



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

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 $v \leq 200 \text{ mm}^2/\text{s}$ (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®MAX2 - 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.

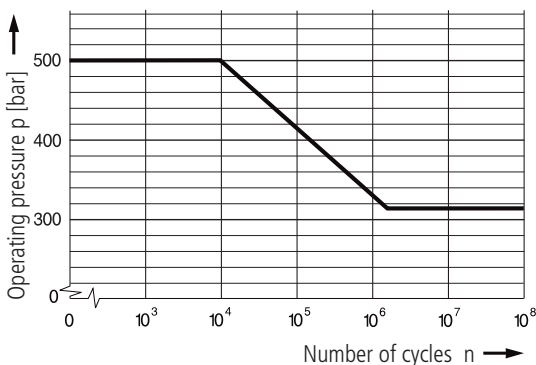
Characteristics

Operating pressure

0 ... 315 bar, min. 2×10^6 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 $v \leq 200 \text{ mm}^2/\text{s}$
- 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:
 - up to 250 bar $\leq 8 \text{ m/s}$
 - > 250 bar $\leq 12 \text{ m/s}$

Filter fineness

$5 \mu\text{m(c)} \dots 30 \mu\text{m(c)}$
 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: $v < 60 \text{ mm}^2/\text{s}$
- as starting viscosity: $v_{\text{max}} = 1.200 \text{ mm}^2/\text{s}$
- 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

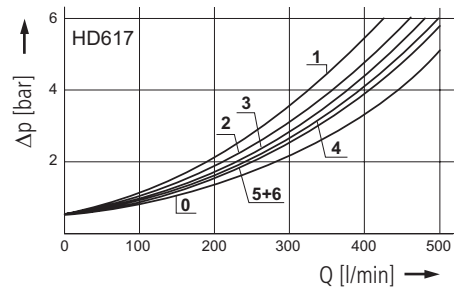
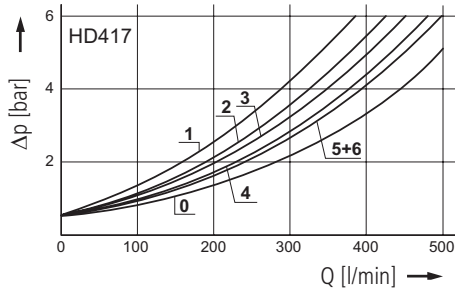
Connection

SAE-flange (6000 psi). Sizes see Selection Chart, column 6

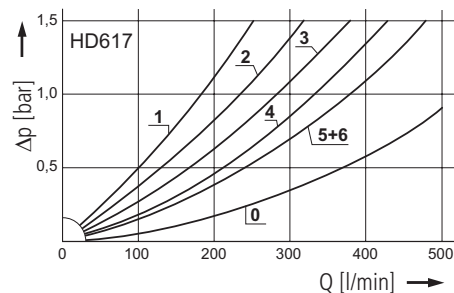
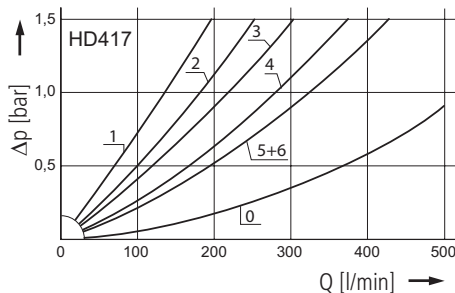
Diagrams

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

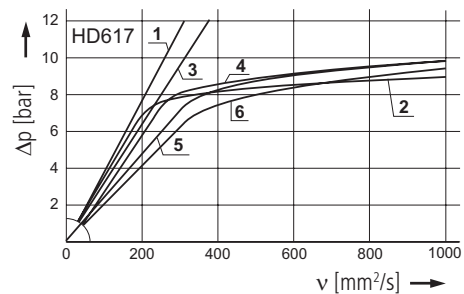
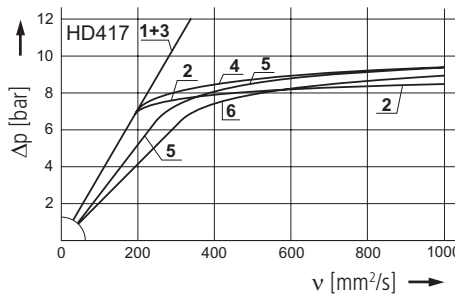
D1 Pressure drop as a function of the **flow volume** at $v = 35 \text{ mm}^2/\text{s}$, measurement **with** reverse flow valves, (0 = casing empty)



D2 Pressure drop as a function of the **flow volume** at $v = 35 \text{ mm}^2/\text{s}$, measurement **without** reverse flow valves, (0 = casing empty)

