

In line high pressure filters HF 745 / HF 748 series



IKRON
Fluid Filtration

Descr.	HF745-20.203-AS-FG010
Filter	HHP52473
Element	HHC02018
Serial	00290 06/2008
	MADE IN ITALY

THE IMPORTANCE OF AN EFFICIENT FILTRATION

The main cause of anomalies in hydraulic systems has to be attributed to the presence of contaminants in the fluid. The nature of the contaminant may be: gaseous, namely air mixed with the fluid; fluid, it depends on water penetrating the fluid; solid, therefore particles of various origins and dimensions.

Customers who operate equipments are always focused on obtaining the best possible performance, lower energy consumptions and greater respect for the environment.

These characteristics can be attained by using top quality components in the hydraulic system for generating and regulating the fluid power, which are also more sensitive to the presence of contaminants in the fluid.

Starting from these requirements, we understand how important and fundamental it is to prevent the presence of air and water from mixing in the fluid tank by using dedicated solutions.

It is also crucial to limit the presence of solid particles in the hydraulic circuit through a suitable filtering system, which is indispensable to maintain the project requirements of the system over time and to keep running costs low.

The correct choice of a filter and its optimum position in the hydraulic system requires the same care and experience needed to choose all the other components.

The use of filters with larger filtering surfaces reduces, at equal flow rates, the superficial contaminant load and therefore the filter's life is extended proportionally.

To maintain the maximum efficiency of the system, the filters must have a clogging indicator showing the differential pressure on the filtering cartridge and to immediately point out when the cartridge needs replacing in order to prevent the by-pass valve from opening.

The following factors should be analysed when choosing the ideal filter:

- The filtration degree required to protect the most sensitive component from contamination
- The points of the circuit in which the filters have to be installed
- The working pressure of the system
- The maximum flow rate and the type of fluid to be filtered
- The duty cycle
- The retention efficiency of the filtering cartridge
- The contaminant accumulation capacity of the filtering cartridge
- The working ambient temperature

Each filter used generates a pressure drop that increases continuously as time goes by. This pressure drop represents an efficiency index of the filter itself.

When the hydraulic system is about to be assembled, all the components must be perfectly clean and the fluid has to be added through a device complete with a filter.

During the test phase, it is advisable to run some work cycles at low pressure in order to create the best possible conditions for all the components.

TECHNICAL CHARACTERISTICS

The filters of the HF745 / HF748 series are connected to the pressure line of the circuit and protect the system's components against contaminant particles.

The standard filters are supplied with by-pass valve calibrated at 87 psi (6 bar).

For applications which need maximum protection of the system, such as servo drives or proportional controls, the filters are equipped with highly resistant filtering elements (versions "HC") and do not have a by-pass valve.

- Flow up to 58 US gpm (220 l/min)
- Maximum working pressure 4496 psi (310 bar)
- High efficiency multilayer system
- Low pressure drop

MATERIALS

Head	Spheroidal cast iron GS 450-10 UNI ISO 1083
Bowl	Steel
Seals	Buna - Viton
End cap	Zinc plated steel
Inner tube	Zinc plated steel
Filter media	Inorganic micro-fibre glass

FLUID COMPATIBILITY

Conforming to ISO 2943 (Norm ISO 6743/4)

Oil mineral (1)	HH - HL - HM - HR - HV - HG
Water emulsion (1)	HFAE - HFAS
Water glycol (1)	HFC
Syntetic fluid (2)	HS - HFDR - HFDU - HFDS
(1) With Buna seals	
(2) With Viton seals	

FLOW

Flow max.	45 US gpm (170 l/min)
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PRESSURE

Working pressure	4496 psi (310 bar)
Testing pressure	6744 psi (465 bar)
Burst pressure	8992 psi (620 bar)
Element collapse pressure	290 psi (20 bar) (version LC)
rating (conforming to ISO 2941)	3045 psi (210 bar) (version HC)

BY-PASS VALVE

By-pass setting	87 psi (6 bar)
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OPERATING TEMPERATURE

With Buna seals	-22 ÷ 195 °F (-30 ÷ 90 °C)
With Viton seals	-4 ÷ 230 °F (-20 ÷ 110 °C)

ENDURANCE STRENGTH

1.000.000 cycle
0 ÷ 4496 psi (0 ÷ 310 bar)

DEGREE OF FILTRATION

Multi-pass test conforming to ISO 16889 (regulation in force)
Contaminant ISO MTD - final Δp 87 psi (6 bar)

Code	Degree of filtration	Ratio $\beta_{x(c)}$	Percentage of efficiency
FG003	5 μm	$\beta_{5(c)} \geq 200$	99,5 %
FG006	7 μm	$\beta_{7(c)} \geq 200$	99,5 %
FG010	10 μm	$\beta_{10(c)} \geq 200$	99,5 %
FG025	21 μm	$\beta_{21(c)} \geq 200$	99,5 %

Multi-pass test conforming to ISO 4572 (previous regulation)
Contaminant ACFTD - final Δp 87 psi (6 bar)

Code	Degree of filtration	Ratio β_x	Percentage of efficiency
FG003	3 μm	$\beta_3 \geq 200$	99,5 %
FG006	6 μm	$\beta_6 \geq 200$	99,5 %
FG010	10 μm	$\beta_{10} \geq 200$	99,5 %
FG025	25 μm	$\beta_{25} \geq 200$	99,5 %

INDICATORS (3)

Visual differential indicator
Visual electrical differential indicator
Visual electrical differential indicator with thermostat

(3) Characteristics and dimensions pag. 14

SIZING – PRESSURE DROP

The total pressure drop of the filter is calculated by summing the pressure drop value in the housing to the one in the filtering element.

$$\text{Total } \Delta p = \Delta p \text{ in housing} + \Delta p \text{ in element}$$

In filters of series HF 745 in normal working conditions, the total Δp must not be more than 11 psi (0,75 bar) whereas, for use in harsh conditions, it must be within 14.5 ÷ 22 psi (1 ÷ 1,5 bar).

To establish the values of pressure drop involved, the following pages provide some diagrams with curves referred to the use of mineral oils ISO VG46 with kinematic viscosity of 120 SSU (30 cSt) and density of 7.29 lb/gal (0,856 kg/dm³).

Calculation example

Filter HF745-20.106-AS-FG010-LC-B60-GD-B-DD-G

Flow rate= 12 US gpm (45 l/min)

Kinematic viscosity: 120 SSU (30 cSt)

Oil density : 7.29 lb/gal (0,856 kg/dm³)

Filtering degree: 10 µm

Data obtained from the diagrams:

Δp in housing = 2.00 psi (0,14 bar) (page 4)

Δp in element = 7.25 psi (0,50 bar) (page 5)

Total Δp = 2.00 + 7.25 = 9.25 psi (0,64 bar) (Δp is lower than maximum value admitted – therefore sizing is correct).

If oil with different kinematic viscosity and different density is used, the values obtained from the diagrams will be re-calculated considering the following indications:

1) The pressure drop of the housing is proportional with the oil density, therefore for oil with density different to 7.29 lb/gal (0,856 kg/dm³) the value of the Δp in the head-bowl will be:

$$\Delta p \text{ in housing} = \frac{\Delta p \text{ of diagram (psi)} \cdot \text{Oil density (lb/gal)}}{7.29 \text{ (lb/gal)}} \quad [\text{psi}]$$

Or

$$\Delta p \text{ in housing} = \frac{\Delta p \text{ of diagram (bar)} \cdot \text{Oil density (kg/dm}^3\text{)}}{0,856 \text{ (kg/dm}^3\text{)}} \quad [\text{bar}]$$

2) The pressure drop of the element is proportional with the oil density and kinematic viscosity, therefore for oil with density different to 7.29 lb/gal (0,856 kg/dm³) and kinematic viscosity different to 120 SSU (30 cSt) the value of Δp in the element will be:

$$\Delta p \text{ element} = \Delta p \text{ of diagram (psi)} \cdot \frac{\text{Oil density (lb/gal)}}{7.29 \text{ (lb/gal)}} \cdot \frac{\text{Oil viscosity (SSU)}}{120 \text{ (SSU)}} \quad [\text{psi}]$$

Or

$$\Delta p \text{ element} = \Delta p \text{ of diagram (bar)} \cdot \frac{\text{Oil density (kg/dm}^3\text{)}}{0,856 \text{ (kg/dm}^3\text{)}} \cdot \frac{\text{Oil viscosity (cSt)}}{30 \text{ (cSt)}} \quad [\text{bar}]$$

Now you sum the values of the pressure drop of the housing to the value of the pressure drop of the filtering element, always making sure the total Δp does not exceed the pressure limit of 11 psi (0,75 bar).

