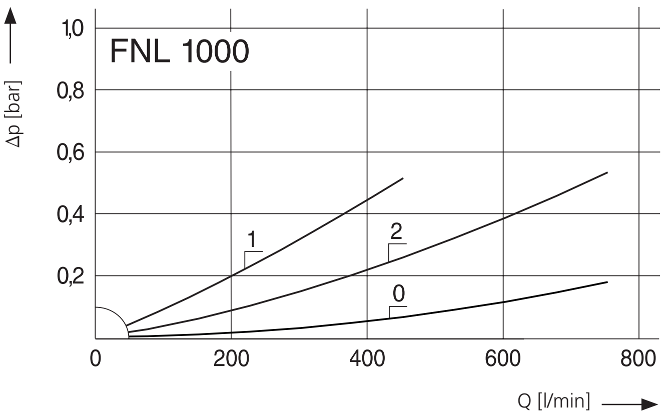
Preferably vertical, filter head at the bottom

Connection

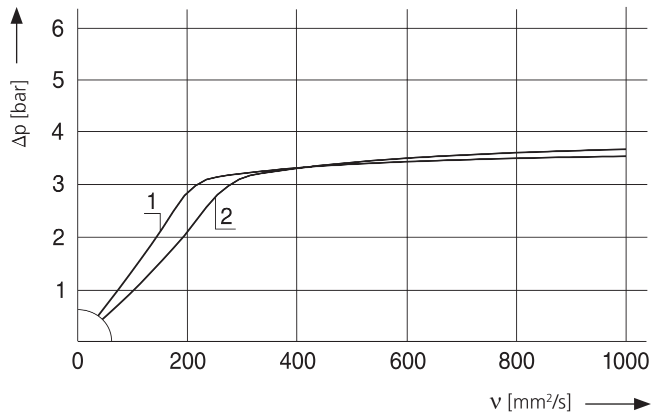
SAE-flange (3000 psi). Sizes see Selection Chart, line 6
(other connections on request).
Standard: connection ports A/B opposed
Optional: connection port A sidewise, connection port B at the bottom

Δp-curves for complete filters in Selection Chart, column 3

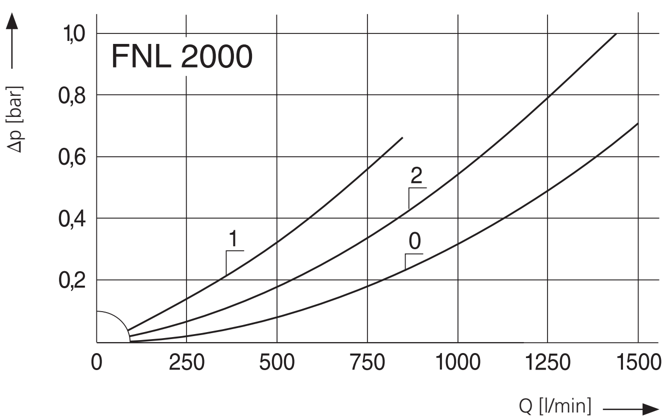
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



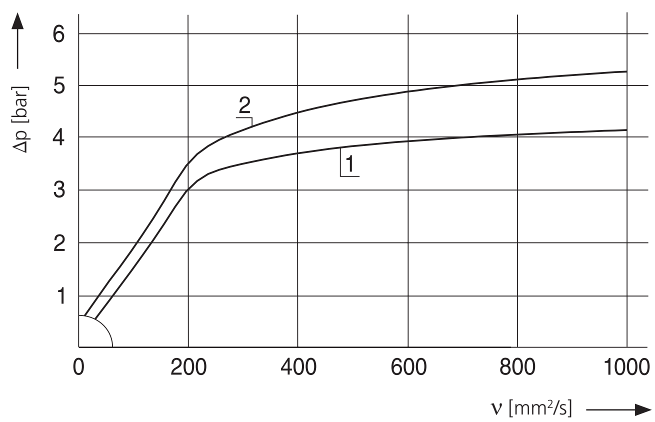
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

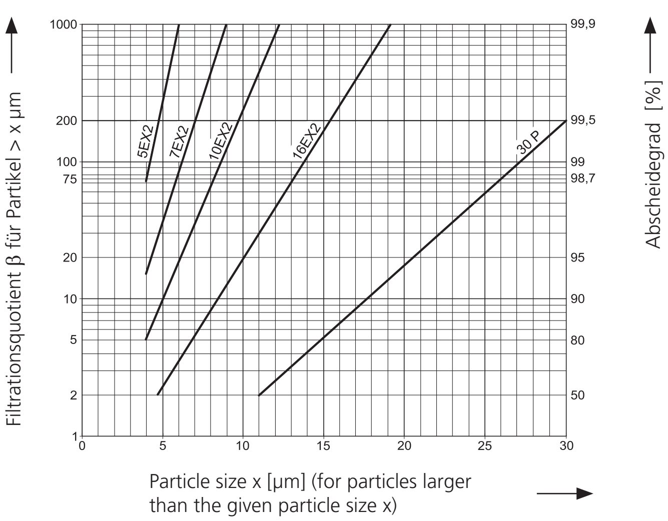


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of bypass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator	Remarks
	l/min			g		bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
FNL 1000-153	420	**D1**/1	5EX2	130	SAE 2	3	4	V3.1449-53	21	optional	-
FNL 1000-156	555	**D1**/2	10EX2	190	SAE 2	3	4	V3.1449-56	21	optional	-
FNL 2000-153	820	**D2**/1	5EX2	260	SAE 4	3	4	V3.1493-53	28	optional	-
FNL 2000-156	1450	**D2**/2	10EX2	370	SAE 4	3	4	V3.1493-56	28	optional	-

Optical or electrical indicators are available to monitor the clogging condition of the element. If the indicator should be already mounted onto the filter head use the abbreviation „M" behind the part number of the indicator. The printed order acknowledgements show both items separately.

Order example: The Filter FNL 1000-153 has to be supplied with electrical clogging indicator - response pressure 2,5 bar.

Order description: **FNL 1000-153** **/** **DG 041-32** **M**
Part No. (basic unit) — FNL 1000-153
Clogging indicator — DG 041-32
Mounted — M

For the appropriate clogging indicator see catalogue sheet 60.30.

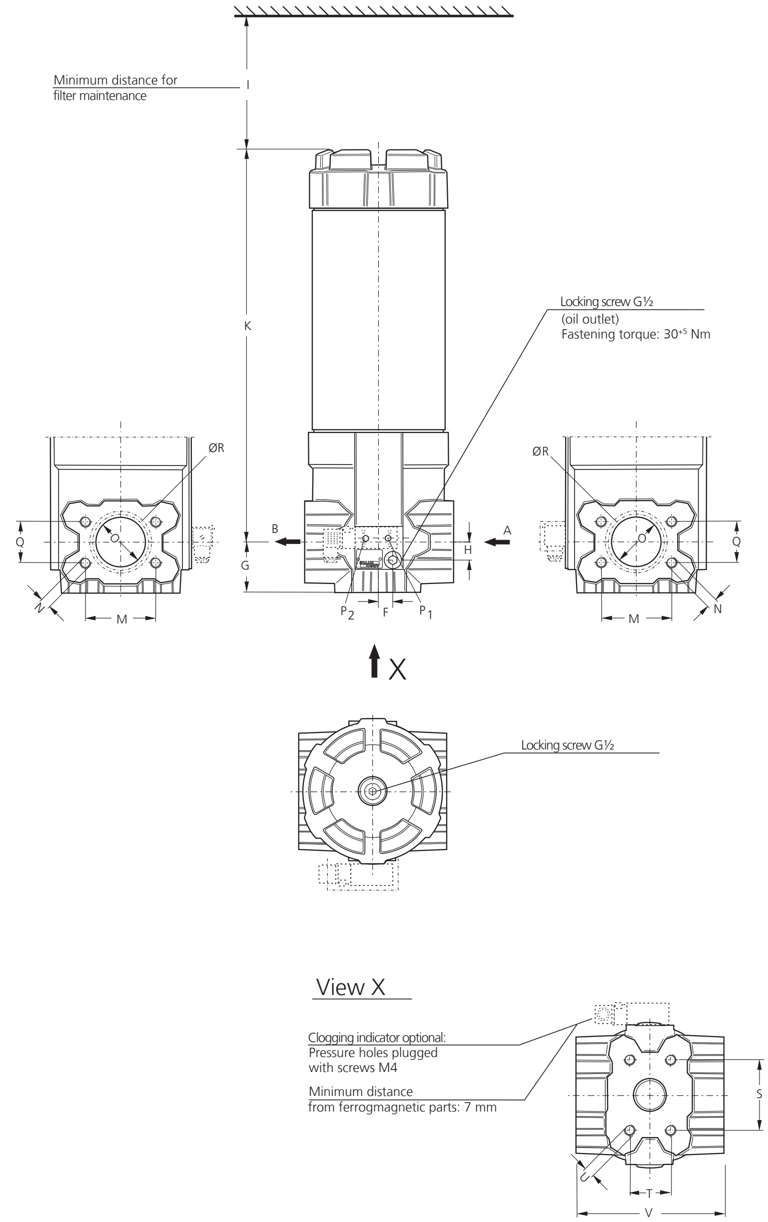
Remarks:

› The switching pressure of the clogging indicator has always to be lower than the cracking pressure of the by-pass valve (see Selection Chart, column 7).
› The filters listed in this chart are standard filters. Other designs available on request.

Optionen:

› Other filter finenesses on request.
› Check valve in filter head on request.
› Connection port A sidewise, connection port B at the bottom (standard: connection ports A/B opposed).

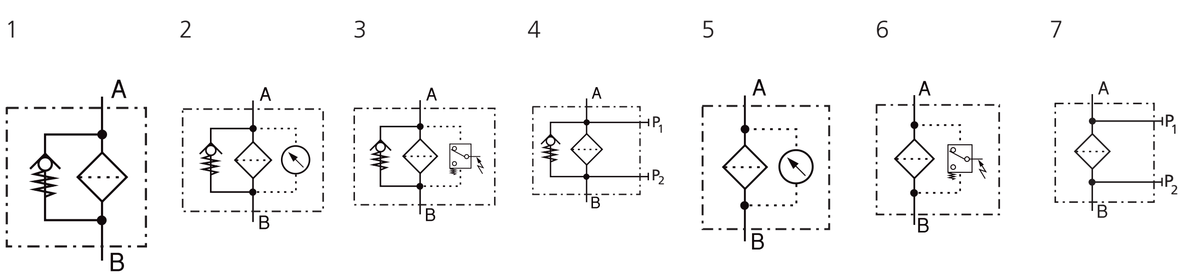
Dimensions



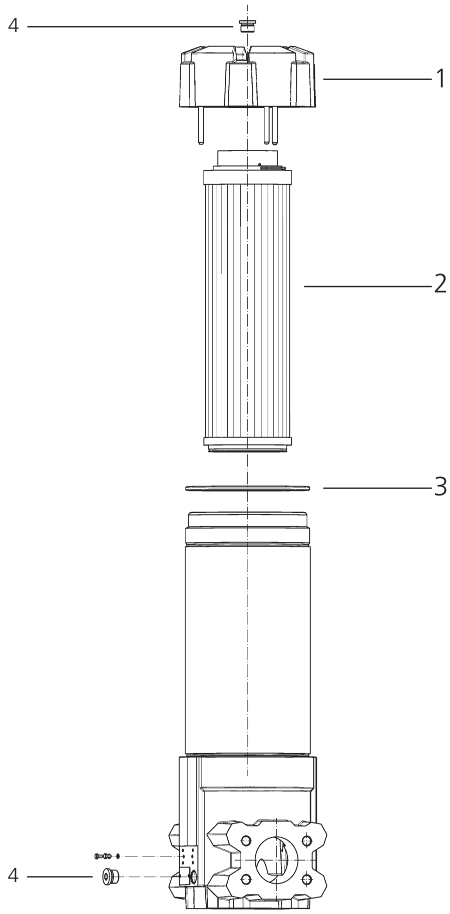
Measurements

Type	A/B	F	G	H	I	K	M	N	O	Q	R	S	T	U	V
FNL 1000	SAE 2	19	76,5	26,5	450	593	77,8	M12	Ø50	42,6	56-64	130,2	77,8	M16	224
FNL 2000	SAE 4	19	76,5	26,5	890	1033	130,2	M16	Ø100	77,8	110-118	130,2	77,8	M16	224

Symbols



Spare Parts



Pos.	Designation	Part No.
1	Cover (complete)	FNL 1000.1200
2	Filter element	see Chart / col. 9
3	O-ring	N007.1905
4	Locking screw	SV 0620.08

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

High-Pressure Safety Filters

HD 040 · HD 081 · HD 150

In-line mounting · Operating pressure up to 500 bar · Nominal flow rate up to 100 l/min

High-Pressure Safety Filter HD 081

Description

Application

In the high-pressure circuits of hydraulic systems.

Performance features

Functional protection:
The high-pressure safety filter retains residues remaining in the system due to installation or after repairs, and intake chops from pumps (especially gear pumps). This prevents functional failures or faults on downstream components, particularly control/ regulation or throttle valves.

Protection against wear:
For wear protection, a fine filter should be installed elsewhere in the system.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material provides:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Materials

Housing:	steel, zinc plated
Seals:	NBR (FPM on request)
Filter media:	stainless steel wire mesh (1.4301)

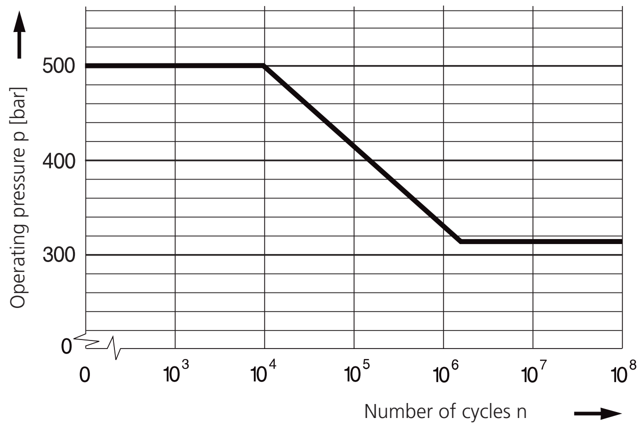
Characteristics

Operating pressure

0 ... 250 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 500 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressure for other numbers of cycles



Nominal flow rate

Up to 100 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

› closed by-pass valve at $\nu \leq 200$ mm²/s
› flow velocity in the connection lines:
up to 250 bar ≤ 8 m/s
> 250 bar ≤ 12 m/s

Filter fineness

60 µm, 100 µm
(see Selection Chart, column 4)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

› at operating temperature: $\nu < 60$ mm²/s
› as starting viscosity: $\nu_{max} = 1200$ mm²/s
› at initial operation:
The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

As desired

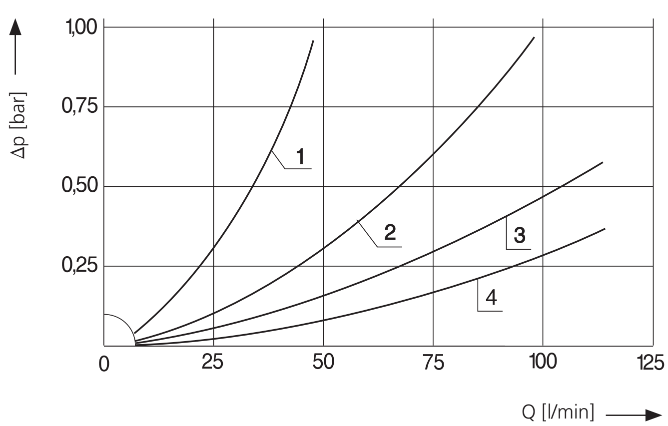
Connection

Threaded ports according to ISO 228, DIN 13 and/or DIN 3861. Sizes see Selection Chart, column 7 (other port threads on request).

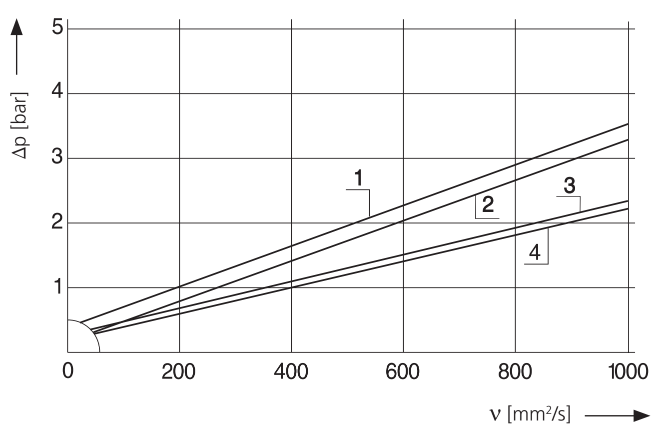
Diagrams

Δ p-curves for the filters in Selection Chart, column 3

D1 Pressure drop as a function of the **flow volume** at $\nu = 35$ mm²/s



Pressure drop as a function of the **kinematic viscosity** at nominal flow



Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness	Filter surface	Cracking pressure of by-pass	Connection A/B	Dimension C	Dimension D	Dimension E	Dimension F	Dimension H	Dimension L	Width across flats AF 1/2	Symbol	Weight	Remarks
	l/min		µm	cm²	bar		mm	mm	mm	mm	mm	mm			kg	
1	2	3	4	5	6	7	8	9	10	11	12	13	14	15	16	17
HD 040-110	40	**D1**/1	100	60	-	M22 x 1,5	12	-	7	15	63	97	36/36	1	0,45	[1+2]
HD 081-111	80	**D1**/2	100	125	-	M26 x 1,5	12	52	7,5	18	11	130	46/46	1	1,10	[1+2]
HD 150-01	100	**D1**/3	100	300	-	G¾	12	65	10,5	-	-	142,5	55/36	1	2,00	[1]
HD 150-50	100	**D1**/4	60	320	3,5	G¾	12	65	10,5	-	-	142,5	55/36	2	1,90	-

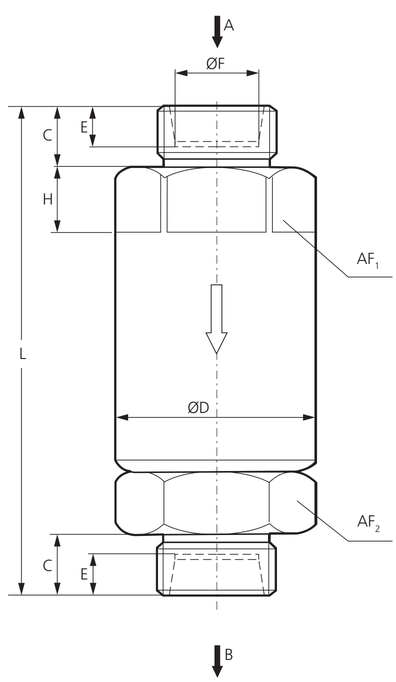
[1] Filter element diffential pressure stable up to 160 bar
[2] Connection according to DIN 3861

Remark:

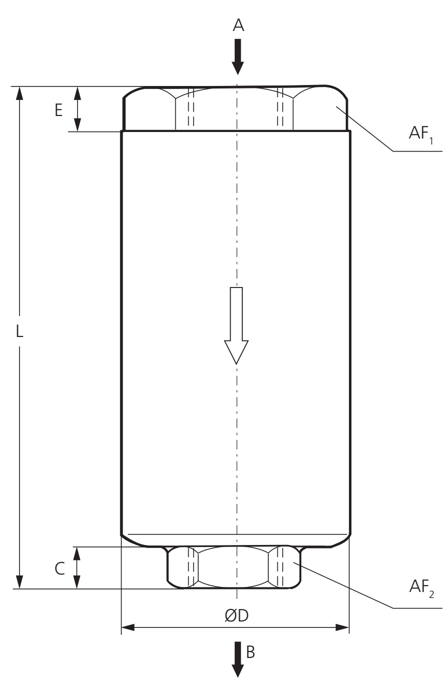
The filters listed in the chart are standrard filters. If modifications are required, e.g. different filter finenesses, we kindly ask for your request.

Dimensions

HD 040 / HD 081



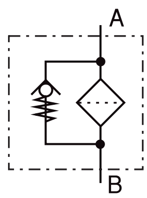
HD 150



Symbols

1

2



Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

High Pressure Filters – Worldline 100

HD 049 · HD 069

In-line mounting · Operating pressure up to 630 bar · Nominal flow rate up to 105 l/min

High Pressure Filter HD 049

Description

Application

In the high pressure circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at ≤ 200 mm²/s (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Spheroidal graphite cast iron (SGI)
Filter bowl:	Cold extruded steel
Coating:	Powder paint resp. phosphate coating/primed
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin

Accessories

If an electrical indicator is used a transparent socket with LED for optical indication is also available with Part No. DG 041.1200.

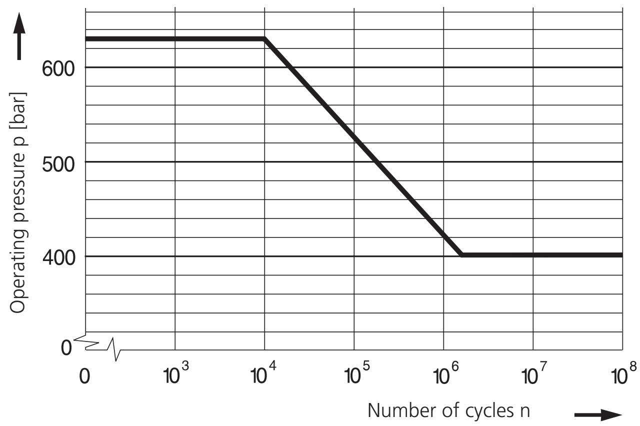
Characteristics

Operating pressure

0 ... 400 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 630 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 105 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines:
  up to 250 bar ≤ 8 m/s
  > 250 bar ≤ 12 m/s

Filter fineness

5 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

Preferably vertical, filter head on top

Connection

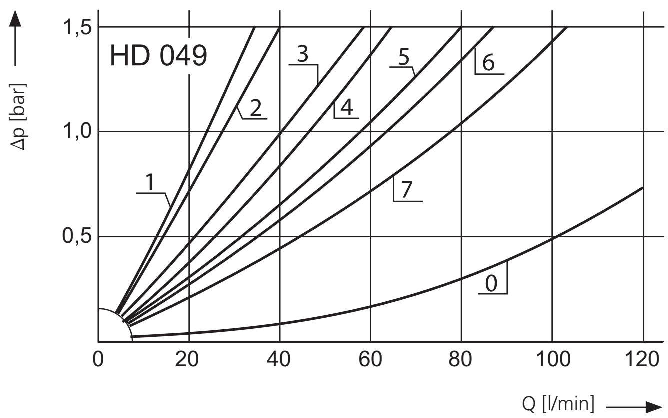
Threaded ports according to ISO 228 or DIN 13. Sizes see Selection Chart, column 6 (other port threads on request).

Electrical clogging indicator

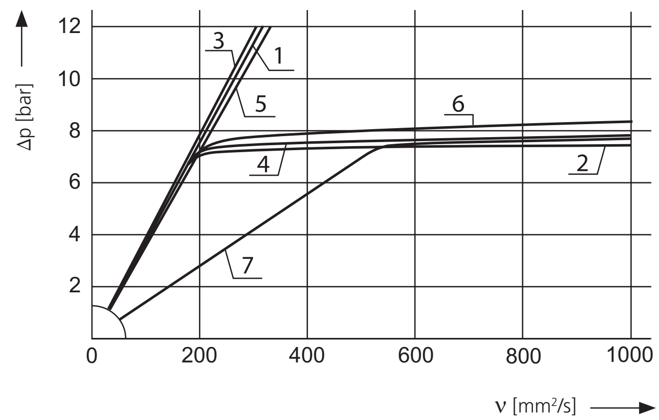
- Switching voltage: max. 120 V AC / 175 V DC
- Switching current: max. 0,17 A AC / 0,25 A DC
- Switching power: max. 3,5 VA AC / 5 W DC
- Type of contact: Change-over
- Electrical protection: IP 65 (with mounted and secured socket)

Δp-curves for complete filters in Selection Chart, column 3

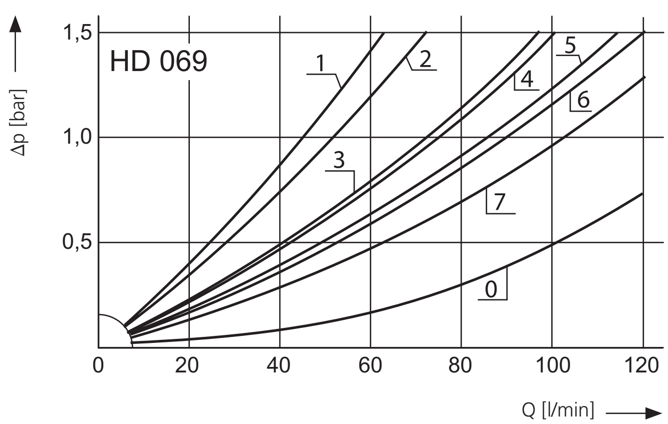
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



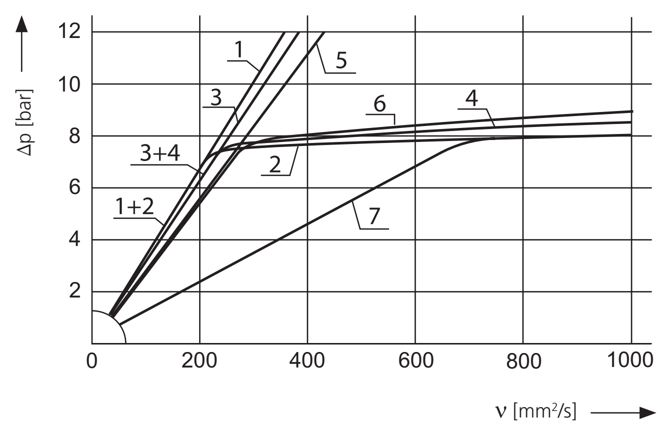
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

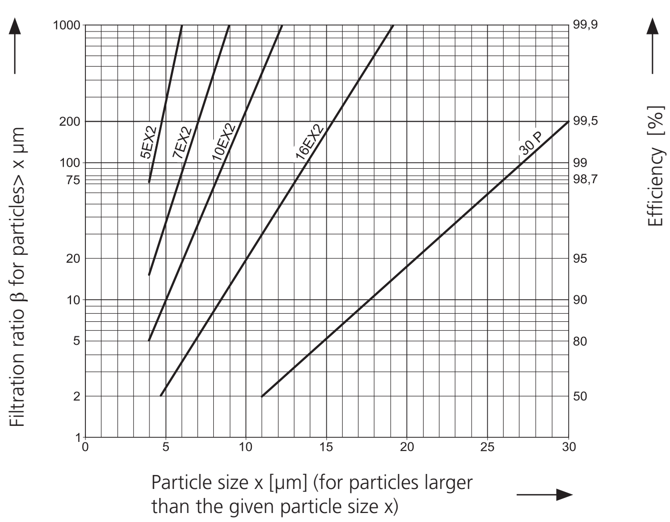


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper element:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

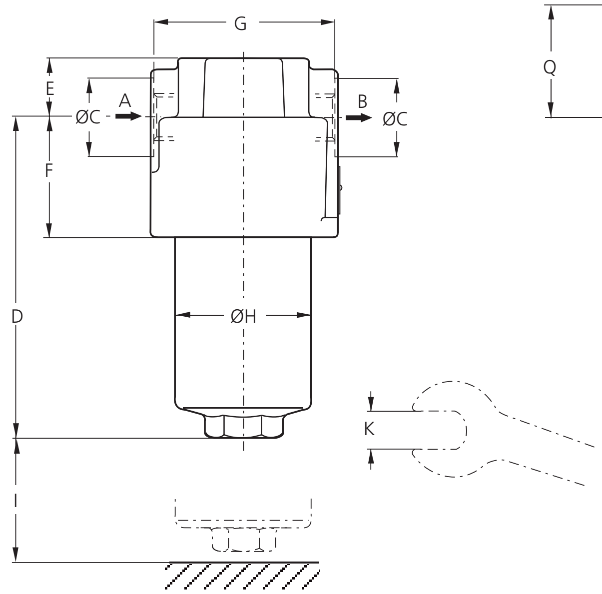
Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement element Part No.	Weight	Clogging indicator Cracking pressure ( )	Remarks
	l/min			g		bar			kg	bar	
1	2	3	4	5	6	7	8	9	10	11	12
HD 049-189	27	**D1**/1	5EX2	5,2	G½	-	6	V3.0510-13[1]	3,9	electrical (5)	change-over
HD 049-169	30	**D1**/2	5EX2	4,9	G½	7	1	V3.0510-03	3,8	-	-
HD 049-179	30	**D1**/2	5EX2	4,9	G½	7	2	V3.0510-03	3,9	optical (5)	-
HD 049-159	30	**D1**/2	5EX2	4,9	G½	7	3	V3.0510-03	3,9	electrical (5)	change-over
HD 049-186	47	**D1**/3	10EX2	5,1	G½	-	6	V3.0510-16[1]	3,9	electrical (5)	change-over
HD 049-166	50	**D1**/4	10EX2	6,8	G½	7	1	V3.0510-06	3,8	-	-
HD 049-176	50	**D1**/4	10EX2	6,8	G½	7	2	V3.0510-06	3,9	optical (5)	-
HD 049-156	50	**D1**/4	10EX2	6,8	G½	7	3	V3.0510-06	3,9	electrical (5)	change-over
HD 049-188	65	**D1**/5	16EX2	5,6	G½	-	6	V3.0510-18[1]	3,9	electrical (5)	change-over
HD 049-268	75	**D1**/6	16EX2	6,9	M18 x 1,5	7	1	V3.0510-08	3,8	-	[3]
HD 049-168	75	**D1**/6	16EX2	6,9	G½	7	1	V3.0510-08	3,8	-	-
HD 049-178	75	**D1**/6	16EX2	6,9	G½	7	2	V3.0510-08	3,9	optical (5)	-
HD 049-158	75	**D1**/6	16EX2	6,9	G½	7	3	V3.0510-08	3,9	electrical (5)	change-over
HD 049-151	55	**D1**/7	30P	3,6	G½	7	1	P3.0510-11[2]	3,8	-	-
HD 049-161	55	**D1**/7	30P	3,6	G½	7	2	P3.0510-11[2]	3,9	optical (5)	-
HD 049-171	55	**D1**/7	30P	3,6	G½	7	3	P3.0510-11[2]	3,9	electrical (5)	change-over
HD 069-189	50	**D2**/1	5EX2	8,7	G½	-	6	V3.0520-13[1]	5,1	electrical (5)	change-over
HD 069-169	60	**D2**/2	5EX2	10	G½	7	1	V3.0520-03	4,9	-	-
HD 069-179	60	**D2**/2	5EX2	10	G½	7	2	V3.0520-03	5,0	optical (5)	-
HD 069-159	60	**D2**/2	5EX2	10	G½	7	3	V3.0520-03	5,0	electrical (5)	change-over
HD 069-186	80	**D2**/3	10EX2	11	G¾	-	6	V3.0520-16[1]	5,1	electrical (5)	change-over
HD 069-166	85	**D2**/4	10EX2	14	G¾	7	1	V3.0520-06	4,9	-	-
HD 069-176	85	**D2**/4	10EX2	14	G¾	7	2	V3.0520-06	5,0	optical (5)	-
HD 069-156	85	**D2**/4	10EX2	14	G¾	7	3	V3.0520-06	5,0	electrical (5)	change-over
HD 069-188	100	**D2**/5	16EX2	12	G¾	-	6	V3.0520-18[1]	5,1	electrical (5)	change-over
HD 069-268	105	**D2**/6	16EX2	15	G¾	7	1	V3.0520-08	4,9	-	[3]
HD 069-168	105	**D2**/6	16EX2	15	G¾	7	1	V3.0520-08	4,9	-	-
HD 069-178	105	**D2**/6	16EX2	15	G¾	7	2	V3.0520-08	5,0	optical (5)	-
HD 069-158	105	**D2**/6	16EX2	15	G¾	7	3	V3.0520-08	5,0	electrical (5)	change-over
HD 069-151	80	**D2**/7	30P	7,1	G¾	7	1	P3.0520-01[2]	4,9	-	-
HD 069-161	80	**D2**/7	30P	7,1	G¾	7	2	P3.0520-01[2]	5,0	optical (5)	-
HD 069-171	80	**D2**/7	30P	7,1	G¾	7	3	P3.0520-01[2]	5,0	electrical (5)	change-over

[1] Element differential pressure up to 160 bar [2] Paper media supported with metal gauze [3] Housing primed/phosphated

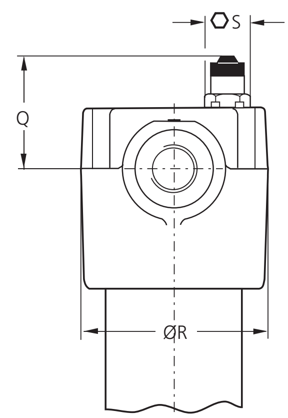
Remarks:

- The filters listed in this chart are standard filters. If modifications are required, e.g. bolt mounted indicators according to catalogue sheet 60.30, we kindly ask for your request.
- If an electrical indicator is used a transparent socket with LED for optical indication is also available with Part No. DG 041.1200.

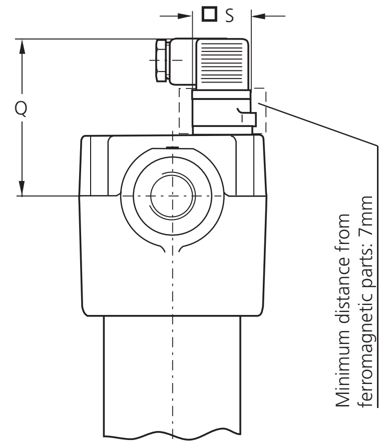
Dimensions



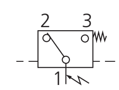
Version with integrated optical clogging indicator

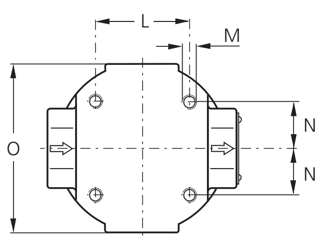


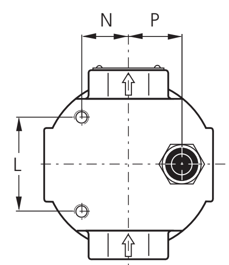
Version with integrated electrical clogging indicator



Terminal connection





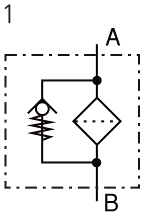


Measurements

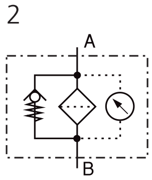
Type	A/B	C	D	E	F	G	H	I	K	L	M Ø/depth	N	O	P	Q opt./electr.	R	S opt./electr.
HD 049	M18 x 1,5 resp. G½	28 resp. 33	158	24,5	61	84	65	55	AF36	40	M8/12	25	89	27,5	55/72	85	24/30
HD 069	G½, G¾	33 resp. 36	254	24,5	61	84	65	55	AF36	40	M8/12	25	89	27,5	55/72	85	24/30

Symbols

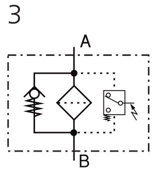
1



2



3



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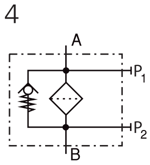

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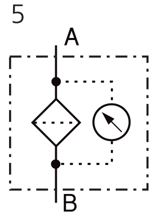

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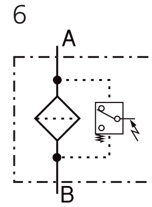

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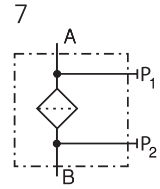
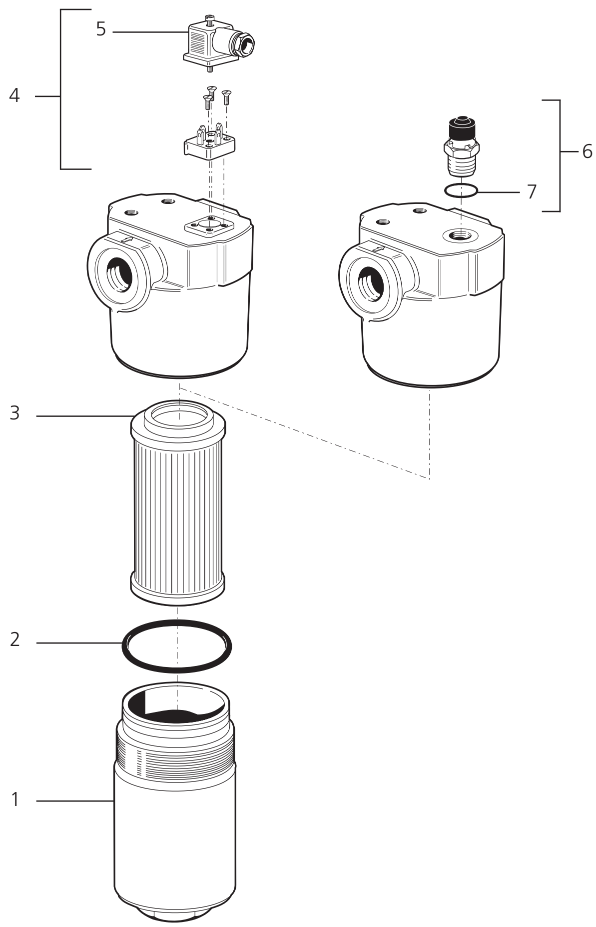


Spare Parts



Pos.	Designation	Part No.
1	Filter bowl HD 049	HD 052.0102
1	Filter bowl HD 069	HD 072.0102
2	O-ring 53,57 x 3,53	N007.0543/1
3	Filter element	s. Chart / col. 9
4	Reed switch with screws and socket (Pos. 5)	HD 049.1410
5	Socket DIN 43650 - AF3	DG 041.1220
6	Optical indicator (with Pos. 7)	HD 049.1400
7	O-ring 17 x 2	N007.0172

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

HD 152 · HD 172

In-line mounting · Operating pressure up to 630 bar · Nominal flow rate up to 190 l/min

High Pressure Filter HD 172

Description

Application

In the high pressure circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:

Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Spheroidal graphite cast iron (SGI)
Filter bowl:	Cold extruded steel
Coating:	Powder paint
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web
	Paper - cellulose web, impregnated with resin

Accessories

If an electrical indicator is used a transparent socket with LED for optical indication is also available with Part No. DG 041.1200.

