

Port	Service Indicator	Drain	Element	Bowl	Thread Form
6...3/4"	00..Without	A...Automatic	1...5µm	D...1 litre (1 quart U.S.) metal with sight glass	A...PTF
8...1"	01..With mechanical indicator	M...Manual, 1/4 turn	2...25µm	M...1 litre (1 quart U.S.) metal without sight glass	B...ISO Rc taper
A...1-1/4"	04..With electrical service indicator		3...40µm		G...ISO G parallel
B...1-1/2"			4...75µm		

* See Norgren publication IM-900.920 for specifications and electrical wire connections of the optional electric service indicator.

TECHNICAL DATA

Fluid: Compressed air
 Maximum pressure: 17 bar (250 psig)
 Operating temperature: * -34° to +80°C (-30° to +175°F)
 * Air supply must be dry enough to avoid ice formation at temperatures below +2°C (+35°F)
 Particle removal: 5 µm, 25 µm, 40 µm, or 75 µm filter element
 Air quality: Within ISO 8573-1, Class 3 and Class 5 (particulates)
 Typical flow with a 40 µm element at 6.3 bar (90 psig) inlet pressure and 0.5 bar (7 psid) pressure drop:
 1" ports: 236 dm³/s (500 scfm)
 Nominal bowl size: 1 litre (1 quart US)
 Drain connection: 1/8" pipe thread
 Automatic drain operating conditions:
 Minimum pressure: 0.7 bar (10 psig).
 Drain opens when bowl pressure drops below 0.2 bar (3 psig).
 Minimum air flow required to close drain: 1 dm³/s (2 scfm)

Materials:

Body: Aluminum
 Bowl: Aluminum
 Bowl sight glass: Pyrex
 Elastomers: Neoprene and nitrile
 Filter element:
 5 µm: Sintered bronze
 25 µm: Sintered bronze
 40 µm: Sintered bronze
 75 µm: Stainless steel screen

REPLACEMENT ITEMS

Service kit (includes items circled on exploded view) ...5778-05	
Liquid level lens kit (20, 22 thru 26)	2273-22
Filter element, 5µm (30)	5311-01
Filter element, 25µm (30)	5311-02
Filter element, 40µm (30)	5311-03
Filter element, screen, 75µm (30)	5656-01
Manual drain (14, 15, 16)	619-50
Automatic drain (17, 18, 19)	3000-10
Mechanical service Indicator (1)	5797-50
Electrical service Indicator (6)	4020-51R

INSTALLATION

- Shut-off air pressure. Install filter in air line -
 - vertically (bowl down),
 - with air flow in direction of arrow on body,
 - upstream of regulators, lubricators, and cycling valves,
 - as close as possible to the air supply when used as a main line filter,
 - as close as possible to the device being serviced when used as a final filter.
- Connect piping to proper ports using pipe thread sealant on male threads only. Do not allow sealant to enter interior of unit.
- Turn bowl (27) into body until arrowhead on bowl is aligned with or to the right of the arrowhead on the body
- Flexible tube with 3mm (0.125") minimum I.D. can be connected to the automatic drain. Avoid restrictions in the tube.

SERVICING

- Open manual drain to expel accumulated liquids. Keep liquids below baffle (28).
- Clean or replace filter element when dirty, when optional mechanical service indicator shows approximately all red, or when optional electrical service indicator provides an electrical output.

DISASSEMBLY

- Filter can be disassembled without removal from air line.
- Shut off inlet pressure. Reduce pressure in inlet and outlet lines to zero.
- Disassemble in general accordance with the item numbers on exploded view. Do not remove the drains or the service indicators (1, 6) unless replacement is necessary. Remove and replace only if they malfunction.

CLEANING

- Clean mechanical indicator lens (3) with warm water only. Clean electrical indicator (6) with dry, clean cloth. Clean other parts with warm water and soap.
- Rinse and dry parts. Blow out internal passages in body (34) with clean, dry compressed air. Blow air through filter element (30) from inside to outside to remove surface contaminants.
- Inspect parts. Replace those found to be damaged.

ASSEMBLY

- Lubricate o-rings with o-ring grease.
- If the 1/4 turn manual drain (14, 15, 16) was removed, lubricate the portion of the drain body (14) that contacts the bowl, and the hole in the manual drain body that accommodates the stem of drain valve (15) with o-ring grease. Press body (14,) thru hole from inside of bowl. Place retainer o-ring (16) over body (14) and position in groove. Press drain valve (15) thru hole in body (14).
- Assemble the liquid indicator parts (20, 21, 22, 23, 24, 25) to bowl. Apply a 0.9 to 1.8 kg (2 to 4 pound) clamping force to upper and lower brackets (21) to pull brackets together. Tighten screws (20) to 0.9 to 1.1 N-m (8 to 10 inch-pounds).
- Assemble filter as shown on the exploded view. Arrows on indicator (3, 8) and body (34) must point in same direction. Press body (33) on louver (32), then press in place into body. Screw baffle (28) onto centerpost until contact is made with filter element (30).
- Torque Table

Torque Table	Torque in N-m (Inch-Pounds)
2, 7 (Screw)	2.8 to 3.9 (25 to 35)
18 (Nut), 28 (baffle)	2.3 to 2.8 (20 to 25)
- Turn bowl (27) into body until arrowhead on bowl is aligned with or to the right of the arrowhead on the body.

CAUTION

Water vapor will pass through these units and could condense into liquid form downstream as air temperature drops. Install an air dryer if water condensation could have a detrimental effect on the application.

WARNING

These products are intended for use in industrial compressed air systems only. Do not use these products where pressures and temperatures can exceed those listed under **Technical Data**. Before using these products with fluids other than air, for nonindustrial applications, or for life-support systems consult Norgren.