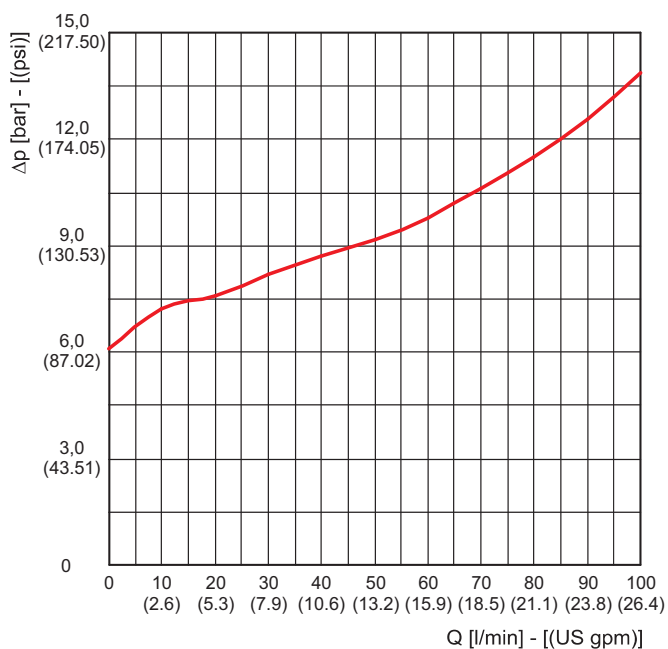
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PRESSURE DROP CURVES THROUGH THE BY-PASS VALVES

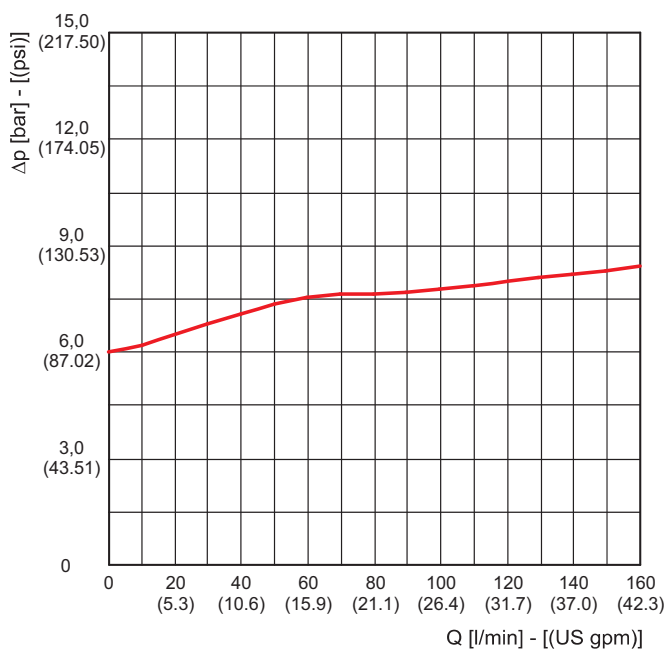
The pressure drop values are directly proportional with the specific weight of the fluid and do not affect the establishment of the total pressure drop of the complete filter.

The curves are obtained in the following conditions:
Mineral oil type ISO VG46
Kinematic viscosity 120 SSU (30 cSt)
Density 7.29 lb/gal (0,856 kg/dm³).

HF 745 / HF748-20



HF 745-30



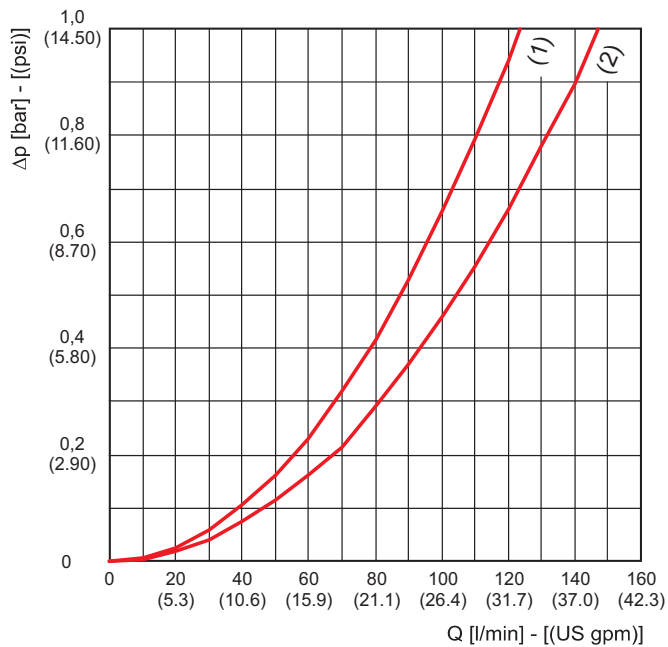
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PRESSURE DROP CURVES THROUGH THE HOUSING

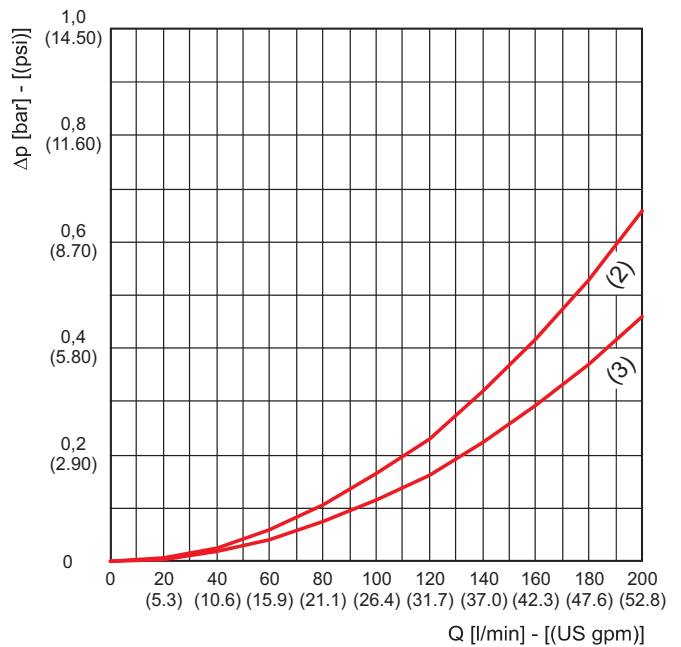
The curves are obtained in the following conditions:
 Mineral oil type ISO VG46
 Kinematic viscosity 120 SSU (30 cSt)
 Density 7.29 lb/gal (0,856 kg/dm³).

- (1) G 1/2
- (2) G 3/4
- (3) G 1

HF 745 / HF 748-20



HF 745-30



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PRESSURE DROP CURVES THROUGH THE ELEMENT HEK85-20

The curves are obtained in the following conditions:

Mineral oil type ISO VG46

Kinematic viscosity 120 SSU (30 cSt)

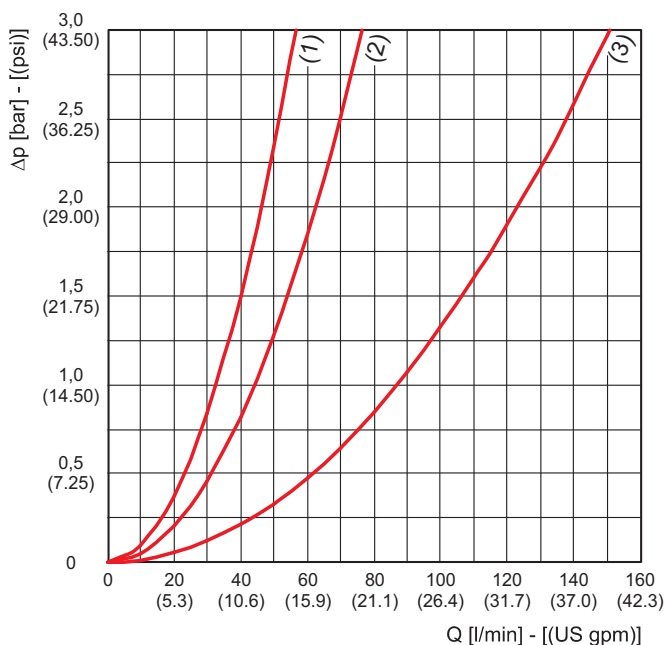
Density 7.29 lb/gal (0,856 kg/dm³).