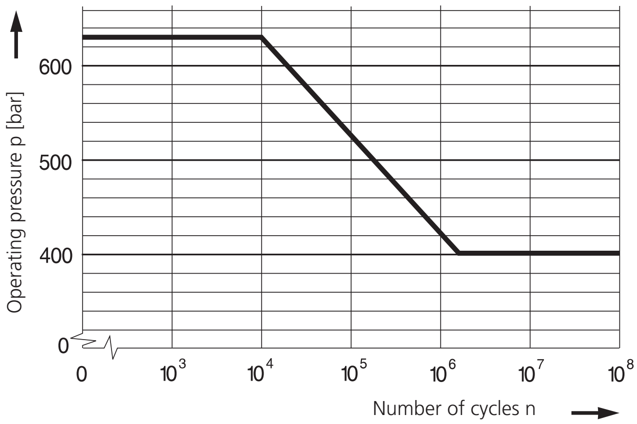
Characteristics

Operating pressure

0 ... 400 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according DIN 24550

0 ... 630 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 190 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

› closed by-pass valve at $\nu \leq 200$ mm²/s
› element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
› flow velocity in the connection lines:
up to 250 bar ≤ 8 m/s
> 250 bar ≤ 12 m/s

Filter fineness

5 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

› at operating temperature: $\nu < 60$ mm²/s
› as starting viscosity: $\nu_{max} = 1200$ mm²/s
› at initial operation:
The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

Preferably vertical, filter head on top

Connection

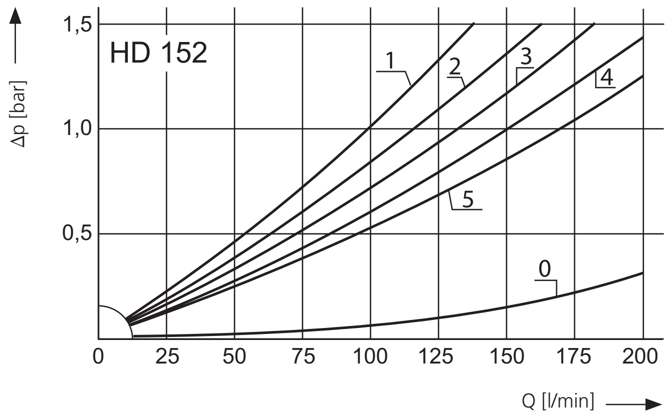
Threaded ports according to ISO 228 or DIN 13. Sizes see Selection Chart, column 6 (other port threads on request).

Electrical clogging indicator

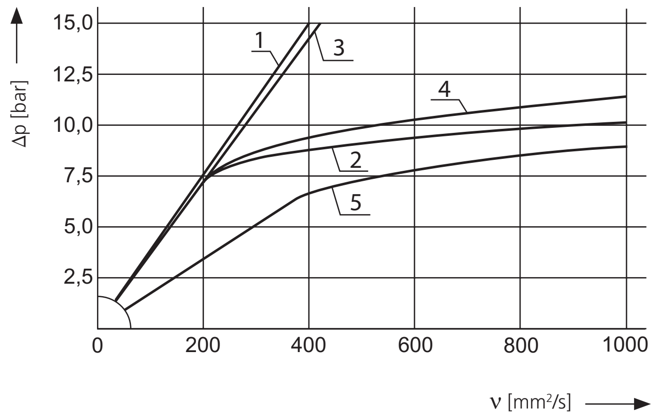
› Switching voltage: max. 120 V AC / 175 V DC
› Switching current: max. 0,17 A AC / 0,25 A DC
› Switching power: max. 3,5 VA AC / 5 W DC
› Type of contact: Change-over
› Electrical protection: IP 65 (with mounted and secured socket)

Δp-curves for complete filters in Selection Chart, column 3

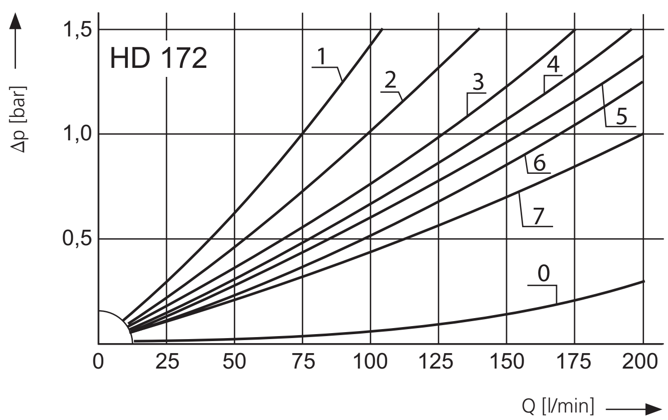
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



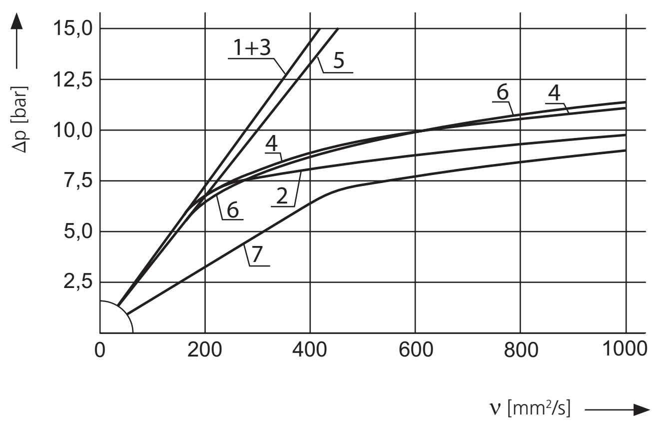
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

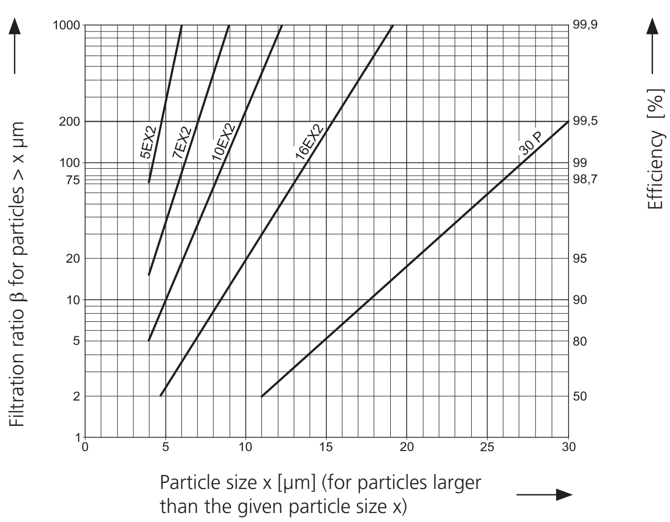


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\bar{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\bar{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\bar{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\bar{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator Cracking pressure in ( )	Remarks
	l/min			g		bar			kg	bar	
1	2	3	4	5	6	7	8	9	10	11	12
HD 152-186	110	**D1**/1	10EX2	13	G¾	-	6	V3.0617-26[1]	7,1	electrical (5)	change-over
HD 152-166	125	**D1**/2	10EX2	17	G¾	7	1	V3.0617-06	6,9	-	-
HD 152-276	125	**D1**/2	10EX2	17	G¾	7	2	V3.0617-06	7,0	optical (5)	-
HD 152-156	125	**D1**/2	10EX2	17	G¾	7	3	V3.0617-06	7,0	electrical (5)	change-over
HD 152-188	150	**D1**/3	16EX2	14	G1	-	6	V3.0617-18[1]	7,1	electrical (5)	change-over
HD 152-168	175	**D1**/4	16EX2	17	G1	7	1	V3.0617-08	6,9	-	-
HD 152-278	175	**D1**/4	16EX2	17	G1	7	2	V3.0617-08	7,0	optical (5)	-
HD 152-158	175	**D1**/4	16EX2	17	G1	7	3	V3.0617-08	7,0	electrical (5)	change-over
HD 152-151	130	**D1**/5	30P	8,7	G1	7	1	P3.0617-01[2]	6,9	-	-
HD 152-261	130	**D1**/5	30P	8,7	G1	7	2	P3.0617-01[2]	7,0	optical (5)	-
HD 172-189	80	**D2**/1	5EX2	16	G1	-	6	V3.0623-13[1]	8,4	electrical (5)	change-over
HD 172-163	110	**D2**/2	5EX2	17	G1	7	1	V3.0623-03	8,0	-	-
HD 172-273	110	**D2**/2	5EX2	17	G1	7	2	V3.0623-03	8,1	optical (5)	-
HD 172-153	110	**D2**/2	5EX2	17	G1	7	3	V3.0623-03	8,1	electrical (5)	change-over
HD 172-186	140	**D2**/3	10EX2	18	G1	-	6	V3.0623-26[1]	8,4	electrical (5)	change-over
HD 172-166	160	**D2**/4	10EX2	23	G1	7	1	V3.0623-06	8,0	-	-
HD 172-276	160	**D2**/4	10EX2	23	G1	7	2	V3.0623-06	8,1	optical (5)	-
HD 172-156	160	**D2**/4	10EX2	23	G1	7	3	V3.0623-06	8,1	electrical (5)	change-over
HD 172-188	180	**D2**/5	16EX2	19	G1	-	6	V3.0623-18[1]	8,4	electrical (5)	change-over
HD 172-168	190	**D2**/6	16EX2	25	G1	7	1	V3.0623-08	8,0	-	-
HD 172-278	190	**D2**/6	16EX2	25	G1	7	2	V3.0623-08	8,1	optical (5)	-
HD 172-158	190	**D2**/6	16EX2	25	G1	7	3	V3.0623-08	8,1	electrical (5)	change-over
HD 172-151	150	**D2**/7	30P	14	G1	7	1	P3.0623-11[2]	8,0	-	-
HD 172-261	150	**D2**/7	30P	14	G1	7	2	P3.0623-11[2]	8,1	optical (5)	-

[1] Filter element differential pressure stable up to 160 bar

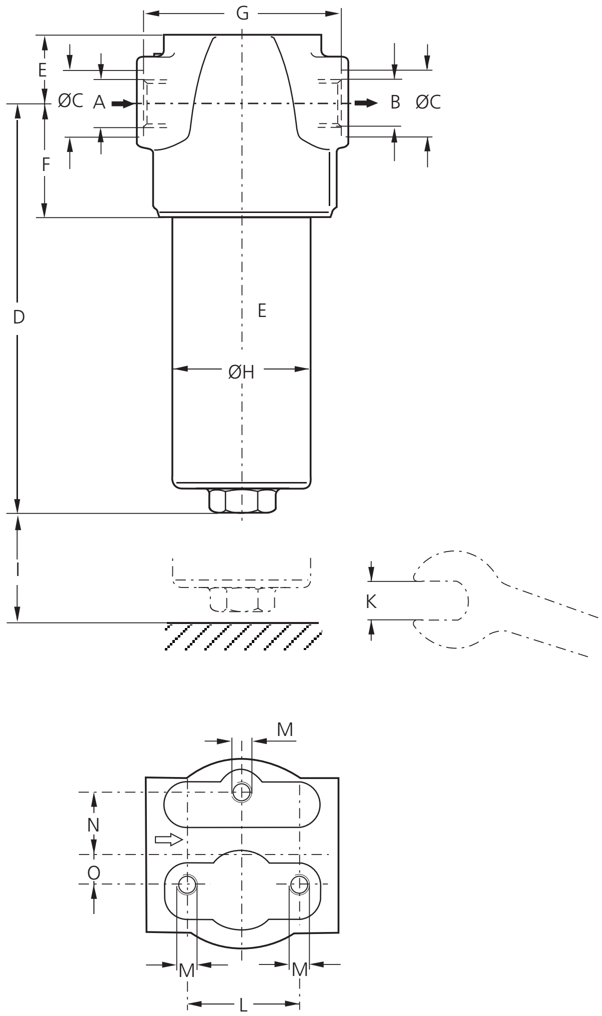
[2] Paper media supported with metal gauze

Remarks:

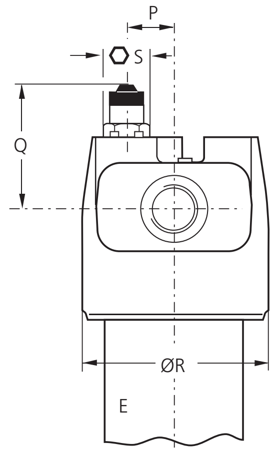
› The filters listed in this chart are standard filters. If modifications are required, e.g. connections SAE ¾ resp. SAE 1 (6000 psi), we kindly ask for your request.

› If an electrical indicator is used a transparent socket with LED for optical indication is also available with Part No. DG 041.1200.

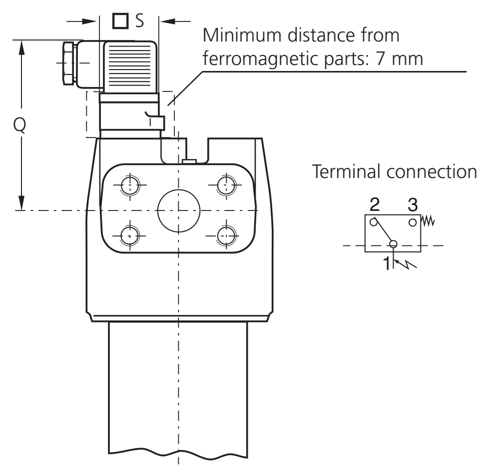
Dimensions



Version with integrated optical clogging indicator



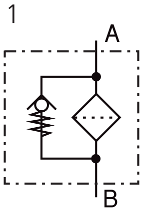
Version with integrated electrical clogging indicator SAE-flange (6000 psi)



Measurements

Type	A/B	C	D	E	F	G	H	I	K	L	M Ø/depth	N	O	P	Q opt./electr.	R	S opt./electr.
HD 152	G¾, G1	36, 45	224	39	66	104	75	70	AF27	60	M10/12	35	17,5	30	69/86	102	24/30
HD 172	G1	45	285	39	66	104	75	70	AF27	60	M10/12	35	17,5	30	69/86	102	24/30

Symbols

1


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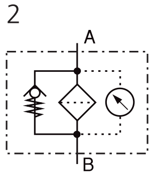

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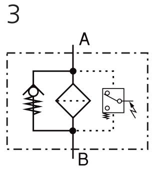

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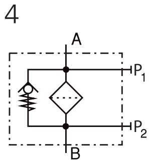

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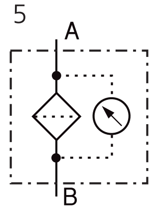

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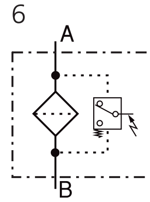

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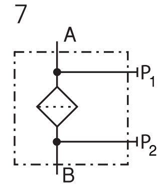
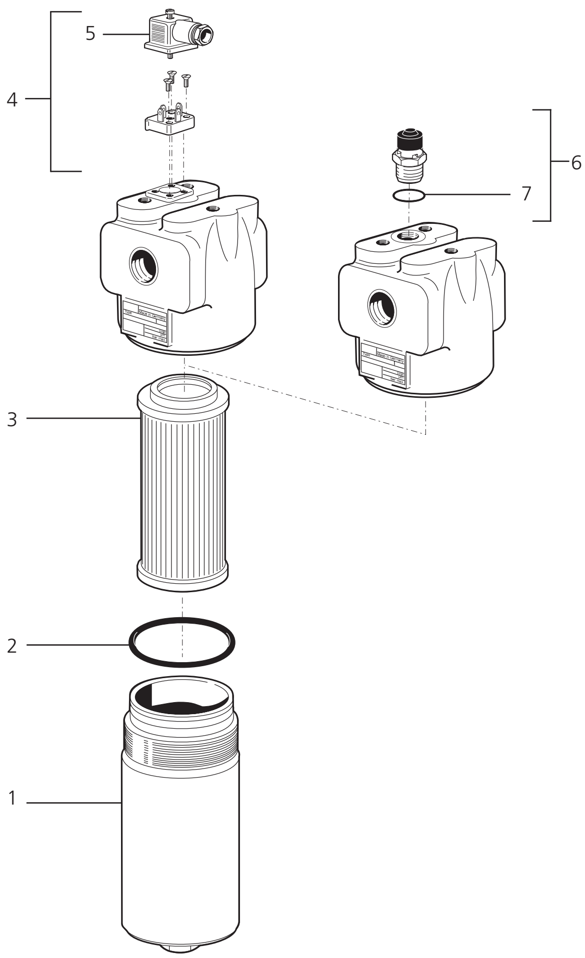


Spare Parts



Pos.	Designation	Part No.
1	Filter bowl HD 152	HD 152.0102
1	Filter bowl HD 172	HD 171.0102
2	O-ring 63 x 3,5	N007.0634
3	Filter element	see Chart/col. 9
4	Reed switch with screws and socket (Pos. 5)	HD 049.1410
5	Socket DIN 43650 - AF3	DG 041.1220
6	Optical indicator (with Pos. 7)	HD 049.1400
7	O-ring 17 x 2	N007.0172

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

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ISO 2941 Verification of collapse/burst pressure rating
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ISO 2943 Verification of material compatibility with fluids
ISO 3968 Evaluation of pressure drop versus flow characteristics
ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

High Pressure Filters - Worldline 300

HD 319 · HD 419 · HD 619

In-line mounting · Operating pressure up to 630 bar · Nominal flow rate up to 450 l/min

High Pressure Filter HD 419

Description

Application

In the high pressure circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200\ mm^2/s$ (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Spheroidal graphite cast iron (SGI)
Filter bowl:	Cold extruded steel
Coating:	Powder paint
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

Accessories

If an electrical indicator is used, a transparent socket with LED for optical indication is also available with Part No. DG 041.1200.

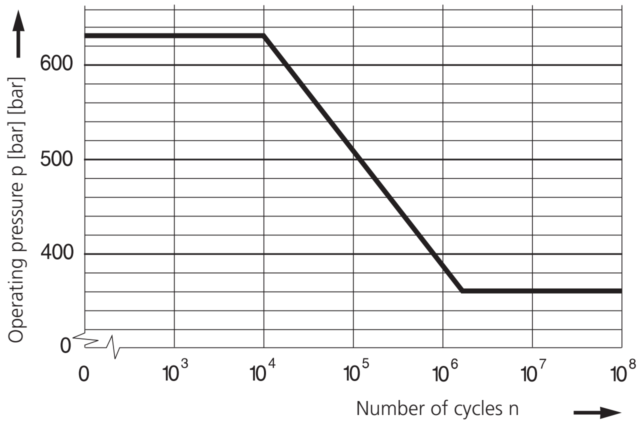
Characteristics

Operating pressure

0 ... 360 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 630 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 450 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines:
  up to 250 bar ≤ 8 m/s
  > 250 bar ≤ 12 m/s

Filter fineness

5 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20).

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

Preferably vertical, filter head on top

Connection

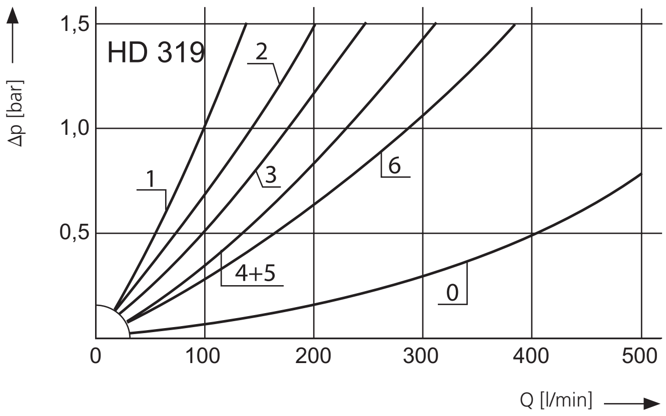
- Threaded ports according to ISO 228 or DIN 13
- SAE-flange (6000 psi)
  Sizes see Selection Chart, column 6 and ordering example (other connections on request).

Electrical clogging indicator

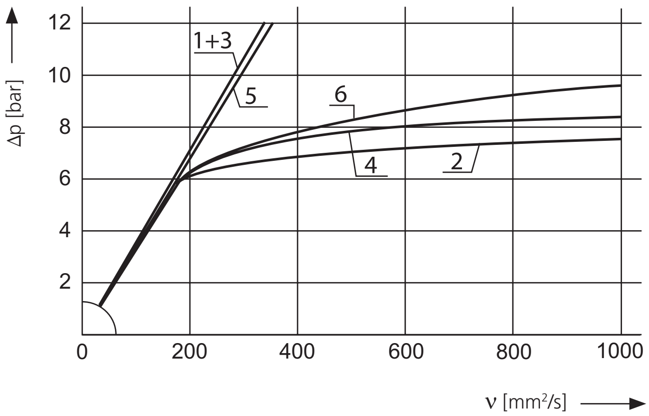
- Switching voltage: max. 120 V AC / 175 V DC
- Switching current: max. 0,17 A AC / 0,25 A DC
- Switching power: max. 3,5 VA AC / 5 W DC
- Type of contact: Change over
- Electrical protection: IP 65 (with mounted and secured socket)

Δp-curves for complete filters in Selection Chart, column 3

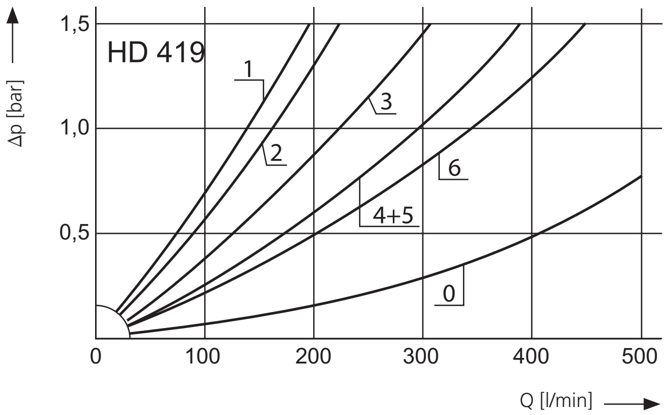
D1 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)



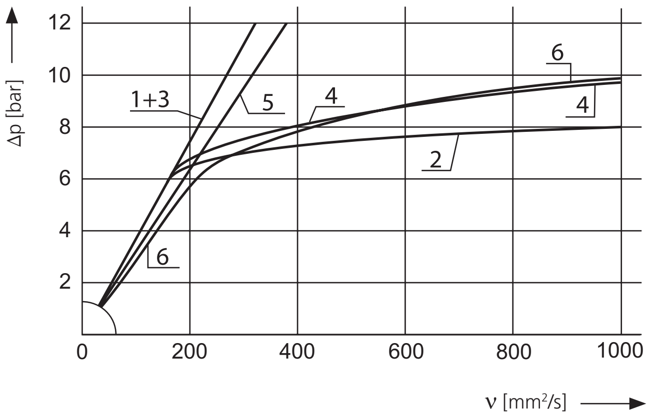
Pressure drop as a function of the
kinematic viscosity at nominal flow



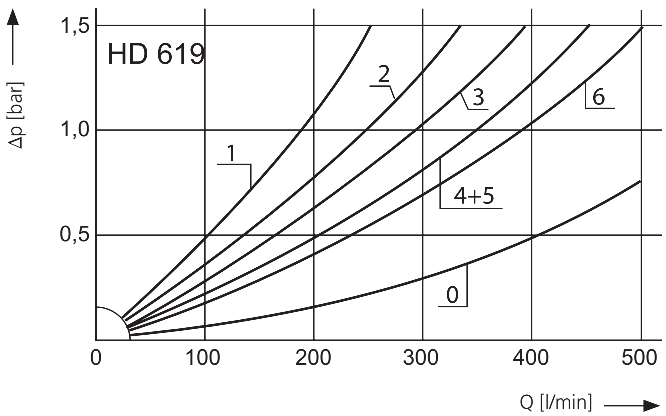
D2 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty))



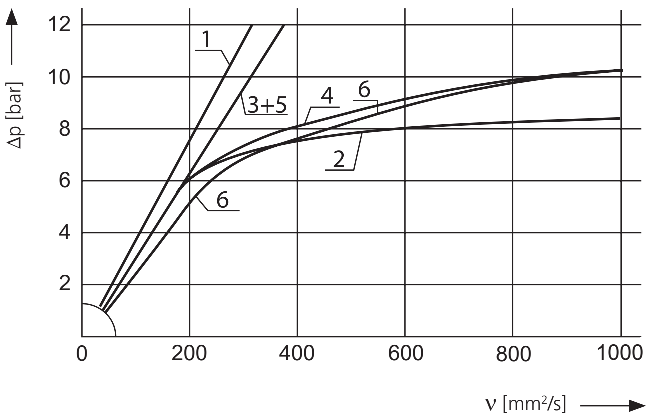
Pressure drop as a function of the
kinematic viscosity at nominal flow



D3 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)

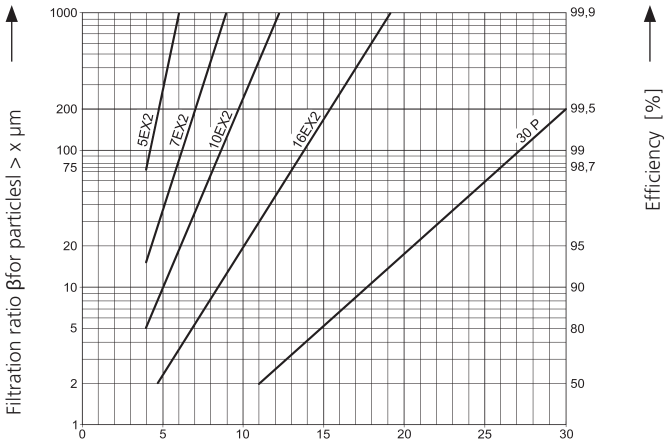


Pressure drop as a function of the
kinematic viscosity at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



Particle size x [µm] (for particles larger than the given particle size x)

The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Order Information

Two different head pieces with two various connecting options are available.

Order example: The Filter HD 319-289 has to be supplied with SAE 1¼ flanged connection.

Order descripton: **HD 319-189**

Connections:

2 options are available

Flanged connection (A/B) SAE 1¼ (6000 psi) — 1

Threaded port (A/B) G1¼ bzw. G1½ [2] — 2

Remarks:

- The filters listed in this chart are standard filters. If modifications are required, e.g. bolt mounted indicators according to catalogue sheet 60.30, we kindly ask for your request.
- If an electrical indicator is used, a transparent socket with LED for optical indication is also available with Part No. DG 041.1200.

[2] G1½ from series HD 619

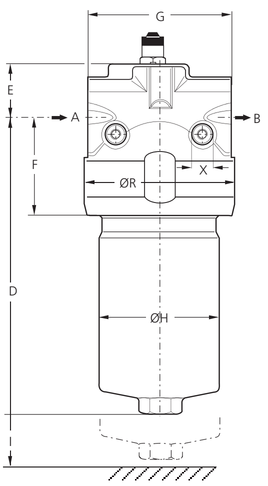
Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **DX**	Dirt-holding capactiy	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator Cracking pressure in ( )	Remarks
	l/min			g		bar			kg	bar	
1	2	3	4	5	6	7	8	9	10	11	12
HD 319-289	110	**D1**/1	5EX2	20	G1¼	-	6	V3.0817-13[1]	16,3	electrical (5)	change-over
HD 319-279	155	**D1**/2	5EX2	24	G1¼	7	2	V3.0817-03	15,9	optical (5)	-
HD 319-259	155	**D1**/2	5EX2	24	G1¼	7	3	V3.0817-03	15,9	electrical (5)	change-over
HD 319-286	195	**D1**/3	10EX2	24	G1¼	-	6	V3.0817-16[1]	16,3	electrical (5)	change-over
HD 319-276	250	**D1**/4	10EX2	33	G1¼	7	2	V3.0817-06	15,9	optical (5)	-
HD 319-256	250	**D1**/4	10EX2	33	G1¼	7	3	V3.0817-06	15,9	electrical (5)	change-over
HD 319-288	270	**D1**/5	16EX2	25	G1¼	-	6	V3.0817-18[1]	16,3	electrical (5)	change-over
HD 319-278	330	**D1**/6	16EX2	33	G1¼	7	2	V3.0817-08	15,9	optical (5)	-
HD 319-258	330	**D1**/6	16EX2	33	G1¼	7	3	V3.0817-08	15,9	electrical (5)	change-over
HD 419-289	155	**D2**/1	5EX2	29	G1¼	-	6	V3.0823-13[1]	17,8	electrical (5)	change-over
HD 419-279	190	**D2**/2	5EX2	33	G1¼	7	2	V3.0823-03	17,2	optical (5)	-
HD 419-259	190	**D2**/2	5EX2	33	G1¼	7	3	V3.0823-03	17,2	electrical (5)	change-over
HD 419-286	265	**D2**/3	10EX2	33	G1¼	-	6	V3.0823-16[1]	17,8	electrical (5)	change-over
HD 419-276	330	**D2**/4	10EX2	47	G1¼	7	2	V3.0823-06	17,2	optical (5)	-
HD 419-256	330	**D2**/4	10EX2	47	G1¼	7	3	V3.0823-06	17,2	electrical (5)	change-over
HD 419-288	330	**D2**/5	16EX2	35	G1¼	-	6	V3.0823-18[1]	17,8	electrical (5)	change-over
HD 419-278	380	**D2**/6	16EX2	48	G1¼	7	2	V3.0823-08	17,2	optical (5)	-
HD 419-258	380	**D2**/6	16EX2	48	G1¼	7	3	V3.0823-08	17,2	electrical (5)	change-over
HD 619-289	220	**D3**/1	5EX2	41	G1½	-	6	V3.0833-13[1]	20,6	electrical (5)	change-over
HD 619-279	280	**D3**/2	5EX2	49	G1½	7	2	V3.0833-03	19,9	optical (5)	-
HD 619-259	280	**D3**/2	5EX2	49	G1½	7	3	V3.0833-03	19,9	electrical (5)	change-over
HD 619-286	330	**D3**/3	10EX2	49	G1½	-	6	V3.0833-16[1]	20,6	electrical (5)	change-over
HD 619-276	400	**D3**/4	10EX2	67	G1½	7	2	V3.0833-06	19,9	optical (5)	-
HD 619-256	400	**D3**/4	10EX2	67	G1½	7	3	V3.0833-06	19,9	electrical (5)	change-over
HD 619-288	450	**D3**/5	16EX2	51	G1½	-	6	V3.0833-18[1]	20,6	electrical (5)	change-over
HD 619-278	450	**D3**/6	16EX2	68	G1½	7	2	V3.0833-08	19,9	optical (5)	-
HD 619-258	450	**D3**/6	16EX2	68	G1½	7	3	V3.0833-08	19,9	electrical (5)	change-over

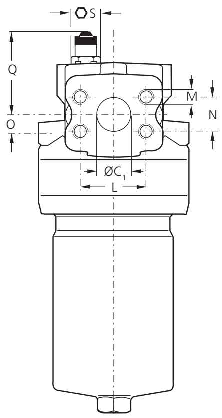
[1] Element differential pressure stable up to 160 bar

Dimensions

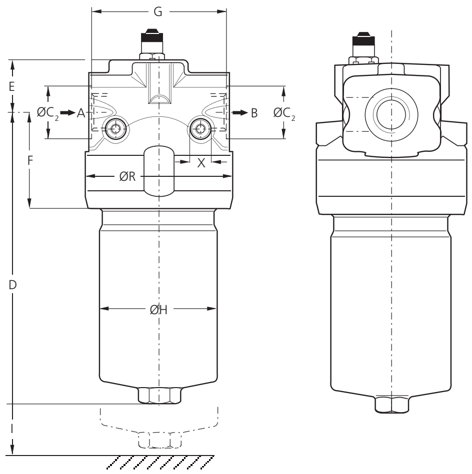
Flanged connection

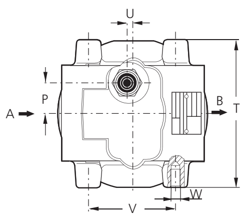


Version with integrated optical clogging indicator

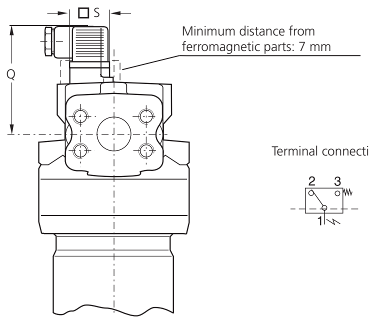


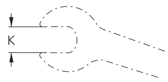
Threaded port





Version with integrated electrical clogging indicator





Terminal connection

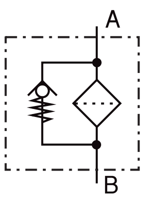
Measurements

Type	A/B	C_1	C_2	D	E	F	G	H	I	K	L	M Ø/depth	N	O	P	Q opt./electr.
HD 319	see	31	65	255	45	86	145	109	80	32	66,7	M14/22	31,8	18,5	33	75/92
HD 419	Selection	31	65	319	45	86	145	109	80	32	66,7	M14/22	31,8	18,5	33	75/92
HD 619	Chart	31	65	420	45	86	145	109	80	32	66,7	M14/22	31,8	18,5	33	75/92

Type	R	S opt./electr	T	U	V	W Ø/depth	X
HD 319	152	24/30	148	8	80	M12/18	27
HD 419	152	24/30	148	8	80	M12/18	27
HD 619	152	24/30	148	8	80	M12/18	27

Symbols

1



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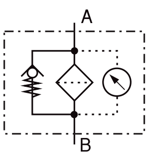

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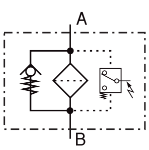

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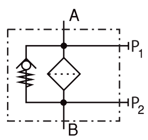
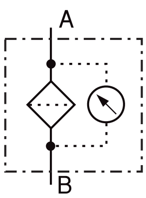


5



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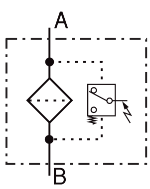
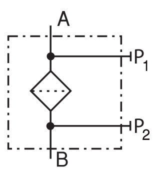
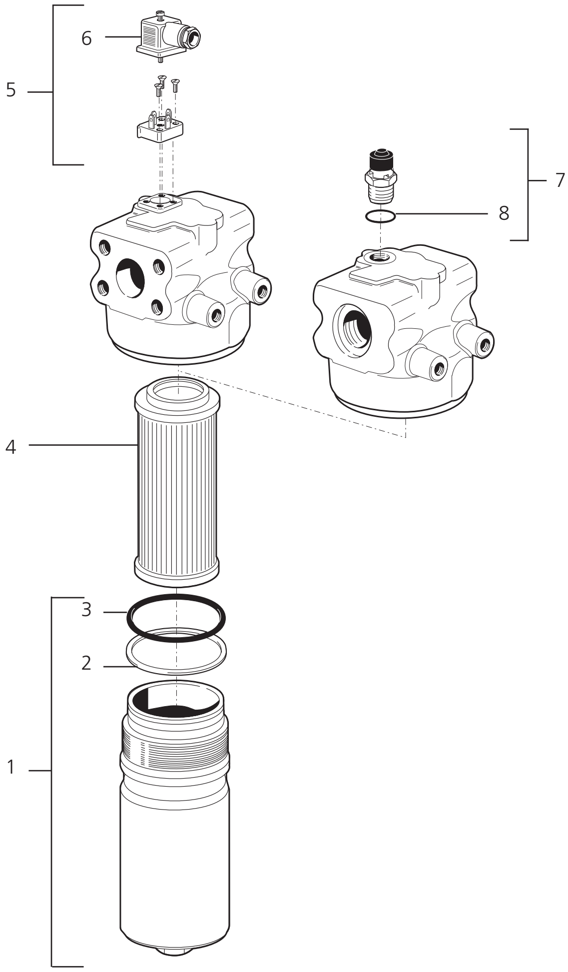


7



Spare Parts



Pos.	Designation	Part No.
1	Filter bowl HD 319 (with Pos. 2 und 3)	HD 250.0701
1	Filter bowl HD 419 (with Pos. 2 und 3)	HD 451.0702
1	Filter bowl HD 619 (with Pos. 2 und 3)	HD 619.0701
2	Back-ring	HD 255.0102
3	O-ring 94,84 x 3,53	N007.0953
4	Filter element	see Chart / col. 9
5	Reed switch with screws and socket (Pos. 6)	HD 049.1410
6	Reed switch with screws DIN 43650 - AF3	DG 041.1220
7	Optical indicator (with Pos. 8)	HD 049.1400
8	O-ring 17 x 2	N007.0172

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

HD 790 · HD 990

In-line mounting · Operating pressure up to 630 bar · Nominal flow rate up to 1.000 l/min

High Pressure Filter HD 990

Description

Application

In the high pressure circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start condition).

Filter elements

Flow direction from outside to center. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Spheroidal graphite cast iron (SGI)
Filter bowl:	Steel
Housing cover:	Spheroidal graphite cast iron (SGI)
Coating:	Powder paint
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 – inorganic multi-layer microfibre web

Accessories

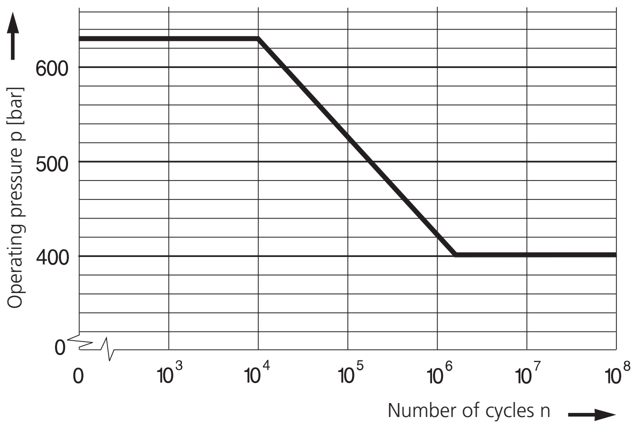
Electrical and/or optical clogging indicators are available – optionally with one or two switching points resp. temperature suppression.
Dimensions and technical data see catalogue sheet 60.30.

Operating pressure

0 ... 400 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 630 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 1000 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0.07 g per l/min flow volume
- flow velocity in the connection lines:
  up to 250 bar ≤ 8 m/s
  > 250 bar ≤ 12 m/s

Filter fineness

5 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

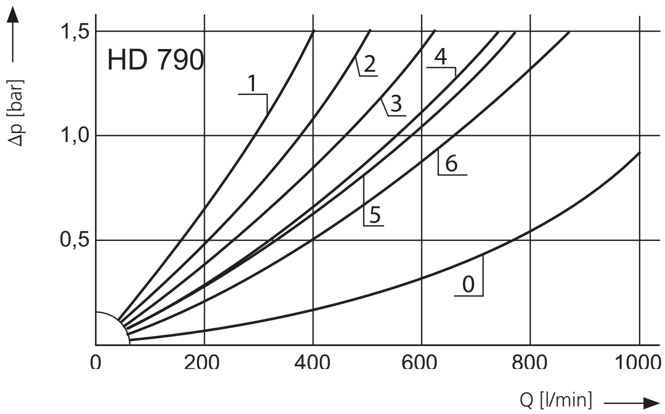
Preferably vertical. The filter head can be mounted in either the uppermost position or the inverse as required.

Connection

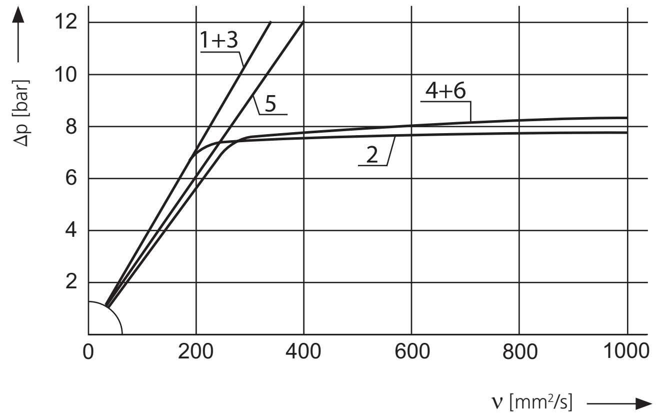
SAE-flange (6000 psi).
Sizes see Selection Chart, column 6 (other connections on request).

