

FILTERING DEGREE FOR DIFFERENT FILTER TYPE AND MACHINING PPM OF SUSPENDED SOLID

RANGE OVER MICROMETER PARTICLES SIZE

OPERATION TYPE	FILTER TYPE	POLLUTION CLASS	PARTICLES SIZE IN μ M						NOTE	
			1-5	5-15	15-25	25-50	50-100	< 100		TOTAL
FOIL ROLLING, SPECIAL WASCHERS SPECIAL GRINDING	MULTITUBE PER COAT	00	20						20	THE FLOW RATE MUST BE DETERMINED IN FUNCTION OF MATERIAL WORKED THE COOLANT TYPE AND MEDIA PERMEABILITY
		0	28	2					30	
		1	35	4	1				40	
SENDZIMIR, ALL.MILL, GUN REAMING GUN DRILL, COLD MILL, HONING, GRINDING, MAPAL, WASCHERS	LVSP - LIQUID VACUUM SANDWICH PANEL SI G1 LVSP SI G2	2	42	6	2				50	
		3	45	10	4	1			60	
		4	48	15	10	5	2		80	
		5	50	20	15	8	5	2	100	
COLD MILL, TURNING, DRILLING MEDIUM GRINDING, COOLONG WATER HOT MILL, MILLER, WASCHERS	FLAT BED according filter media LVWW - LIQUID VACUUM WEDGE-WIRE according filter media	6	70	32	20	12	10	6	150	
		7		70	50	40	30	10	200	
		8		80	60	50	35	25	250	
TURNING, DRILLING, ROUGH GRINDING MILLER, COOLONG WATER, HOT MILL, MILLER	LVWW - LIQUID VACUUM WEDGE-WIRE ONLY	9		100	90	70	50	40	350	
		10		120	110	100	70	55	450	
		11		170	140	110	95	85	600	
COARSE MACHINING		12		210	200	180	160	150	900	
		ww	NOT CONSIDERED		500	400	350	250	1500	

THE ABOVE DATA ARE THE AVERAGE VALUE OBTAINED ON SAMPLES OF COOLANT TAKEN BEFORE AND AFTER THE CICLE INDEX.
 THE DATA ARE THE AVERAGE OF 345 FILTERING SYSTEM TESTED.
 THE CONCENTRATION OF SUSPENDED SOLID WAS DETERMINED BY PASSING PORTION OF EACH SAMPLED THROUGH 5 10 20 40 80 100 MICRON
 NYLON SCREEN NOT IN SEQUENTIAL MANNER.
 THE SAMPLES TESTED WERE TAKEN AT THE MACGHINE SPRAY NOZZLES.

NOTE: FOR MORE FINES FILTRATION WITH RANGE UNDER MICROMETER PARTICLE SIZE, TESTED WITH TURBIDIMETER METHOD, USE IN-DEPTH DEEP-BED FILTER ONLY.

PERCORSO DI RICERCA /cod3/users/vit	DISEGNO N° ST-1584	MODIFICA A	DENOMINAZIONE TIPOLOGY OF FILTERING DEGREE		WATER AND MECHANICAL TECHNOLOGY s.r.l. Comano - Milano - Italia
DISCO / CASSETTA C	FILE ST-1584				