(1) HEK85-20.080

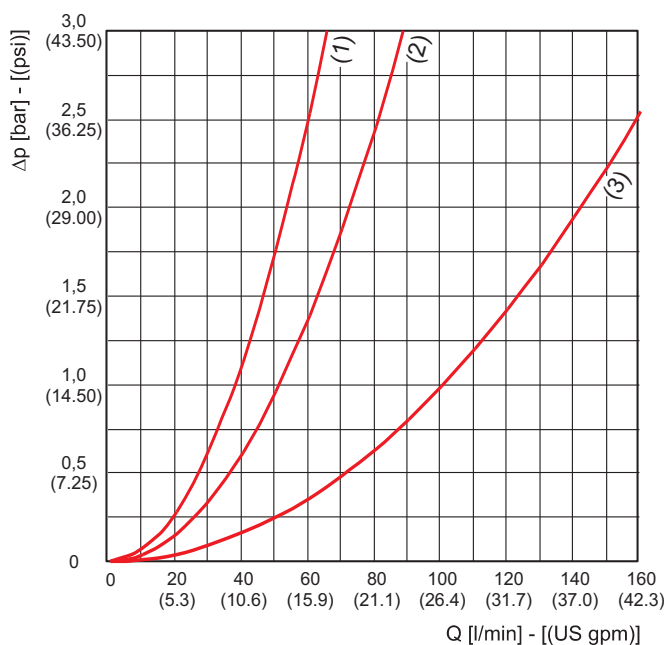
(2) HEK85-20.106

(3) HEK85-20.203

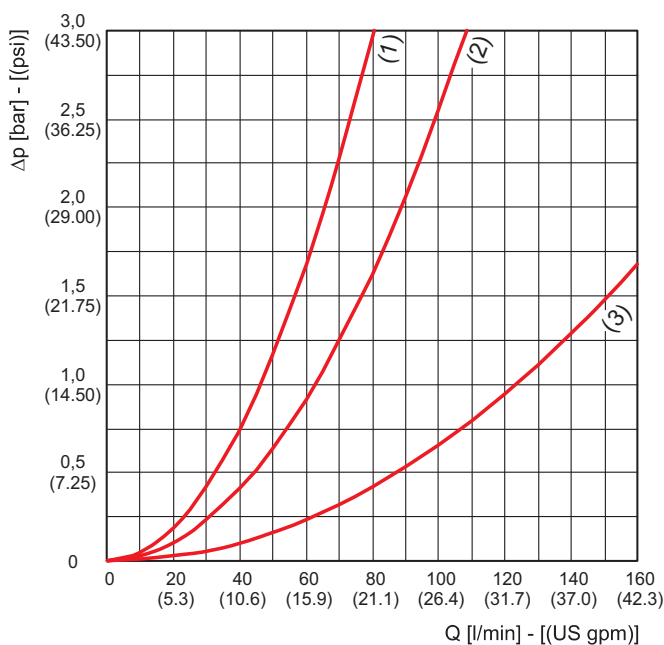
FG003



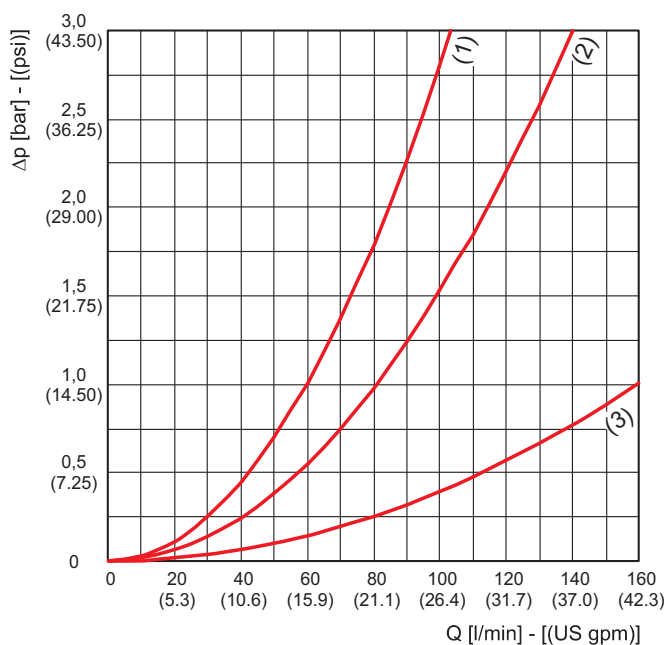
FG006



FG010



FG025



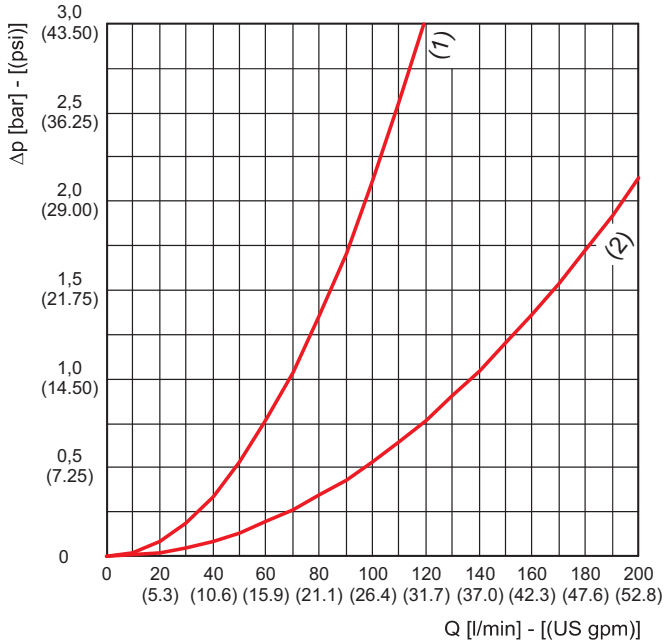
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PRESSURE DROP CURVES THROUGH THE ELEMENT HEK85-30

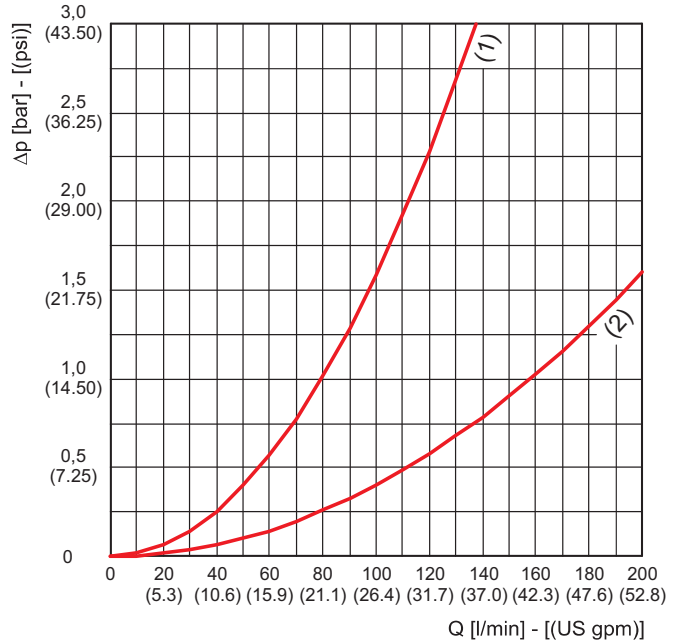
The curves are obtained in the following conditions:
 Mineral oil type ISO VG46
 Kinematic viscosity 120 SSU (30 cSt)
 Density 7.29 lb/gal (0,856 kg/dm³).