Δp-curves for complete filters in Selection Chart, column 3

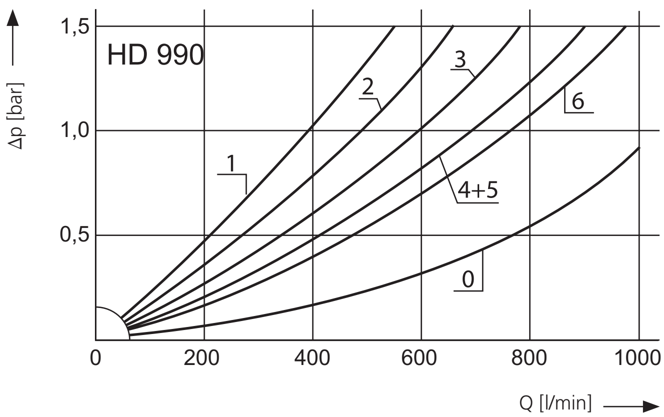
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



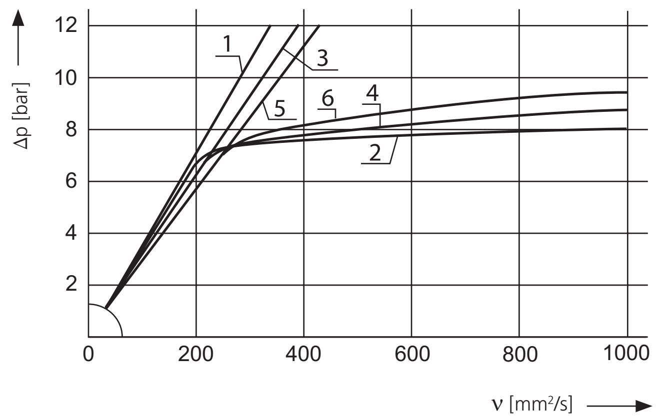
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

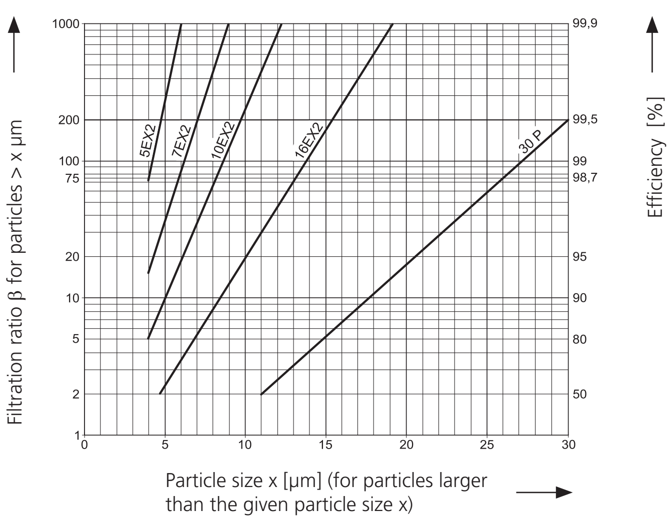


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator	Remarks
	l/min			g		bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
HD 790-189	320	**D1**/1	5EX2	58	SAE 2	-	7	V3.1040-13*	47	optional	-
HD 790-159	440	**D1**/2	5EX2	63	SAE 2	7	4	V3.1040-03	46	optional	-
HD 790-186	540	**D1/3**	10EX2	71	SAE 2	-	7	V3.1040-16*	47	optional	-
HD 790-156	640	**D1**/4	10EX2	88	SAE 2	7	4	V3.1040-06	46	optional	-
HD 790-188	660	**D1**/5	16EX2	72	SAE 2	-	7	V3.1040-18*	47	optional	-
HD 790-158	750	**D1**/6	16EX2	89	SAE 2	7	4	V3.1040-08	46	optional	-
HD 990-189	460	**D2**/1	5EX2	85	SAE 2	-	7	V3.1060-13*	56	optional	-
HD 990-159	570	**D2**/2	5EX2	95	SAE 2	7	4	V3.1060-03	55	optional	-
HD 990-186	680	**D2**/3	10EX2	110	SAE 2	-	7	V3.1060-16*	56	optional	-
HD 990-156	780	**D2**/4	10EX2	130	SAE 2	7	4	V3.1060-06	55	optional	-
HD 990-188	870	**D2**/5	16EX2	110	SAE 2	-	7	V3.1060-18*	56	optional	-
HD 990-158	1000	**D2**/6	16EX2	140	SAE 2	7	4	V3.1060-08	55	optional	-

* Element differential pressure stable up to 160 bar, clogging indicator is obligatory

Optical or electrical indicators are available to monitor the clogging condition of the element. If the indicator should be already mounted onto the filter head use the abbreviation “M” behind the part number of the indicator. The printed order acknowledgements show both items separately.

Order example: The filter HD 790-156 has to be supplied with optical clogging indicator – response pressure 5,0 bar

Order description: **HD 790-156** **/** **DG 042-02** **M**

Part No. (Basic unit) — **HD 790-156**

Mounted — **M**

Clogging indicator — **DG 042-02**

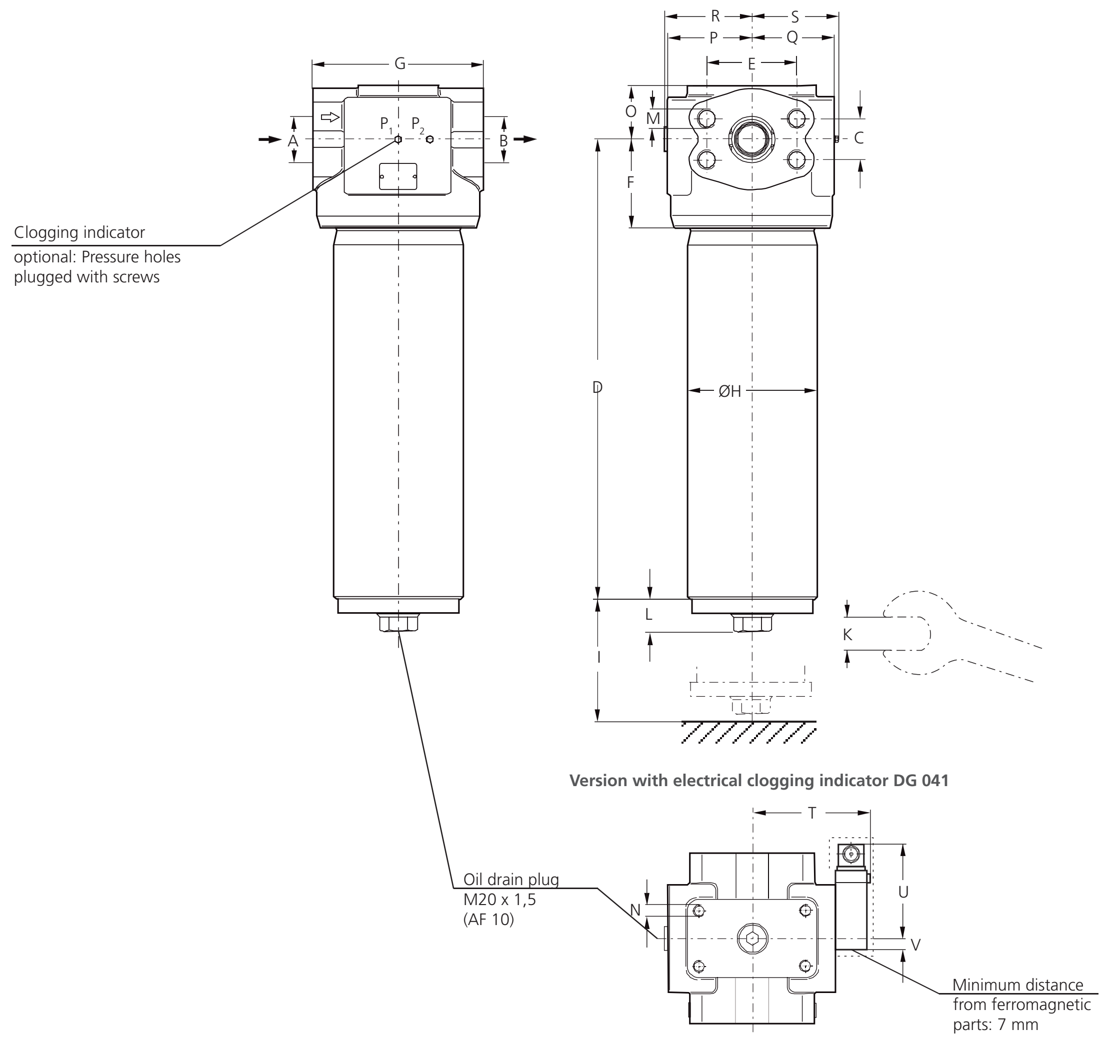
For the appropriate clogging indicators see catalogue sheet 60.30.

Remarks:

› Filter versions without by-pass valves must always be equipped with a clogging indicator.

› The filters listed in this chart are standard filters. Other designs available on request.

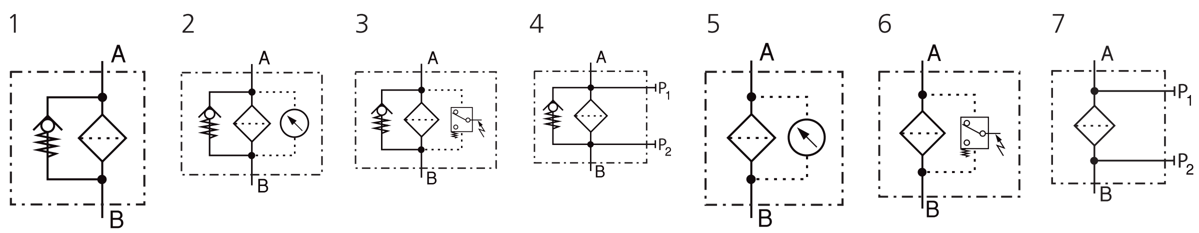
Dimensions



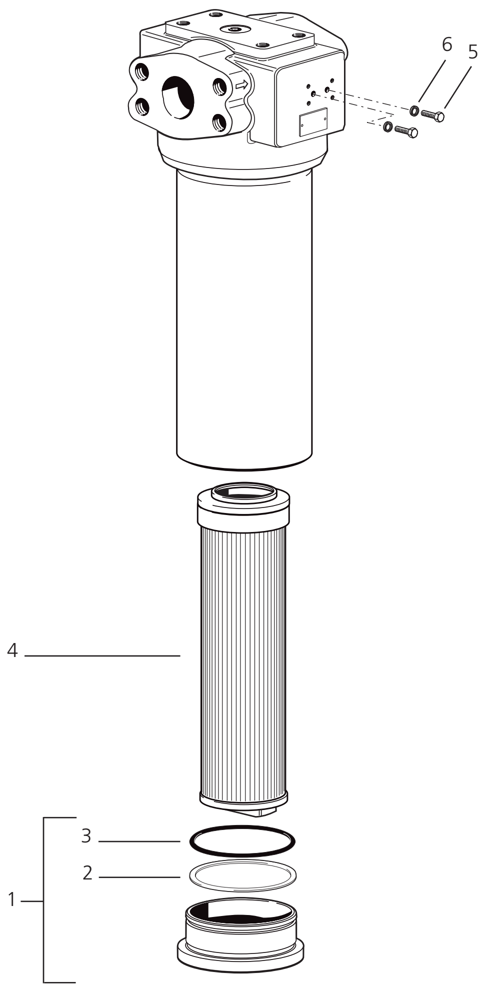
Measurements

Type	A/B	C	D	E	F	G	H	I	K	L	M Ø/depth	N Ø/depth	O	P	Q	R	S	T	U	V
HD 790	SAE 2	44,4	495	96,6	96	184	140	430	AF36	36	M20/32	M12/20	58	91	89	95	93	122	102	13
HD 990	SAE 2	44,4	700	96,6	96	184	140	640	AF36	36	M20/32	M12/20	58	91	89	95	93	122	102	13

Symbols



Spare Parts



Pos.	Designation	Part No.
1	Housing cover (with Pos. 2 and 3)	HD 990.1900
2	Back-ring	HD 256.0104
3	O-ring 104,37 x 3,53	N007.1044S
4	Filter element	see Chart / col. 9
5	Hexagonal head screw M4 x 8 ISO 4017-8.8	11385800
6	Bonded seal 4,1 x 7,2 x 1	12504600

The functions of the complete filters, as well as the outstanding features of the filter elements assured by ARGO-HYTOS, can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

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ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters..

HD 044 · HD 064

Flangeable · Operating pressure up to 500 bar · Nominal flow rate up to 105 l/min

High Pressure Filter HD 064

Description

Application

In the high pressure circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Spheroidal graphite cast iron (SGI)
Filter bowl:	Cold extruded steel
Coating:	Powder paint
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

Accessories

Electrical and/or optical clogging indicators are available - optionally with one or two switching points resp. temperature suppression.
Dimensions and technical data see catalogue sheet 60.30.

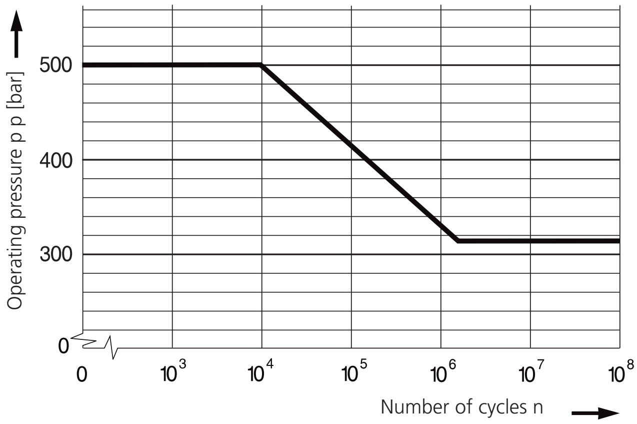
Characteristics

Operating pressure

0 ... 315 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 500 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 105 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines:
  up to 250 bar ≤ 8 m/s
  > 250 bar ≤ 12 m/s

Filter fineness

5 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: < 60 mm²/s
- as starting viscosity: ν_{max} = 1200 mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

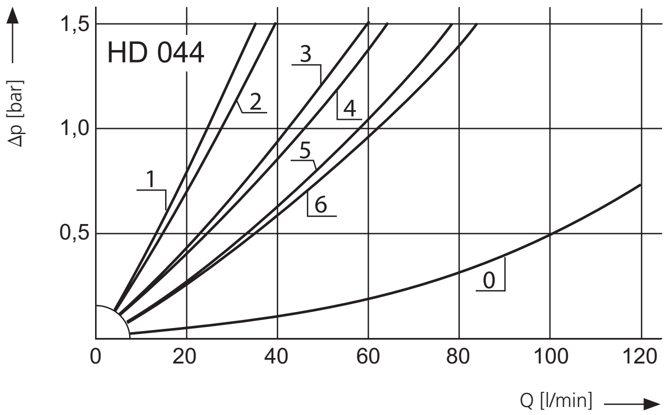
Preferably vertical, filter head on top

Connection

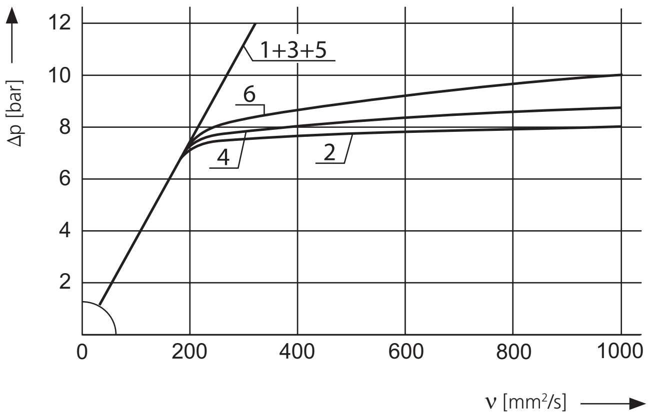
2 x Ø 15 mm on plain flange

Δp-curves for complete filters in Selection Chart, column 3

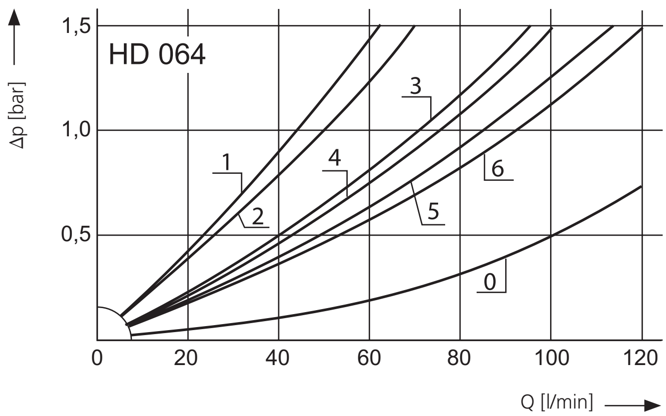
D1 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)



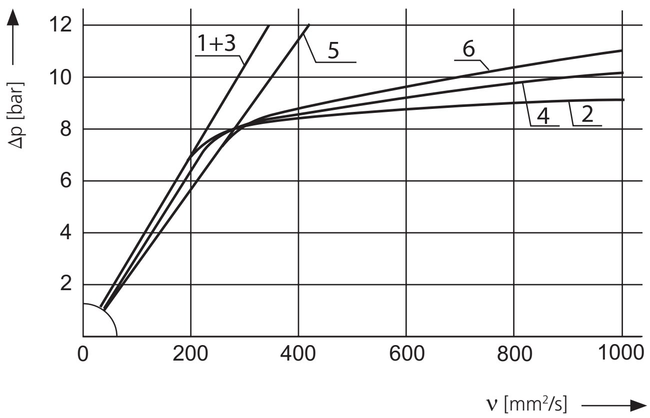
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s (0 = casing empty)

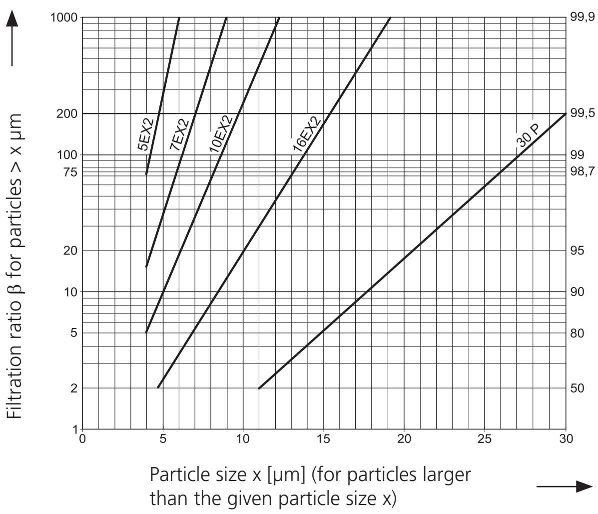


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator	Remarks
	l/min			g	mm	bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
HD 044-183	27	**D1**/1	5EX2	5,2	Ø 15	-	7	V3.0510-13[1]	3,4	optional	-
HD 044-153	30	**D1**/2	5EX2	4,9	Ø 15	7	4	V3.0510-03	3,4	optional	-
HD 044-186	47	**D1**/3	10EX2	5,1	Ø 15	-	7	V3.0510-16[1]	3,4	optional	-
HD 044-156	50	**D1**/4	10EX2	6,8	Ø 15	7	4	V3.0510-06	3,4	optional	-
HD 044-178	65	**D1**/5	16EX2	5,6	Ø 15	-	7	V3.0510-18[1]	3,4	optional	-
HD 044-158	75	**D1**/6	16EX2	6,9	Ø 15	7	4	V3.0510-08	3,4	optional	-
HD 064-183	50	**D2**/1	5EX2	8,7	Ø 15	-	7	V3.0520-13[1]	4,6	optional	-
HD 064-153	60	**D2**/2	5EX2	10	Ø 15	7	4	V3.0520-03	4,5	optional	-
HD 064-196	85	**D2**/3	10EX2	11	Ø 15	-	7	V3.0520-16[1]	4,6	optional	-
HD 064-156	85	**D2**/4	10EX2	14	Ø 15	7	4	V3.0520-06	4,5	optional	-
HD 064-178	100	**D2**/5	16EX2	12	Ø 15	-	7	V3.0520-18[1]	4,6	optional	-
HD 064-158	105	**D2**/6	16EX2	15	Ø 15	7	4	V3.0520-08	4,5	optional	-

[1] Element differential pressure stable up to 160 bar, clogging indicator is obligatory

Optical or electrical indicators are available to monitor the clogging condition of the element. If the indicator should be already mounted onto the filter head use the abbreviation "M" behind the part number of the indicator. The printed order acknowledgements show both items separately.

Order example: The filter HD 064-156 has to be supplied with optical clogging indicator - response pressure 5,0 bar

Order description: **HD 064-156** **/** **DG 042-02** **M**

Part No. (Basic unit)

Clogging indicator

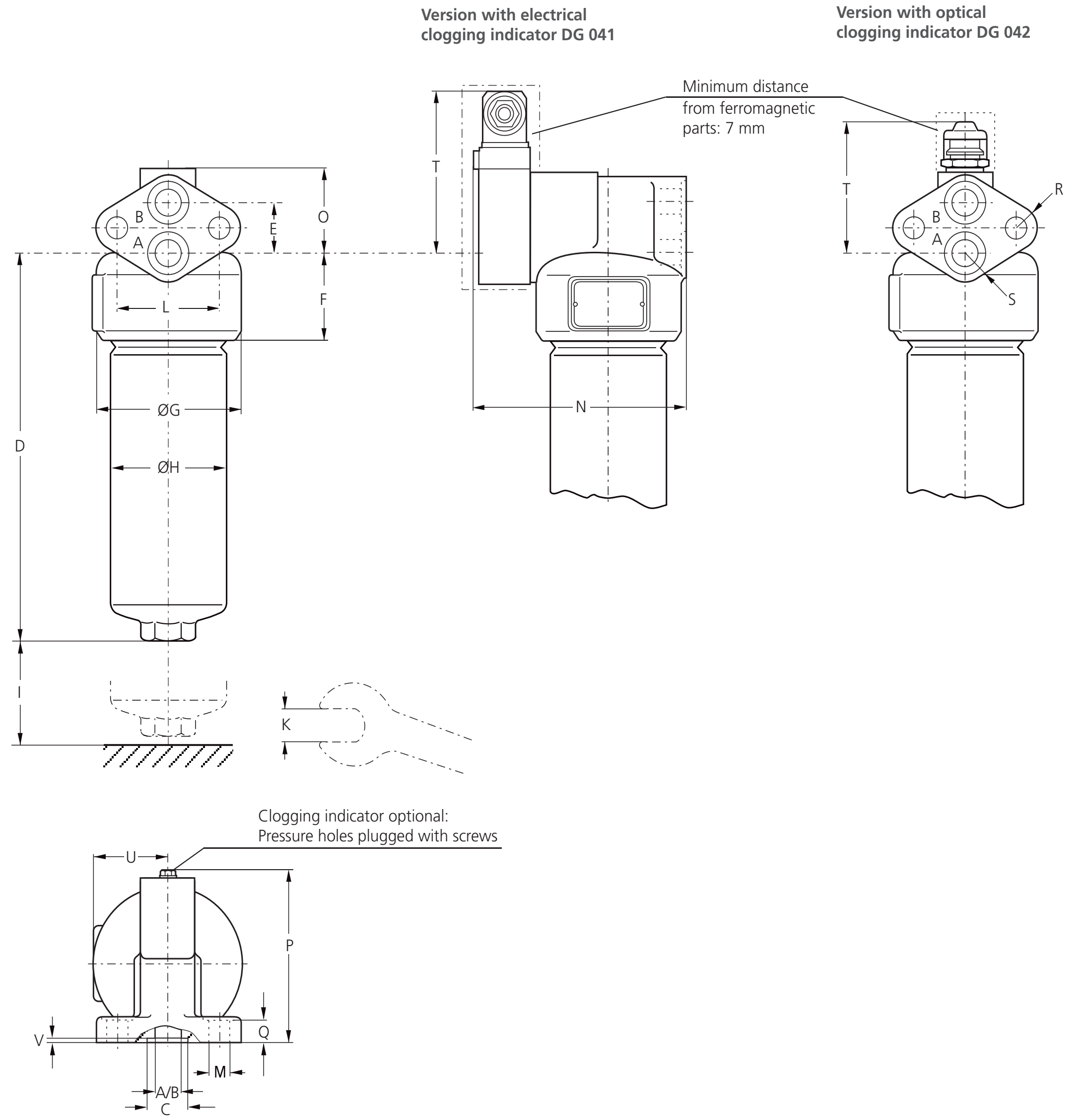
Mounted

For the appropriate clogging indicators see catalogue sheet 60.30.

Remarks:

- Filter versions without by-pass valves must always be equipped with a clogging indicator.
- The filters listed in this chart are standard filters. If modifications are required, e.g. filter fineness 30P, we kindly ask for your request.

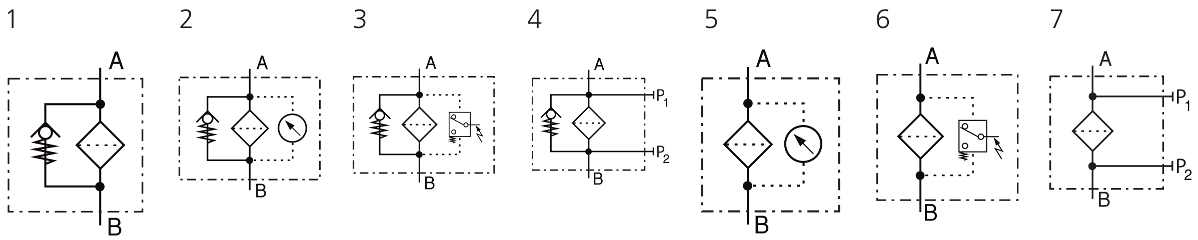
Dimensions



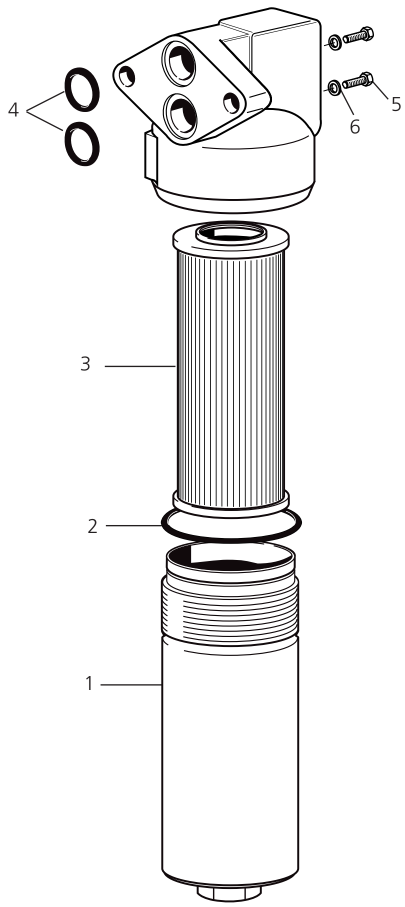
Measurements

Type	A/B	C	D	E	F	G	H	I	K	L	M	N	O	P	Q	R	S	T electr./opt.	U	V
HD 044	Ø 15	23,5	145	26	49	83	66	70	AF36	58	12,5	118,5	48	90	17	13	16	106 / 79	45	2
HD 064	Ø 15	23,5	241	26	49	83	66	70	AF36	58	12,5	118,5	48	90	17	13	16	106 / 79	45	2

Symbols



Spare Parts



Pos.	Designation	Part No.
1	Filter bowl HD 044	HD 052.0102
1	Filter bowl HD 064	HD 072.0102
2	O-ring 53,57 x 3,53	N007.0543/1
3	Filter element	s. Chart / col. 9
4	O-ring 18,72 x 2,62 *	N007.0193
5	Hexagonal head screw M4 x 8 DIN 933-8.8	11385800
6	Bonded Seal 4,1 x 7,2 x 1	12504600

*Not supplied with filter - has to be ordered separately

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941 Verification of collapse/burst pressure rating
ISO 2942 Verification of fabrication integrity (Bubble Point Test)
ISO 2943 Verification of material compatibility with fluids
ISO 3968 Evaluation of pressure drop versus flow characteristics
ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

High Pressure Filters

HD 314 · HD 414 · HD 614

Flangeable · Operating pressure up to 500 bar · Nominal flow rate up to 400 l/min

High Pressure Filter HD 414

Description

Application

In the high pressure circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at ≤ 200 mm²/s (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Spheroidal graphite cast iron (SGI)
Filter bowl:	Cold extruded steel
Coating:	Powder paint
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin

Accessories

Electrical and/or optical clogging indicators are available - optionally with one or two switching points resp. temperature suppression.
Dimensions and technical data see catalogue sheet 60.30.

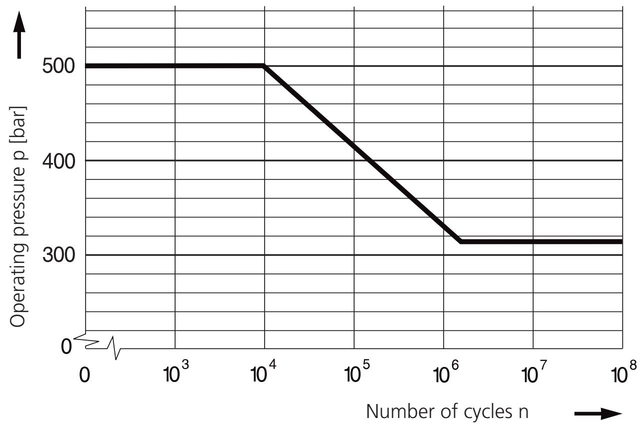
Characteristics

Operating pressure

0 ... 315 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 500 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 400 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm^2/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines:
  up to 250 bar ≤ 8 m/s
  > 250 bar ≤ 12 m/s

Filter fineness

5 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm^2/s
- as starting viscosity: $\nu_{max} = 1200$ mm^2/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

Preferably vertical, filter head on top

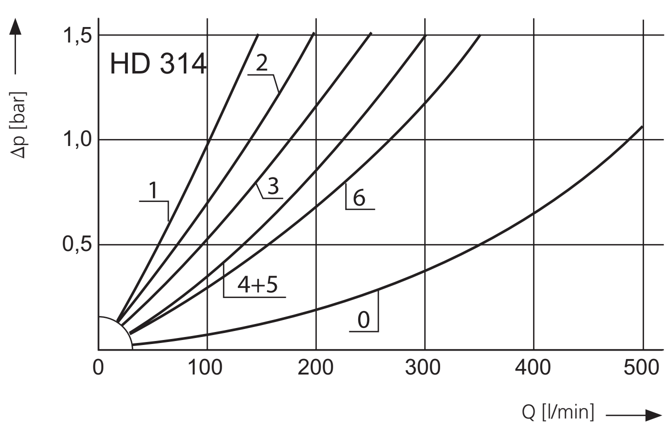
Connection

2 x Ø 31 mm on plain flange

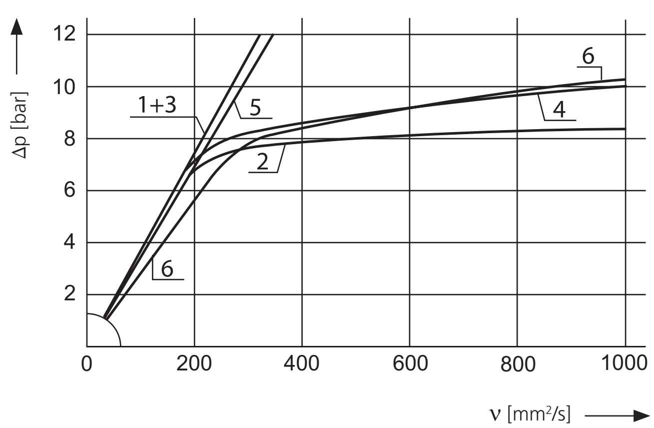
Diagrams

Δp-curves for complete filters in Selection Chart, column 3

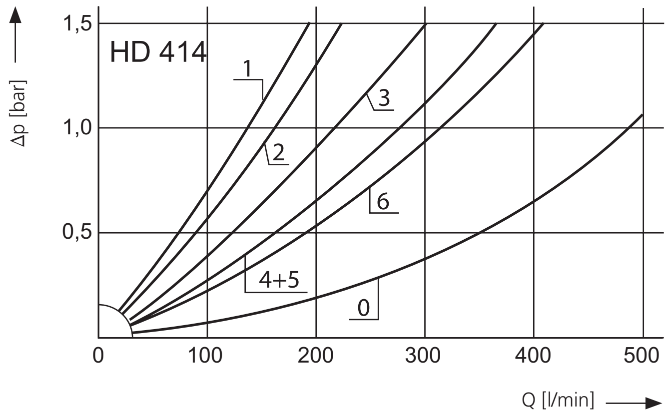
D1 Pressure drop as a function of the **flow volume** at $\nu = 35$ mm^2/s (0 = casing empty)



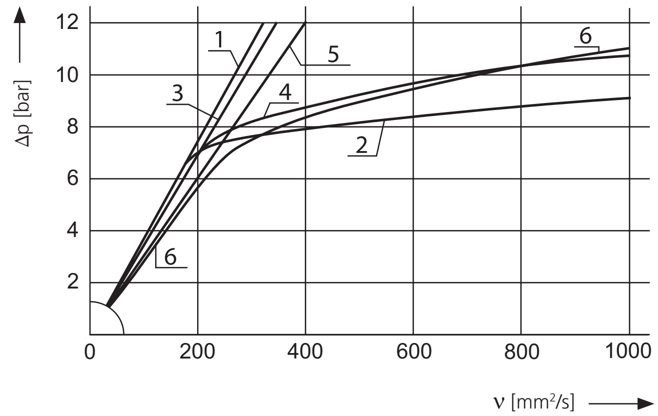
Pressure drop as a function of the **kinematic viscosity** at nominal flow



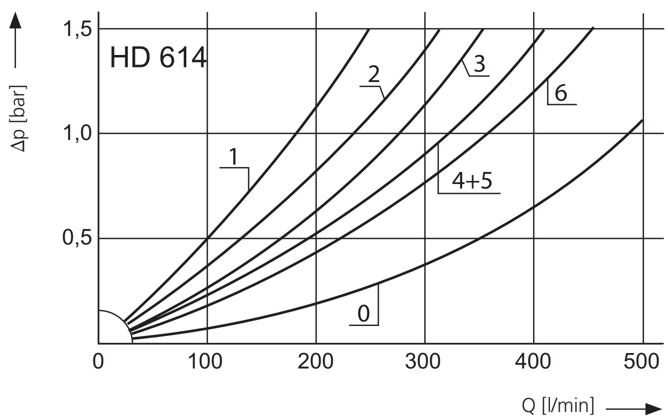
D2 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)



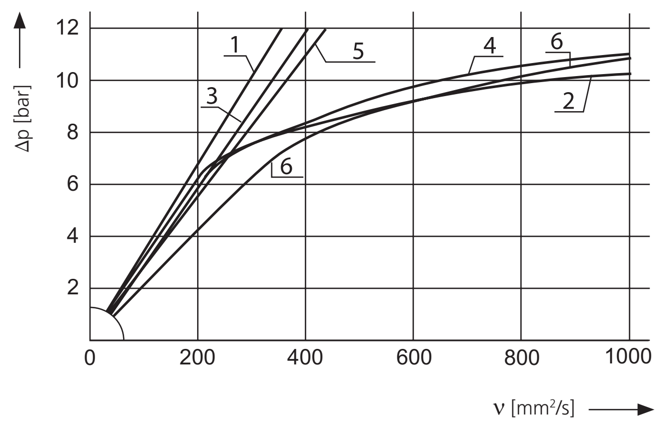
Pressure drop as a function of the
kinematic viscosity at nominal flow



D3 Pressure drop as a function of the
flow volume at ν = 35 mm²/s (0 = casing empty)

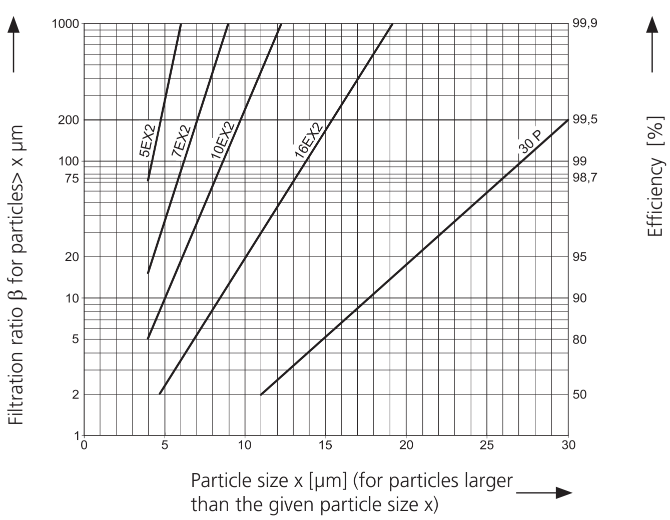


Pressure drop as a function of the
kinematic viscosity at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$ = 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$ = 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$ = 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$ = 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$ = 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator	Remarks
	l/min			g	mm	bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
HD 314-279	110	**D1**/1	5EX2	20	Ø 31	-	7	V3.0817-13*	14,2	optional	-
HD 314-259	155	**D1**/2	5EX2	24	Ø 31	7	4	V3.0817-03	13,8	optional	-
HD 314-246	195	**D1**/3	10EX2	24	Ø 31	-	7	V3.0817-16*	14,2	optional	-
HD 314-256	250	**D1**/4	10EX2	33	Ø 31	7	4	V3.0817-06	13,8	optional	-
HD 314-248	260	**D1**/5	16EX2	25	Ø 31	-	7	V3.0817-18*	14,2	optional	-
HD 314-258	300	**D1**/6	16EX2	33	Ø 31	7	4	V3.0817-08	13,8	optional	-
HD 414-279	155	**D2**/1	5EX2	29	Ø 31	-	7	V3.0823-13*	15,7	optional	-
HD 414-259	190	**D2**/2	5EX2	33	Ø 31	7	4	V3.0823-03	15,1	optional	-
HD 414-296	250	**D2**/3	10EX2	33	Ø 31	-	7	V3.0823-16*	15,7	optional	-
HD 414-256	310	**D2**/4	10EX2	47	Ø 31	7	4	V3.0823-06	15,1	optional	-
HD 414-298	310	**D2**/5	16EX2	35	Ø 31	-	7	V3.0823-18*	15,7	optional	-
HD 414-258	360	**D2**/6	16EX2	48	Ø 31	7	4	V3.0823-08	15,1	optional	-
HD 614-279	210	**D3**/1	5EX2	41	Ø 31	-	7	V3.0833-13*	18,5	optional	-
HD 614-259	270	**D3**/2	5EX2	49	Ø 31	7	4	V3.0833-03	17,8	optional	-
HD 614-246	310	**D3**/3	10EX2	49	Ø 31	-	7	V3.0833-16*	18,5	optional	-
HD 614-256	360	**D3**/4	10EX2	67	Ø 31	7	4	V3.0833-06	17,8	optional	-
HD 614-288	400	**D3**/5	16EX2	51	Ø 31	-	7	V3.0833-18*	18,5	optional	-
HD 614-258	400	**D3**/6	16EX2	68	Ø 31	7	4	V3.0833-08	17,8	optional	-

* Element differential pressure stable up to 160 bar, clogging indicator is obligatory

Optical or electrical indicators are available to monitor the clogging condition of the element. If the indicator should be already mounted onto the filter head use the abbreviation "M" behind the part number of the indicator. The printed order acknowledgements show both items separately.

Order example: The filter HD HD 314-279 has to be supplied with optical clogging indicator - response pressure 5,0 bar

Order description: **HD 314-279** **/** **DG 042-02** **M**

Mounted

Part No. (Basic unit)

Clogging indicator

For the appropriate clogging indicators see catalogue sheet 60.30.