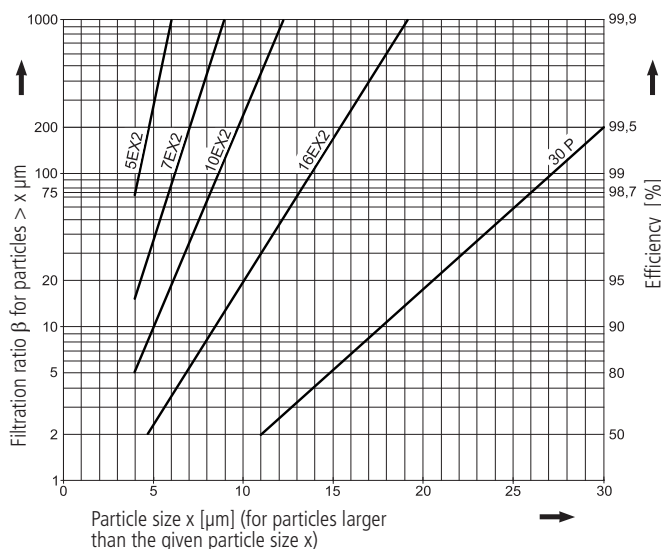


D3 Pressure drop as a function of the **kinematic viscosity** at nominal flow, measurement **without** reverse flow valves



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[®]MAX 2- 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 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	Filter fineness see diagram Dx	Dirt-holding capacity	Connection A/B	Cracking pressure of by-pass	Symbol	Replacement filter element Part No.	Weight	Clogging indicator	Remarks
1	l/min	3	4	g	bar	8	9	10	11	12	
HD 417-149	150	D1,2,3/1	5EX2	29	SAE1¼	-	3	V3.0823-13 ¹	20,3	optional	²
HD 417-179	220	D1,2,3/2	5EX2	33	SAE1¼	7	1	V3.0823-03	19,7	optional	-
HD 417-146	260	D1,2,3/3	10EX2	33	SAE1¼	-	3	V3.0823-16 ¹	20,3	optional	²
HD 417-176	320	D1,2,3/4	10EX2	47	SAE1¼	7	1	V3.0823-06	19,7	optional	-
HD 417-168	350	D1,2,3/5	16EX2	48	SAE1¼	7	1	V3.0823-08	19,7	optional	-
HD 417-161	350	D1,2,3/6	30P	26	SAE1¼	7	1	P3.0823-01 ³	19,7	optional	-
HD 617-149	220	D1,2,3/1	5EX2	41	SAE1½	-	3	V3.0833-13 ¹	23,1	optional	²
HD 617-179	280	D1,2,3/2	5EX2	49	SAE1½	7	1	V3.0833-03	22,4	optional	-
HD 617-146	320	D1,2,3/3	10EX2	49	SAE1½	-	3	V3.0833-16 ¹	23,1	optional	²
HD 617-176	380	D1,2,3/4	10EX2	67	SAE1½	7	1	V3.0833-06	22,4	optional	-
HD 617-178	420	D1,2,3/5	16EX2	68	SAE1½	7	1	V3.0833-08	22,4	optional	-
HD 617-161	420	D1,2,3/6	30P	34	SAE1½	7	1	P3.0833-01 ³	22,4	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 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.

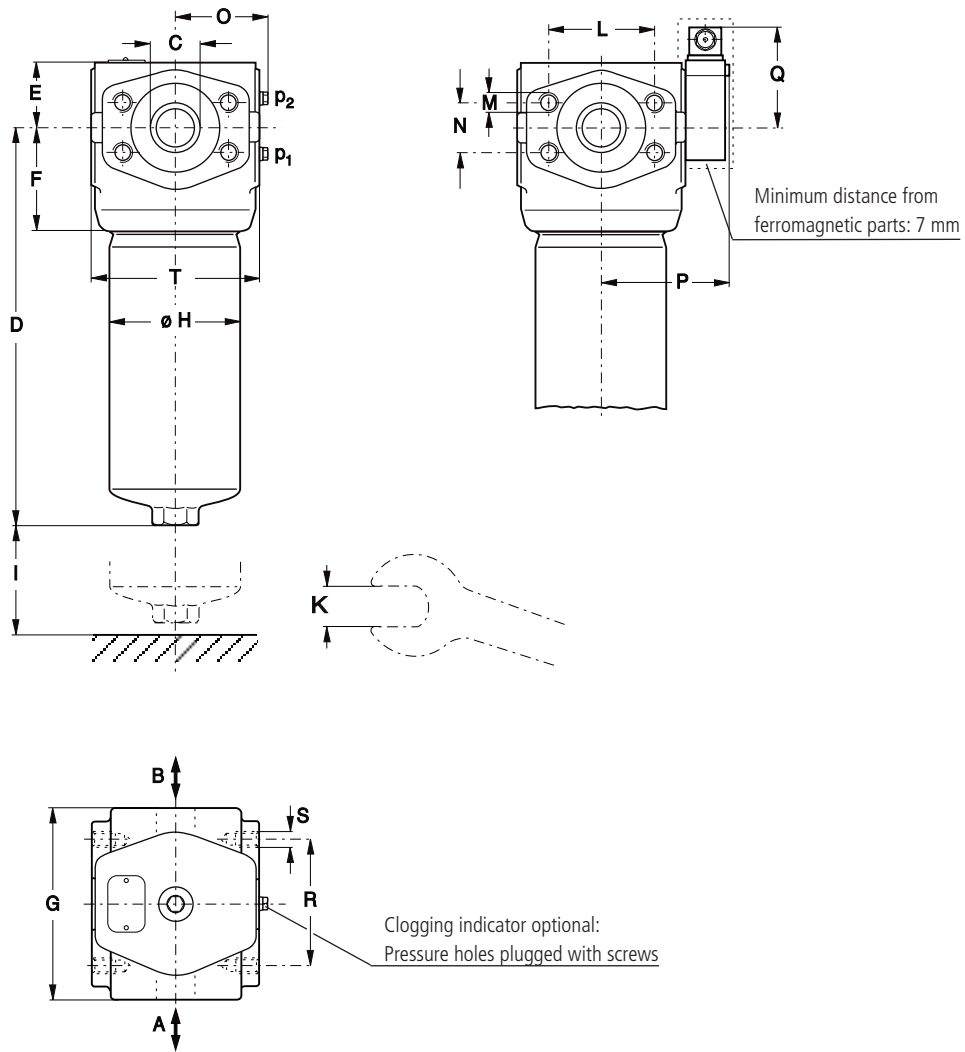
Remarks:

- 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.

¹ Element differential pressure up to 160 bar
² Clogging indicator is obligatory
³ Paper media supported with metal gauze

Dimensions

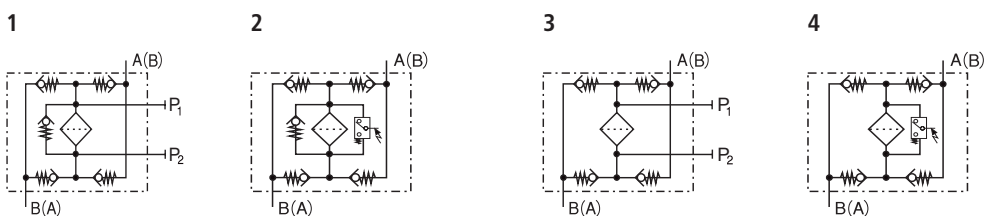
Version with electrical clogging indicator DG 041



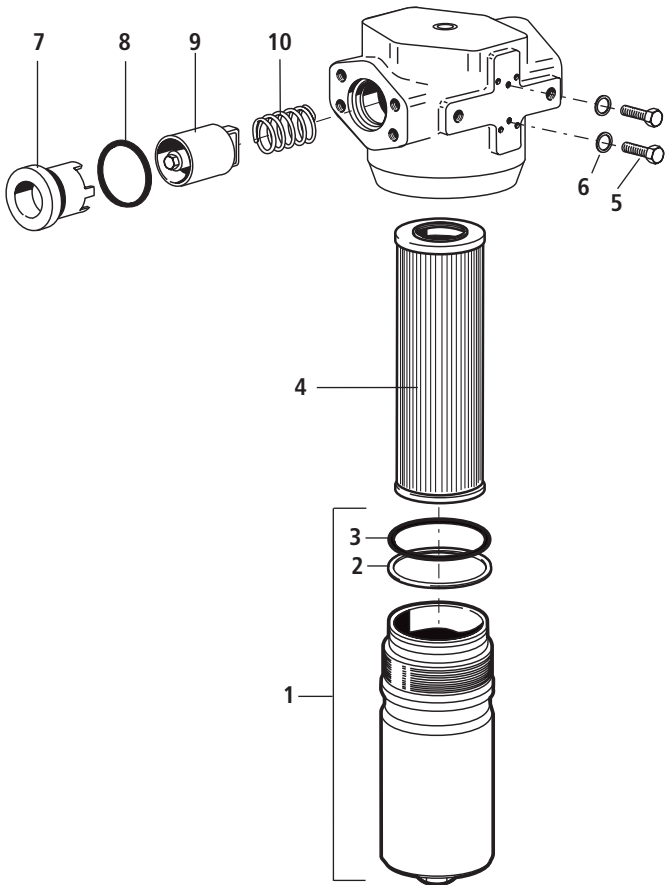
Measurements

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	SAE1¼	31,5	328	58	87,5	156	108	80	32	66,7	M 14/22	31,8	73	102	87	100	M 12/18	138
HD 617	SAE1½	31,5	428	58	87,5	156	108	80	32	79,4	M 16/24	36,5	73	102	87	100	M 12/18	138

Symbols



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.

Our engineers will be glad to advice you in questions concerning filter application, selection as well as the cleanliness class of the filtered medium attainable under practical operating conditions.

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



We produce fluid power solutions

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