- (1) HEK85-30.115
- (2) HEK85-30.223

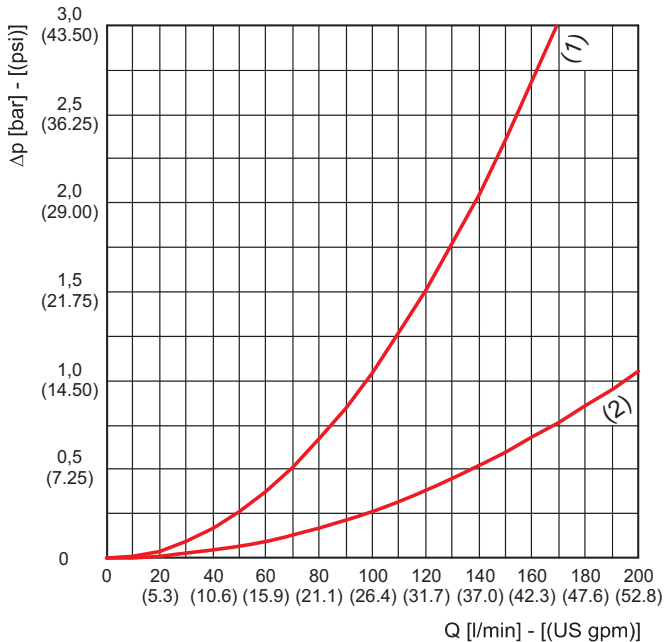
FG003



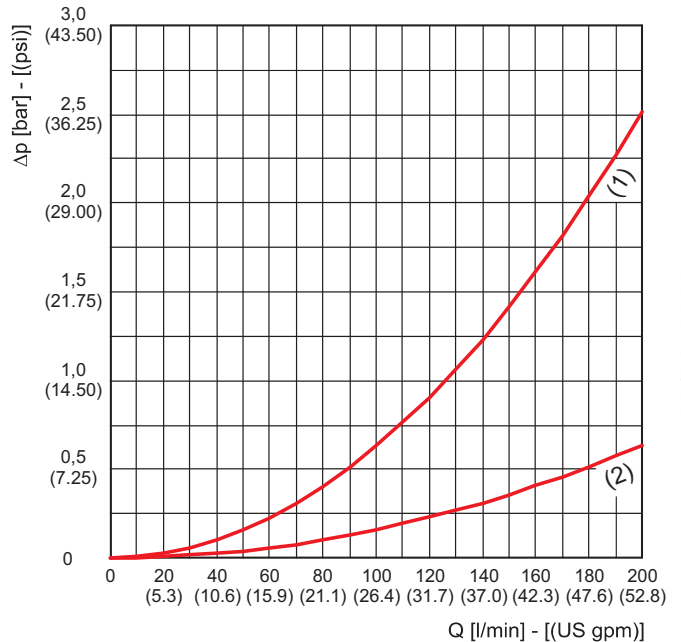
FG006



FG010



FG025



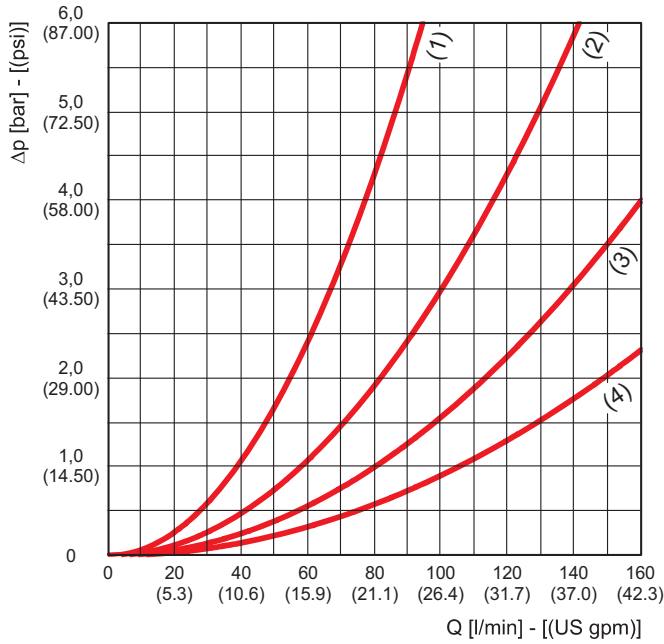
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PRESSURE DROP CURVES THROUGH THE ELEMENT HEK86-20

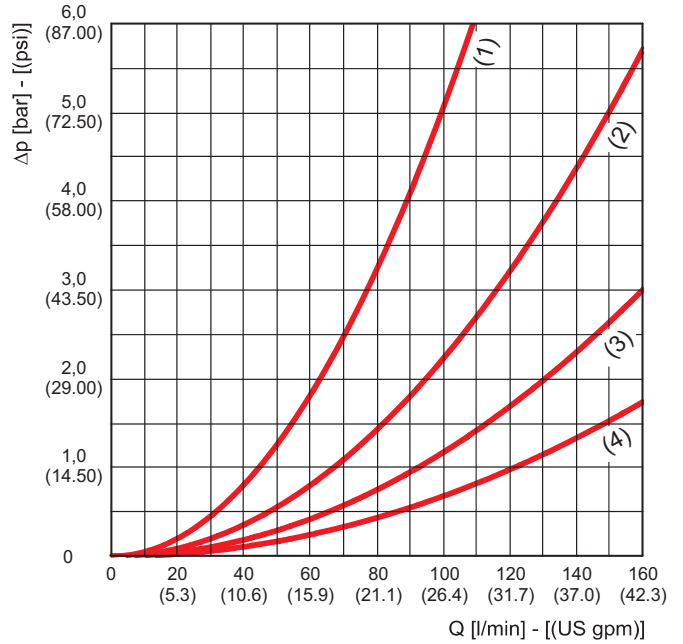
The curves are obtained in the following conditions:
 Mineral oil type ISO VG46
 Kinematic viscosity 120 SSU (30 cSt)
 Density 7.29 lb/gal (0,856 kg/dm³).

- (1) HEK86-20.074
- (2) HEK86-20.111
- (3) HEK86-20.153
- (4) HEK86-20.201

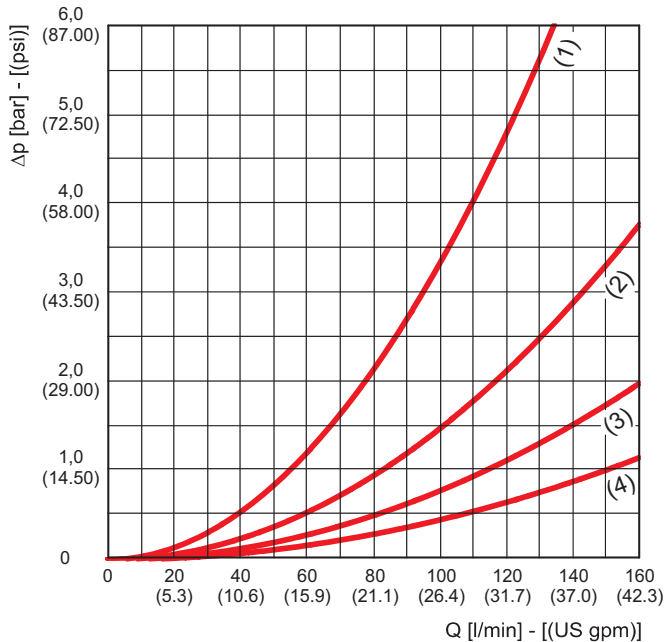
FG003



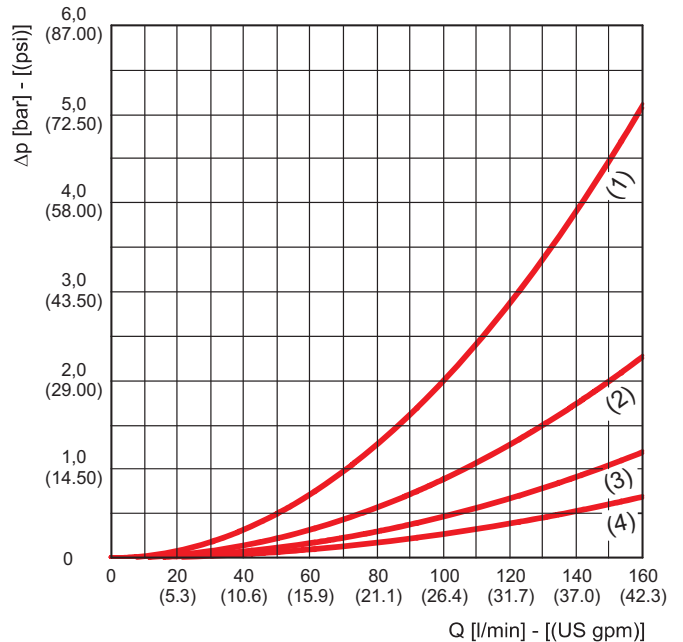
FG006



FG010



FG025



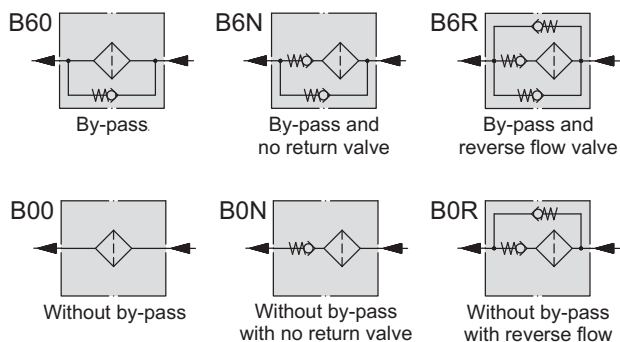
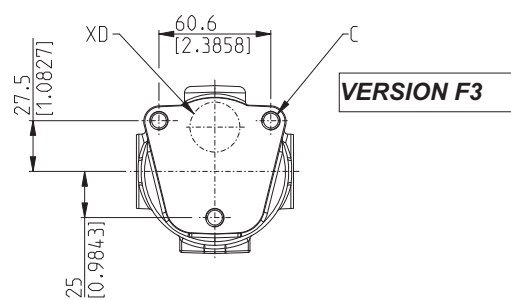
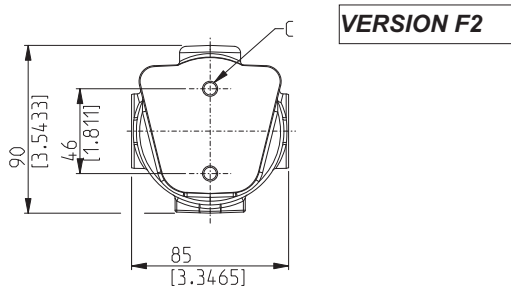
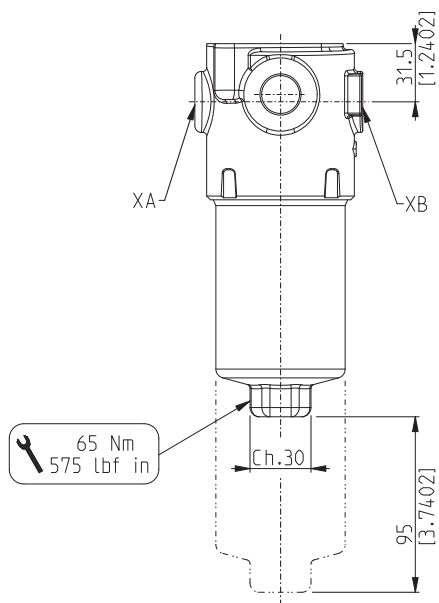
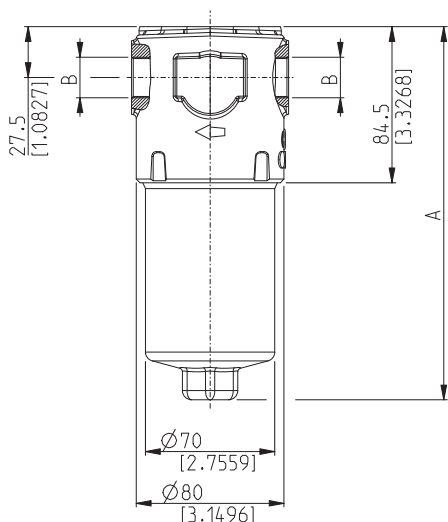
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FLOW