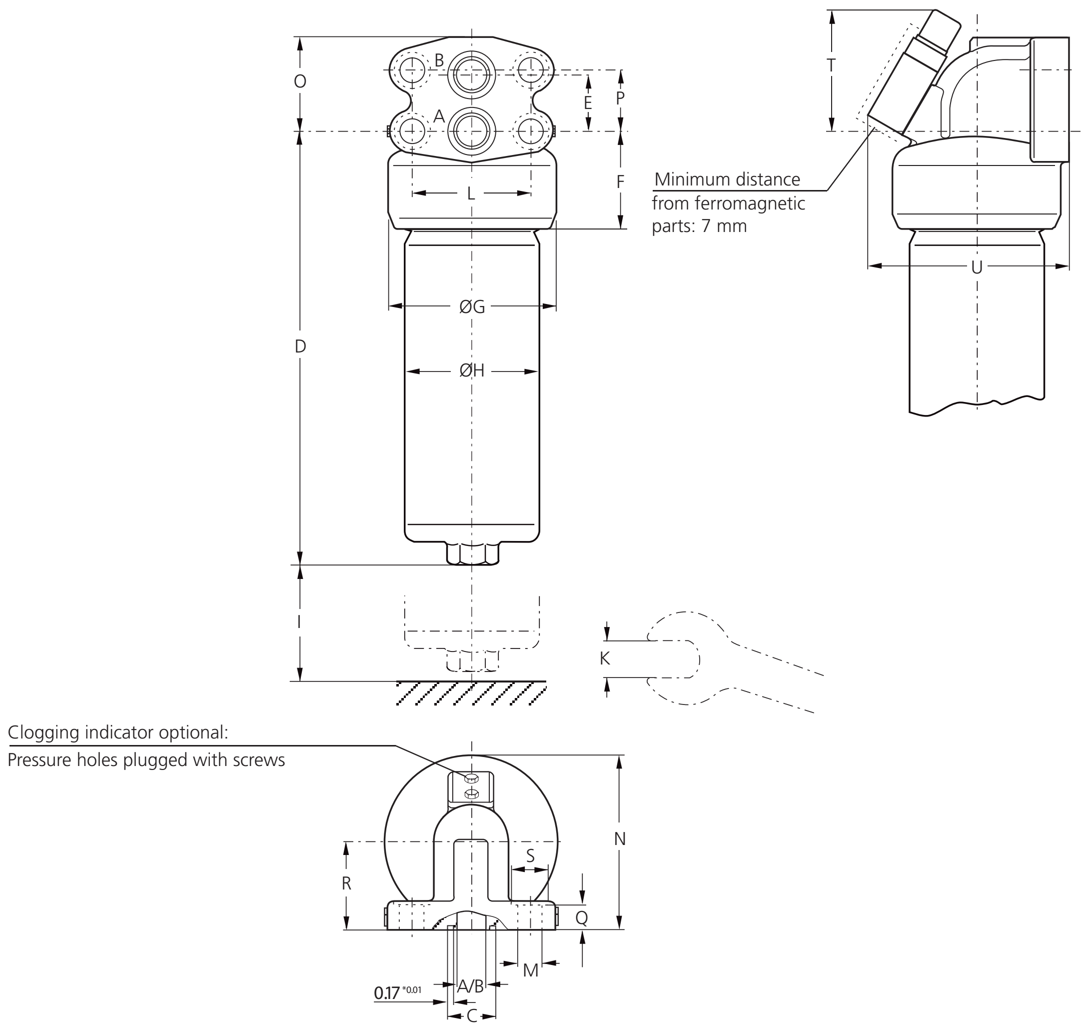
Remarks:

› Filter versions without by-pass valves must always be equipped with a clogging indicator.

› The filters listed in this chart are standard filters. If modifications are required, e.g. filter fineness 30P, we kindly ask for your request.

Dimensions

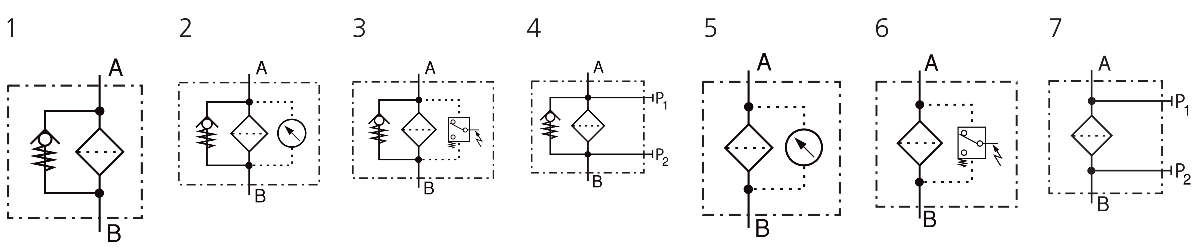
Version with electrical clogging indicator DG 041



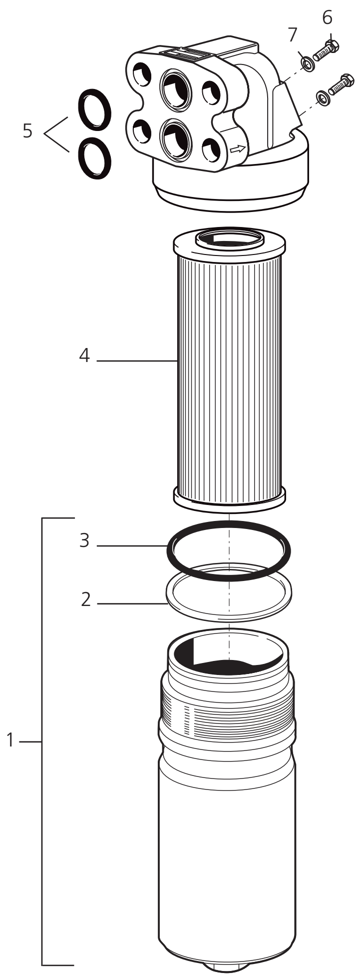
Measurements

Type	A/B	C	D	E	F	G	H	I	K	L	M	N	O	P	Q	R	S	T	U
HD 314	Ø 31	44,4	263	52	82	138	109	80	AF32	95	21,5	150	83	58	25	80	34	93	165
HD 414	Ø 31	44,4	325	52	82	138	109	80	AF32	95	21,5	150	83	58	25	80	34	93	165
HD 614	Ø 31	44,4	426	52	82	138	109	80	AF32	95	21,5	150	83	58	25	80	34	93	165

Symbols



Spare Parts



Pos.	Designation	Part No.
1	Filter bowl HD 314 (with Pos. 2 und 3)	HD 250.0701
1	Filter bowl HD 414 (with Pos. 2 und 3)	HD 451.0702
1	Filter bowl HD 614 (with Pos. 2 und 3)	HD 619.0701
2	Back-ring	HD 255.0102
3	O-ring 94,84 x 3,53	N007.0953
4	Filter element	s. Chart / col. 9
5	O-ring 37,69 x 3,53 *	N007.0384
6	Hexagonal head screw M4 x 8 DIN 933-8.8	11385800
7	Bonded Seal 4,1 x 7,2 x 1	12504600

* Not supplied with filter - has to be ordered separately

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941 Verification of collapse/burst pressure rating
ISO 2942 Verification of fabrication integrity (Bubble Point Test)
ISO 2943 Verification of material compatibility with fluids
ISO 3968 Evaluation of pressure drop versus flow characteristics
ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

High Pressure Filters

HD 417 · HD 617

Bi-directional flow · In-line mounting · Operating pressure up to 500 bar · Nominal flow rate up to 420 l/min

High Pressure Filter HD 417

Description

Application

In the high pressure circuits of hydraulic systems with changing flow direction.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start condition).

Special features

Reverse flow valves:
The "Graetz" system (see Symbols) integrated into the head piece ensures the filtration of the hydraulic fluid in both flow directions.

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter head:	Spheroidal graphite cast iron (SGI)
Filter bowl:	Cold extruded steel
Coating:	Powder paint
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web Paper - cellulose web, impregnated with resin

Accessories

Electrical and/or optical clogging indicators are available - optionally with one or two switching points resp. temperature suppression.
Dimensions and technical data see catalogue sheet 60.30.

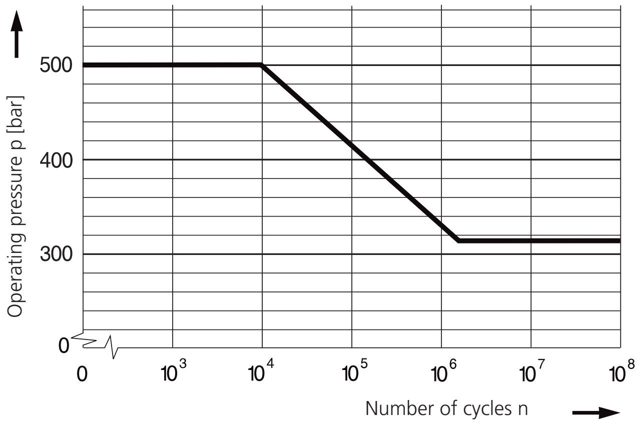
Characteristics

Operating pressure

0 ... 315 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 500 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 420 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines:
  up to 250 bar ≤ 8 m/s
  > 250 bar ≤ 12 m/s

Filter fineness

5 µm(c) ... 30 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity: $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

Mounting position

Preferably vertical, filter head on top

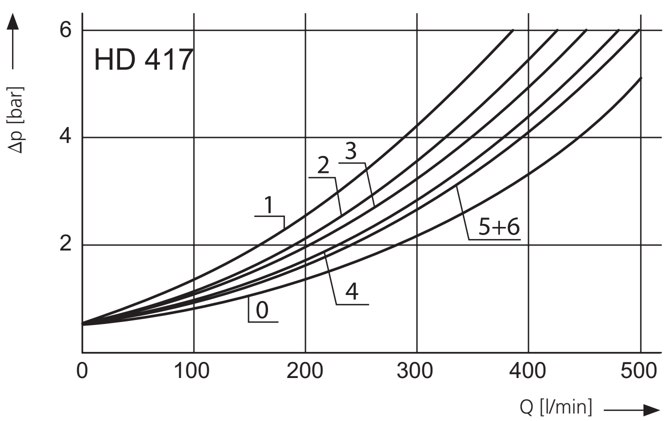
Connection

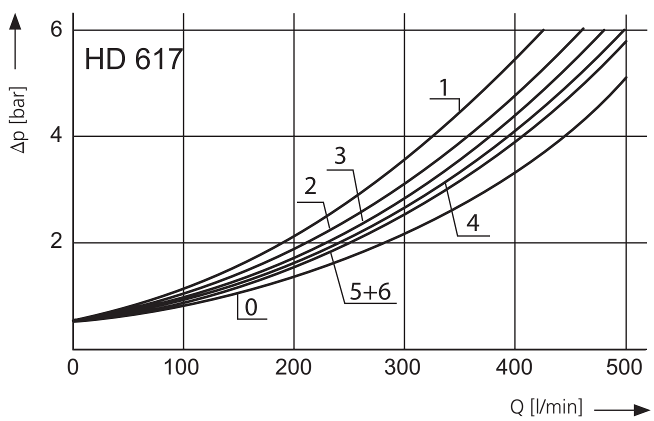
SAE-flange (6000 psi). Sizes see Selection Chart, column 6
(other connections on request)

Diagrams

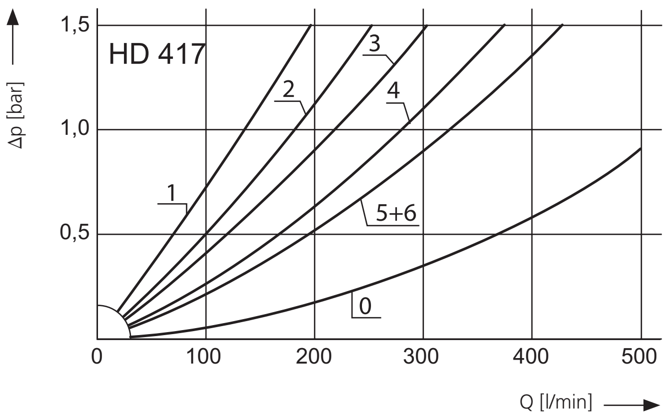
Δp-curves for complete filters in Selection Chart, column 3

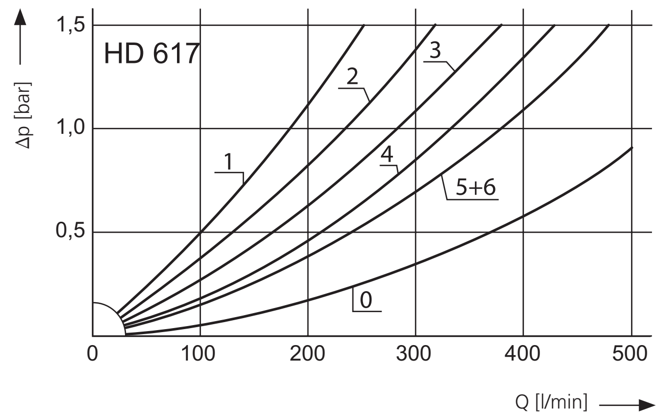
D1 Pressure drop as a function of the **flow volume** at $\nu = 35$ mm²/s, measurement **with** reverse flow valves, (0 = casing empty)



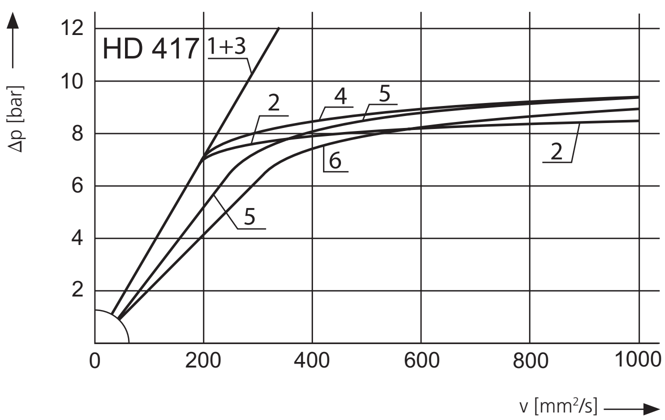


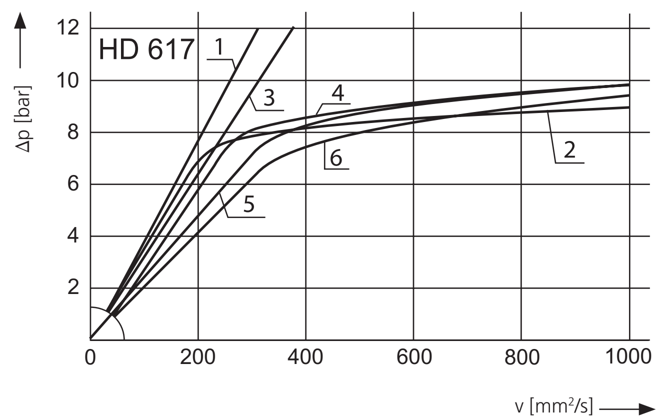
D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s, measurement **without** reverse flow valves, (0 = casing empty)





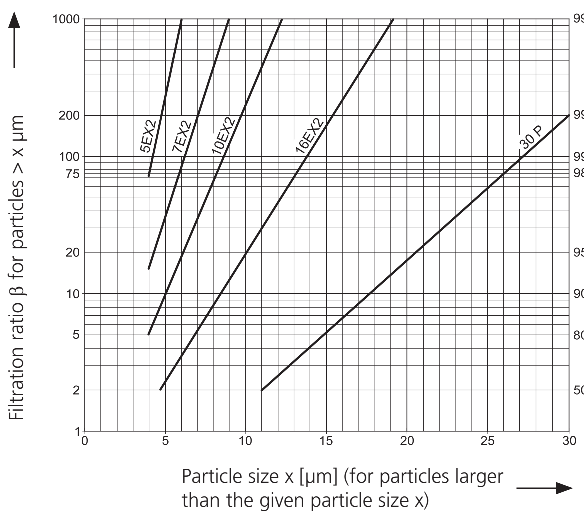
D3 Pressure drop as a function of the **kinematic viscosity** at nominal flow, measurement **without** reverse flow valves





Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses:

For EXAPOR®MAX2 and Paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\overline{\beta}_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator	Remarks
	l/min			g		bar			kg		
1	2	3	4	5	6	7	8	9	10	11	12
HD 417-149	150	**D1,2,3**/1	5EX2	29	SAE 1¼	-	3	V3.0823-13[1]	20,3	optional	[2]
HD 417-179	220	**D1,2,3**/2	5EX2	33	SAE 1¼	7	1	V3.0823-03	19,7	optional	-
HD 417-146	260	**D1,2,3**/3	10EX2	33	SAE 1¼	-	3	V3.0823-16[1]	20,3	optional	[2]
HD 417-176	320	**D1,2,3**/4	10EX2	47	SAE 1¼	7	1	V3.0823-06	19,7	optional	-
HD 417-168	350	**D1,2,3**/5	16EX2	48	SAE 1¼	7	1	V3.0823-08	19,7	optional	-
HD 417-161	350	**D1,2,3**/6	30P	26	SAE 1¼	7	1	P3.0823-01[3]	19,7	optional	-
HD 617-149	220	**D1,2,3**/1	5EX2	41	SAE 1½	-	3	V3.0833-13[1]	23,1	optional	[2]
HD 617-179	280	**D1,2,3**/2	5EX2	49	SAE 1½	7	1	V3.0833-03	22,4	optional	-
HD 617-146	320	**D1,2,3**/3	10EX2	49	SAE 1½	-	3	V3.0833-16[1]	23,1	optional	[2]
HD 617-176	380	**D1,2,3**/4	10EX2	67	SAE 1½	7	1	V3.0833-06	22,4	optional	-
HD 617-178	420	**D1,2,3**/5	16EX2	68	SAE 1½	7	1	V3.0833-08	22,4	optional	-
HD 617-161	420	**D1,2,3**/6	30P	34	SAE 1½	7	1	P3.0833-01[3]	22,4	optional	-

[1] Element differential pressure up to 160 bar
[2] Clogging indicator is obligatory
[3] Paper media supported with metal gauze

Optical or electrical indicators are available to monitor the clogging condition of the element. If the indicator should be already mounted onto the filter head use the abbreviation „M“ behind the part number of the indicator. The printed order acknowledgements show both items separately.

Order example: The filter HD 417-149 has to be supplied with electrical clogging indicator - cracking pressure 5,0 bar

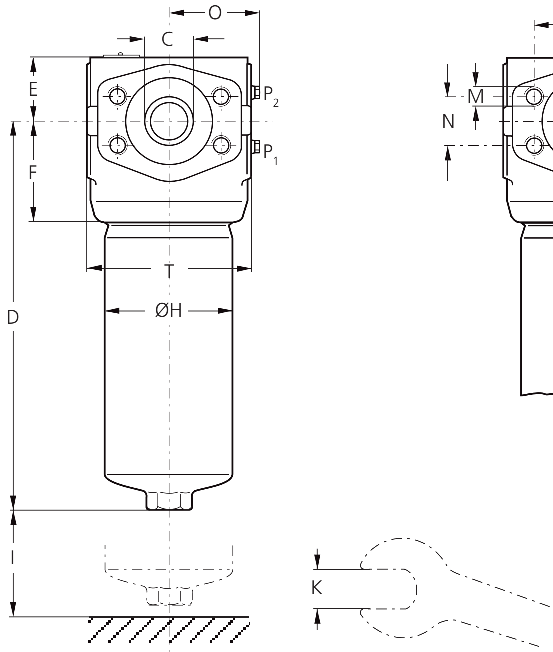
Order description: **HD 417-149** / **DG 041-33** **M**
Part No. (Basic unit) **Mounted**
Clogging indicator

For the appropriate clogging indicators see catalogue sheet 60.30.

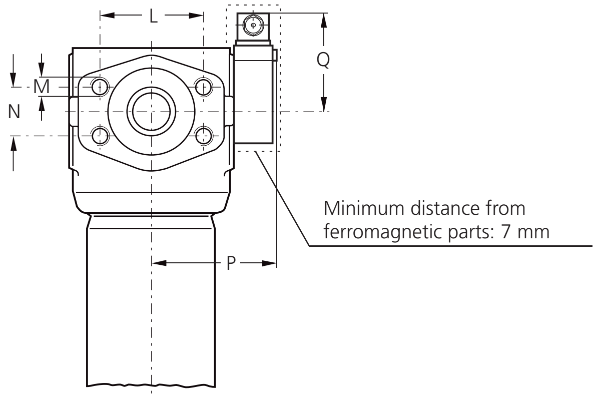
Remarks:

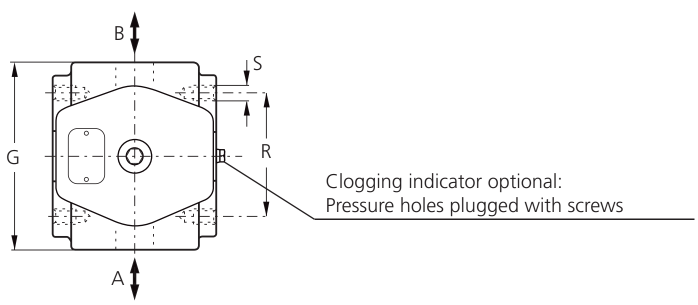
› Filter versions without by-pass valves must always be equipped with a clogging indicator.
› The filters listed in this chart are standard filters. Other designs available on request.

Dimensions



Version with electrical clogging indicator DG 041



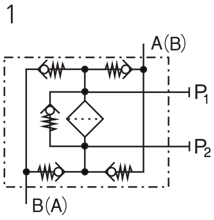


Measurements

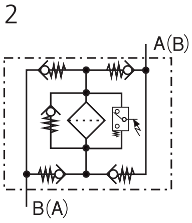
Type	A/B	C	D	E	F	G	H	I	K	L	M Ø/depth	N	O	P	Q	R	S Ø/depth	T
HD 417	SAE 1¼	31,5	328	58	87,5	156	108	80	AF32	66,7	M14/22	31,8	73	102	87	100	M12/18	138
HD 617	SAE 1½	31,5	428	58	87,5	156	108	80	AF32	79,4	M16/24	36,5	73	102	87	100	M12/18	138

Symbols

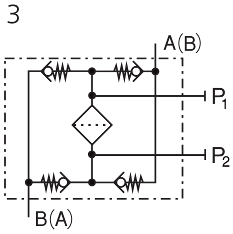
1



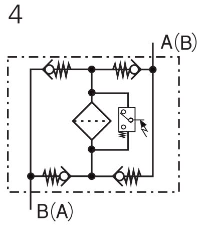
2



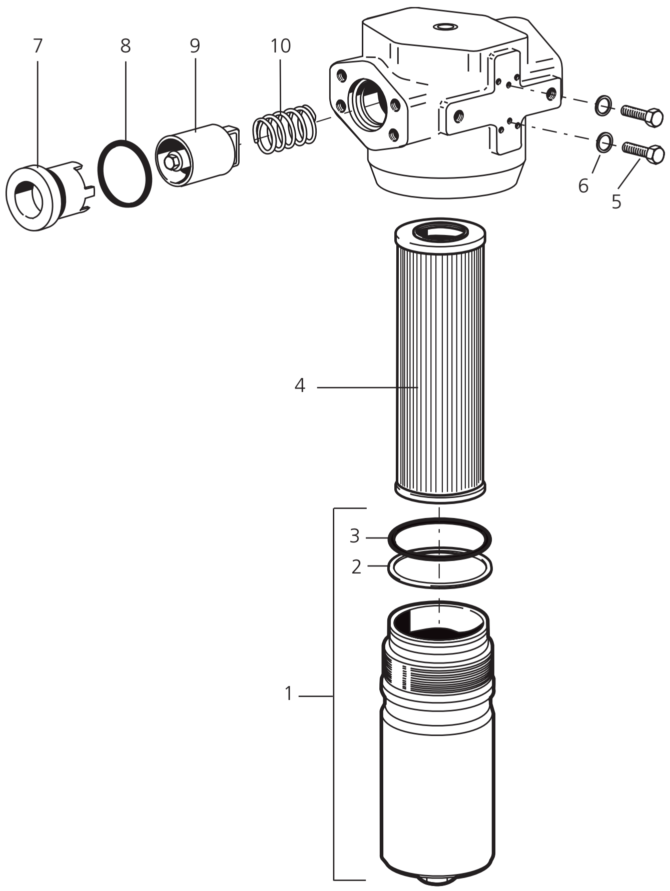
3



4



Spare Parts



Pos.	Designation	Part No.
1	Filter bowl HD 417 (with Pos. 2 and 3)	HD 451.0702
1	Filter bowl HD 617 (with Pos. 2 and 3)	HD 619.0701
2	Back-ring	HD 255.0102
3	O-ring 94,84 x 3,53	N007.0953
4	Filter element	see Chart / col. 9
5	Hexagonal head screw M4 x 8 DIN 933-8.8	11385800
6	Bonded seal 4,1 x 7,2 x 1	12504600
7	Sleeve	HD 417.0505
8	O-ring 42,52 x 2,62	N007.0433
9	Reverse flow valve	HD 417.1520
10	Spring DM 38	N015.3801

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

High Pressure Filter Kits

HD 049 · HD 069 · HD 172 · HD 319 · HD 419 · HD 619

Operating pressure up to 630 bar · Nominal flow rate up to 450 l/min

High Pressure Filter Kit HD 049

Description

Application

In the high pressure circuits of hydraulic systems.

Performance features

Protection against wear:
By means of filter elements that, in full-flow filtration, meet even the highest demands regarding cleanliness classes.

Protection against malfunction:
Through installation near to the control valves or other expensive components. The specific determined flow rate guarantees a closed by-pass valve even at $\nu \leq 200$ mm²/s (cold start condition).

Filter elements

Flow direction from outside to centre. The star-shaped pleating of the filter material results in:

- large filter surfaces
- low pressure drop
- high dirt-holding capacities
- long service life

Filter maintenance

By using a clogging indicator the correct moment for maintenance is stated and guarantees the optimum utilization of the filter life.

Materials

Filter bowl:	Cold extruded steel
Coating:	Powder paint
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 2 - inorganic multi-layer microfibre web

Accessories

To monitor the clogging, screw-in (see section Dimensions) or flange-mounted differential pressure switches are available. Flange-mounted clogging indicators optionally with one or two switching points resp. temperature suppression – Dimensions and technical data see catalogue sheet 60.30.

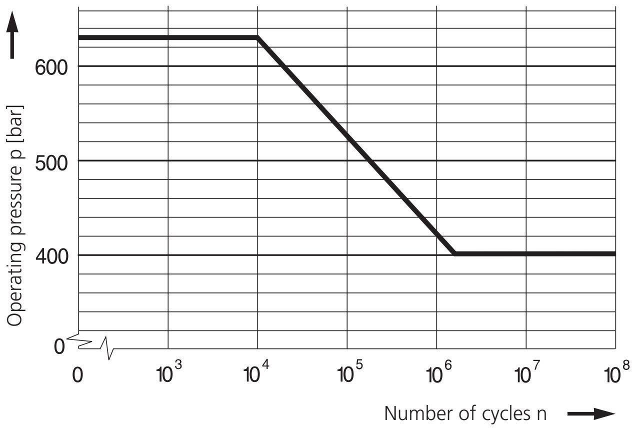
Characteristics

Operating Pressure

0 ... 400 bar, min. 2 x 10^6 pressure cycles
Nominal pressure according to DIN 24550

0 ... 630 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Permissible pressures for other numbers of cycles



Nominal flow rate

Up to 450 l/min (see Selection Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- closed by-pass valve at $\nu \leq 200$ mm²/s
- element service life > 1000 operating hours at an average fluid contamination of 0,07 g per l/min flow volume
- flow velocity in the connection lines:
  up to 250 bar ≤ 8 m/s
  > 250 bar ≤ 12 m/s

Filter fineness

5 µm(c) ... 16 µm(c)
β-values according to ISO 16889
(see Selection Chart, column 4 and diagram Dx)

Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889
(see Selection Chart, column 5)

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Viscosity at nominal flow rate

- at operating temperature: $\nu < 60$ mm²/s
- as starting viscosity $\nu_{max} = 1200$ mm²/s
- at initial operation:
  The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70 % Δp of the cracking pressure of the by-pass valve on the vertical axis. Draw a horizontal line so that it intersects the Δp curve at a point. Read this point on the horizontal axis for the viscosity.

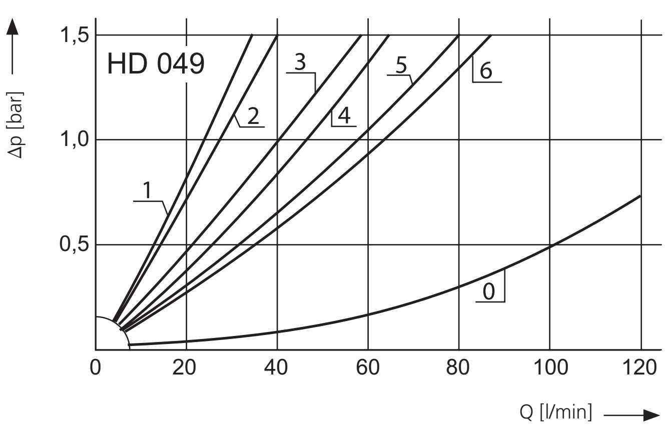
Mounting position

Preferably vertical

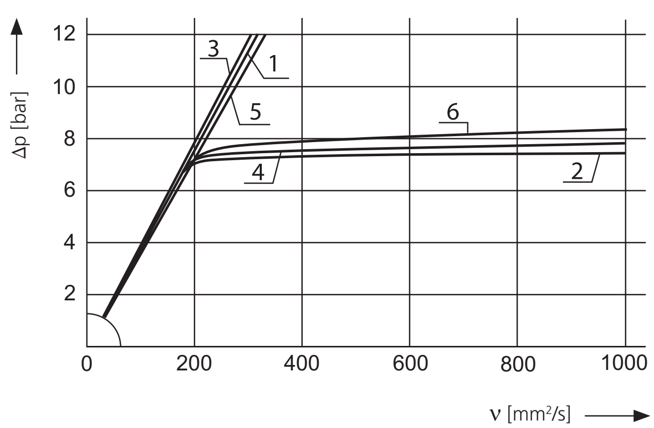
Diagrams

Δp-curves for complete filters in Selection Chart, column 3

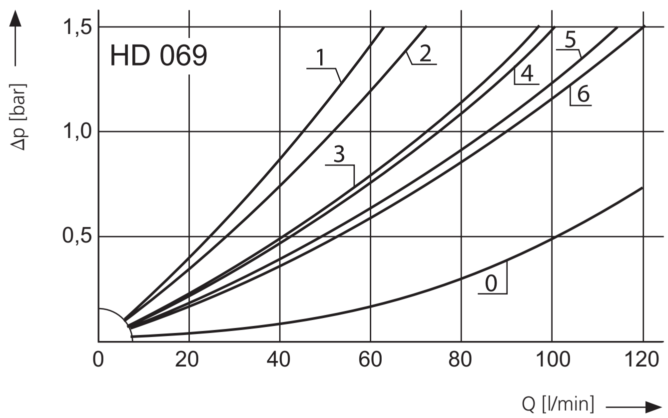
D1 Pressure drop as a function of the **flow volume** at $\nu = 35$ mm²/s



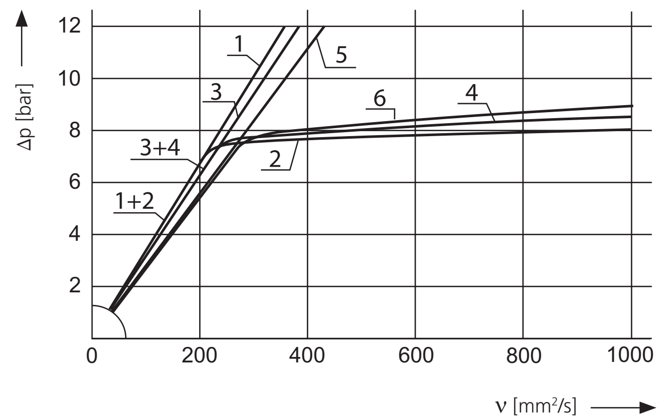
Pressure drop as a function of the **kinematic viscosity** at nominal flow



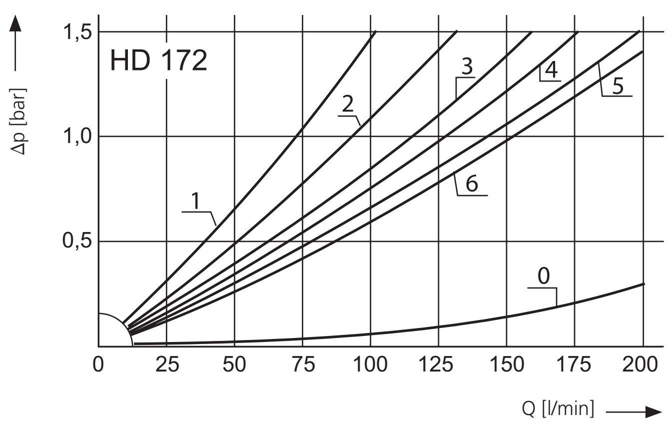
D2 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s



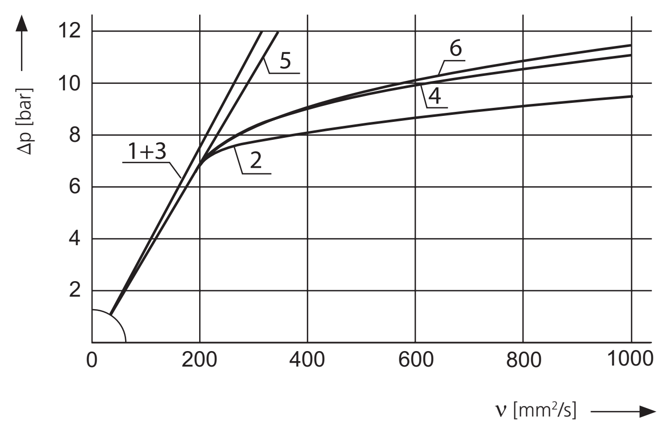
Pressure drop as a function of the **kinematic viscosity** at nominal flow



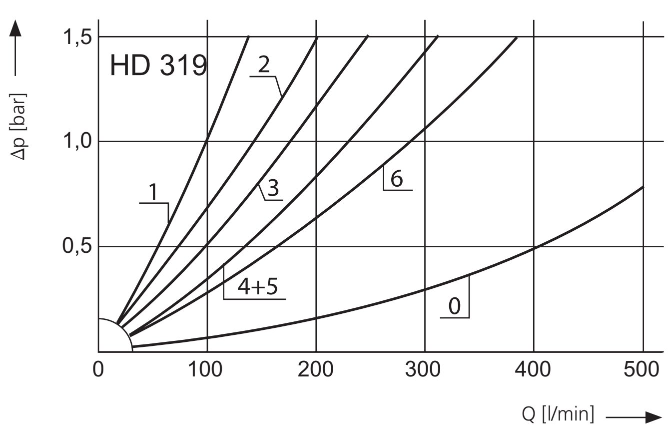
D3 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s



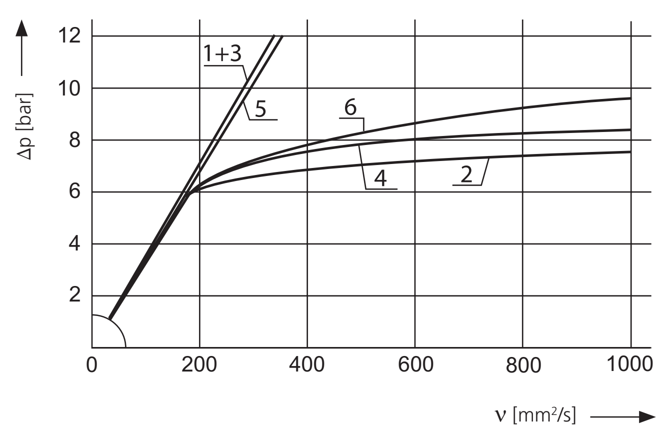
Pressure drop as a function of the **kinematic viscosity** at nominal flow



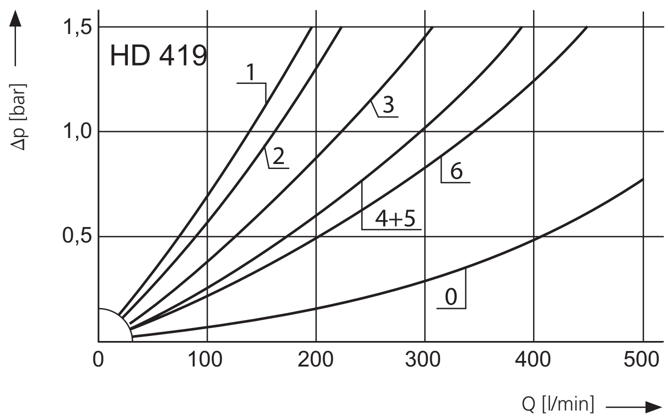
D4 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s



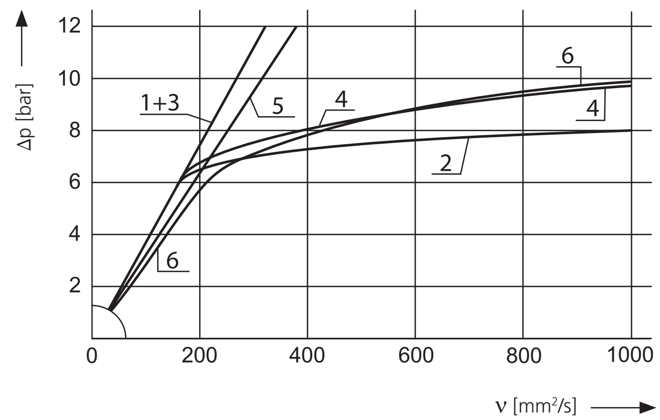
Pressure drop as a function of the **kinematic viscosity** at nominal flow



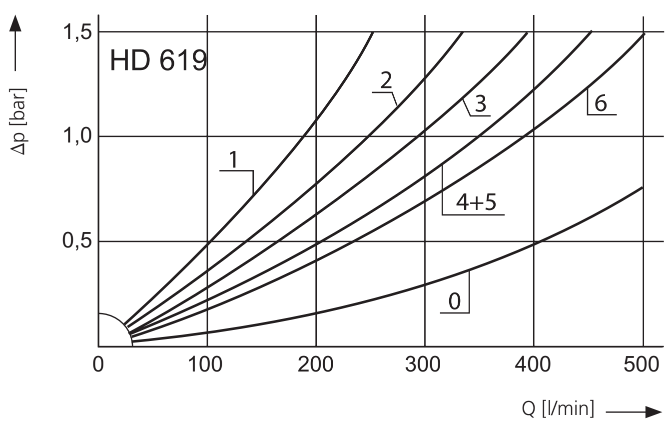
D5 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s



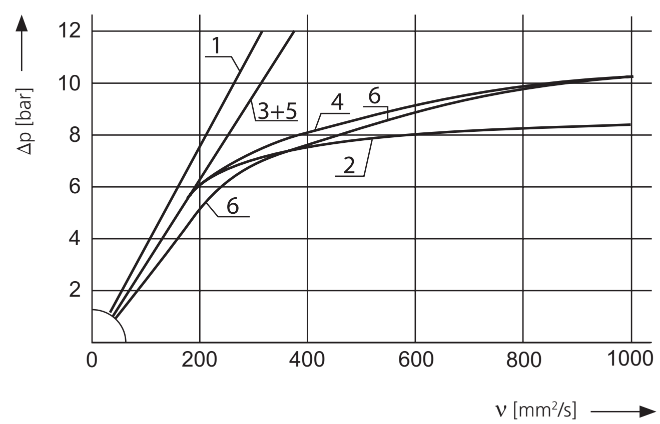
Pressure drop as a function of the **kinematic viscosity** at nominal flow



