

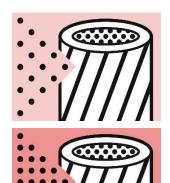
SPECIALIST INFORMATION HIGH PRESSURE MACHINE CONTAMINATION SYMBOLS



MACHINE CONTAMINATION SYMBOLS



- // Requirement and configuration of a high pressure unit varies greatly by the degree of machine contamination
- // Developed symbols should allow to determine the correct high-pressure unit with regard to the degree of machine contamination more or less at a glance
- // Different high pressure units can be the right choice for differing requirements



// Low degree of machine contamination (e. g. free cutting steel, rough chips, just few fine chips)

// Medium degree of machine contamination (e. g. free cutting steel, stainless steel, mixed fine / rough chip ratio)

// High degree of machine contamination (e. g. aluminum, brass, cast, titanium, mainly fine chips by finishing and milling)

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DEGREE OF MACHINE CONTAMINATION

Degree of machine contamination (in relation to fine / rough chip)	High pressure filter concept (CL und CS)	Chip conveyor concept (combistream)	Process flow (empirical values)	Müller symbols
20% fine chip 80% rough chip	Exchangeable filter 25, 40 or 60 µm	BK10	 Filter cleaning (change) up to once a month Cleaning of machine tank up to once a quarter 	
30% fine chip 70% rough chip	Exchangeable filter as twin filter 25, 40 or 60 μm	BK10	 Filter cleans automatically Floor cleaning of machine tank (manual) cleaning max. twice a year) 	
60% fine chip / crumble chip 40% rough chip (more twirly, wooly chips, fine chips aluminum)	Automatic filter 30, 40 μm	BK30	 Filter cleans itself automatically Upper tank with chip cascade for easy cleaning Cleaning of the machine tank three times a year 	
70% fine chip 30% twirly chip	Automatic filter 30, 40 μm	BK11	Filter cleans automaticallyCleaning of machine tank up to once a quarter	
100% fine chip 0% rough chip (fine chip brass, extremely high milling rate)	Automatic filter 30, 40 µm	BK31 (slotted screen 500 bzw. 300 μm)	 Filter cleans automatically Floor cleaning of machine tank (manual cleaning max. twice a year) 	
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