Filter type	Ports IN/OUT			Degree of filtration							
				Flow US gpm (l/min) Δp= 11 psi (0.75 bar)				Flow US gpm (l/min) Δp= 21.8 psi (1.5 bar)			
	GAS (BSPP)	NPT	SAE J514b	FG003	FG006	FG010	FG025	FG003	FG006	FG010	FG025
HF 745-20.080	G 1/2	1/2 NPT	3/4-16 UNF-2B	6.6 (25)	7.9 (30)	9.2 (35)	11.9 (45)	9.2 (35)	11.9 (45)	14.5 (55)	17.2 (65)
	G 3/4	3/4 NPT	1 1/16-12 UN-2B	6.6 (25)	7.9 (30)	9.2 (35)	11.9 (45)	10.6 (40)	11.9 (45)	14.5 (55)	17.2 (65)
HF 745-20.106	G 1/2	1/2 NPT	3/4-16 UNF-2B	9.2 (35)	10.6 (40)	13.2 (50)	15.9 (60)	13.2 (50)	14.5 (55)	18.5 (70)	22.5 (85)
	G 3/4	3/4 NPT	1 1/16-12 UN-2B	9.2 (35)	10.6 (40)	13.2 (50)	15.9 (60)	14.5 (55)	15.9 (60)	19.8 (75)	22.5 (85)
HF 745-20.203	G 1/2	1/2 NPT	3/4-16 UNF-2B	15.9 (60)	17.2 (65)	19.8 (75)	22.5 (85)	22.5 (85)	25.1 (95)	29.1 (110)	31.7 (120)
	G 3/4	3/4 NPT	1 1/16-12 UN-2B	17.2 (65)	18.5 (70)	21.1 (80)	25.1 (95)	25.1 (95)	27.7 (105)	30.4 (115)	34.3 (130)
HF 745-30.115	G 3/4	3/4 NPT	1 1/16-12 UN-2B	15.9 (60)	17.2 (65)	21.1 (80)	26.4 (100)	21.1 (80)	23.8 (90)	29.1 (110)	34.3 (130)
	G 1	1 NPT	1 5/16-12 UN-2B	15.9 (60)	18.5 (70)	22.5 (85)	27.7 (105)	21.1 (80)	23.8 (90)	29.1 (110)	37.0 (140)
HF 745-30.223	G 3/4	3/4 NPT	1 1/16-12 UN-2B	27.7 (105)	31.7 (120)	35.7 (135)	40.9 (155)	39.6 (150)	44.9 (170)	50.2 (190)	55.5 (210)
	G 1	1 NPT	1 5/16-12 UN-2B	29.1 (110)	33.0 (125)	38.3 (145)	44.9 (170)	39.6 (150)	44.9 (170)	52.8 (200)	58.1 (220)

Filter type	Ports IN/OUT			Degree of filtration							
				Flow US gpm (l/min) Δp= 11 psi (0.75 bar)				Flow US gpm (l/min) Δp= 21.8 psi (1.5 bar)			
	GAS (BSPP)	NPT	SAE J514b	FG003	FG006	FG010	FG025	FG003	FG006	FG010	FG025
HF 748-20.074	G 1/2	1/2 NPT	3/4-16 UNF-2B	9.2 (35)	10.6 (40)	11.9 (45)	14.5 (55)	10.6 (40)	13.2 (50)	15.9 (60)	19.8 (75)
	G 3/4	3/4 NPT	1 1/16-12 UN-2B	9.2 (35)	10.6 (40)	11.9 (45)	14.5 (55)	11.9 (45)	14.5 (55)	17.2 (65)	21.1 (80)
HF 748-20.111	G 1/2	1/2 NPT	3/4-16 UNF-2B	11.9 (45)	14.2 (55)	15.9 (60)	18.5 (70)	15.9 (60)	18.5 (70)	22.5 (85)	26.4 (100)
	G 3/4	3/4 NPT	1 1/16-12 UN-2B	11.9 (45)	14.2 (55)	17.2 (65)	19.8 (75)	17.2 (65)	19.8 (75)	23.8 (90)	27.7 (105)
HF 748-20.153	G 1/2	1/2 NPT	3/4-16 UNF-2B	15.9 (60)	17.2 (65)	19.8 (75)	22.5 (85)	21.1 (80)	23.8 (90)	27.7 (105)	31.7 (120)
	G 3/4	3/4 NPT	1 1/16-12 UN-2B	17.2 (65)	18.5 (70)	21.1 (80)	23.8 (90)	22.5 (85)	25.1 (95)	29.1 (110)	35.7 (135)
HF 748-20.201	G 1/2	1/2 NPT	3/4-16 UNF-2B	18.5 (70)	19.8 (75)	22.5 (85)	25.1 (95)	26.4 (100)	27.7 (105)	31.7 (120)	34.3 (130)
	G 3/4	3/4 NPT	1 1/16-12 UN-2B	19.8 (70)	22.5 (80)	25.1 (95)	27.7 (105)	27.7 (105)	30.4 (115)	34.3 (130)	38.3 (145)

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HF745-20 DIMENSIONS


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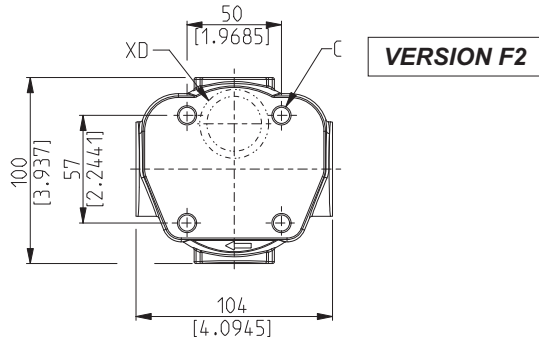
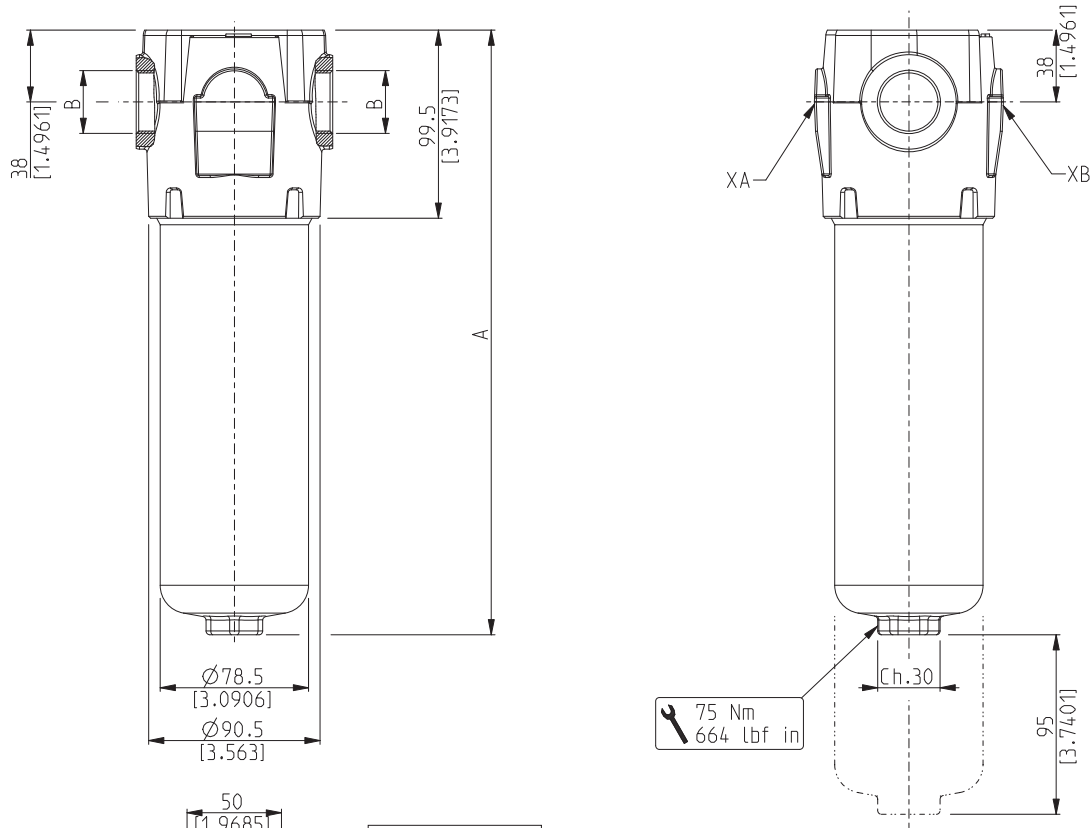
Filter type	Weight	A	B (Ports) (1)	C (2)
	kg (lbs)	mm (in)	Availability	
HF745-20.080	3,8 (8.38)	173 (6.8110)	GAS (BSPP)	M 8 (drilling F2)
HF745-20.106	4,2 (9.26)	199 (7.8346)	NPT	M10 (drilling F3)
HF745-20.203	5,7 (12.57)	299 (11.7716)	SAE J514b	