D6 Pressure drop as a function of the **flow volume** at ν = 35 mm²/s

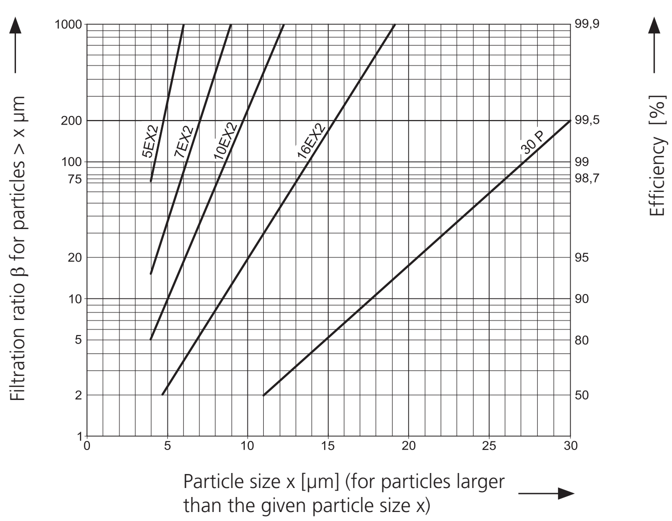


Pressure drop as a function of the **kinematic viscosity** at nominal flow



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following β-values resp. finenesses

For EXAPOR®MAX2 and paper elements:

5EX2	=	$\overline{\beta}_{5\,(c)}$	= 200	EXAPOR®MAX 2
7EX2	=	$\overline{\beta}_{7\,(c)}$	= 200	EXAPOR®MAX 2
10EX2	=	$\overline{\beta}_{10\,(c)}$	= 200	EXAPOR®MAX 2
16EX2	=	$\overline{\beta}_{16\,(c)}$	= 200	EXAPOR®MAX 2
30P	=	$\beta_{30\,(c)}$	= 200	Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For screen elements:

40S	=	screen material with mesh size	40 µm
60S	=	screen material with mesh size	60 µm
100S	=	screen material with mesh size	100 µm

Tolerances for mesh size according to DIN 4189

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

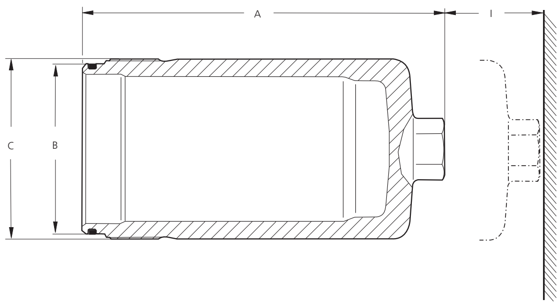
Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Dirt-holding capacity	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Remarks
	l/min			g	bar			kg	
1	2	3	4	5	6	7	8	9	10
HD 049-0213	27	**D1**/1	5EX2	5,2	-	5	V3.0510-13*	1,6	with screw-in bushing
HD 049-1503	30	**D1**/2	5EX2	4,9	7	1	V3.0510-03	1,5	-
HD 049-0216	47	**D1**/3	10EX2	5,1	-	5	V3.0510-16*	1,6	with screw-in bushing
HD 049-1506	50	**D1**/4	10EX2	6,8	7	1	V3.0510-06	1,5	-
HD 049-0218	65	**D1**/5	16EX2	5,6	-	5	V3.0510-18*	1,6	with screw-in bushing
HD 049-1508	75	**D1**/6	16EX2	6,9	7	1	V3.0510-08	1,5	-
HD 069-0213	50	**D2**/1	5EX2	8,7	-	5	V3.0520-13*	2,7	with screw-in bushing
HD 069-1503	60	**D2**/2	5EX2	10	7	1	V3.0520-03	2,6	-
HD 069-0216	80	**D2**/3	10EX2	11	-	5	V3.0520-16*	2,7	with screw-in bushing
HD 069-1506	85	**D2**/4	10EX2	14	7	1	V3.0520-06	2,6	-
HD 069-0218	100	**D2**/5	16EX2	12	-	5	V3.0520-18*	2,7	with screw-in bushing
HD 069-1508	105	**D2**/6	16EX2	15	7	1	V3.0520-08	2,6	-
HD 172-0213	80	**D3**/1	5EX2	16	-	5	V3.0623-13*	4,2	with screw-in bushing
HD 172-1503	105	**D3**/2	5EX2	17	7	1	V3.0623-03	3,9	-
HD 172-0226	130	**D3**/3	10EX2	18	-	5	V3.0623-26*	4,2	with screw-in bushing
HD 172-1506	150	**D3**/4	10EX2	23	7	1	V3.0623-06	3,9	-
HD 172-0218	165	**D3**/5	16EX2	19	-	5	V3.0623-18*	4,2	with screw-in bushing
HD 172-1508	180	**D3**/6	16EX2	25	7	1	V3.0623-08	3,9	-
HD 319-0213	110	**D4**/1	5EX2	20	-	5	V3.0817-13*	6,5	with screw-in bushing
HD 319-1503	115	**D4**/2	5EX2	24	7	1	V3.0817-03	6	-
HD 319-0216	195	**D4**/3	10EX2	24	-	5	V3.0817-16*	6,5	with screw-in bushing
HD 319-1506	250	**D4**/4	10EX2	33	7	1	V3.0817-06	6	-
HD 319-0218	270	**D4**/5	16EX2	25	-	5	V3.0817-18*	6,5	with screw-in bushing
HD 319-1508	330	**D4**/6	16EX2	33	7	1	V3.0817-08	6	-
HD 419-0213	155	**D5**/1	5EX2	29	-	5	V3.0823-13*	8,8	with screw-in bushing
HD 419-1503	190	**D5**/2	5EX2	33	7	1	V3.0823-03	8,2	-
HD 419-0216	265	**D5**/3	10EX2	33	-	5	V3.0823-16*	8,8	with screw-in bushing
HD 419-1506	330	**D5**/4	10EX2	47	7	1	V3.0823-06	8,2	-
HD 419-0218	330	**D5**/5	16EX2	35	-	5	V3.0823-18*	8,8	with screw-in bushing
HD 419-1508	380	**D5**/6	16EX2	48	7	1	V3.0823-08	8,2	-
HD 619-0213	220	**D6**/1	5EX2	41	-	5	V3.0833-13*	11,9	with screw-in bushing
HD 619-1503	280	**D6**/2	5EX2	49	7	1	V3.0833-03	11,1	-
HD 619-0216	330	**D6**/3	10EX2	49	-	5	V3.0833-16*	11,9	with screw-in bushing
HD 619-1506	400	**D6**/4	10EX2	67	7	1	V3.0833-06	11,1	-
HD 619-0218	450	**D6**/5	16EX2	51	-	5	V3.0833-18*	11,9	with screw-in bushing
HD 619-1508	450	**D6**/6	16EX2	68	7	1	V3.0833-08	11,1	-

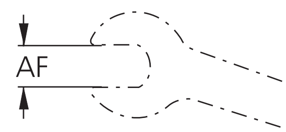
* Element differential pressure stable up to 160 bar, clogging indicator obligatory

Remarks:

- Filter versions without by-pass valves must be equipped with a clogging indicator.
- The filter sets listed in this chart are standard filters. If modifications are required, we kindly ask for your request.
- Clogging indicators to screw into the hydraulic block see section Dimensions.
- For the appropriate, flange-mounted clogging indicators see catalogue sheet 60.30.

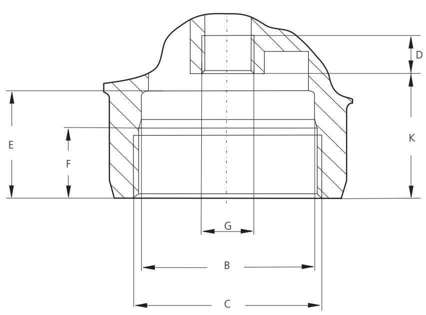
Dimensions



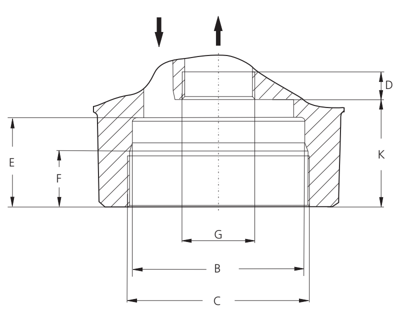


Version with by-pass valve

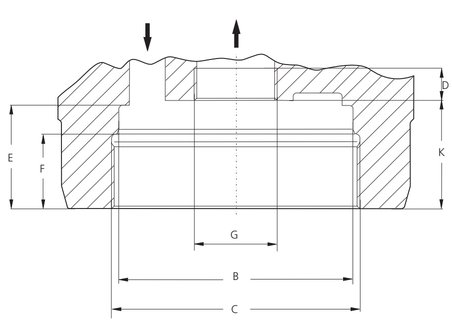
HD 049 / 069



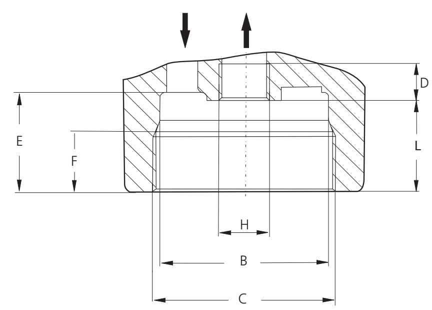
HD 172

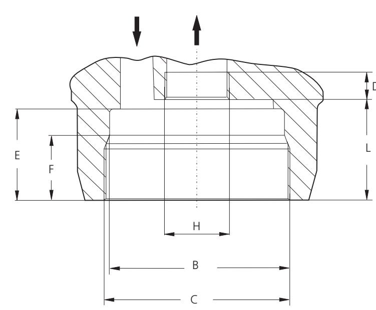


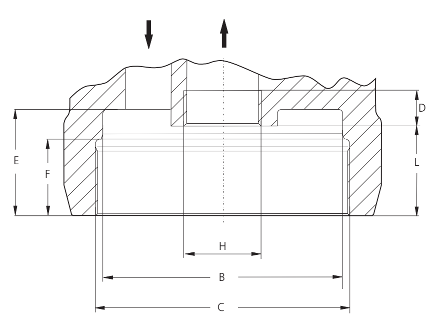
HD 319 / 419 / 619



Version with screw-in bushing





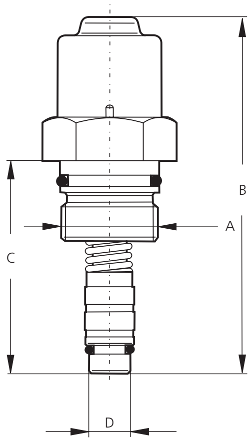


All measurements and tolerances required for machining are available on request.

Dimensions

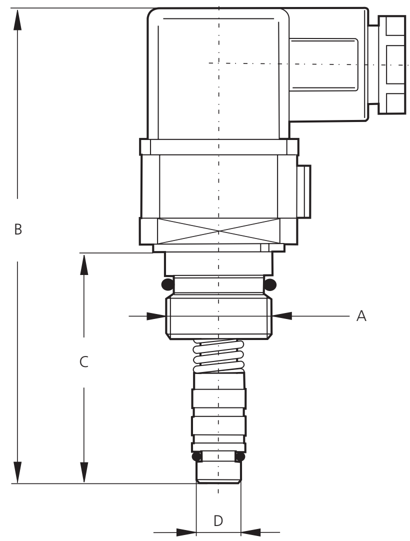
Optical differential pressure indicator

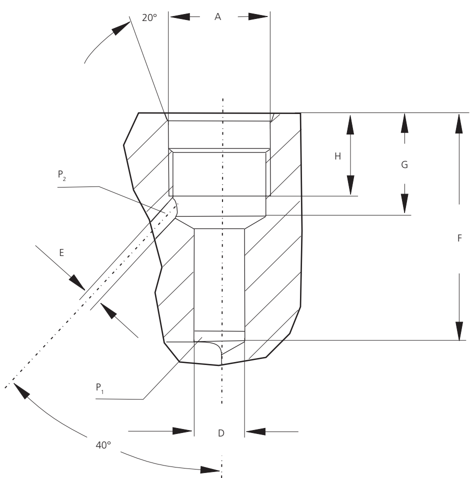
DG 032.1700



Electrical differential pressure switch (change-over)

DG 031.1700





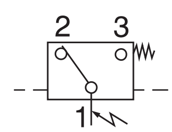
Response/Switching pressure of the clogging indicators

5 bar

Electrical clogging indicator

- Switching voltage: max. 120 V AC / 175 V DC
- Switching current: max. 0,17 A AC / 0,25 A DC
- Switching power: max. 3,5 VA AC / 5 W DC
- Type of contact: change-over
- Electrical protection: IP 65 (with mounted and secured socket)

Terminal connection

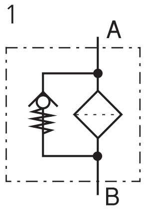


All measurements and tolerances required for machining are available on request.

Measurements

Type	A	B	C	D	E	F	G	H	I	K	L	M
HD 049/069	133/227,5	60	M65 x 1,5	min. 13	35,5	22,5	M18 x 1,5	M18 x 1,5	55	42	32,5	AF36
HD 172	256,5	71	M75 x 1,5	min. 13	37	22,5	M30 x 1	M26 x 1,5	70	47,5	41	AF27
HD 319/419/619	218/282/383	102	M108 x 1,5	min. 14	45	32,5	M36 x 1	M36 x 1,5	80	47	38	AF32
DG 031.1700	M20 x 1,5	93	44	Ø10	Ø2,5	45,8	20,5	16,5	-	-	-	AF30
DG 032.1700	M20 x 1,5	74	44	Ø10	Ø2,5	45,8	20,5	16,5	-	-	-	AF24

Symbols

1


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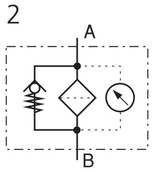

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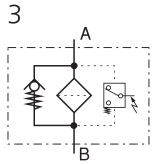

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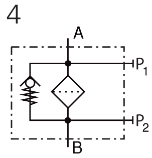

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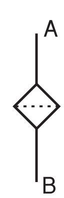

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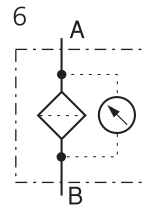

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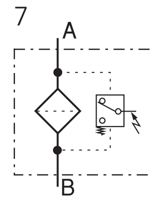

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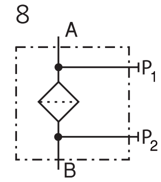
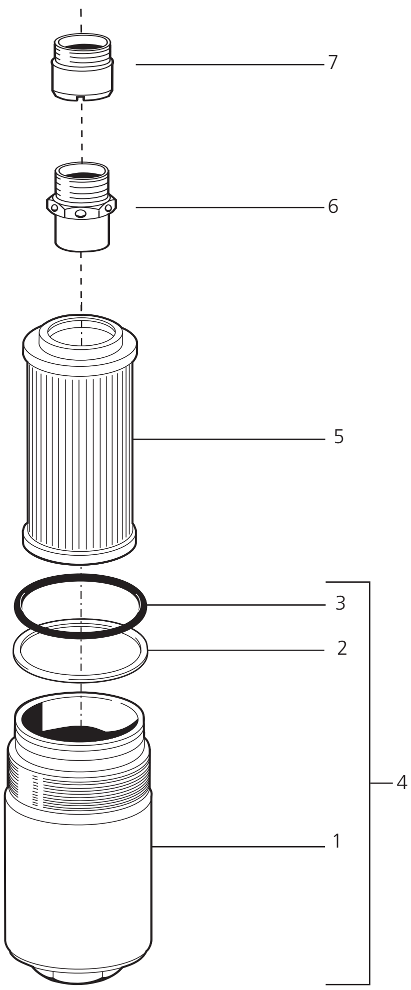


Spare Parts



HD 049 / HD 069

Pos.	Designation	Part No.
1	Filter bowl HD 049	HD 052.0102
1	Filter bowl HD 069	HD 072.0102
3	O-ring 53,57 x 3,53	N007.0543/1
5	Filter element	see Chart / col. 8
6	By-pass valve	HD 045.1510
7	Screw-in bushing	HD 049.0503

HD 172

Pos.	Designation	Part No.
1	Filter bowl HD 172	HD 171.0102
3	O-ring 63 x 3,5	N007.0634
5	Filter element	see Chart / col. 8
6	By-pass valve	HD 172.1500
7	Screw-in bushing	HD 171.0205

HD 319 / HD 419 / HD 619

Pos.	Designation	Part No.
2	Back-ring	HD 255.0102
3	O-ring 94,84 x 3,53	N007.0953
4	Filter bowl HD 319 (with Pos. 2 and 3)	HD 250.0701
4	Filter bowl HD 419 (with Pos. 2 and 3)	HD 451.0702
4	Filter bowl HD 619 (with Pos. 2 and 3)	HD 619.0701
5	Filter element	see Chart / col. 8
6	By-pass valve	HD 319.1510
7	Screw-in bushing	HD 319.0212

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Before release into the series production the filter casing is tested for fatigue strength in our pressure pulse test rig. Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Illustrations may sometimes differ from the original. ARGO-HYTOS is not responsible for any unintentional mistake in this specification sheet.

Ventilating Filters

L1.0406 · L1.0506 · L1.0706 · L1.0807

Connection up to M60 x 2 · Nominal flow rate up to 850 l/min

Ventilating Filter L1.0807

Description

Application

Ventilation of tanks for hydraulic and lubrication systems and gearboxes.

General

The oil levels in the tanks of hydraulic systems are subject to continuous variation due to temperature changes and the operation of cylinders and pressure vessels.
In order to prevent over pressure in the tanks, an exchange of air with the external atmosphere is necessary. By the use of a ventilating filter, the outside air that is drawn in is filtered and the ingress of dust is therefore prevented.

Special features

The ventilation openings are designed that dust on the surface of the tank is not drawn in, and that the ingress of spray and rainwater is largely prevented. The use in marine applications presents no problem due to the use of synthetic materials and stainless steel.

Design

Flow direction bi-directional (air IN/OUT). The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Ordering options / versions

Integrated oil-level dipstick (for all types):
A dipstick can be integrated in the ventilating filter for checking the oil level. Therefore, a separate dipstick or an additional opening in the tank is not required.

Oil separator (L1.0406, L1.0706, L1.0807):
An effective protection against splashing oil in mobile operation.

Double check valves (L1.0506, L1.0807):
By the use of double check valves, the exchange of air between the tank and the environment can be considerably reduced, whereby the ingress of dust is minimized and the lifetime of the ventilating filter can be increased.
With the double check valve, an over-pressure can be created in the tank in order to improve the suction conditions for the pumps. A further advantage is the reduction of spray water entry and the loss of oil through the ventilating filter.

Roll-over protection (L1.0506):
Ventilating filter with safety valve to prevent the hydraulic oil spilling out should the machinery roll or tip over.

Vandalism proof types (L1.0807):
Ventilating filters in patented vandalism proof version, please see catalogue sheet 50.20.
Filling and ventilating filters in standard or patented vandalism proof version, see catalogue sheet 50.30.

Maintenance

Ventilating filters should be changed at least every 1000 operating hours, or at minimum once a year.

Characteristics

Nominal flow rate

Up to 850 l/min (see Selction Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following criteria:

- Ventilating filters without double check valve: Δp < 0,03 bar
- Ventilating filters with double check valve: Δp < 0,1 bar for air IN

Connection

Threaded ports according to ISO 228, DIN 13 or DIN 20400.
Sizes see Selection Chart, column 6 (other port threads on request).

Filter fineness

2 µm
Tested in a single pass test with ISO MTD

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info sheet 00.20)

Temperature range hydraulic fluid

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Temperature range environment

-30 °C ... +100 °C

Materials

Cap:	Polyamide, GF reinforced (L1.0506 Polyester, GK reinforced)
Base:	Polyamide, GF reinforced
Dipstick:	Stainless steel (1.4301)
Gaskets:	NBR (FPM on request)
Filter media:	Composite, multi-layer

Mounting position

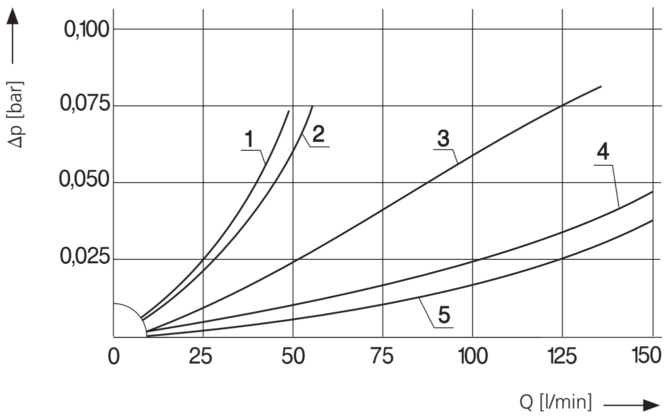
No limitation, position on the tank see section Layout.

Ventilating filters with roll-over protection must be installed vertically.

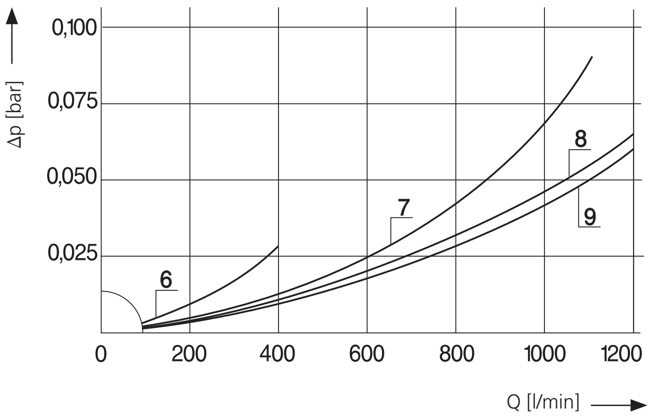
Diagrams

Δp-curves for complete filters in Selection Chart, column 3

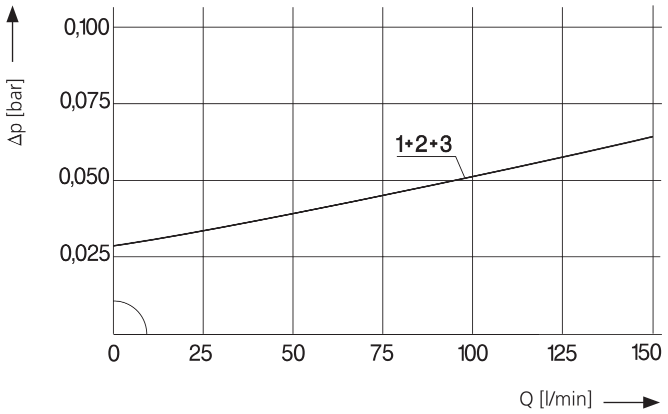
D1 Pressure drop as a function of the **flow volume Air IN/OUT**



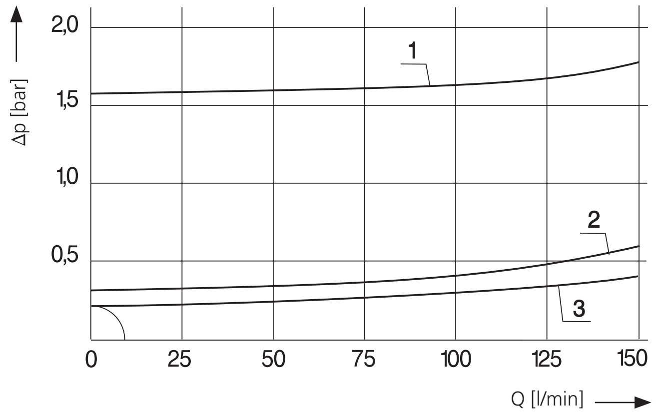
Pressure drop as a function of the **flow volume Air IN/OUT**



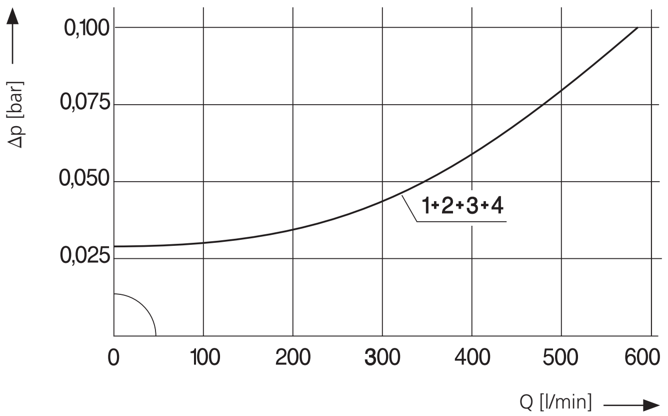
D2 Pressure drop as a function of the **flow volume**
Air IN



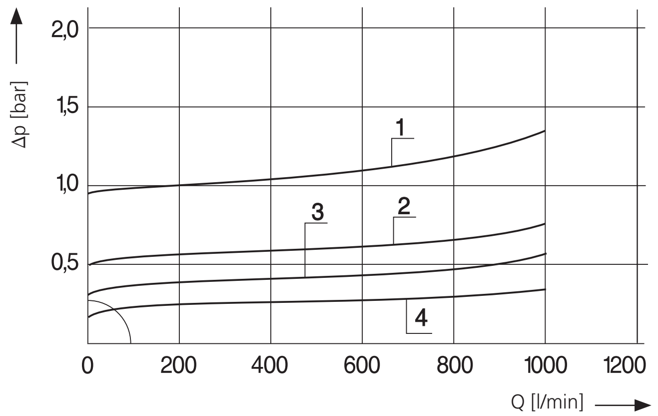
Pressure drop as a function of the **flow volume**
Air OUT



D3 Pressure drop as a function of the **flow volume**
Air IN

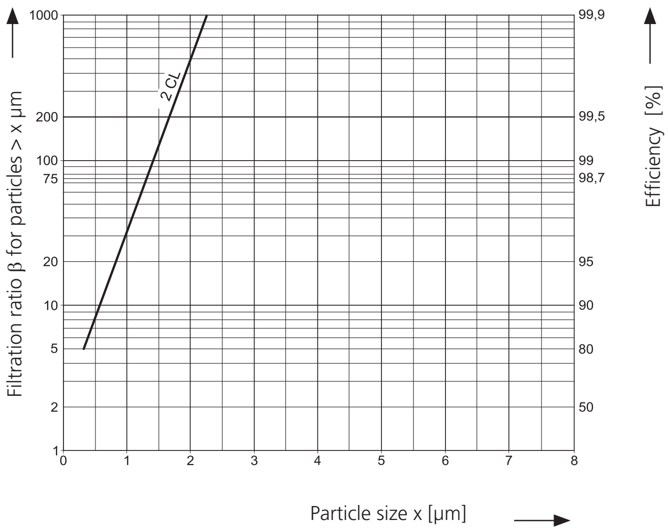


Pressure drop as a function of the **flow volume**
Air OUT



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x tested in a single pass test with ISO MTD



The abbreviation represents the following β-values resp. finenesses:

2CL

› 2 µm Composite
99,5 % efficiency for particles of size 2 µm
tested in a single pass test with ISO MTD

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Filter surface	Connection A	Cracking pressure air IN	Cracking pressure air OUT	Dipstick measurement L1	Dipstick measurement L2	Dipstick measurement L3	Symbol	Weight	Remarks
	l/min			cm^2		bar	bar	mm	mm	mm		g	
1	2	3	4	5	6	7	8	9	10	11	12	13	14
L1.0406-12	120	**D1**/4	2CL	35	M18 x 1,5	-	-	-	-	-	1	25	-
L1.0406-21	25	**D1**/1	2CL	35	M18 x 1,5	-	-	-	-	-	1	25	with labyrinth oil separator
L1.0406-73	25	**D1**/1	2CL	35	M18 x 1,5	-	-	75	70	55	1	30	with labyrinth oil separator
L1.0406-76	25	**D1**/1	2CL	35	M18 x 1,5	-	-	80	75	60	1	30	with labyrinth oil separator
L1.0406-45	25	**D1**/1	2CL	35	M18 x 1,5	-	-	95	90	45	1	35	with labyrinth oil separator
L1.0406-69	25	**D1**/1	2CL	35	M18 x 1,5	-	-	100	95	80	1	35	with labyrinth oil separator
L1.0406-56	25	**D1**/1	2CL	35	M18 x 1,5	-	-	130	125	100	1	35	with labyrinth oil separator
L1.0406-03	135	**D1**/5	2CL	35	M22 x 1,5	-	-	-	-	-	1	25	-
L1.0406-87	30	**D1**/2	2CL	35	M22 x 1,5	-	-	-	-	-	1	25	with labyrinth oil separator
L1.0406-60	30	**D1**/2	2CL	35	M22 x 1,5	-	-	85	80	55	1	30	with labyrinth oil separator
L1.0406-79	135	**D1**/2	2CL	35	M22 x 1,5	-	-	120	115	90	1	35	-
L1.0406-51	30	**D1**/2	2CL	35	M22 x 1,5	-	-	130	125	-	1	35	with labyrinth oil separator
L1.0406-59	30	**D1**/2	2CL	35	M22 x 1,5	-	-	130	125	100	1	35	with labyrinth oil separator
L1.0406-98	30	**D1**/2	2CL	35	M22 x 1,5	-	-	180	175	150	1	40	with labyrinth oil separator
L1.0406-33	30	**D1**/2	2CL	35	M22 x 1,5	-	-	250	235	215	1	40	with labyrinth oil separator
L1.0406-101	16	**D1**/3	2CL	6	M22 x 1,5	-	-	-	-	-	1	25	-
L1.0506-73	150*	**D2**/3	2CL	35	M22 x 1,5	-0,03	0,20	-	-	-	2	55	-
L1.0506-91	150*	**D2**/2	2CL	35	M22 x 1,5	-0,03	0,35	-	-	-	2	55	-
L1.0506-43	150*	**D2**/1	2CL	35	M22 x 1,5	-0,03	1,60	-	-	-	2	55	-
L1.0506-185	10	**D2**/4	2CL	35	M22 x 1,5	-	-	-	-	-	3	60	with roll-over-protection
L1.0506-195	10	**D2**/4	2CL	35	Rd42 x 5,0	-	-	-	-	-	3	75	with roll-over-protection
L1.0706-03	250	**D1**/6	2CL	50	M30 x 1,5	-	-	-	-	-	1	50	-
L1.0706-02	250	**D1**/6	2CL	50	M42 x 2,0	-	-	-	-	-	1	50	-
L1.0706-07	250	**D1**/6	2CL	50	Rd42 x 5,0	-	-	-	-	-	1	60	with labyrinth oil separator

* $\Delta p < 0,1$ bar for air IN

Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagram **D**/curve no.	Filter fineness see diagr. **Dx**	Filter surface	Connection A	Cracking pressure air IN	Cracking pressure air OUT	Dipstick measurement L1	Dipstick measurement L2	Dipstick measurement L3	Symbol	Weight	Remarks
	l/min			cm²		bar	bar	mm	mm	mm		g	
1	2	3	4	5	6	7	8	9	10	11	12	13	14
L1.0807-04	800	**D1**/8	2CL	203	M30 x 1,5	-	-	-	-	-	1	145	with labyrinth oil separator
L1.0807-11	800	**D1**/8	2CL	203	M30 x 1,5	-	-	-	-	-	1	140	with flat gasket
L1.0807-61	550*	**D3**/3	2CL	203	M30 x 1,5	-0,03	0,35	-	-	-	2	160	-
L1.0807-07	650	**D1**/7	2CL	203	G¾	-	-	-	-	-	1	145	with labyrinth oil separator
L1.0807-21	650	**D1**/7	2CL	203	G¾	-	-	-	-	-	1	140	-
L1.0807-81	550*	**D3**/4	2CL	203	G¾	-0,03	0,20	-	-	-	2	160	with flat gasket
L1.0807-71	550*	**D3**/3	2CL	203	G¾	-0,03	0,35	-	-	-	2	160	with flat gasket
L1.0807-93	550*	**D3**/2	2CL	203	G¾	-0,03	0,50	-	-	-	2	160	-
L1.0807-63	550*	**D3**/1	2CL	203	G¾	-0,03	1,00	-	-	-	2	160	-
L1.0807-05	850	**D1**/9	2CL	203	M42 x 2,0	-	-	-	-	-	1	145	with labyrinth oil separator
L1.0807-31	850	**D1**/9	2CL	203	M42 x 2,0	-	-	-	-	-	1	140	-
L1.0807-91	550*	**D3**/4	2CL	203	M42 x 2,0	-0,03	0,20	-	-	-	2	160	-
L1.0807-51	550*	**D3**/3	2CL	203	M42 x 2,0	-0,03	0,35	-	-	-	2	160	-
L1.0807-06	850	**D1**/9	2CL	203	M60 x 2,0	-	-	-	-	-	1	150	with labyrinth oil separator
L1.0807-14	850	**D1**/9	2CL	203	M60 x 2,0	-	-	-	-	-	1	140	-

* $\Delta p < 0{,}1$ bar for air IN

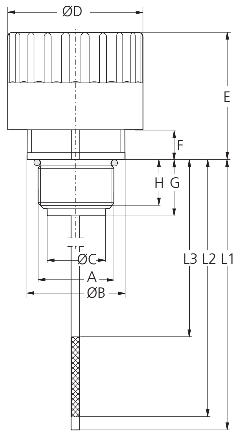
Remarks:

› The ventilating filters listed in this chart are standard filters. If modifications are required, e.g., with integrated dipstick, we kindly ask for your request.

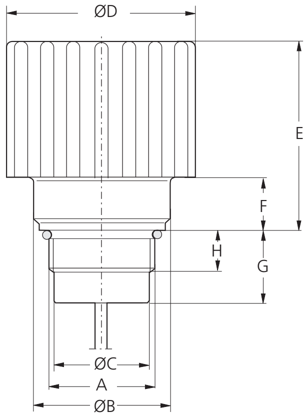
› Ventilating filters in Vandalism Proof design see catalogue sheet 50.20.

Dimensions

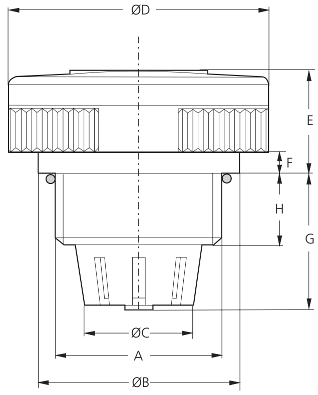
L1.0406



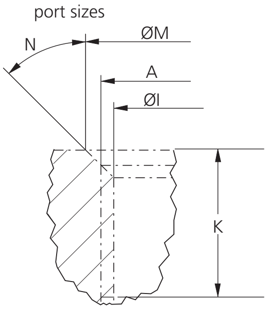
L1.0506



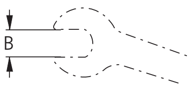
L1.0706



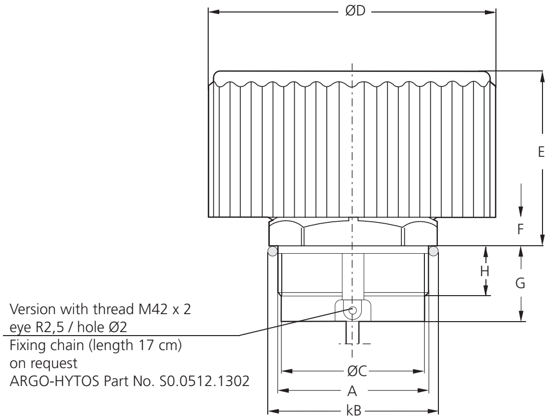
Recommended port sizes



Spanner size L1.0807



L1.0807



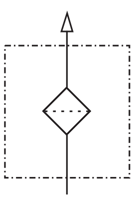
Measurements

Type	A*	B	C	D	E	F	G	H	I	K	M	N
L1.0406	M18 x 1,5, M22 x 1,5	31,5	16	37	33,5	7,5	16,5	13,5	-	-	as A	45°
L1.0506	M22 x 1,5	29	19,5	46	47	13,0	17,5	10,5	-	-	as A	45°
	Rd42 x 5,0**	50	35,0	46	44	10,5	28,0	28,0	35,5	min. 28	45	45°
L1.0706	M30 x 1,5	51	20,5	66	26,5	6	35	18	-	-	as A	45°
	M42 x 2,0	51	28	66	26,5	6	35	18	-	-	as A	45°
	Rd42 x 5,0**	51	28	66	26,5	6	35	28	35,5	min. 28	45	45°
L1.0807	M30 x 1,5	AF47	27	80	50	7,5	17,5	13,5	-	-	as A	45°
	G¾	AF33	24	80	50	7,5	17,5	13,5	-	-	as A	45°
	M42 x 2,0	AF47	40	80	50	8	21	14	-	-	48	45°
	M60 x 2,0	AF47	56,4	80	52	11	18	15	-	-	as A	45°

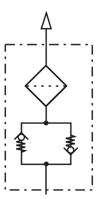
* The thread dimensions do not exactly conform to the DIN ISO standard thread (functioning with the DIN ISO standard thread is guaranteed)
** Round thread according to DIN 20400, not conforming to thread depth standards (functioning with the DIN standard thread is guaranteed)

Symbols

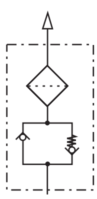
1



2



3



Layout

Sizes

The determining factor for selecting the size is the maximum over / under pressure allowed in the container.
For versions without double check valves, the initial pressure drop with a clean air filter should not exceed 0,03 bar.
For versions with double check valves, the initial pressure drop for air IN with a clean air filter should not exceed 0,1 bar.

Filter fineness

In the ideal case, the fineness of the ventilating filter matches the fineness of the system filter (see also CETOP RP 98 H).
By the use of filter fineness 2 CL the ingress of dust into the tank is effectively reduced.

Mounting

The ventilating filter should be mounted in a low-dust area of the machine and not in depressions in which water can collect.
For mobile use, the ventilating filter is to be mounted on the tank such that neither splashing oil from the inside nor spray water from the outside can reach the area of the ventilation opening.

Double check valves

By the use of double check valves, the exchange of air between the tank and the environment can be considerably reduced, whereby the ingress of dust is minimized and the lifetime of the ventilating filter is increased.
With the double check valve, a predefined level of pressure can be created in the tank in order to improve the suction conditions for the pumps.
The valve opening pressure required for the ventilating filter can be approximately determined with the ideal gas equation depending on the following system characteristics:

- differential volume
- volume of oil in the system
- volume of air in the tank
- operating temperatures

Calculation tool available.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Ventilating Filters - Vandalism Proof

L1.0808 · L1.0809

Connection up to M42 x 2 · Nominal flow rate up to 850 l/min

Ventilating Filter L1.0809

Ventilating Filter L1.0808

Description

Application

Ventilation of tanks for hydraulic and lubrication systems and gearboxes.

General

The oil levels in the tanks of hydraulic systems are subject to continuous variation due to temperature changes and the operation of cylinders and pressure vessels.
In order to prevent over pressure in the tanks, an exchange of air with the external atmosphere is necessary. By the use of a ventilating filter, the outside air that is drawn in is filtered and the ingress of dust is therefore prevented.

Special features

The ventilation openings are designed that dust on the surface of the tank is not drawn in, and that the ingress of spray and rainwater is largely prevented.
The use in marine applications presents no problem due to the use of synthetic materials and stainless steel.
The patented vandalism proof ventilating filters can only be removed with the special tool supplied. This makes the removal of the ventilating filter or the ingress of dirt via the tank port considerably more difficult.

Design

Flow direction bi-directional (air IN/OUT). The star-shaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Ordering options / versions

Integrated oil-level dipstick:
A dipstick can be integrated in the ventilating filter for checking the oil level. Therefore, a separate dipstick or an additional opening in the tank is not required.

Double check valves:
By the use of double check valves, the exchange of air between the tank and the environment can be considerably reduced, whereby the ingress of dust is minimized and the lifetime of the ventilating filter can be increased.
With the double check valve, an over-pressure can be created in the tank in order to improve the suction conditions for the pumps. A further advantage is the reduction of spray water ingress and the loss of oil through the ventilating filter.

Vandalism proof version "Standard" (L1.0808):
Ventilating filters in the patented vandalism proof version can only be removed with the special spanner supplied (A/F 47). This makes the removal of the ventilating filter or the ingress of dirt via the tank port considerably more difficult.

Vandalism proof version "Easy Lock" (L1.0809):
Ventilators in the patented "Easy Lock" version can only be removed with the special pin supplied.

Standard ventilating filters without vandalism proof see catalogue sheet 50.10.
Filling and ventilating filters with and without vandalism proof see catalogue sheet 50.30

Maintenance

Ventilating filters should be changed at least every 1000 operating hours, or at minimum once a year.

Characteristics

Nominal flow rate

Up to 850 l/min (see Selction Chart, column 2)
The nominal flow rates indicated by ARGO-HYTOS are based on the following criteria:

- Ventilating filters without double check valve:
  $\Delta p < 0{,}03$ bar
- Ventilating filters with double check valve:
  $\Delta p < 0{,}1$ bar for air IN

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 (other port threads on request).

Filter fineness

2 µm
Tested in a single pass test with ISO MTD

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info sheet 00.20)

Temperature range hydraulic fluid

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Temperature range environment

-30 °C ... +100 °C

Materials

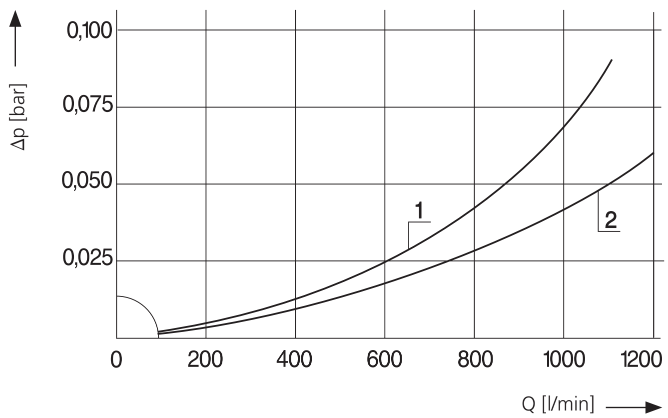
Cap:	Polyamide, GF reinforced
Base:	Polyamide, GF reinforced
Dipstick:	Stainless steel (1.4301)
Spanner:	Steel, galvanized
Gaskets:	NBR (FPM on request)
Filter media:	Composite, multi-layer

Mounting position

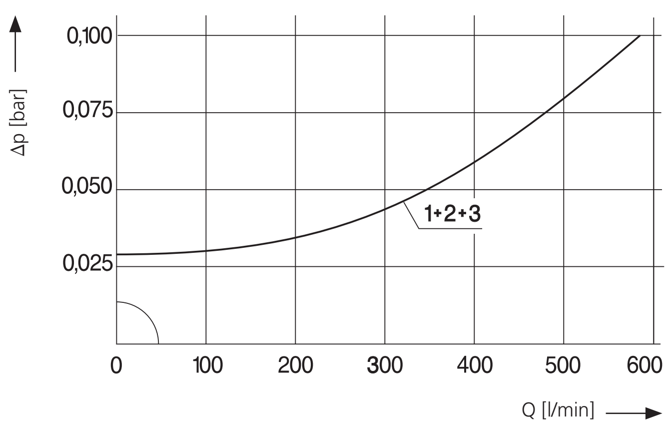
No limitation, position on the tank see section Layout

Δp-curves for complete filters in Selection Chart, column 3

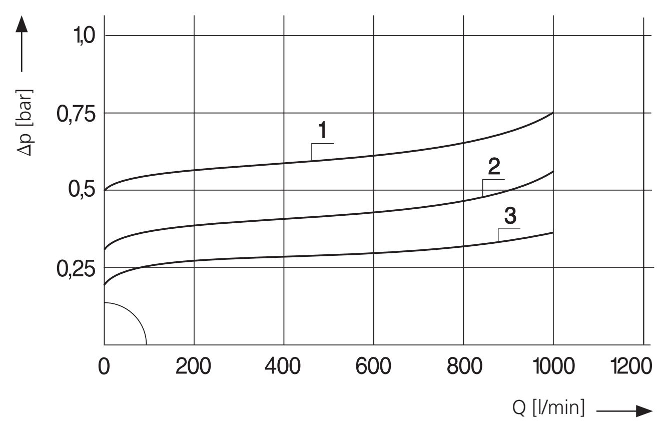
D1 Pressure drop as a function of the **flow volume**
Air IN/OUT



D2 Pressure drop as a function of the **flow volume**
Air IN

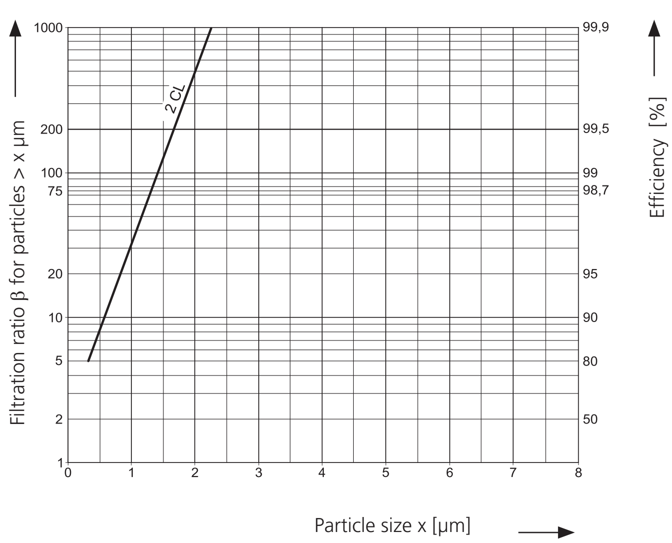


Pressure drop as a function of the **flow volume**
Air OUT



Filter fineness curves in Selection Chart, column 4

Dx Filtration ratio β as a function of particle size x tested in a single pass test with ISO MTD



The abbreviation represents the following β-values resp. finenesses:

2CL

› 2 µm Composite
99,5 % efficiency for particles of size 2 µm
tested in a single pass test with ISO MTD

For special applications, finenesses differing from these curves are also available by using special composed filter media.

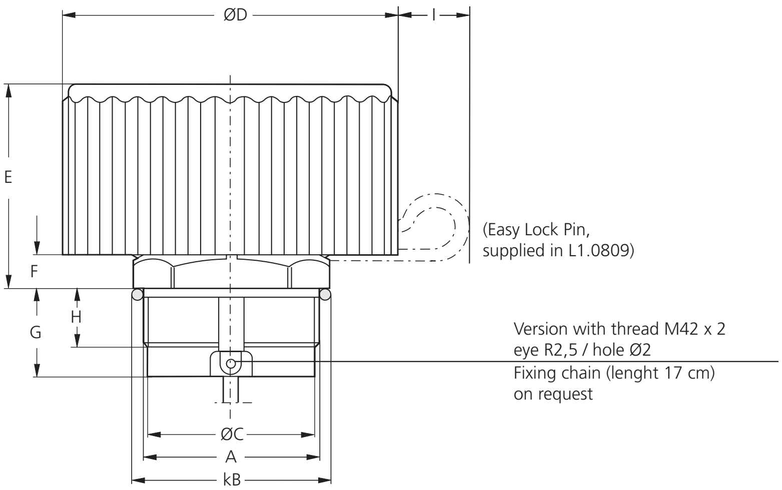
Selection Chart

Part No.	Nominal flow rate	Pressure drop see diagramm **D**/curve no.	Filter fineness see diagr. **Dx**	Filter surface	Connection A	Cracking pressure air IN	Cracking pressure air OUT	Dipstick measurement L1	Dipstick measurement L2	Dipstick measurement L3	Symbol	Weight	Remarks
	l/min			cm^2		bar	bar	mm	mm	mm		g	
1	2	3	4	5	6	7	8	9	10	11	12	13	14
L1.0808-00	850	**D1**/2	2CL	203	M42 x 2,0	-	-	-	-	-	1	140	with spanner AF 47
L1.0808-53	550*	**D2**/3	2CL	203	M42 x 2,0	-0,03	0,20	-	-	-	2	160	with spanner AF 47
L1.0808-52	550*	**D2**/2	2CL	203	M42 x 2,0	-0,03	0,35	-	-	-	2	160	with spanner AF 47
L1.0808-61	550*	**D2**/1	2CL	203	M42 x 2,0	-0,03	0,50	-	-	-	2	160	with spanner AF 47
L1.0809-00	650	**D1**/1	2CL	203	G¾	-	-	-	-	-	1	140	with Easy Lock Pin
L1.0809-52	550*	**D2**/3	2CL	203	G¾	-0,03	0,20	-	-	-	2	160	with Easy Lock Pin
L1.0809-51	550*	**D2**/2	2CL	203	G¾	-0,03	0,35	-	-	-	2	160	with Easy Lock Pin
L1.0809-53	550*	**D2**/1	2CL	203	G¾	-0,03	0,50	-	-	-	2	160	with Easy Lock Pin
L1.0809-01	850	**D1**/2	2CL	203	M42 x 2,0	-	-	-	-	-	1	140	with Easy Lock Pin
L1.0809-54	550*	**D2**/3	2CL	203	M42 x 2,0	-0,03	0,20	-	-	-	2	160	with Easy Lock Pin
L1.0809-55	550*	**D2**/2	2CL	203	M42 x 2,0	-0,03	0,35	-	-	-	2	160	with Easy Lock Pin
L1.0809-56	550*	**D2**/1	2CL	203	M42 x 2,0	-0,03	0,50	-	-	-	2	160	with Easy Lock Pin

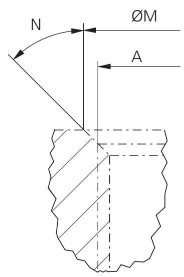
*$\Delta p < 0,1$ bar for air IN

Remarks:
The ventilating filters listed in this chart are standard filters. If modifications are required, e.g., with integrated dipstick or oil separator, we kindly ask for your request.

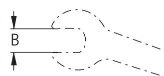
Dimensions



Recommended port sizes



Spanner size
(special wrench, supplied with L1.0808)



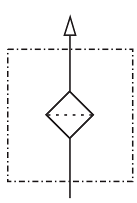
Measurements

Type	A*	B	C	D	E	F	G	H	I	M	N
L1.0808	M42 x 2	AF47	40	80	50	8	21	14	-	48	45°
L1.0809	G¾	AF33	24	80	50	7,5	17,5	13,5	16	as A	45°
	M42 x 2	AF47	40	80	50	8	21	14	16	48	45°

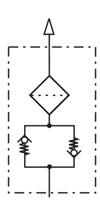
* The thread dimensions do not exactly conform to the DIN ISO standard thread (functioning with the DIN ISO standard thread is guaranteed)

Symbols

1



2



Layout

Sizes

The determining factor for selecting the size is the maximum over / under pressure allowed in the container.
For versions without double check valves, the initial pressure drop with a clean air filter should not exceed 0,03 bar.
For versions with double check valves, the initial pressure drop for air IN with a clean air filter should not exceed 0,1 bar.

Filter fineness

In the ideal case, the fineness of the ventilating filter matches the fineness of the system filter (see also CETOP RP 98 H).
By the use of filter fineness 2 CL the ingress of dust into the tank is effectively reduced.

Mounting

The ventilating filter should be mounted in a low-dust area of the machine and not in depressions in which water can collect.
For mobile use, the ventilating filter is to be mounted on the tank such that neither splashing oil from the inside nor spray water from the outside can reach the area of the ventilation opening.

Double check valves

By the use of double check valves, the exchange of air between the tank and the environment can be considerably reduced, whereby the ingress of dust is minimized and the lifetime of the ventilating filter is increased.
With the double check valve, a predefined level of pressure can be created in the tank in order to improve the suction conditions for the pumps.
The valve opening pressure required for the ventilating filter can be approximately determined with the ideal gas equation depending on the following system characteristics:

- differential volume
- volume of oil in the system
- volume of air in the tank
- operating temperatures

Calculation tool available.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Ventilating Filters - Vandalism Proof

LE.0716 · LE.0817 · LE.0827 · LE.0818 · LE.0819

With filling filter · 6 hole flange · Nominal flow rate up to 850 l/min

M

Ventilating Filter
LE.0817

Description

Application

Filling / ventilation of tanks for hydraulic and lubrication systems as well as gearboxes.

General

The oil levels in the tanks of hydraulic systems are subject to continuous variation due to temperature changes and the operation of cylinders and pressure vessels.
In order to prevent over pressure in the tanks, an exchange of air with the external atmosphere is necessary. By the use of a ventilating filter, the outside air that is drawn in is filtered and the ingress of dust is therefore prevented.
A combined filling filter prevents coarse impurities from entering during filling or re-filling due to maintenance or repair reasons.

Special features

The profiled metal flange with elastomer sealing and the mounting with 6 screws ensure that the filling / ventilating filters seal reliable even on non-planar tank surfaces. Filler screens made of sturdy expanded metal offer 100% safety during filling of the tank – which excludes any damage being caused for example by the filler neck. The ventilating filter is fixed by a chain at the filling filter to prevent it from being lost (exception: LE.0716).
The ventilation openings of the ventilating filters are designed that dust on the surface of the tank is not drawn in, and that the ingress of spray and rainwater is largely prevented.
The patented vandalism proof ventilating filters can only be removed with the special tool supplied. This makes the misuse of the ventilating filter or the ingress of dirt via the tank port considerably more difficult.

Design

Filling filter:
Cylinder screen - flow direction from centre to outside.

Ventilating filter:
Flow direction bi-directional (air IN / OUT). The starshaped pleating of the filter material results in:

› large filter surfaces
› low pressure drop
› high dirt-holding capacities
› long service life

Ordering options / versions

Integrated oil-level dipstick
A dipstick can be integrated in the ventilating filter for checking the oil level. Therefore, a separate dipstick or an additional opening in the tank is not required.

Double check valve in the ventilating filter:
By the use of double check valves, the exchange of air between the tank and the environment is considerably reduced, whereby the ingress of dust is minimized and the lifetime of the ventilating filter is increased.
With the double check valve, an over-pressure is created in the tank in order to improve the suction conditions for the pumps. A further advantage is the reduction of spray water ingress and the loss of oil through the ventilating filter.

Vandalism proof version "Standard" (LE.0818):
Ventilating filters in the patented vandalism proof version can only be removed with the special spanner supplied (A/F 47).

This makes the misuse of the ventilating filter or the ingress of dirt via the tank port considerably more difficult.

Vandalism proof version "Easy Lock" (L1.0819):
Ventilating filters in the patented "Easy Lock" version can only be removed with the special pin supplied.

Maintenance

Ventilating filters should be changed at least every 1000 operating hours, or at minimum once a year.

Characteristics

Nominal flow rate

Filling filter:	up to 200 l/min
Ventilating filter:	up to 850 l/min (see Selection Chart, column 2)

The nominal flow rates indicated by ARGO-HYTOS are based on the following criteria:

- Ventilating filters without double check valve: $\Delta p < 0{,}03$ bar for air IN
- Ventilating filters with double check valve: $\Delta p < 0{,}1$ bar for air IN

Connection

Filling filter:	6 hole flange, hole pattern according to DIN 24557/T2
Ventilating filter:	outer thread M 42 x 2 (the thread dimensions do not exactly conform to the ISO standard thread / functioning with the ISO standard thread is guaranteed)

Mounting / sealing

Version without double check valve:
6 self-tapping screws ISO 1479-ST4,8x16-C with washers

Version with double check valve:
6 philips head screws ISO 7045 M5x16-4.8-Z with O-rings

Sealing of flange with elastomer gasket
(mounting accessories and gaskets included in basic equipment)

Filter fineness

Filling filter:	800 µm
Ventilating filter:	2 µm, tested in a single pass test with ISO MTD

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info sheet 00.20)

Temperature range hydraulic fluid

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

Temperature range environment

-30 °C ... +100 °C

Materials

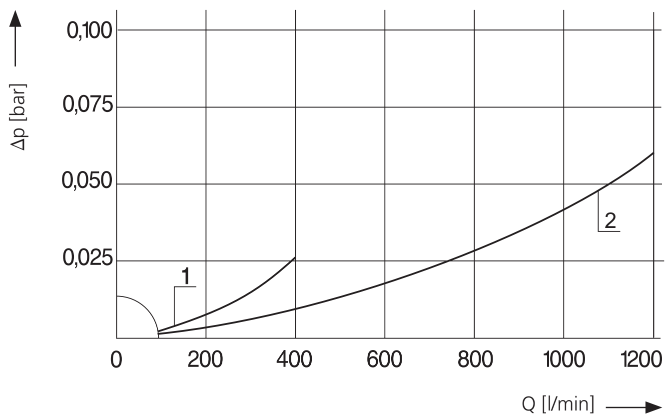
Cap:	Polyamide, GF reinforced
Base:	Polyamide, GF reinforced
Filler screen:	Steel, galvanized
Spanner:	Steel, galvanized
Gaskets:	NBR (FPM on request)
Filter media:	Composite, multi-layer

Mounting position

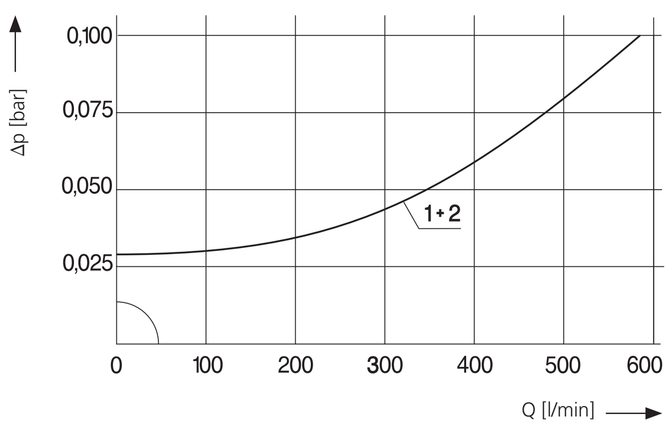
No limitation, position on the tank see section Layout

Δp-curves for complete filters in Selection Chart, column 2

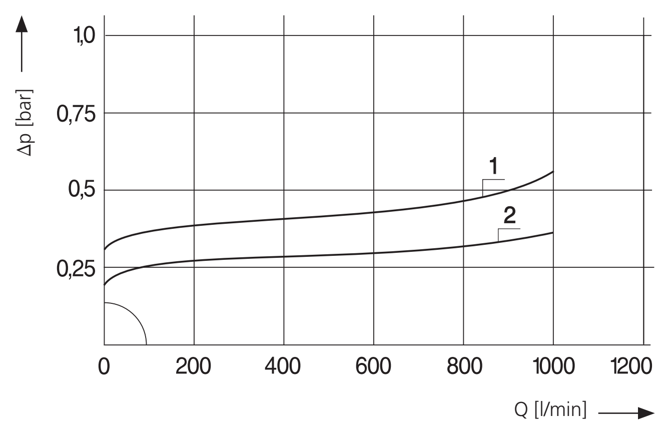
D1 Pressure drop as a function of the **flow volume**
Air IN/OUT



D2 Pressure drop as a function of the **flow volume**
Air IN

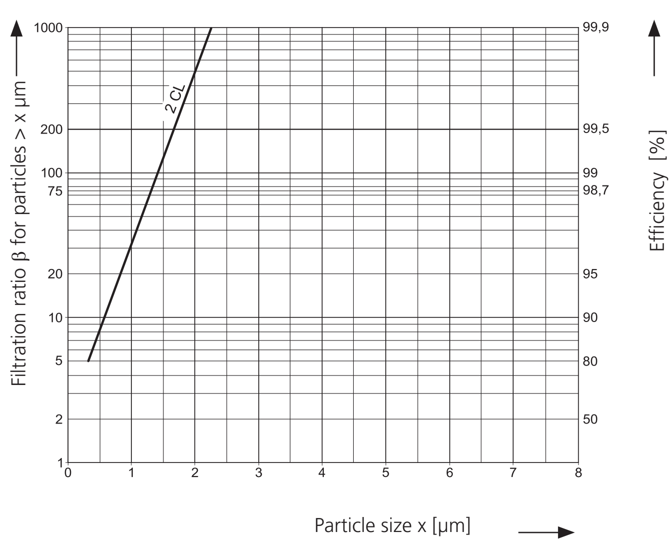


Pressure drop as a function of the **flow volume**
Air OUT



Filter fineness curves in Selection Chart, column 5

Dx Filtration ratio β as a function of particle size x tested in a single pass test with ISO MTD



The abbreviation represents the following β-values resp. finenesses:

2CL

- 2 µm Composite
  99,5 % efficiency for particles of size 2 µm
  tested in a single pass test with ISO MTD.

For special applications, finenesses differing from these curves are also available by using special composed filter media.

Selection Chart

Part No.	Pressure drop see diagram **D**/curve no.	Nominal flow rate filling filter	Nominal flow rate ventilating filter	Filter fineness vent. filter	Filter surface vent. filter	Filter fineness filling filter	Filter surface filling filter	Cracking pressure air IN	Cracking pressure air OUT	Spare ventilating filter	Symbol	Weight	Remarks
		l/min	l/min		cm²	µm	cm²	bar	bar			g	
1	2	3	4	5	6	7	8	9	10	11	12	13	14
LE.0716-02	**D1**/1	110[1]	250	2CL	50	800	160	-	-	L1.0706-02	1	255	without chain[3]
LE.0817-01	**D1**/2	110[1]	850	2CL	203	800	160	-	-	L1.0807-31	1	350	-
LE.0817-91	**D2**/2	110[1]	550[2]	2CL	203	800	160	-0,03	0,20	L1.0807-91	2	370	-
LE.0817-51	**D2**/1	110[1]	550[2]	2CL	203	800	160	-0,03	0,35	L1.0807-51	2	370	-
LE.0827-01	**D1**/2	200[1]	850	2CL	203	800	285	-	-	L1.0807-31	1	400	-
LE.0827-91	**D2**/2	200[1]	550[2]	2CL	203	800	285	-0,03	0,20	L1.0807-91	2	420	-
LE.0827-51	**D2**/1	200[1]	550[2]	2CL	203	800	285	-0,03	0,35	L1.0807-51	2	420	-
LE.0818-01[4]	**D1**/2	110[1]	850	2CL	203	800	160	-	-	L1.0808-00	1	350	with spanner AF 47
LE.0818-53[4]	**D2**/2	110[1]	550[2]	2CL	203	800	160	-0,03	0,20	L1.0808-53	2	370	with spanner AF 47
LE.0818-51[4]	**D2**/1	110[1]	550[2]	2CL	203	800	160	-0,03	0,35	L1.0808-52	2	370	with spanner AF 47
LE.0819-01[4]	**D1**/2	110[1]	850	2CL	203	800	160	-	-	L1.0809-01	1	350	with Easy Lock Pin
LE.0819-54[4]	**D2**/2	110[1]	550[2]	2CL	203	800	160	-0,03	0,20	L1.0809-54	2	370	with Easy Lock Pin
LE.0819-55[4]	**D2**/1	110[1]	550[2]	2CL	203	800	160	-0,03	0,35	L1.0809-55	2	370	with Easy Lock Pin

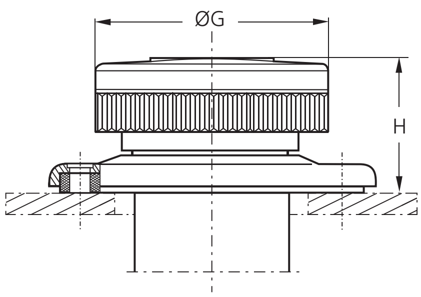
[1] at 200 mm²/s (ISO VG 46 at approx. 15°C)
[2] $\Delta p < 0{,}1$ bar for air IN
[3] Ventilating filter not fixed by a chain at the filling filter
[4] Vandalism Proof

Remark:

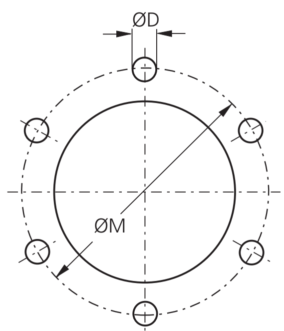
The ventilating filters listed in this chart are standard filters. If modifications are required, e.g. with integrated dipstick, we kindly ask for your inquiry.

Dimensions

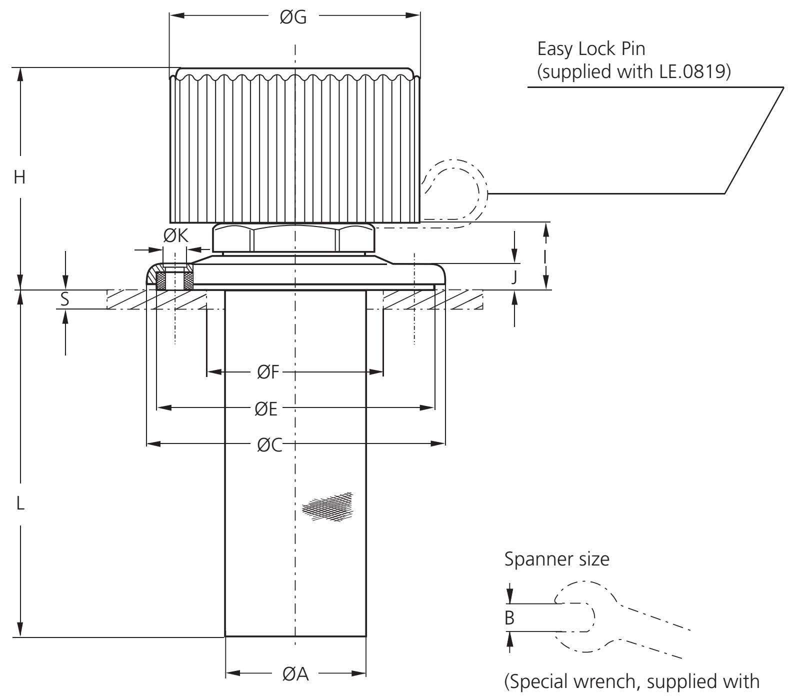
LE.0716



Hole pattern for tank
(core hole ØD for steel material as per table)



LE.0817 · LE.0827 · LE.0818 · LE.0819



Spanner size

B

(Special wrench, supplied with LE.0818)

Measurements

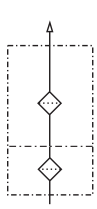
Type	A	B	C	E	F	G	H	I	J	K	L	M
LE.0716	46	-	89,5	84,5	58	66	36	15	6	5,6 ± 0,3	111	73
LE.0817	46	47	89,5	84,5	58	80	61	20	6	5,6 ± 0,3	111	73
LE.0827	46	47	89,5	84,5	58	80	61	20	6	5,6 ± 0,3	200	73
LE.0818	46	47	89,5	84,5	58	80	61	20	6	5,6 ± 0,3	111	73
LE.0819	46	47	89,5	84,5	58	80	61	20	6	5,6 ± 0,3	111	73

Plate thickness S over / up to	Hole D*
1,00 / 1,75	3,9
1,75 / 3,00	4,1
3,00 / 4,75	4,4
4,75	M5

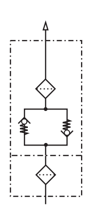
* Core hole Ø D for self-tapping screws according to DIN 7975 for versions without double check valve. For versions with double check valve always use M5.
Fastening screws included in basic equipment

Symbols

1



2



Layout

Sizes

The determining factor for selecting the size is the maximum over / under pressure allowed in the tank.

For versions without double check valves, the initial pressure drop with a clean air filter should not exceed 0,03 bar.

For versions with double check valves, the initial pressure drop for air IN with a clean air filter should not exceed 0,1 bar.

Filter fineness

In the ideal case, the fineness of the ventilating filter matches the fineness of the system filter (see also CETOP RP 98 H).
By the use of filter fineness 2 CL the ingress of dust into the tank is effectively reduced.

Mounting

The ventilating filter should be mounted in a low-dust area of the machine and not in depressions in which water can collect. For mobile use, the ventilating filter is to be mounted on the tank such that neither splashing oil from the inside nor spray water from the outside can reach the area of the ventilation opening.

Double check valves

By the use of double check valves, the exchange of air between the tank and the environment can be considerably reduced, whereby the ingress of dust is minimized and the lifetime of the ventilating filter is increased.
With the double check valve, a predefined level of pressure can be created in the tank in order to improve the suction conditions for the pumps.
The valve opening pressure required for the ventilating filter can be approximately determined with the ideal gas equation depending on the following system characteristics:

› differential volume
› volume of oil in the system
› volume of air in the tank
› operating temperatures

Calculation tool available.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

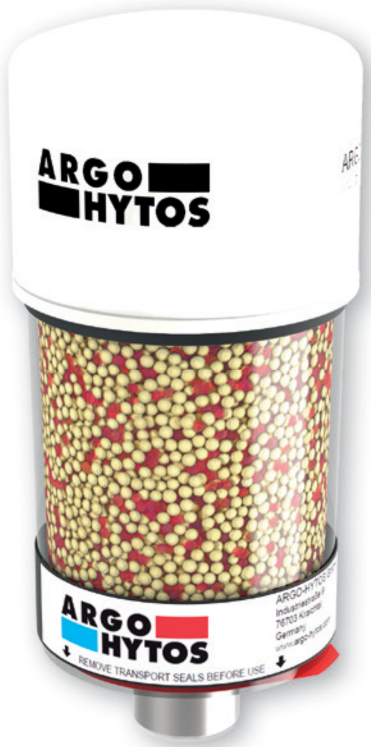
Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Ventilating Dryer

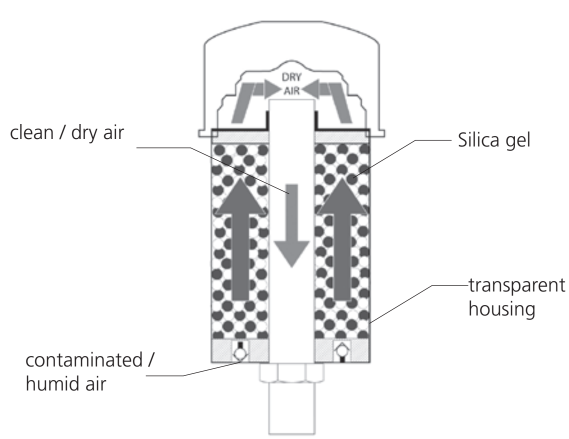
LT.1021-51 · LT.1325-51

Connection up to G1¼ · Nominal flow rate up to 400 l/min

M



Ventilating dryer LT.1021-51



Description

Application

The ventilating dryer is mounted at tanks of hydraulic and lucbrication systems in order to prevent humidity from entering the system during ventilation.

General

Water in hydraulic and lubrication oils may have the following causes:

- Environment humidity
- Spray-water

Already small quantities of free water in oil can lead to acidification. Corrosion of surfaces can be the result. Due to free water the oil characteristics change, e.g. decreased load-carrying capacity, reduced temperature resistance. In order to avoid economic damage, the oil must be protected against free water.

Special features

Ventilating dryers prevent solid particles as well as humidity, snow, spray- or rainwater from entering. They may even be used in sea atmosphere without any problems. The filter consists of a vessel with silica gel and an integrated ventilator.

Performance features

- Water abstraction from the humid air to maintain the lubrication effect and to prevent oxidation
- Colour change when the maximum dirt holding capacity of the filter element is reached

Maintenance

With colour change of the silica gel from red to orange or with clogged filter element.

Accessories

Additional humidity sensors for monitoring of the pressure fluid are available on request - LubCos humidity sensors dimensions and technical data see data sheet LubCos H_2O and LubCos H_2O+ II.

Operation

The air flows via the in the bottom integrated valves into the ventilating dryer, therein the humid air is first dried in Silica gel, then the solid particle contamination is filtered with a 3 µm filter.

Characteristics

Nominal flow rate
400 l/min

Connection
Screw-in thread BSP

Filter fineness
3 µm

Pressure fluid

Mineral oils:	H, HL, HLP, HVLP
Synthetic ester:	HESS
Polyalphaolefin:	HEPR

Other oils on request

Temperature range
- 40 °C ... + 90 °C

Materials

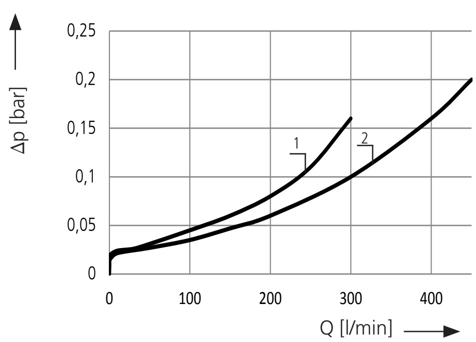
Housing:	Styrene acrylonitrile (SAN)
Tank connection:	Stainless steel
Ventilator housing:	Steel, painted
Drying material:	Silica Gel (non-toxic)
Filter material:	Glass fibre

Mounting position
Preferably vertical, on top of the reservoir

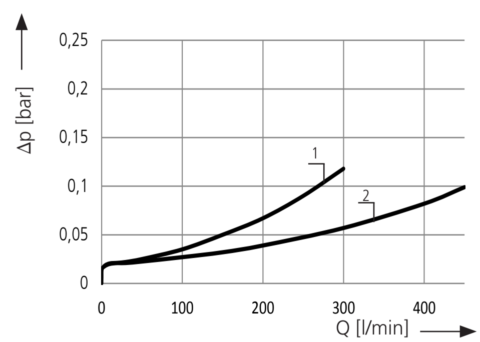
Diagrams

Δp-curves

D1 Pressure drop as a function of the **flow volume** **AIR IN**



Pressure drop as a function of the **flow volume** **AIR OUT**

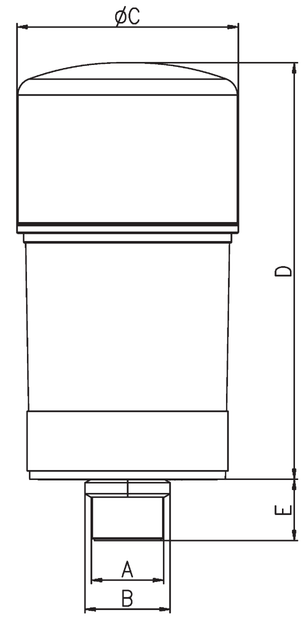


Selection Chart

Part No.	Pressure drop see diagram **D**/curve no.	Nominal flow rate ventilating filter	Filter fineness	Filter surface	Water absorbtion	Cracking pressure air IN	Cracking pressure air OUT	Connection	Symbol	Weight	Remarks
		l/min	µm	cm²	g	bar	bar			kg	
1	2	3	4	5	6	7	8	9	10	11	12
LT.1021-51	**D1**/1	300	3	754	172	0,01	0,01	G¾“	1	1,5	-
LT.1325-51	**D1**/2	400	3	2116	288	0,01	0,01	G1¼“	1	2,7	-

Remark:
The ventilating filters listed in this chart are standard filters. If modifications are required, we kindly ask for your request.

Dimensions

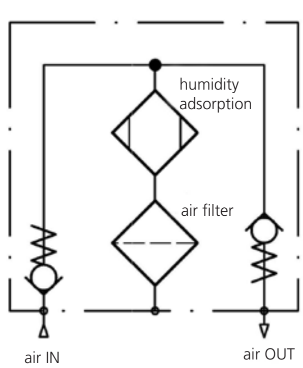


Measurements

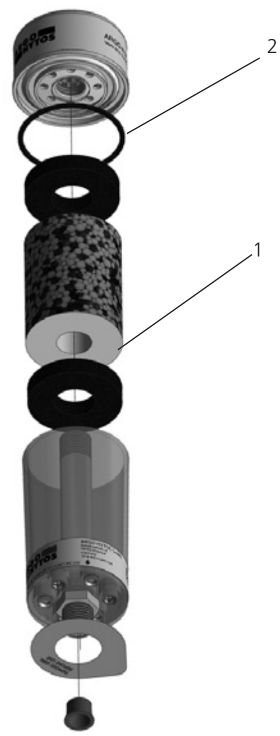
Type	A	B	ØC	D	E
LT.1021-51	G¾	AF 32	96	210	20
LT.1325-51	G1¼	AF 50	128	250	30

Symbol

1



Spare Parts



LT.1021-51

Pos.	Designation	Spare Part No.
1	Silica Gel	X9.1021-01 (delivered as refill)
2	Ventilator, Spin On	X9.1021-21 incl. seal

LT.1325-51

Pos.	Designation	Spare Part No.
1	Silica Gel	X9.1325-01 (delivered as refill)
2	Ventilator, Spin On	X9.1325-21 incl. seal

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

ISO 2941	Verification of collapse/burst pressure rating
ISO 2942	Verification of fabrication integrity (Bubble Point Test)
ISO 2943	Verification of material compatibility with fluids
ISO 3968	Evaluation of pressure drop versus flow characteristics
ISO 16889	Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
ISO 23181	Determination of resistance to flow fatigue using high viscosity fluid

Various quality controls during the production process guarantee the leakfree function and solidity of our filters.

Clogging Indicators

DG 100 · DG 101 · DG 200 · DG 813 · DG 815 · DG 819 · DG 902

for Suction or Return Filters · Connection G¼ resp. M12 x 1,5 · Response/switching pressure up to 2,5 bar

M

Manometer DG 100

Pressure switch DG 815

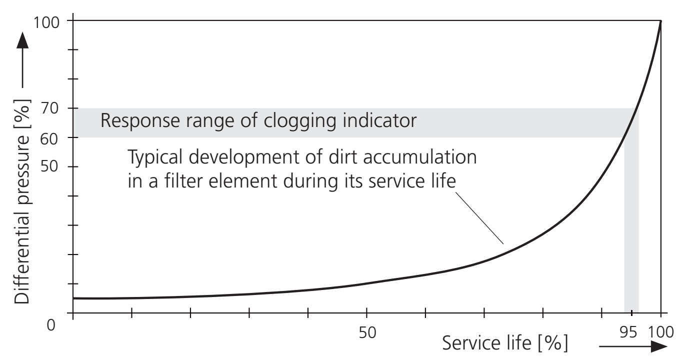
Description

Application

Monitoring the contamination of suction resp. return filters.

General

Filter elements installed in hydraulic filters remove dirt from a hydraulic system and therefore become contaminated themselves.
Free pores or spaces in the filter material are obstructed by dirt particles, which causes a continuous increase in the pressure loss.



The dirt load collected in a filter element gradually increases during service, which also leads to a higher pressure drop. The resulting vacuum or back pressure is monitored by a clogging indicator. Once a preset value is reached, an electrical and/or optical signal is generated.
The following must be observed in this context:
The pressure drop caused by the filter element increases depending on the flow rate, the dirt load, and the viscosity of the pressure fluid. Therefore, a filter element is not regarded contaminated before the clogging indicator responds at operating temperature of the hydraulic system, causing a continuous signal.