(1) Ports dimensions: see pages 15 ÷ 16

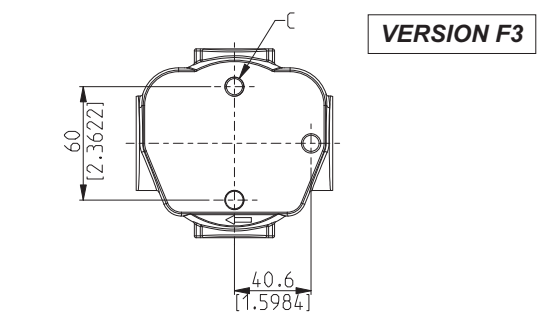
(2) Are available the respective threads 5/16-18 UNC-2B for drilling F2 and 3/8-16 UNC-2B for drilling F3.

On request, mounting holes can have special threads and different locations between center lines.

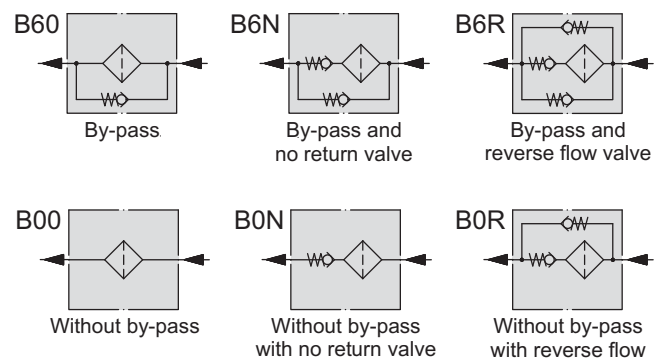
HF745-30 DIMENSIONS



VERSION F2



VERSION F3



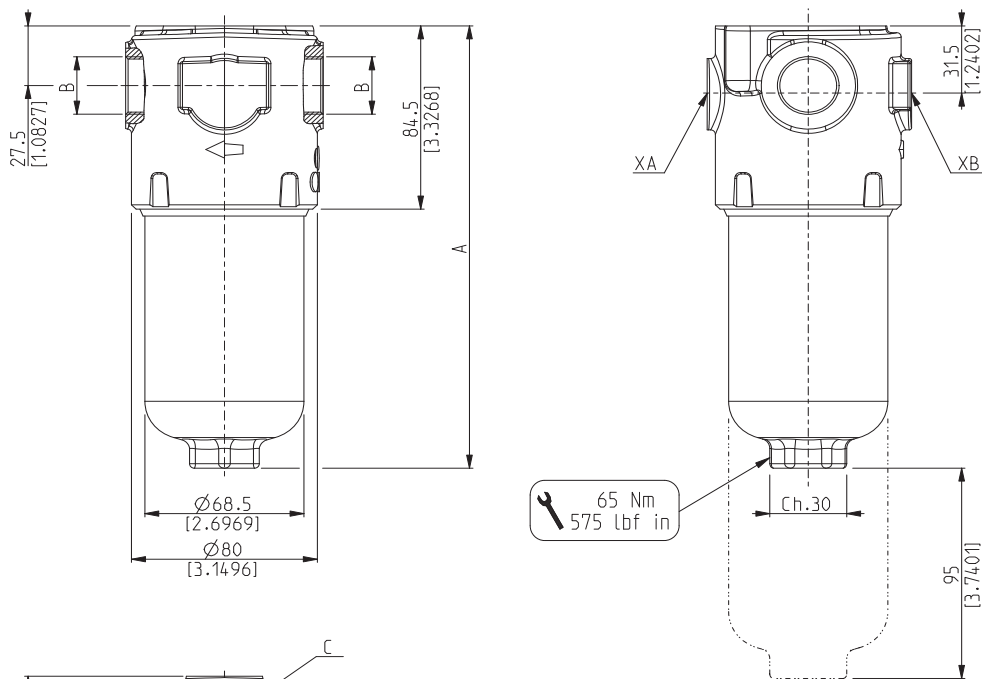
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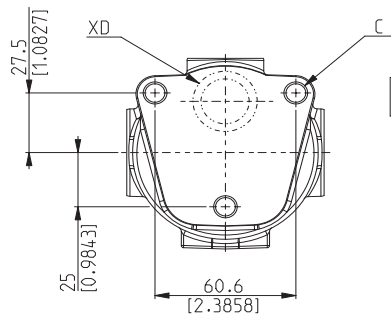
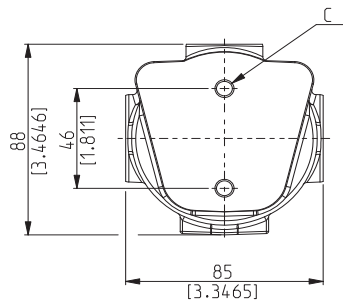
Filter type	Weight	A	B (ports) (1)	C (2)
	kg (lbs)	mm (in)	Availability	
HF745-30.115	6,0 (13.23)	213 (8.3858)	GAS (BSPP) NPT	M 10
HF745-30.223	7,8 (17.20)	320 (12.5984)	SAE J514b	

(1) Ports dimensions: see pages 15 ÷ 16
 (2) The respective threads 3/8-16 UNC-2B are available.
On request, mounting holes can have special threads and different locations between center lines.

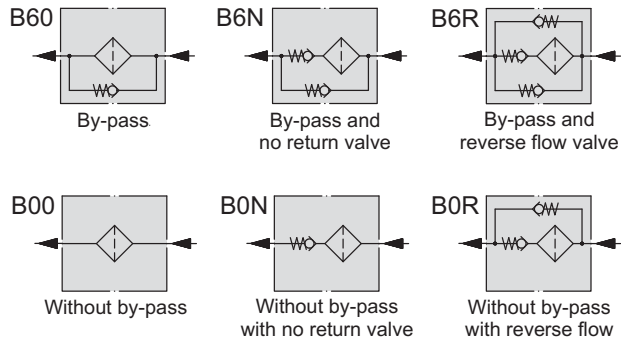
HF748-20 DIMENSIONS



VERSION F2



VERSION F3



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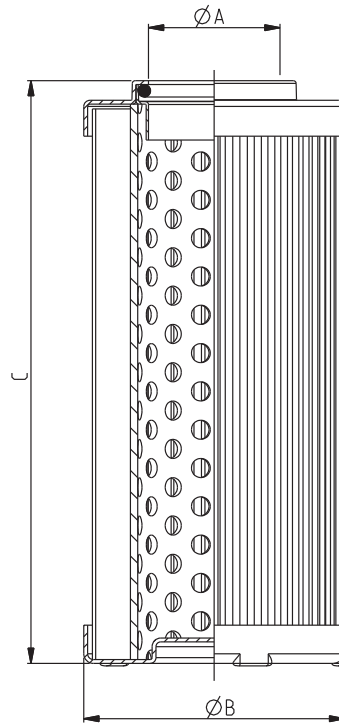
Filter type	Weight	A	B (Ports) (1)	C (2)
	kg (lbs)	mm (in)	Availability	
HF748-20.074	3,4 (7.49)	171 (6.7322)		
HF748-20.111	3,8 (8.38)	204 (8.0314)	GAS (BSPP)	M 8 (drilling F2)
HF748-20.153	4,2 (9.26)	250 (9.8424)	NPT	M10 (drilling F3)
HF748-20.201	4,8 (10.58)	301 (11.8503)	SAE J514b	

(1) Ports dimensions: see pages 15 ÷ 16

(2) Are available the respective threads 5/16-18 UNC-2B for drilling F2 and 3/8-16 UNC-2B for drilling F3.

On request, mounting holes can have special threads and different locations between center lines.

ELEMENTS DIMENSIONS FOR HF745



ICAT_011_004_HF760

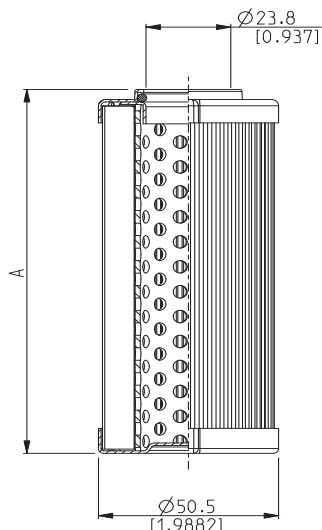
Filtering elements with Δp - collapse pressure of 3046 psi (210 bar) are also available (please consult our technical department).