Consequences of an overdue filter element change

Filters with by-pass valve:
The more dirt has collected in the filter element, the more frequently the bypass valve opens and part of the hydraulic fluid remains unfiltered. The high pressure drop causes unnecessary power consumption.

Suction filters with-out by-pass valve:
There is a high risk of pump cavitation with increasing vacuum caused by contaminated elements.

Operating pressure

- DG 100: -1,0 ... +0,25 bar
- DG 101: -1,0 ... +0,25 bar
- DG 902: -0,5 ... +1,0 bar
- DG 200: 0 ... +10,0 bar
- DG 813: 0 ... +10,0 bar
- DG 815: 0 ... +10,0 bar
- DG 819: 0 ... +10,0 bar

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see Selection Chart, column 6 (other port threads on request).

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range of fluids

- DG 100: -30 °C ... +100 °C (short term 120 °C)
- DG 101: -30 °C ... +100 °C (short term 120 °C)
- DG 902: -15 °C ... +100 °C (short term 130 °C)
- DG 200: -20 °C ... + 90 °C
- DG 813: -30 °C ... +100 °C (short term 120 °C)
- DG 815: -30 °C ... +100 °C (short term 120 °C)
- DG 819: -30 °C ... +100 °C (short term 120 °C)

Ambient temperature range

- DG 100: -30 °C ... +80 °C
- DG 101: -30 °C ... +80 °C
- DG 902: -30 °C ... +80 °C*
- DG 200: -20 °C ... +90 °C
- DG 813: -30 °C ... +80 °C
- DG 815: -30 °C ... +80 °C
- DG 819: -30 °C ... +80 °C

* Design-related the switching tolerance increases at temperatures -15°C.

Materials

DG 100: Housing steel, fitting brass, seal copper
DG 101: Housing steel, fitting brass, seal copper
DG 902: Housing brass, protection cap polyamide, diaphragm FPM, seal NBR
DG 200: Housing polyamide, fitting brass, seal PTFE
DG 813 /
DG 819: Housing steel galvanized, protection cap NBR, diaphragm NBR, seal copper
DG 815: Housing polyamide, fitting steel galvanized, diaphragm NBR, seal copper

Operating voltage

10 ... 30 V DC (only required for clogging indicators with built-in LEDs)

Electrical service life

DG 902/DG 813/DG 815/DG 819:
min. 10^6 switching cycles

Electrical protection

- DG 902: IP 44 (with protection cap)
- DG 813: IP 65 (switch housing), IP 54 (with protection cap)
- DG 815: IP 65 (with mounted and secured socket)
- DG 819: IP 67 (in connected condition)

Electrical connection

- DG 902: Flat plugs DIN 46247 - 6,3 x 1
  Cable diameter approx. 6,5 mm
- DG 813: Flat plugs DIN 46244 - A 6,3 - 0,8
  Cable diameter approx. 4 mm
- DG 815: Socket DIN 43650 - AF3
  Cable diameter 6 ... 8 mm
- DG 819: Mating plug AMP superseal and Deutsch DT04-2P resp.
  Cable diameter approx. 4 mm

Mounting position

No limitation

Overview of types

DG 100 / DG 101 - Manometer for Suction Filters

Function:
Manometer for optical monitoring of the dirt load in suction filters.
Green reading area = filter element O.K.,
Red reading area = filter element clogged.

Option:
Bottom-mounted fitting (DG 101), making it possible to turn the manometer into the direction from which it is viewed, as compared to a fitting mounted on the back (standard)

DG 902 - Vacuum Switch for Suction Filters (change-over)

Function:
When the preset vacuum is reached, the built-in diaphragm switch changes over.
The change-over (CO) switch makes it possible to indicate a broken wire by means of a suitable electronic circuit, as compared to a make contact (normally open / NO) switch

DG 200 - Manometer for Return Filters

Function:
Manometer for optical monitoring of the dirt load in return filters.
Green reading area = filter element O.K.,
Red reading area = filter element clogged.
In order to protect the measuring element from pressure peaks, the unit is provided with a built-in orifice system.

Option:
Bottom-mounted fitting, making it possible to turn the manometer into the direction from which it is viewed, as compared to a fitting mounted on the back (standard).

DG 813 / DG 819 - Pressure Switch for Return Filters (make/break)

Function:
The diaphragm switch closes resp. opens as soon as the pressure exceeds the preset value.

Accessories:
Suitable protection caps for DG 813 are available under part no. DG 813.0701 (central hole for cable Ø 1,5 up to 5 mm) and DG 813.0702 (2 holes for cable Ø 1,7 up to 2,2 mm).

DG 815 - Pressure Switch for Return Filters (change-over)

Function:
When the preset back pressure is reached, the built-in diaphragm switch changes over.
The change-over (CO) switch makes it possible to indicate a broken wire by means of a suitable electronic circuit, as compared to a make contact (normally open / NO) switch.

Option:
The transparent socket with 2 built-in LEDs makes it possible to have an additional optical indication of the element contamination.
When the operating voltage is switched on, a green LED lights up. When the switching pressure is reached, a yellow LED lights up in addition.

Selection Chart

Part No.	Optical indicator	Electrical switch	Temperature suppression < +32 °C	Response/switching pressure	Type of contact	Switching voltage U	Switching current I	Switching power P	Symbol	Weight	Remarks
				bar		V AC/DC	A AC/DC	VA/W AC/DC		kg	
1	2	3	4	5	6	7	8	9	10	11	12
DG 100-00	•	-	-	-0,25	-	-	-	-	1	0,11	fitting on the back
DG 101-04	•	-	-	-0,25	-	-	-	-	1	0,11	bottom fitting
DG 902-11	-	•	-	-0,15	change-over	250/24	6,0/2,0	1.500/48	2	0,13	with protection cap
DG 902-12	-	•	-	-0,25	change-over	250/24	6,0/2,0	1.500/48	2	0,13	with protection cap
DG 200-05	•	-	-	+1,0	-	-	-	-	1	0,07	fitting on the back
DG 200-11[1]	•	-	-	+1,0	-	-	-	-	1	0,07	fitting on the back
DG 200-06	•	-	-	+2,0	-	-	-	-	1	0,07	fitting on the back
DG 200-15[1]	•	-	-	+2,0	-	-	-	-	1	0,07	fitting on the back
DG 200-16[2]	•	-	-	+2,0	-	-	-	-	1	0,07	fitting on the back
DG 200-10	•	-	-	+2,0	-	-	-	-	1	0,07	bottom fitting
DG 813-00	-	•	-	+1,2	make	42/42	4,0/4,0	100/100	3	0,09	without protection cap
DG 813-03	-	•	-	+1,5	make	42/42	4,0/4,0	100/100	3	0,09	without protection cap
DG 813-01	-	•	-	+2,0	make	42/42	4,0/4,0	100/100	3	0,09	without protection cap
DG 813-05	-	•	-	+2,5	make	42/42	4,0/4,0	100/100	3	0,09	without protection cap
DG 813-20	-	•	-	+1,2	break	42/42	4,0/4,0	100/100	4	0,09	without protection cap
DG 813-21	-	•	-	+2,0	break	42/42	4,0/4,0	100/100	4	0,09	without protection cap
DG 819-21	-	•	-	+2,0	break	42/42	≤4,0	100/100	4	0,09	AMP Superseal
DG 819-22	-	•	-	+2,0	break	42/42	≤4,0	100/100	4	0,09	Deutsch DT04-2P
DG 815-01	-	•	-	+1,2	change-over	250/30	4,0/4,0	250/60	5	0,13	incl. socket
DG 815-11	•	•	-	+1,2	change-over	-/30	-/0,25	-/3,0	6	0,13	incl. socket
DG 815-02	-	•	-	+2,0	change-over	250/30	4,0/4,0	250/60	5	0,13	incl. socket
DG 815-12	•	•	-	+2,0	change-over	-/30	-/0,25	-/3,0	6	0,13	incl. socket

[1] for FR 043 / FR 072 (with preformed seals)

[2] for FNA 008 / FNA 016 (as DG 200-06 but without throttle screw)

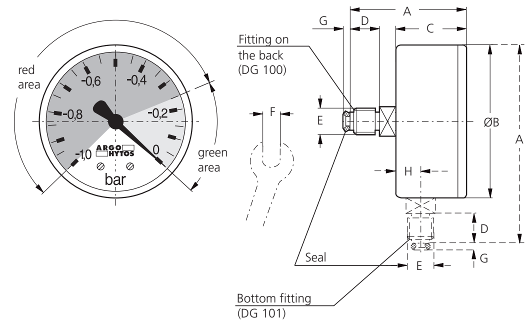
Remarks:

› With return filters, the response/switching pressure of the clogging indicator used must be lower than the cracking pressure of the bypass valve, with suction filters it must be higher.

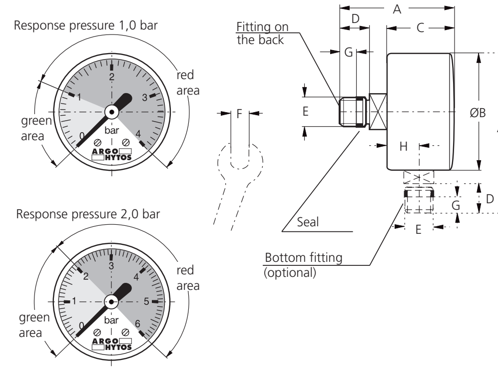
› The clogging indicators listed in this chart are standard units. Other designs available on request.

Dimensions

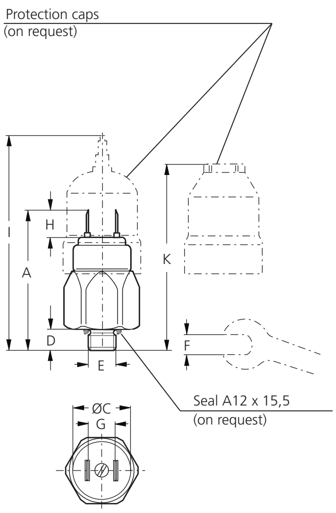
DG 100 / DG101



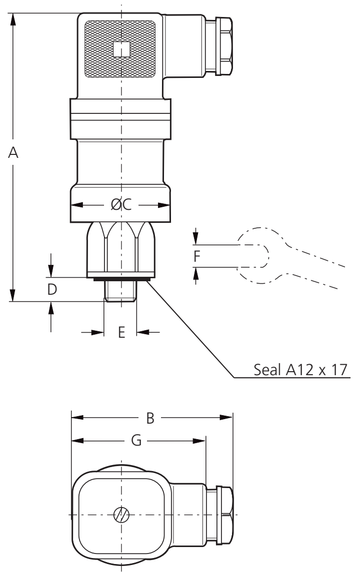
DG 200



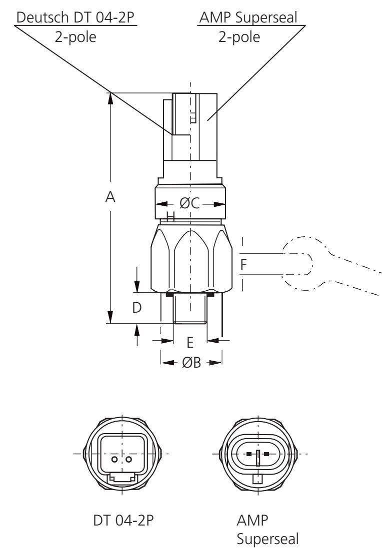
DG 813



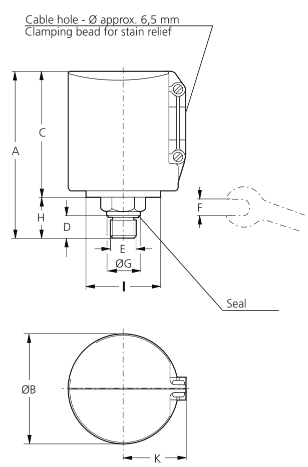
DG 815



DG 819



DG 902



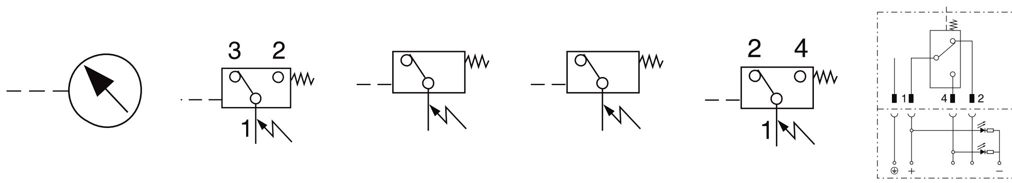
Measurements

Type	A	B	C	D	E	F	G	H	I	K
DG 100 / 101*	50 / 84*	64	30	13	G¼	14	3,2	10*	-	-
DG 902	76	50	56	10	G¼	21	18,5	20	34	30
DG 200	47 / 59*	41	26 / 24*	12	M12 x 1,5	14 / 12*	5	9*	-	-
DG 813	55	23,3	24	9	M12 x 1,5	AF 24	13	9	88	74
DG 815	92	50	34	9	M12 x 1,5	AF 27	40	-	-	-
DG 819-21	70	23,3	24	9	M12 x 1,5	AF 24	-	-	-	-
DG 819-22	71	23,3	24	9	M12 x 1,5	AF 24	-	-	-	-

* Bottom fitting

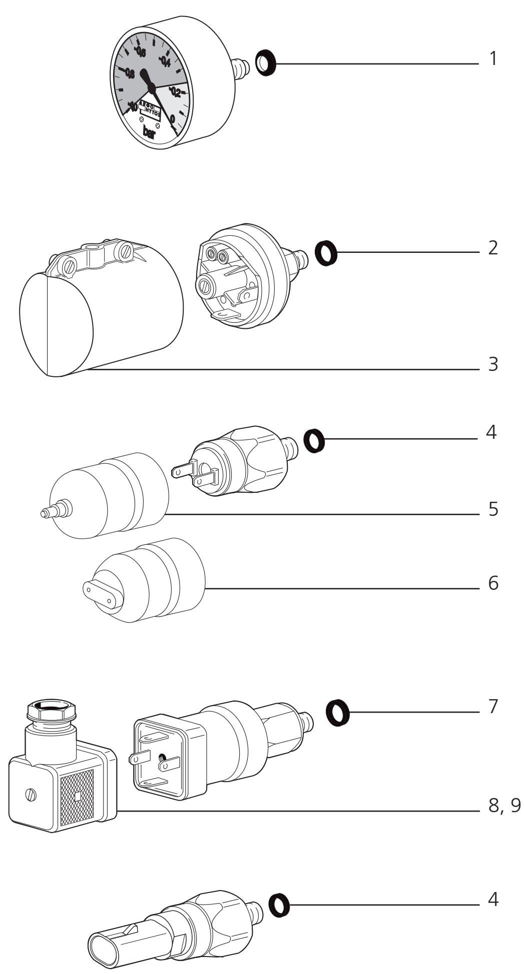
Symbols

1 2 3 4 5 6



Spare Parts

DG 100
DG 101
DG 902
DG 813
DG 815
DG 819



Pos.	Designation	Part No.
1	Seal	DG 100.0101
2	Seal	DG 902.0103
3	Protection cap	DG 902.1701
4	Seal * A12 x 15,5 DIN 7603-Cu	11049900
5	Protection cap *	DG 813.0701
6	Protection cap *	DG 813.0702
7	Seal A12 x 17 DIN 7603-Cu	11164200
8	Socket DIN 43650 - AF3	DG 041.1220
9	Socket with 2 LED DIN 43650 - AF3	DG 041.1200

*Not included in basic unit

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

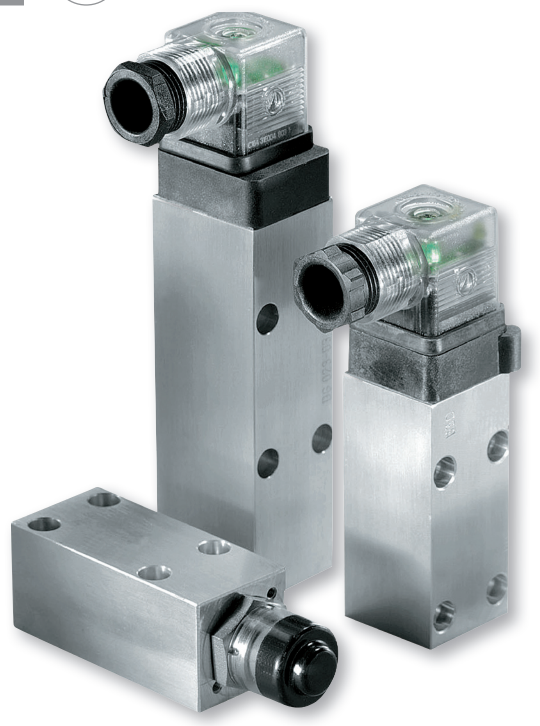
Quality Assurance

Quality management according to DIN EN ISO 9001
Various quality controls during the production process guarantee the leakfree function and solidity of our products.

Clogging Indicators

DG 023 · DG 024 · DG 041 · DG 042

for Pressure and High Pressure Filters · Operating pressure up to 450 bar · Response/switching pressure up to 5,0 bar



Clogging Indicators

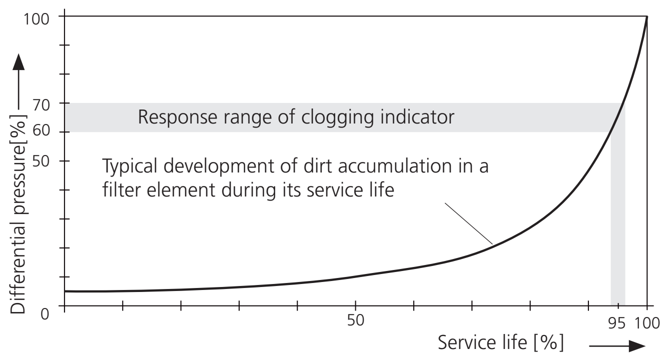
Description

Application

Monitoring the contamination of pressure and high pressure filters.

General

Filter elements installed in hydraulic filters remove dirt from a hydraulic system and therefore become contaminated themselves. Free pores or spaces in the filter material are obstructed by dirt particles, which causes a continuous increase in the pressure loss.



The dirt load collected in a filter element gradually increases during service, which also leads to a higher pressure drop. The resulting differential pressure Δp is monitored by a clogging indicator. Once a preset value is reached, an electrical and/or optical signal is generated.
The following must be observed in this context:
The pressure drop caused by the filter element increases depending on the flow rate, the dirt load, and the viscosity of the pressure fluid.
Therefore, a filter element is not regarded contaminated before the clogging indicator responds at operating temperature of the hydraulic system, causing a continuous signal.

Consequences of an overdue filter element change

For filters equipped with a bypass valve:
The more dirt has collected in the filter element, the more frequently the bypass valve opens and part of the hydraulic fluid remains unfiltered. The high pressure loss causes unnecessary power consumption.

For filters without a bypass valve:
The increasing pressure loss across the filter element, which reduces the efficiency of the hydraulic system, eventually causes malfunctions to occur or a pressure relief valve to respond.

Design and principle of operation

Within the clogging indicator, the differential pressure $\Delta p = p_1 - p_2$ (pressure upstream of the element minus pressure downstream of the element) caused by the filter element acts on a magnetic piston against the force of a spring.
In optical (mechanical) clogging indicators, the increasing differential pressure causes the piston to approach a second magnet with reversed polarity which in turn causes the indicator to change from green to red.
In electrical clogging indicators, the magnetic piston triggers a reed switch.

Special design features

Piston seal:
The piston actuated by the differential pressure is equipped with a leak-free O-ring seal. As a result, the total flow passes the filter element.

Proximity position sensing:
Piston movement is detected by sensing a magnetic field, i.e. without mechanical contact. For this reason, ARGO-HYTOS clogging indicators are absolutely leakfree.

Characteristics

Operating pressure

0 ... 315 bar, min. 10^7 pressure cycles
Nominal pressure according to DIN 24550

0 ... 450 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Connection

For the flange hole layout please refer to the section Dimensions (other fittings on request).

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range of fluids

-30 °C ... +100 °C (short term 125 °C)

Ambient temperature range

-30 °C ... +80 °C

Materials

Housing:	Aluminium alloy
Piston:	Brass
Socket:	Polyamide
Display piece DG 042:	Polyamide
Seals:	NBR (FPM on request)

Operating voltage

10 ... 30 V DC
(only required for clogging indicators with built-in LEDs)

Electrical service life

Min. 10^7 switching cycles

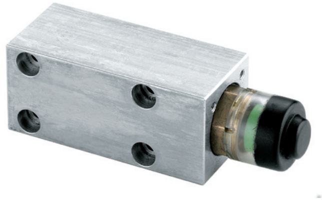
Electrical protection

IP 65 (with mounted and secured socket)

Mounting position

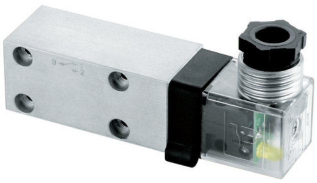
No limitation

DG 042 - Optical differential pressure indicator



Function:
When the preset differential pressure is reached, the optical indicator changes from green to red. If the pressure differential returns to a value below the preset limit, the indicator changes back to green, i.e. no manual reset of the indicator is required.

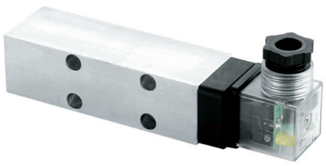
DG 041-Electrical differential pressure switch (change-over)



Function:
When the preset differential pressure is reached, the built-in Reed switch changes over.
The change-over (CO) switch makes it possible to indicate a broken wire by means of a suitable electronic circuit, as compared to a make contact (normally open NO) switch.

Option:
The transparent socket with 2 built-in LEDs makes it possible to have an additional optical indication of the filter contamination. When the operating voltage is switched on, a green LED lights up. When the switching pressure is reached, a yellow LED lights up in addition.

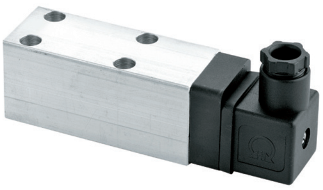
DG 023 - Electrical differential pressure switch with temperature suppression (change-over)



Function:

The built-in Reed switch changes over when the preset differential pressure is exceeded.
If the temperature drops below 32 °C, a temperature switch opens and suppresses the signal of the differential pressure switch.
The transparent socket with 2 built-in LEDs makes it possible to have an additional optical indication of the filter contamination (function described at DG 041).

DG 024 - Electrical differential pressure switch with 2 switching points (break)



Function:
When 70 % of the preset differential pressure is reached, the first Reed switch opens, at 100 % the second built-in Reed switch opens.

Note:
Since the differential pressure of a filter element rises at an exponential rate towards the end of the element's service life (refer to the Description section), approximately 95 % of the service life has expired when the first Reed contact opens (at 70 % of Δp setting).

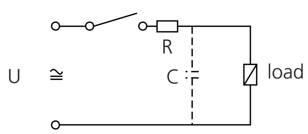
Part no.	Optical indicator	Electrical switch	Temperature suppression < +32 °C S_1	Response/switching pressure S_2/S_3	Type of contact	Switching voltage U	Switching current I	Switching power P	Symbol	Weight	Remarks
				bar		V AC/DC	A AC/DC	VA/W AC/DC		kg	
1	2	3	4	5	6	7	8	9	10	11	12
DG 042-01	•	-	-	2,0	-	-	-	-	1	0,17	-
DG 042-02	•	-	-	5,0	-	-	-	-	1	0,17	-
DG 041-61	-	•	-	1,2	change-over	120/175	0,17/0,25	3,5/5,0	2	0,19	with socket
DG 041-31	-	•	-	2,0	change-over	120/175	0,17/0,25	3,5/5,0	2	0,19	with socket
DG 041-44	•	•	-	2,0	change-over	- /30	- /0,25	- /3,0	3	0,19	with socket
DG 041-32	-	•	-	2,5	change-over	120/175	0,17/0,25	3,5/5,0	2	0,19	with socket
DG 041-33	-	•	-	5,0	change-over	120/175	0,17/0,25	3,5/5,0	2	0,19	with socket
DG 041-43	•	•	-	5,0	change-over	- /30	- /0,25	- /3,0	3	0,19	with socket
DG 023-03	•	•	•	2,0	change-over	- /30	- /0,25	- /3,0	4	0,34	with socket
DG 023-02	•	•	•	5,0	change-over	- /30	- /0,25	- /3,0	4	0,34	with socket
DG 024-02	-	•	-	3,5/5,0	break	120/175	0,17/0,25	3,5/5,0	5	0,27	with socket

Remarks:

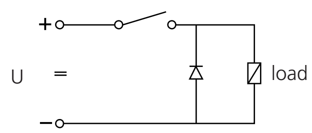
- The response/switching pressure of the clogging indicator must be lower than the cracking pressure of the bypass valve of the filter.
- The clogging indicators listed in this chart are standard units. Other designs available on request.
- Mounting accessories are not included in the scope of delivery and must be ordered separately (Part-no. see spare parts).
- Reed switches are sensitive of excessively strong currents. Even a short-term overload causes an increased contact resistance or failure of the switch. By taking the following precautions, premature failure of Reed switches due to overload is avoided.

Wiring suggestions:

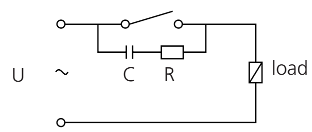
Current limiter for DC and AC voltage:
If light bulbs or other loads are connected over long distances (conductor capacity!), a protective resistor should be connected in series in order to limit the current.
The same applies when capacitance loads are connected.



Spark suppression in DC applications:
The contacts of Reed switches open extremely fast, causing voltage peaks to be induced when switching off inductive loads, such as relays, lifting magnets, or solenoid valves.
The resulting self-induction currents are short-circuited by connecting a diode in parellel to the inductive load.

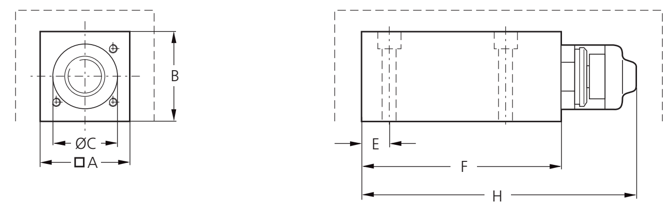


Spark suppression in AC applications:
In AC applications, a diode connected in parallel to the load is not sufficient.
RC elements should be used here, connected in parallel to the Reed switch.
Please contact our design engineers for advice in order to select a suitable RC element.

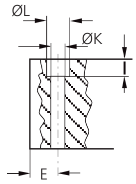


Dimensions

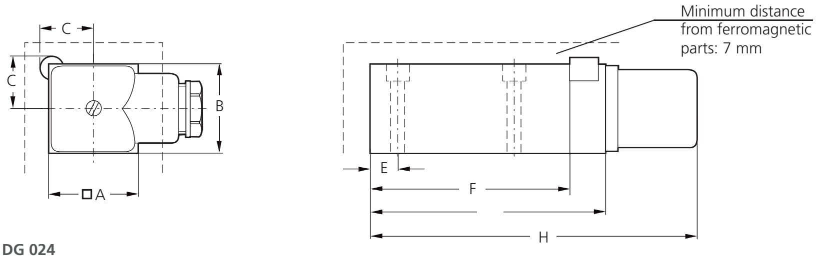
DG 042



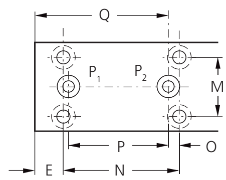
Mounting holes



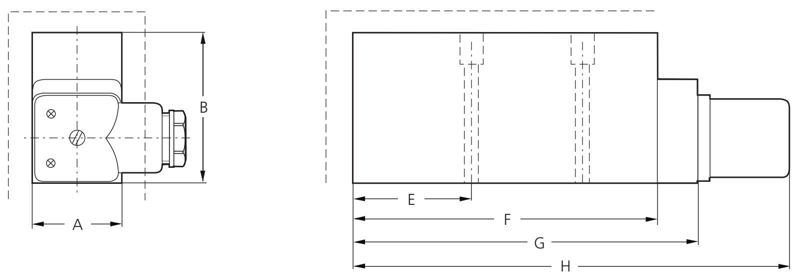
DG 041



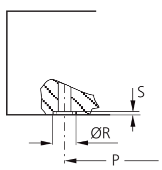
Flange hole layout



DG 023 / DG 024



Holes p_1 / p_2
p_1 = Higher static pressure
p_2 = Lower static pressure

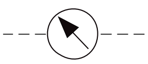


Measurements

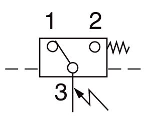
Type	A	B	C	E	F	G	H	I	K	L	M	N	O	P	Q	R	S	T	U
DG 042	30	30	21,5	8	67	-	93	6	4,5	8	20	39	3	34	44	7,2	1,1	M4	6
DG 041	30	30	17,5	11	70	83	115	6	4,5	8	20	39	3	34	47	7,2	1,1	M4	6
DG 023	30	50	-	12	76	88	121	6	4,5	8	20	39	3	34	48	7,2	1,1	M4	6
DG 024	30	35	-	9	77	89	122	11	4,5	8	20	39	3	34	45	7,2	1,1	M4	6

Symbols

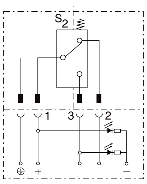
1



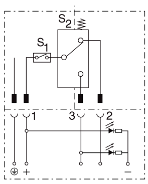
2



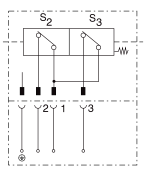
3



4

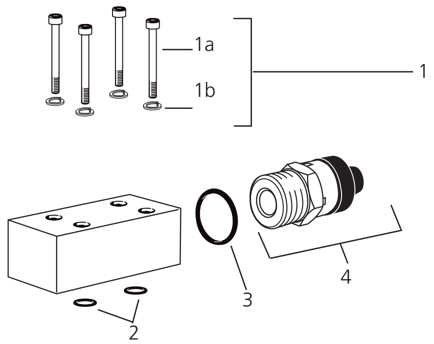


5

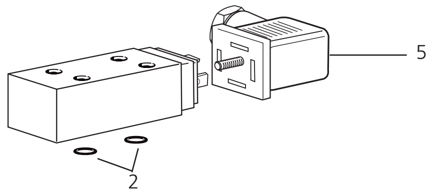


Spare Parts

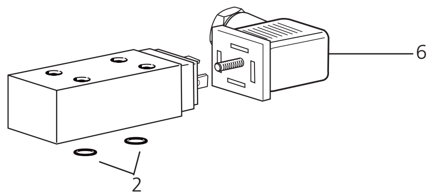
DG 042



DG 041 / DG 024



DG 041 / DG 023



Pos.	Designation	Part No.
1	Mounting accessories * for versions without temperature compensation	DG 020.1710
1	Mounting accessories * for versions with temperature compensation	DG 020.1730
1a	Bolt* M4 x 30 DIN 912-8.8	11272600
1a	Bolt* M4 x 50 DIN 912-8.8	18077800
1b	Spring washer* B4 DIN 127	11272700
2	O-ring 4,5 x 1,5	N007.0041
3	O-ring 12,3 x 2,4	N007.0124
4	Display piece assy (with pos. 3)	DG 042.1410
5	Socket DIN 43650 - AF3	DG 041.1220
6	Socket with 2 LED DIN 43650 - AF3	DG 041.1200

*Not included in basic unit

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001
Various quality controls during the production process guarantee the leakfree function and solidity of our products.

Clogging Indicators

DG 060 · DG 061 · DG 062 · DG 063 · DG 064

for Pressure and High Pressure Filters · Operating pressure up to 600 bar · Response/switching pressure up to 5,0 bar

Clogging indicators
DG 062 and DG 064

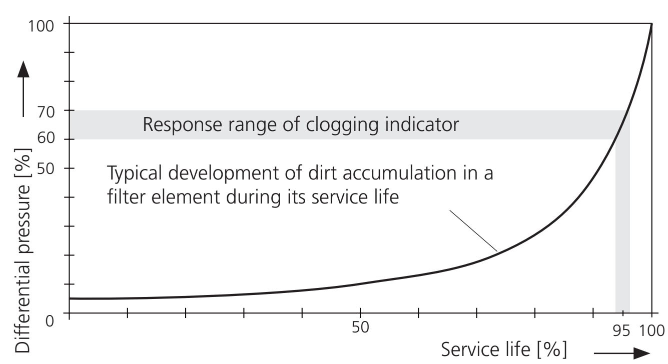
Description

Application

Monitoring the contamination of pressure and high pressure filters.

General

Filter elements installed in hydraulic filters remove dirt from a hydraulic system and therefore become contaminated themselves. Free pores or spaces in the filter material are obstructed by dirt particles, which causes a continuous increase in the pressure loss.



The dirt load collected in a filter element gradually increases during service, which also leads to a higher pressure drop. The resulting differential pressure Δp is monitored by a clogging indicator. Once a preset value is reached, an electrical and/or optical signal is generated.
The following must be observed in this context:
The pressure drop caused by the filter element increases depending on the flow rate, the dirt load, and the viscosity of the pressure fluid.
Therefore, a filter element is not regarded contaminated before the clogging indicator responds at operating temperature of the hydraulic system, causing a continuous signal.

Consequences of an overdue filter element change

For filters equipped with a bypass valve:
The more dirt has collected in the filter element, the more frequently the bypass valve opens and part of the hydraulic fluid remains unfiltered. The high pressure loss causes unnecessary power consumption.

For filters without a bypass valve:
The increasing pressure loss across the filter element, which reduces the efficiency of the hydraulic system, eventually causes malfunctions to occur or a pressure relief valve to respond.

Design and principle of operation

Within the clogging indicator, the differential pressure $\Delta p = p_1 - p_2$ (pressure upstream of the element minus pressure downstream of the element) caused by the filter element acts on a magnetic piston against the force of a spring.
In optical (mechanical) clogging indicators, the increasing differential pressure causes the piston to approach a second magnet with reversed polarity which in turn causes the indicator to change from green to red.
In electrical clogging indicators, the magnetic piston triggers a reed switch.

Special design features

Piston seal:
The piston actuated by the differential pressure is equipped with a leak-free O-ring seal. As a result, the total flow passes the filter element.

Proximity position sensing:
Piston movement is detected by sensing a magnetic field, i.e. without mechanical contact. For this reason, ARGO-HYTOS clogging indicators are absolutely leakfree.

Characteristics

Operating pressure

0 ... 420 bar, min. 10^7 pressure cycles
Nominal pressure according to DIN 24550

0 ... 600 bar, min. 10^4 pressure cycles
Quasi-static operating pressure

Connection

Profiled bore, see section Dimensions

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range of fluids

-30 °C ... +100 °C (short term 125 °C)

Ambient temperature range

-30 °C ... +80 °C

Materials

Housing:	Stainless steel
Piston:	Polyamide
Socket:	Polyamide
Display piece DG 062 / DG 064	Polyamide
Seals:	NBR (FPM on request)

Operating voltage

max. 48 V DC

Electrical service life

10^7 switching cycles

Electrical protection

IP 67 (in connected condition) for DG 060, DG 061, DG 062

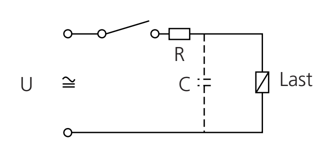
Exception:	IP 65 (with mounted and secured socket) for versions with connector socket according to DIN EN 175301-803.

Mounting position

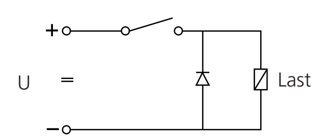
No limitation

Wiring suggestions

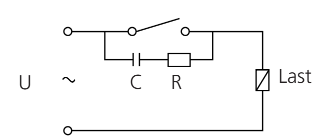
Current limiter for DC and AC voltage:
If light bulbs or other loads are connected over long distances (conductor capacity!), a protective resistor should be connected in series in order to limit the current.
The same applies when capacitance loads are connected.



Spark suppression in DC applications:
The contacts of Reed switches open extremely fast, causing voltage peaks to be induced when switching off inductive loads, such as relays, lifting magnets, or solenoid valves.
The resulting self-induction currents are short-circuited by connecting a diode in parellel to the inductive load.

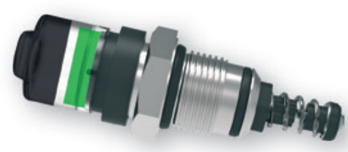


Spark suppression in AC applications:
In AC applications, a diode connected in parallel to the load is not sufficient.
RC elements should be used here, connected in parallel to the Reed switch.
Please contact our design engineers for advice in order to select a suitable RC element.



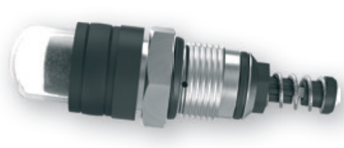
Overview of types

DG 063 - Optical differential pressure indicator with automatic reset



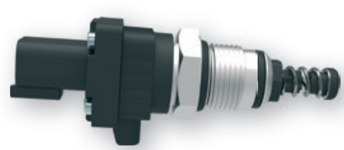
Function:
When the preset differential pressure is reached, the optical indicator changes from green to red. If the pressure differential returns to a value below the preset limit, the indicator changes back to green, i.e. no manual reset of the indicator is required.

DG 064 - Optical differential pressure indicator with manual reset



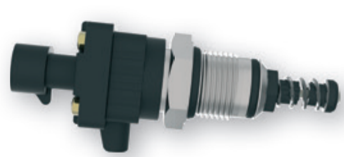
Function:
When the preset differential pressure is reached, a red pin retracts from the hole of the indication.
If the pressure differential returns to a value below the preset limit, the pin does not disappear automatically.
Due to the fitted resting fuction, a manual reset of the indicator is required.

DG 060 - Electrical differential pressure switch (make)



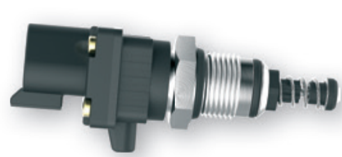
Function:
The built-in Reed switch closes when the preset differential pressure is reached.

DG 061 - Electrical differential pressure switch (break)



Function:
The built-in Reed switch opens when the preset differential pressure is reached.

DG 062 - Electrical differential pressure switch (change-over)



Function:
When the preset differential pressure is reached, the built-in Reed switch changes over.
The change-over (CO) switch makes it possible to indicate a broken wire by means of a suitable electronic circuit, as compared to a make contact (normally open NO) switch.

Option:
For versions with connector plug according to DIN EN 175301-803 and symbol 6, a transparent socket with 2 built-in LEDs is available. This socket makes it possible to have an additional optical indication of the filter contaminsation.
When the operating voltage is switched on, a green LED lights up. When the switching pressure is reached, a yellow LED lights up in addition.

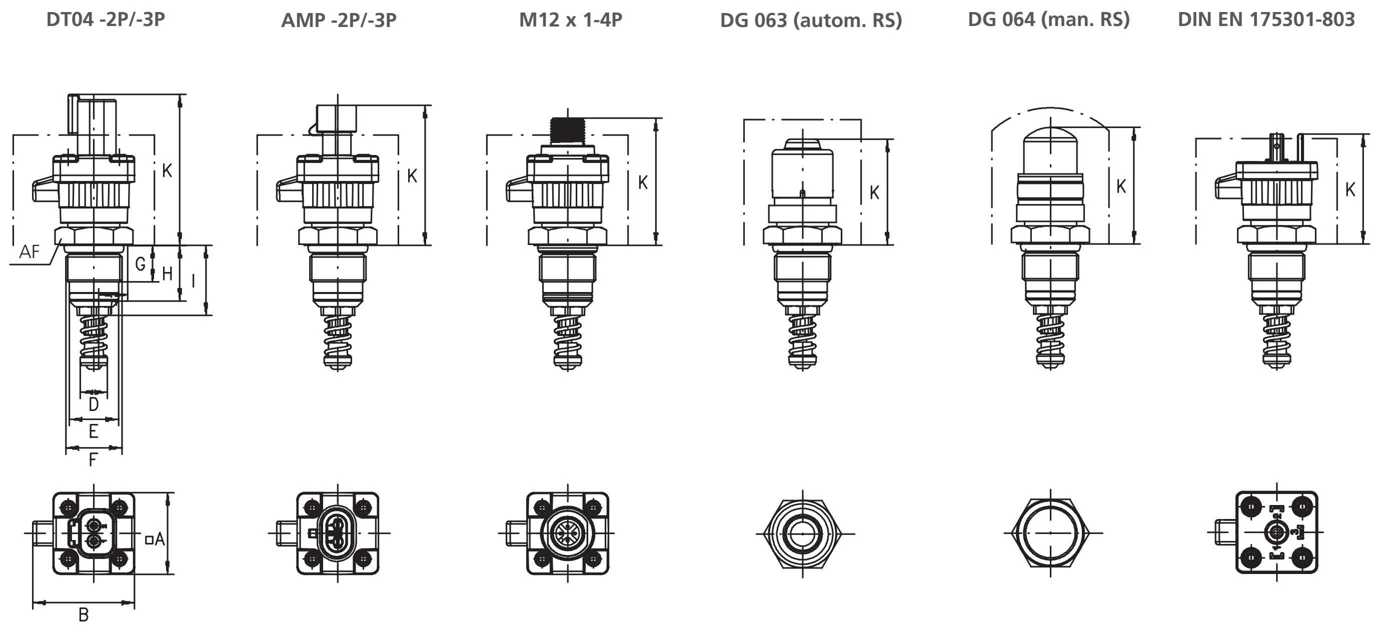
Part No.	Optical indicator	Electrical indicator	Response/switching pressure	Type of contact	Switching voltage U	Switching current I	Switching power P	Symbol	Weight	Remarks
			bar		V AC/DC	A AC/DC	V A/W AC/DC		kg	
1	2	3	4	5	6	7	8	9	10	11
DG 063-02	•	-	2,0	-	-	-	-	1	0,09	automatic reset
DG 063-05	•	-	5,0	-	-	-	-	1	0,09	automatic reset
DG 064-02	•	-	2,0	-	-	-	-	2	0,09	manual reset
DG 064-05	•	-	5,0	-	-	-	-	2	0,09	manual reset
DG 060-31	-	•	2,0	make	48/48	0,5/0,5	10/10	3	0,09	AMP Superseal-2P*
DG 060-21	-	•	2,0	make	48/48	0,5/0,5	10/10	3	0,09	Deutsch DT04-2P*
DG 060-30	-	•	5,0	make	48/48	0,5/0,5	10/10	3	0,09	AMP Superseal-2P*
DG 060-20	-	•	5,0	make	48/48	0,5/0,5	10/10	3	0,09	Deutsch DT04-2P*
DG 061-31	-	•	2,0	break	48/48	0,5/0,5	10/10	4	0,09	AMP Superseal-2P*
DG 061-21	-	•	2,0	break	48/48	0,5/0,5	10/10	4	0,09	Deutsch DT04-2P*
DG 061-30	-	•	5,0	break	48/48	0,5/0,5	10/10	4	0,09	AMP Superseal-2P*
DG 061-20	-	•	5,0	break	48/48	0,5/0,5	10/10	4	0,09	Deutsch DT04-2P*
DG 062-04	-	•	2,0	change-over	48/48	0,5/0,5	10/10	5	0,09	DIN EN 175301-803*
DG 062-05	-	•	2,0	change-over	48/48	0,5/0,5	10/10	6	0,09	DIN EN 175301-803*
DG 062-01	-	•	5,0	change-over	48/48	0,5/0,5	10/10	5	0,09	DIN EN 175301-803*
DG 062-02	-	•	5,0	change-over	48/48	0,5/0,5	10/10	6	0,09	DIN EN 175301-803*
DG 062-31	-	•	2,0	change-over	48/48	0,5/0,5	10/10	7	0,09	AMP Superseal-3P*
DG 062-21	-	•	2,0	change-over	48/48	0,5/0,5	10/10	8	0,09	Deutsch DT04-3P*
DG 062-41	-	•	2,0	change-over	48/48	0,5/0,5	10/10	9	0,09	M12 x 1-4P*
DG 062-30	-	•	5,0	change-over	48/48	0,5/0,5	10/10	7	0,09	AMP Superseal-3P*
DG 062-20	-	•	5,0	change-over	48/48	0,5/0,5	10/10	8	0,09	Deutsch DT04-3P*
DG 062-40	-	•	5,0	change-over	48/48	0,5/0,5	10/10	9	0,09	M12 x 1-4P*

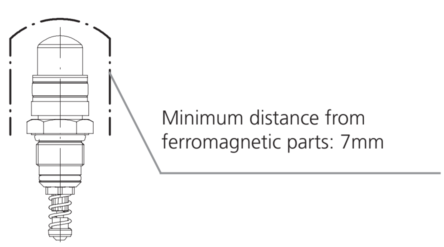
*Design of the connector plug - connector socket not included in the scope of delivery.

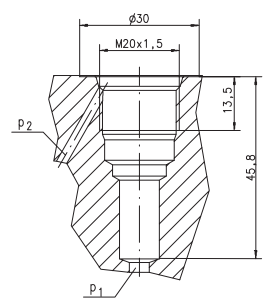
Remarks:

- The response/switching pressure of the clogging indicator must be lower than the cracking pressure of the bypass valve of the filter.
- The clogging indicators listed in this chart are standard units. Other designs available on request.
- Reed switches are sensitive of excessively strong currents. Even a short-term overload causes an increased contact resistance or failure of the switch. By taking the precautions described in paragraph wiring suggestions, premature failure of Reed switches due to overload is avoided.

Dimensions





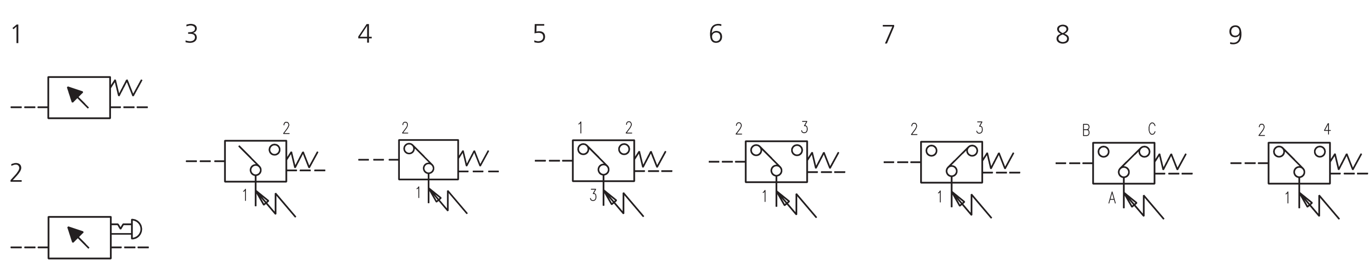


All for processing necessary measurements and tolerances are available on request.

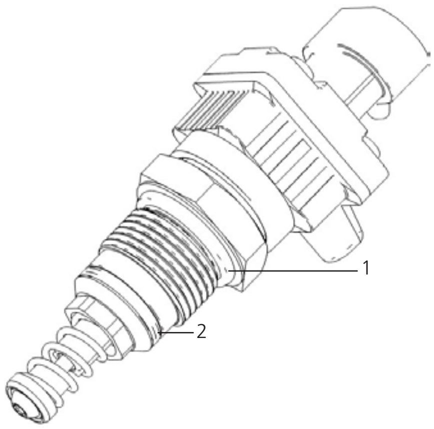
Measurements

Type	A	B	D	E	F	G	H	I	K	AF
DT04 -2P/-3P	□ 29	36,5	9,7	17,5	M20 x 1,5	13	20	25	55	24
AMP -2P/-3P	□ 29	36,5	9,7	17,5	M20 x 1,5	13	20	25	50	24
M12 x 1-4P	□ 29	36,5	9,7	17,5	M20 x 1,5	13	20	25	46	24
DG 063	-	-	9,7	17,5	M20 x 1,5	13	20	25	37,5	24
DG 064	-	-	9,7	17,5	M20 x 1,5	13	20	25	41,5	24
DIN EN 175301-803	□ 29	36,5	9,7	17,5	M20 x 1,5	13	20	25	39	24

Symbols



Spare Parts



Pos.	Designation	Part No.
1	O-ring 17,3 x 2,2	N007.0172-4
2	O-ring 14 x 1,78	N007.0142

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

Quality Assurance

Quality management according to DIN EN ISO 9001
Various quality controls during the production process guarantee the leakfree function and solidity of our products.

Illustrations may sometimes differ from the original. ARGO-HYTOS is not responsible for any unintentional mistake in this specification sheet.

Oil Level Dipsticks

C4.0410 · C4.0412 · C4.0421 · C4.0431 · C4.0450 · C4.0464

With mounting bolts · Bolt thread M10 · Dipstick length up to 640 mm

M

Oil Level Dipstick C4.0410-00330

Description

Application

Controlling the oil level in hydraulic oil or lubricant reservoirs.

Construction and function

ARGO-HYTOS oil level dipsticks are robust semicircular metal rods with an O-ring seal. A mounting bolt with a suitable hole is supplied with each dipstick. Dipsticks are available in various lengths, with various markings, and with various mounting bolts (see selection chart).

Special features

› The robust material withstands even the most severe operating conditions.
› Absolutely leak-free due to integrated O-ring.
› A suitable dipstick mounting bolt can also replace one of the mounting bolts of an in-tank return or suction filter.

Mounting

The bolt supplied with the oil level dipstick is installed either in a separate threaded hole or in an already existing mounting hole for an in-tank filter.
If used as a filter mounting bolt, a separate threaded hole is eliminated.Care should be taken to provide a proper seal between the tank, the filter and the mounting bolt.

Selection Chart

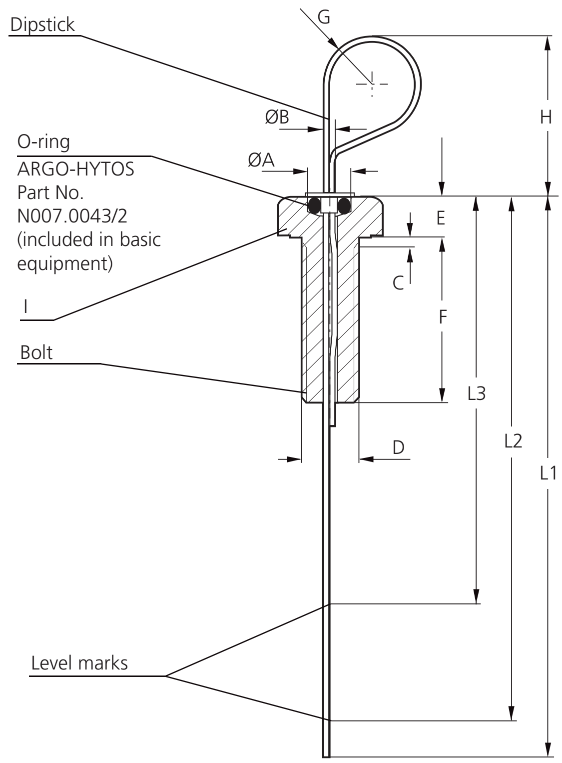
Part No.	Dipstick dimension L1	Dipstick dimension L2	Dipstick dimension L3	Mounting bolt	Grade	Remarks
	mm	mm	mm			
1	2	3	4	5	6	7
C4.0410-00330	100	-	-	SV.2810.05	8.8	-
C4.0410-01330	100	95	64	SV.2810.05	8.8	-
C4.0412-00330	120	-	-	SV.2810.05	8.8	-
C4.0412-03330	120	97	47	SV.2810.05	8.8	-
C4.0412-04330	120	100	75	SV.2810.05	8.8	-
C4.0421-00330	210	-	-	SV.2810.05	8.8	-
C4.0421-04330	210	118	88	SV.2810.05	8.8	-
C4.0421-06330	210	71	46	SV.2810.05	8.8	-
C4.0431-00330	310	-	-	SV.2810.05	8.8	-
C4.0431-01330	310	190	160	SV.2810.05	8.8	-
C4.0450-00330	500	-	-	SV.2810.05	8.8	-
C4.0464-00330	640	-	-	SV.2810.05	8.8	-
C4.0464-01330	640	630	90	SV.2810.05	8.8	-

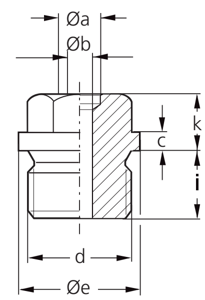
Remarks:

The dipsticks listed in the chart are standard dipsticks. If modifications are required, e.g. for the use in pressurized tanks, we kindly ask for your request.

Dimensions

Dipstick with bold





Dimensions

Mounting bolt	A	B	C	D	E	F	G	H	I
SV.2810.05	10	3,7	4,5	M10	7	30	10	39	AF 17

Characteristics

Operating pressure

Max. 1 bar (abs.)
(not suitable for use in pressurized hydraulic oil tanks)

Connection

Threaded ports according to ISO 228 or DIN 13.
Sizes see section Dimensions (other port threads on request).

Hydraulic fluids

Mineral oil and biodegradable fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range

-30 °C ... +100 °C (temporary 125 °C)

Ambient temperature range

-30 °C ... +80 °C (temporary 100 °C)

Materials

Dipsticks:	Steel, zinc plated
Bolts:	Steel, zinc plated
Seals:	NBR (FPM on request)

Mounting position

Preferably in vertical position

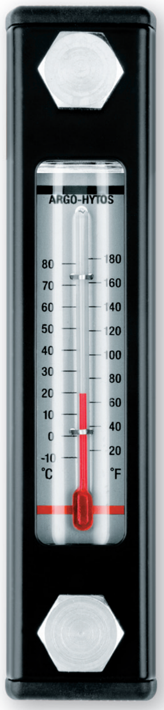
Quality Assurance

Quality management according to DIN EN ISO 9001
Various quality controls during the production process guarantee the leakfree function and solidity of our products.

Oil Level Gauges

C5.3511 · C5.3516 · C5.3529

Indication range up to 194 mm · With thermometer · Temperature indication up to 80 °C



Oil Level Gauges C5.3516-50

Description

Application

Indicates the oil level and the oil temperature in hydraulic oil or lubricant reservoirs.

Design and function

ARGO-HYTOS oil level gauges consist of a robust metal housing equipped with a sight level tube and built-in thermometer. The fluid enters the thermometer chamber through the mounting bolts, which are hollow. O-rings provide a seal against the housing and the reservoir wall.

Special features

› The robust metal housing is designed to withstand even the most severe operating conditions.
› The integrated scale shows the oil temperature in °C and °F.

Mounting

The hollow screws and the locking nuts supplied with the gauge, enable installation on the reservoir wall.
The locking nuts serve the purpose of retightening the bolts from the outside (assembly torque: 8 Nm).
If the wall of the reservoir is more than 8 mm thick, no lockings nuts are needed. Threaded holes are required instead of smooth bore holes.

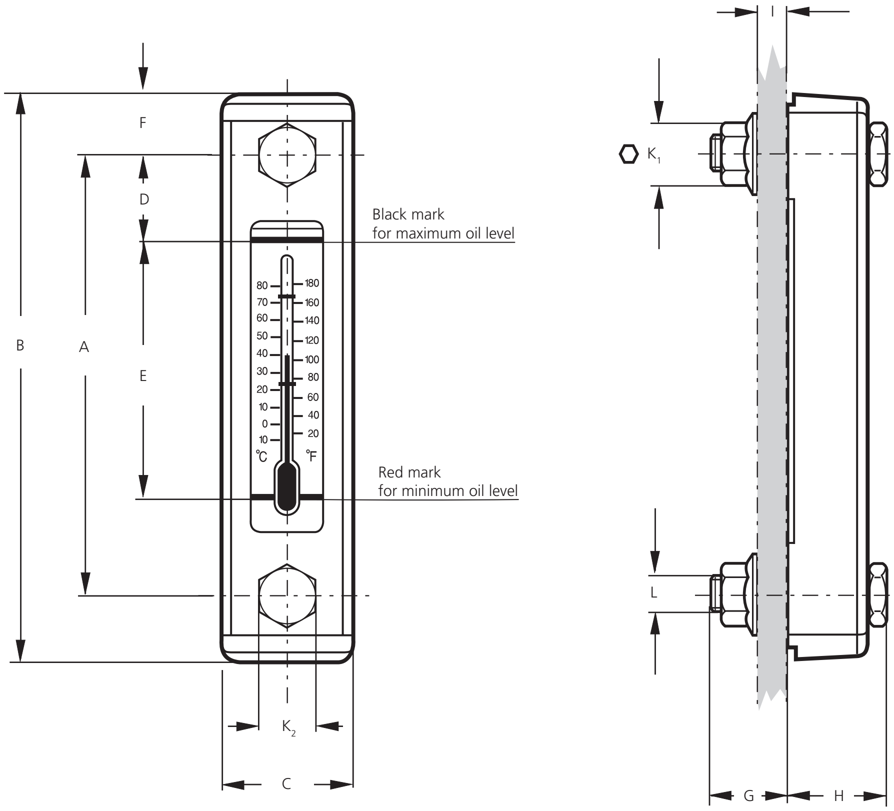
Selection Chart

Part No.	Oil level indicating range E	Total height B	Temperature indicating range	Temperature indicating range	Mounting bolts	Weight	Remarks
	mm	mm	°C	°F		kg	
1	2	3	4	5	6	7	8
C5.3511-50	33	108	+20 ... +80	80 ... 180	M10	0,18	-
C5.3516-50	74	159	-10 ... +80	20 ... 180	M12	0,24	-
C5.3529-50	194	285	-10 ... +80	20 ... 180	M12	0,32	-

Remarks:

The gauges listed in the chart are standard gauges. If modifications are required, we kindly ask for your request.

Dimensions



At the housing C5.3529-50 the vision panel is splitted in two sections

Measurements

Typ	A	B	C	D	E	F	G	H	I max.*	K_1	K_2	L
C5.3511-50	76	108	34,5	22,5	33	16	17	28	8	15	17	M10
C5.3516-50	127	159	34,5	27,5	74	16	17	28	8	18	17	M12
C5.3529-50	254	286	34,5	31	194	16	17	28	8	18	17	M12

* With a wall reservoir of more than 8 mm thickness, threaded holes are required instead of smooth bore holes.

Characteristics

Operating pressure

Max. 2 bar (abs.)

Connection

Threaded ports according to DIN 13. Sizes see Selection Chart, column 6 and section Dimensions.

Hydraulic fluids

Mineral oil and biodegradable fluids (HEES and HETG, see info-sheet 00.20)

Temperature range

-20 °C ... +80 °C

Ambient temperature range

-25 °C ... +80 °C

Materials

Housing:	Steel, powder coated, black
Sight level tube:	Polyamide
Scale:	Aluminium
Thermometer:	Glass
Bolts:	Steel, zinc plated
Seals:	NBR (FPM on request)

Mounting position

In the min./max. oil level range on the side wall of the hydraulic oil reservoir.

Quality Assurance

Quality management according to DIN EN ISO 9001

Various quality controls during the production process guarantee the leakfree function and solidity of our products.

AV · TV

For mobile and industrial applications · Connection up to M 32 x 1,5 / R1

Oil drain valves

Description

Application

Alternatively to oil drain plugs at oil tanks you can also insert ARGO-HYTOS oil drain valves of type series AV20 or TV. The oil can precisely be discharged over the drain hole into a container or be sucked off by connected oil pumps or ARGO-HYTOS oil service units. Oil change or oil service is being simplified and can be effected almost without loosing any oil.
Examples for applications: Oil storage tanks in all industries, gear boxes, test benches, axles of rail vehicles.

Design and function

ARGO-HYTOS oil drain valves consist of a housing with spindle and poppet sealing. The poppet is opened by the spindle and the oil then will be drained. Threads at the oil drain hole allow connection of oil pumps or ARGO-HYTOS oil service units.

Special design features

› Sealing by precise steel ball
› With Type AV additional sealing of the spindle

Fixing

At the bottom of the tank by screw connection

Operating pressure

Max. 1 bar absolute (not applicable with pressurized containers)

Connection

Threaded port – see Measurements

Hydraulic fluids

Mineral oil and biodegradable hydraulic fluids
(HEES and HETG, see info-sheet 00.20)

Temperature range of fluids

-30 °C … +100 °C

Ambient temperature range

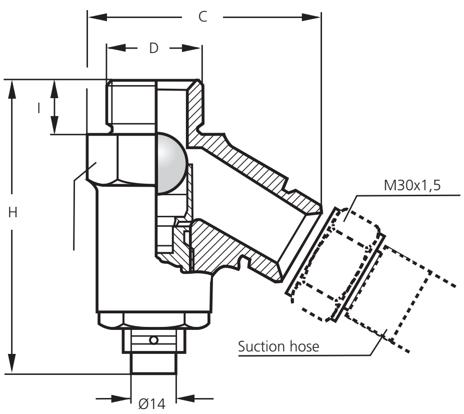
-30 °C … +80 °C

Materials

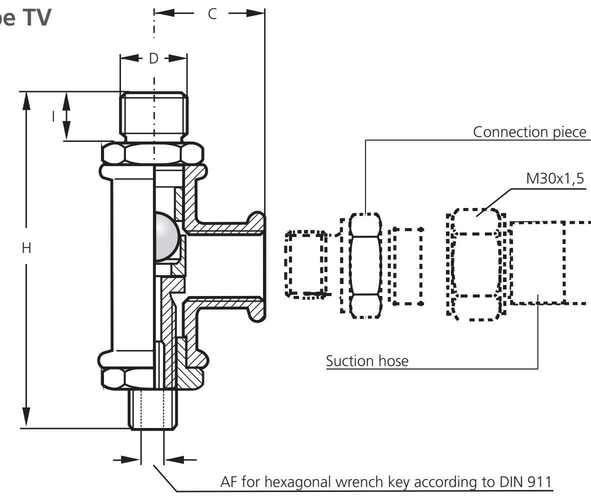
Housing:	GTW-40 powder-coated
Spindle and ball:	steel
Operating position:	vertical or horizontal

Dimensions

Type AV



Type TV



Measurements

Type AV

Type	D	C	H	I	A/F	Part No.
AV20	M32 x 1,5	75	93	16	14	EC330400
AV20/1	M30 x 1,5	75	93	16	14	EC330410

Type TV

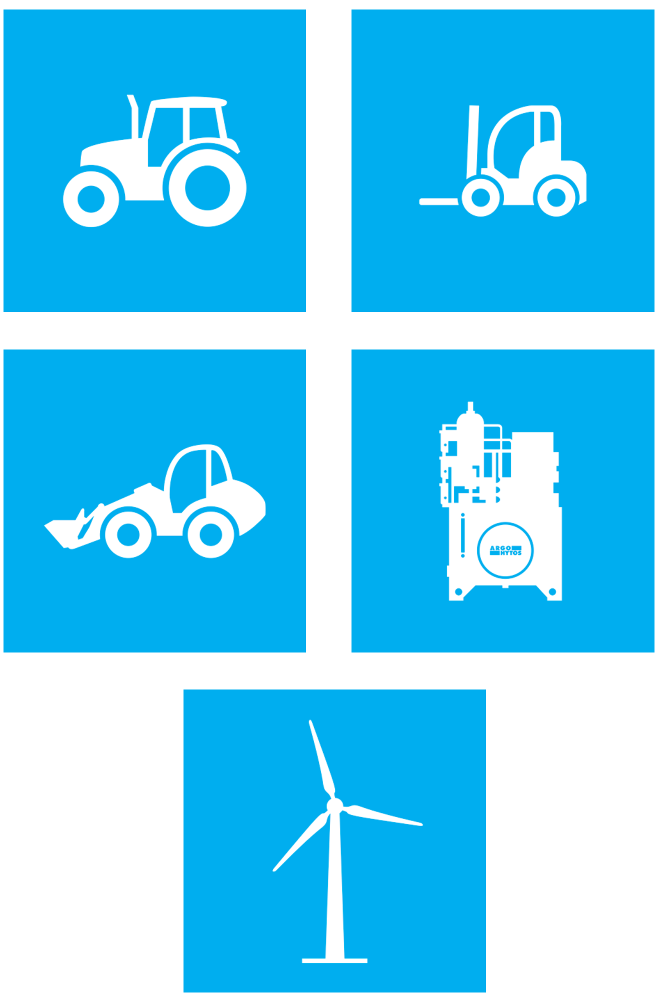
Type	D	C	H	I	Connec-tion A	SW	Part No.
TV R ½“	R 1/2“	28	92	15	M30 x 1,5 to R 1/2“	6	EC330110
TV R ¾“	R 3/4“	33	102	16	M30 x 1,5 to R 3/4“	8	EC330120
TV R1“*	R 1“	38	125	18	M30 x 1,5 to R 1“	8	EC330130

* For type TV R1“ the spindle is additionally sealed with cap nut and flat gasket (not shown in drawing).

The new generation of filter elements

EXAPOR®MAX 2

Innovation in Filtration



Description

Higher machine availability, longer service intervals and lower operating costs. These were the development goals for the new generation of filter elements.

With the introduction of EXAPOR®MAX 2, ARGO-HYTOS is opening a new chapter in filtration for hydraulic and lubrication systems.

The structure of the specially developed 3-layer filter material was designed for optimum performance, using glass and polyester fibers of different finenesses combined with an improved hybrid support fabric (patented) made of stainless steel and polyester. This sets the standard for:

› Pressure loss
› Dirt holding capacity
› Flow fatigue stability

The plastic sleeve used on the EXAPOR®MAX 2 for the first time offers the following benefits:

› Custom label
› Protection from damage
› Improvement of flow fatigue stability

For the user, these improvements bring:

› Extended service intervals
› Higher operational reliability
› Improved oil cleanliness
› Increased performance
› Positive element identification
› Reduced operating and maintenance costs

Extended service intervals

Higher dirt holding capacity and improved flow fatigue stability are of particular importance in achieving extended service intervals.
The new performance-oriented structure of the filter material makes a substantial contribution to improving dirt holding capacity, reducing pressure losses and improving the differential pressure stability. The improved hybrid support fabric (patented) dissipates electrostatic charge completely, gives the best possible flexural strength while reducing pressure losses. The plastic sleeve shrunk onto the filter bellows ensures that it tightly fits the edges of the hole, which has a positive effect on flow fatigue stability. These improvements make a substantial contribution to increasing the life of the filter elements.

Higher operational reliability

When used on existing machinery with fixed service intervals, EXAPOR®MAX 2 filter elements bring greater operational reliability, minimizing the risk of sudden machine downtimes as well as reducing downtime caused by time-consuming and expensive maintenance work.

Improved oil cleanliness

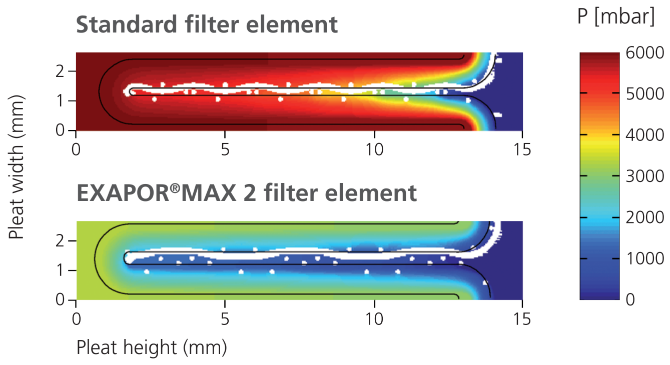
A high degree of oil cleanliness has a positive effect on both the life of components and that of the hydraulic medium itself. To meet rising standards, in the new generation of filter elements the filter fineness has been improved to 10 µm(c) compared with 12 µm(c) previously. The EXAPOR®MAX 2 filter elements are available in filter finenesses of 5 µm(c), 10 µm(c) and 16 µm(c).

Positive identification of elements

The plastic sleeve used on the EXAPOR®MAX 2 filter elements can be printed as required. This substantially improves positive identification and is an important feature for building up and securing a strategic spare part business.

Increased performance

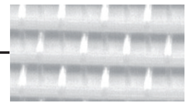
The factors that influence pressure loss could be worked out with the aid of calculations and flow simulations, and the structure of the filter material optimized accordingly. The result is a reduction in pressure losses in the pleat of up to 50 % and up to 40 % in the filter element. Conversely, this means that at a constant pressure loss the EXAPOR®MAX 2 filter elements can achieve a flow rate that is up to 65 % higher. The substantial reduction in pressure losses allied to an improved dirt holding capacity leads to an increase in power density, so that, depending on the application, smaller filters could be used.



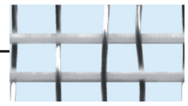
Reduced operating and maintenance costs

These innovations work together to reduce operating and maintenance costs and bring about an improvement in the productivity and economy of machinery and plant.

Schematic construction



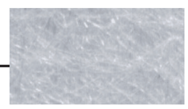
Plastic sleeve
Custom label, damage protection, improved flow fatigue stability



Hybrid support fabric (patented)
Protection of filter materials from external mechanical damage, prevents electrostatic charge, keeps the pleats open for the free flow of hydraulic medium.

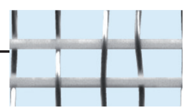
Pre-filter layer
Separation of coarse particles, increase in the dirt holding capacity

Fine filter layer
Separation of fine particles, improvement of oil cleanliness

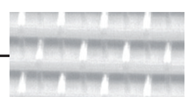


Protective fleece
Protection of the fine filter layer, improved differential pressure and flow fatigue stability

Safety fabric
Additional protection of the filter elements with a differential pressure stability of 160 bar



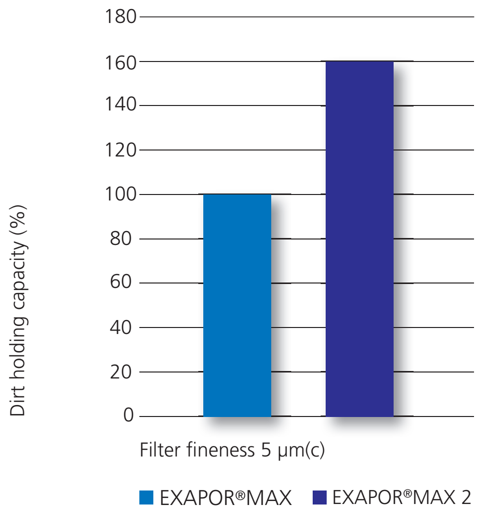
Hybrid support fabric (patented)
Support of the filter materials, keeping the pleats open for free flow of medium. Prevents build-up of electrostatic charges, improved flow fatigue stability

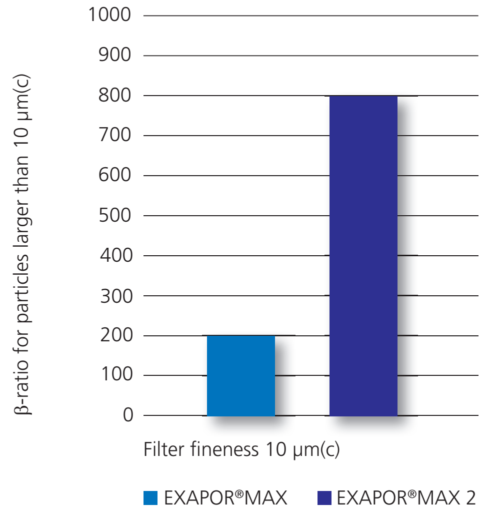


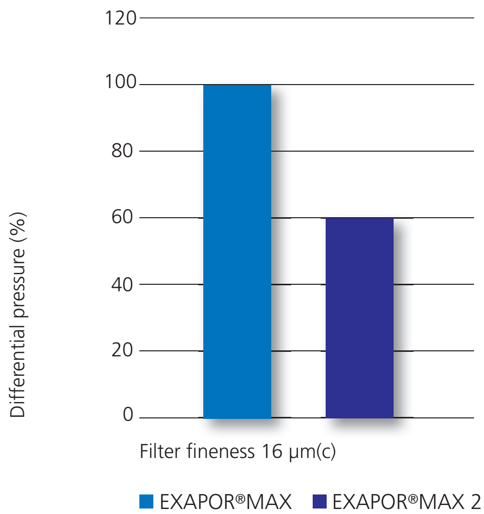
Woven sleeve
Fine wire mesh provides additional support for the pleated filter material with filter elements that have a differential pressure stability of 160 bar

Perforated core
Full surface support of the pleated filter material, ensuring collapse pressure stability

Overview of the improvements in EXAPOR®MAX 2 filter elements







Filter element

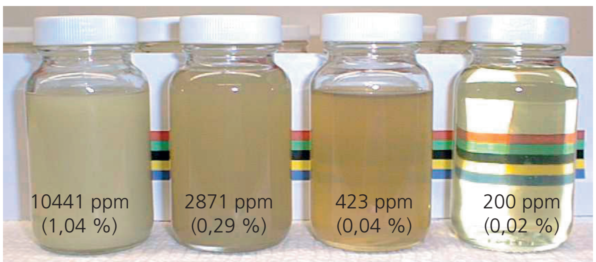
EXAPOR®AQUA

for Water Separation

EXAPOR®AQUA filter elements

Filling unit FA 016

Oil service unit FNA 008/016



Oil samples with varying water content

Quick and efficient dewatering of hydraulic and lubrication oils

Water in hydraulic and lubrication oils may have the following causes:

› Radiator leakage
› Environment humidity
› Spray-water
› Fresh oil

Already small quantities of free water in oil can lead to acidification.
Corrosion of surfaces at components can be the result. Due to free water the oil characteristics change, e.g. decreased load-carrying capacity, reduced temperature resistance. In order to avoid economic damage, the oil must be protected against free water or existing water must be withdrawn as fast as possible.

Large water quantities can be withdrawn by oil change, flushing of the system or with dewatering units.
On systems with hygroscopic (materials that absorb water are described as hygroscopic) oils or with permanent water entry through seals (e.g. hydraulic excavator used in water constructions) ARGO-HYTOS off-line filters and filter units with EXAPOR®AQUA filter elements can be installed permanent in the system, in order to withdraw water.
To withdraw remaining water quantities, e.g. after new filling, the ARGO-HYTOS EXAPOR®AQUA elements in portable off-line filter units also can be used during operation of the system.

EXAPOR®AQUA filter elements are applicable in different ARGO-HYTOS filter units. Depending on the operating situation the water absorption amounts to approx. 350 ml/element. The combination of water absorbing filter layers with micro-filter material also allows the use of EXAPOR®AQUA in hydraulic and lubrication systems with high requirements to the oil cleanliness.

The efficiency of the EXAPOR®AQUA can be analyzed on-site. As long as a turbidity is visible in the cooled down oil, the water content is, in most cases, unacceptably high. If the cooled down oil sample appears clear, the water content usually lies in the permissible range. An exact measurement of the water content is made by an oil sample analysis in the laboratory (e.g. water content regulation after the Karl Fischer method in accordance with DIN 51777).

EXAPOR®AQUA Filter element	Water capacity per element at ν = 30 mm²/s	Filter fineness	Dirt-holding capacity (values in g test dust ISO MTD according to ISO 16889)	Applicable in ARGO-HYTOS filter units
Y7.1220-05	350 ml	8E-A $\beta_{8(c)} \geq 200$	64 g	FA 016, FNA 008, FNA 016, FAPC 016 (with filter element size V7.1220)

ARGO HYTOS

Filter Elements

EXAPOR®SPARK PROTECT

For protection against electrostatic discharges

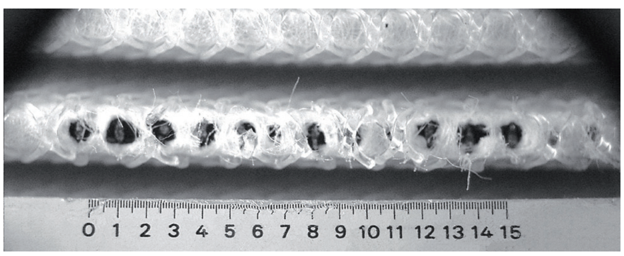
The new EXAPOR®SPARK PROTECT filter elements combine the well-known high performance characteristics with 100 % protection against electrostatic discharges.

When using modern hydraulic oils as e.g. biologically degradable oils, it should be taken into account that these oils are zinc and ash-free in most cases, so that they possess hardly any or just a low electrostatic conductivity, often a lot lower than 500 pS/m.

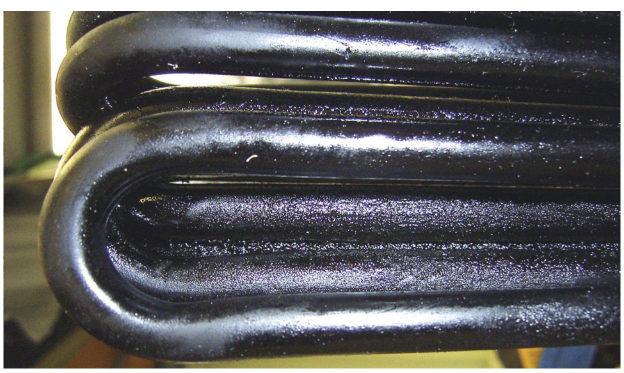
This can lead to a charge separation within the hydraulic system caused by friction, which allows an electrostatic charge in the filter element to increase to such dimensions that flashes of several thousand volts might appear.

Consequences of electrostatic discharges

- Sudden discharges which may destruct the filter material layers and also the electric components
- High temperatures, caused by flashes, lead to increased oil aging, thus to a deterioration of the oil characteristics and to reduced oil lifetime
- Earlier contamination of filter elements due to oil aging products
- Higher wear and hydraulic components failures



Damages at the filter material caused by electrostatic discharges



Oil aging products at tube bundels of an oil cooler

The new element technology

The filter elements with the designation EXAPOR®SPARK PROTECT have especially been developped for non-conductive or low-conductive hydraulic fluids and provide a controlled charge balance in the filter material, so that the oil within the filter element is not exposed to an additional electrostatic charge.

Regarding the construction no further measures are needed, merely the exchange of the standard filter element by the EXAPOR®SPARK PROTECT element.

Availability and performance

The new technology is available for all filter elements of ARGO-HYTOS and does not have an influence on the performance data of the filter elements that are characterized by:

- High dirt holding capacity
- Excellent filter fineness
- Low pressure loss
- High flow fatigue restistance
- Very good media resistance

Additional aspects:

- 100 % protection against electrostatic discharges in the filter and prevention of all related disadvantages.

Customer benefits:

- No destruction of the filter material layers by electrostatic discharges
- No premature oil aging due to electrostatic discharges
- Protection of electronic components against destruction or failures
- Optimum utilization of the filter life and hydraulic fluids
- No rebuilding or additional measures at already installed filters
- Higher operational safety

ARGO-HYTOS recommends:

In case the electrostatic conductivity of the used hydraulic fluid should be

- higher than 500 pS/m at 20 °C, e.g. the proven EXAPOR®MAX 2 filter elements
- lower than 500 pS/m at 20 °C, the new EXAPOR®SPARK PROTECT filter elements