Technical data for (MS) version elements are available on request.

Element type	Ø A	Ø B	C	Filtering surface (AS)	Dirt holding capacity (ISO MTD)			
					$\Delta p = 72.5 \text{ psi (5 bar)}$			
					FG003	FG006	FG010	FG025
mm (in)	mm (in)	mm (in)	cm ² (in ²)	gr (lbs)	gr (lbs)	gr (lbs)	gr (lbs)	
HEK85-20.080			87 (3.4252)	415 (64.3251)	2,3 (0.0051)	3,0 (0.0066)	3,3 (0.0073)	4,8 (0.0106)
HEK85-20.106	25,5 (1.0039)	46,5 (1.8307)	113 (4.4488)	560 (86.8002)	3,1 (0.0069)	4,0 (0.0089)	4,5 (0.0099)	6,5 (0.0143)
HEK85-20.203			210 (8.2677)	1103 (170.9653)	6,2 (0.0136)	7,9 (0.0175)	8,8 (0.0195)	12,8 (0.0282)
HEK85-30.115	27,5 (1.0827)	54,5 (2.1457)	122 (4.8031)	908 (140.7403)	5,1 (0.0112)	6,5 (0.0144)	7,3 (0.0160)	10,5 (0.0232)
HEK85-30.223			230 (9.0551)	1808 (280.2405)	10,1 (0.0223)	13,0 (0.0287)	14,5 (0.0319)	21,0 (0.0462)

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ELEMENTS DIMENSIONS FOR HF748



ICAT_018_004_HF745

Filtering elements with Δp - collapse pressure of 3046 psi (210 bar) are also available (please consult our technical department).

Technical data for (MS) version elements are available on request.

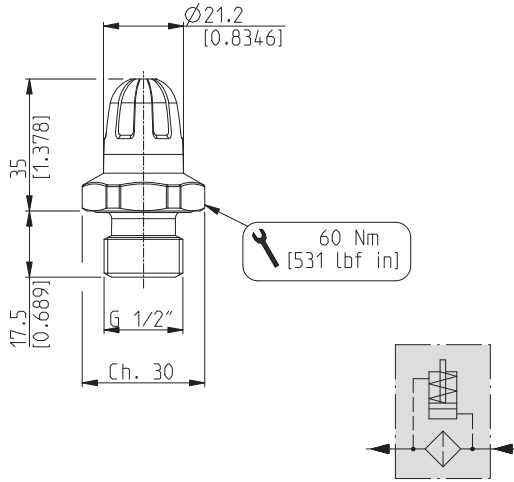
Element type	A	Filtering surface (AS)	Dirt holding capacity (ISO MTD)			
			$\Delta p = 72.5 \text{ psi (5 bar)}$			
			FG003	FG006	FG010	FG025
mm (in)	cm ² (in ²)	gr (lbs)	gr (lbs)	gr (lbs)	gr (lbs)	
HEK86-20.074	80 (3.1495)	493 (76.4151)	2,8 (0.0061)	3,5 (0.0077)	3,9 (0.0085)	5,7 (0.0125)
HEK86-20.111	117 (4.6062)	739 (114.5452)	4,1 (0.0090)	5,3 (0.0116)	5,9 (0.0130)	8,6 (0.0189)
HEK86-20.153	157 (6.1810)	1019 (157.9453)	5,7 (0.0125)	7,3 (0.0160)	8,1 (0.0178)	11,8 (0.0260)
HEK86-20.201	207 (8.1495)	1339 (207.5454)	7,5 (0.0165)	9,6 (0.0211)	10,7 (0.0235)	15,5 (0.0348)

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INDICATORS

VISUAL DIFFERENTIAL

Code: **H**

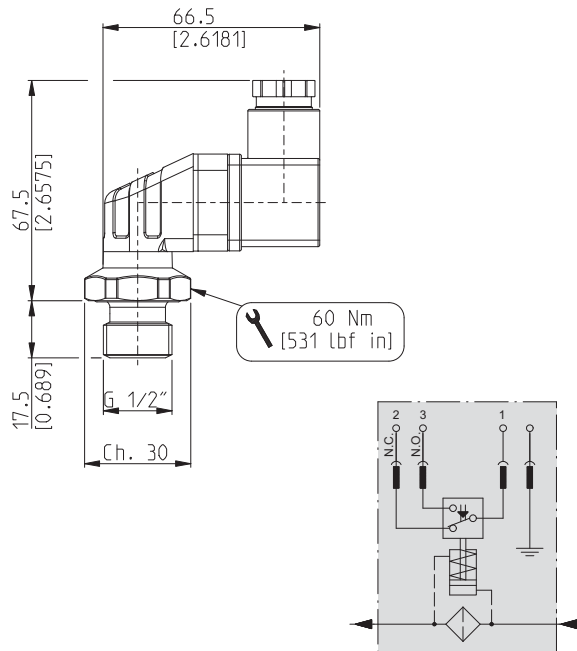


ICAT_011_006_HF760

Differential pressure setting	116 psi (8 bar) without by-pass
	72.5 psi (5 bar) with by-pass

VISUAL ELECTRICAL DIFFERENTIAL

Code: **U**

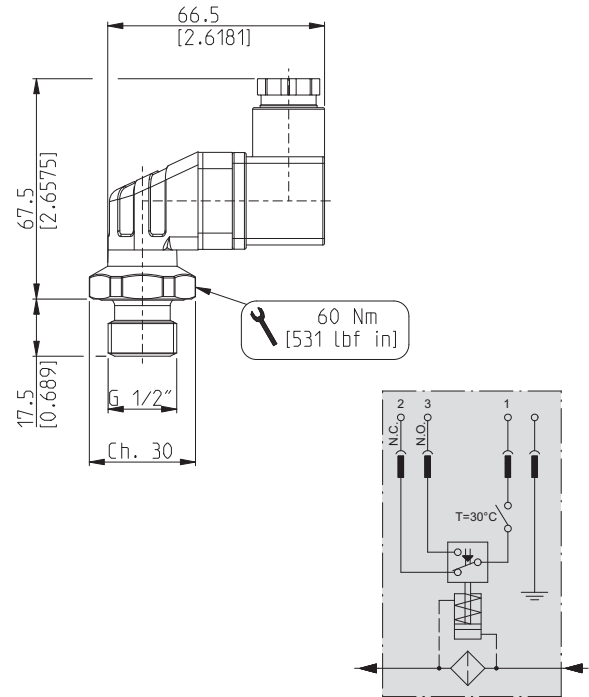


ICAT_011_007_HF760

Differential pressure setting	116 psi (8 bar) without by-pass
	72.5 psi (5 bar) with by-pass
Max. working voltage	250 VAC
	30 VCC
Max. working current	3 A (resistivity)
	3 A (inductive)
Protection class	IP 66 - Cable clamp PG 11

VISUAL ELECTRICAL DIFFERENTIAL WITH THERMOSTAT

Code: **W**



ICAT_011_011_HF760

Differential pressure setting	116 psi (8 bar) without by-pass
	72.5 psi (5 bar) with by-pass
Max. working voltage	250 VAC
	30 VCC
Max. working current	3 A (resistivity)
	3 A (inductive)
Protection class	IP 66 - Cable clamp PG 11
Min. function temperature	86 °F (30 °C)

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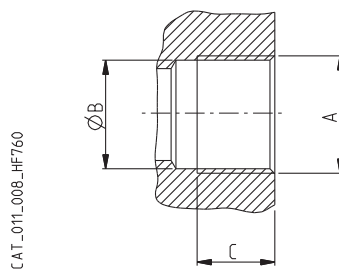
PORTS IN/OUT

Filter type	PORTS TYPE			
	Nominal size	Gas BSPP	NPT	SAE ODT
HF745-20	1/2"	GD	ND	OB
HF748-20	3/4"	GE	NE	OD
HF 745-30	3/4"	GE	NE	OD
	1"	GF	NF	OF


GAS STRAIGHT THREAD PORTS

BSPP

British standard pipe parallel (55°) conforms to UNI - ISO 228



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CODE	Nominal size	A	Ø B	C	 Nm (lbf in)
			mm (in)	mm (in)	
GD	1/2"	G 1/2	19,0 (0.7480)	16,0 (0.6299)	50 ^{+2,5} (443 ÷ 465)
GE	3/4"	G 3/4	24,5 (0.9646)	18,0 (0.7087)	90 ⁺⁵ (797 ÷ 841)
GF	1"	G 1	30,5 (1.2008)	22,0 (0.8661)	130 ⁺¹⁰ (1151 ÷ 1239)

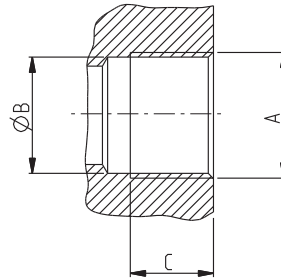
PORTS IN/OUT

NPT STRAIGHT THREAD PORTS

NPT

NPT thread (60°) conforms to ANSI - ASME B1-20

ICAT_011_008_HF760



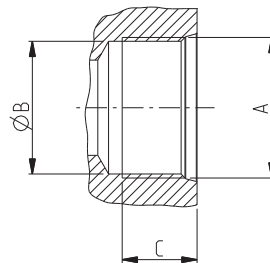
CODE	Nominal size	A	Ø B	C	Nm (lbf in)
			mm (in)	mm (in)	
ND	1/2"	1/2 NPT	18,0 (0.7087)	13,5 (0.5315)	45 ^{+2,5} (398 ÷ 420)
NE	3/4"	3/4 NPT	23,5 (0.9252)	14,0 (0.5512)	75 ⁺⁵ (664 ÷ 708)
NF	1"	1 NPT	29,5 (1.1614)	17,5 (0.6889)	120 ⁺¹⁰ (1062 ÷ 1151)

SAE STRAIGHT THREAD PORTS J514

ODT

American straight thread UNC-UNF 60° conforms to ANSI B 1.1

ICAT_011_009_HF760



CODE	Nominal size	A	Ø B	C	Nm (lbf in)
			mm (in)	mm (in)	
OB	1/2"	3/4" - 16 UNF - 2B	17,3 (0.6811)	15,0 (0.5906)	45 ^{+2,5} (398 ÷ 420)
OD	3/4"	1 1/16" - 12 UN - 2B	24,7 (0.9724)	20,0 (0.7874)	120 ⁺¹⁰ (1062 ÷ 1151)
OF	1"	1 5/16" - 12 UN - 2B	31,0 (1.2205)	20,0 (0.7874)	170 ⁺¹⁰ (1505 ÷ 1593)

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ASSEMBLY AND REPLACING ELEMENT INSTRUCTIONS

ASSEMBLY

Once you have checked the integrity of the filter inside its package, proceed as follows:

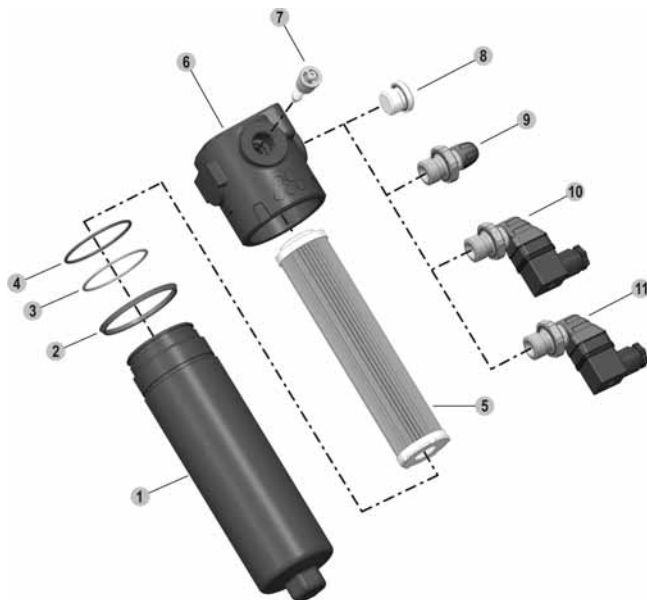
- A Secure the filter to the attachment device via the threaded holes in the head (pos.6).
- B Take the protection caps off the oil inlet and outlet.
- C Connect the circuit pipes to the filter, checking the flow direction, which is pointed out by the arrow on the head (pos.6).
- D If the clogging indicator (pos.9 - 10 - 11) is immediately mounted in the filter, take the protection cap off and screw the indicator in the dedicated seat, then tighten to a tightening torque of 531 lbf in (60 Nm). If the indicator is electric, complete the required connections.
- E Start the circuit for a few minutes.
- F Make sure there are no leaks.

REPLACING ELEMENT

Once the working hours limit indicated in the maintenance instructions of the system is reached, or when the clogging indicators point out the limit pressure drop created inside the filter, the cartridge must be replaced, remembering that this procedure involves the drainage of hydraulic oil and therefore you need to prepare suitable containers to collect the oil.

Proceed as follows:

- A Stop the system in "Machine stopped" status.
- B Secure any shut-off valves on the hydraulic circuit.
- C Unscrew the filter container (pos.1).
- D Remove the clogged filtering cartridge (pos.5), making sure no residual particles have settled on the bowl bottom (pos.1).
- E Make sure the seal (pos.2), the O-ring (pos.4) and the anti-extrusion ring (pos.3) are not damaged, otherwise replace them and consequently position the new ones correctly.
- F Insert the new filtering cartridge, lubricating the sealing O-ring beforehand.
- G Screw the container tight (pos.1) making sure the threading is screwed correctly. Tighten to a tightening torque as indicated on pages 9, 10 and 11.
- H Start the machine for a few minutes.
- I Make sure there are no leaks.



Pos.	Description
1	Filter bowl
2	External O-Ring
3	Anti-extrusion ring
4	Sealing O-Ring
5	Filtering element
6	Filter head
7	By-pass valve
8	Sealing cap
9	Visual differential indicator
10	Visual electrical differential indicator
11	Visual electrical differential indicator with thermostat

When ordering spare parts, always specify the reference number, the filter code and quantity.

Example: Spare part pos. 4 - HHP51430 - Qty 2

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HOW TO ORDER A COMPLETE FILTER

1

2

3

4

5

6

7

8

9

10

HF745 - 20.080 - AS - FG010 - LC - B60 - GD - B - XA - G - F2
 HF748

1	Filter type	CODE
	See table from pag. 9 to pag. 11	HF74..

2	Filtering surface	CODE
	Standard	AS
	Multilayer	MS

3	Degree of filtration	CODE
	3 [µm] Micro-fibre glass	FG003
	6 [µm] Micro-fibre glass	FG006
	10 [µm] Micro-fibre glass	FG010
	25 [µm] Micro-fibre glass	FG025

4	Δp collaps pressure	CODE
	290 [psi] (20 [bar])	LC
	3046 [psi] (210 [bar])	HC

5	Valves	CODE
	By-pass setting 87 [psi] (6 [bar])	B60
	By-pass setting 87 [psi] (6 [bar]) and no return valve	B6N
	By-pass setting 87 [psi] (6 [bar]) and reverse flow valve	B6R
	Without	B00
	Without by-pass, with no return valve	B0N
	Without by-pass, with reverse flow valve	B0R

6	Ports IN/OUT	CODE
	Threads GAS (BSPP)	
	G 1/2	GD
	G 3/4	GE
	G 1	GF
	Threads NPT	
	1/2	ND
	3/4	NE
	1	NF
	Threads SAE ODT	
	1/2	OB
	3/4	OD
	1	OF

7	Seals	CODE
	Buna	B
	Viton	V

8	Indicator ports	CODE
	Right side arranged	XA
	Left side arranged	XB
	Upper side arranged (only for HF745/748-20...F3 and HF745-30...F2)	XD

9	Indicator	CODE
	Without indicator, with plug	G
	Visual differential indicator	H
	Visual electrical differential indicator	U
	Visual electrical differential indicator with thermostat	W

10	Drilling	CODE
	2 Holes M8 (HF745/HF748-20)	F2
	4 Holes M10 (HF745-30)	F2
	3 Holes M10	F3

Standard
 On request

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HOW TO ORDER A REPLACEMENT ELEMENT

	1	2	3	4	5					
HEK85	-	20.080	-	AS	-	FG010	-	LC	-	B
HEK86										

1	Element type	CODE
	See table pag. 11	HEK85-..
	See table pag. 13	HEK86-..

2	Filtering surface	CODE
	Standard	AS
	Multilayer	MS

3	Degree of filtration	CODE
	3 [µm] Micro-fibre glass	FG003
	6 [µm] Micro-fibre glass	FG006
	10 [µm] Micro-fibre glass	FG010
	25 [µm] Micro-fibre glass	FG025

4	Δp collapse pressure	CODE
	290 [psi] (20 [bar])	LC
	3046 [psi] (210 [bar])	HC

5	Seals	CODE
	Buna	B
	Viton	V

Standard
 On request

Building & construction

Agriculture

Truck Market

Material Handling

Industrial



Full range of filters
for all hydraulic circuits

Suction filters

HF 410
HF 412
HF 431
HF 434
HF 437

Tank mounted return line filters

HF 502
HF 508
HF 547
HF 554
HF 570
HF 575
HF 578

Tank mounted return and suction line filters

HF 525

In line filters Spin-On

HF 620
HF 625
HF 650

In line medium and high pressure filters

HF 690
HF 705
HF 710
HF 725
HF 735
HF 745
HF 748
HF 760
HF 761

Accessories

Filler breathers
Air filters
Level and temperature gauges
Pressure gauges
Pressure/vacuum gauges
Clogging indicators

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Replaces: HF 745 05 T A

HF 745 06 T A Edition: 06/03.2016

