







Inlet Vacuum Filters

www.solbergmfg.com

Note: Please read the maintenance instructions given by the OEM for the machinery first. The OEM's manual should be adhered to in order to protect the equipment. Solberg Manufacturing, Inc has made every effort to make sure that these instructions are accurate but is not responsible for any typos, slight variations or for human errors that may occur.

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Maintenance Manual

Inlet Vacuum Filters

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**For Further Information Please Call: 630-773-1363*

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Section A

INTRODUCTION

The purpose of this manual is instruction on the proper assembly and care of Solberg inlet vacuum filters.

WARNING

This manual must be read and thoroughly understood before using and caring for this vacuum filter. Failure to comply could result in explosion, product/system contamination or personal injury.

This manual should be used as a supplement to the user's understanding of the proper care needed to maintain a safe and dependable vacuum filter. It is the responsibility of the user to interpret and explain all instructions to persons who do not read or understand English BEFORE they are allowed to maintain and use this filter.

This manual should be readily available to all operators responsible for operation and maintenance of the inlet vacuum filters.

We thank you for selecting products from Solberg Manufacturing, Inc. We are confident that our superior filter designs will meet your application requirements.

Section B

GENERAL INFORMATION

1. Identification of Solberg Inlet Vacuum Filters

All Solberg inlet vacuum filters should have an identification label/nameplate that gives the following information:

Assembly Model #
Replacement Element #

(The exception is OEM supplied units. In this case, please enter the OEM part numbers in Table 1.)

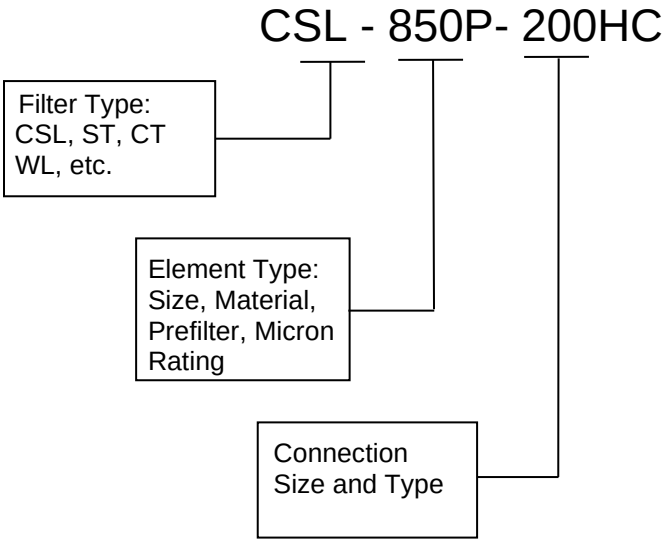
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Fill in the actual nameplate data from your new Solberg inlet vacuum filter(s):

No.	Filter Model Number	Replacement Element	Initial Delta P Readings
1			
2			
3			
4			
5			

Table 1

The model number designates the filter type, the original element configuration and housing connection size. For example, the following part number identifies the filter as being a 'CSL' design filter with an 850 element with prefilter and 2" NPSC half coupling connection:



2. Filtration Rules of Thumb

General: For peak output performance from a compressor, blower, vacuum pump, engine, or any other machine that consumes air, one must have clean, unrestricted air. Proper filtration can help stabilize the working environment within rotating equipment even when the external conditions may be quite severe. A critical component in creating the right working conditions is filter sizing. With the properly sized filter, equipment will run smoothly over its entire expected operating life.

A major factor in filtration and filter sizing is air velocity through the filter media. Generally, the slower the velocity of air through a media the higher the filter efficiency and, conversely, the lower the pressure drop. Therefore, the primary goal in filter sizing is to optimize the velocity of air through the media (sometimes called face velocity).

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Rule of Thumb #1: Always begin with the filter cartridge requirements when sizing a filter. Once the appropriate element has been selected then move on to the housing requirements.

Rule of Thumb #2: Always ask or specify a filter based on a micron rating ***with filtration efficiencies***. As an example, stating a requirement for a 1-micron filter is misleading because no efficiency rating has been specified. A 1-micron filter at 95% efficiency may be less efficient than a 5-micron filter at 99% efficiency. For proper air system performance in light and industrial duty environments, a filter with a minimum of 99% filtration efficiency at 5 microns is required.

Rule of Thumb #3: Size your filter correctly by understanding the impact air velocity through a media has on efficiency and pressure drop. Maintain the suggested Air-to-Media ratios listed below based on the external environment listings and Filtration efficiency needs.

Filtration Efficiency Requirements (99%+ efficiency)	**Environmental Conditions**	**Air to Media Ratio**	
Industrial Grade 2-micron **Paper**	Industrial Duty (clean, office/warehouse-like)	30 CFM/ft^2	(549m^3/h)/m^2
	Severe Duty (workshop, factory-like)	15 CFM/ft^2	(274.5m^3/h)/m^2
	Extreme Duty (Foundry, Construction-like)	10 CFM/ft^2	(183m^3/h)/m^2
Industrial Grade 5-micron **Polyester**	Industrial Duty (clean, office/warehouse-like)	65 CFM/ft^2	(1189.5m^3/h)/m^2
	Severe Duty (workshop, factory-like)	40 CFM/ft^2	(732m^3/h)/m^2
	Extreme Duty (Foundry, Construction-like)	25 CFM/ft^2	(457.5m^3/h)/m^2
Industrial Grade 1-micron **Polyester**	Severe Duty (Foundry, Construction-like)	25 CFM/ft^2	(457.5m^3/h)/m^2
Industrial Grade 0.3-micron **HEPA** Glass @ 99.97% Efficiency	Industrial Duty (Pre-filtered Applications)	9 CFM/ft^2	(164.7m^3/h)/m^2
	Severe Duty (workshop, factory-like)	7 CFM/ft^2	(128m^3/h)/m^2
	Extreme Duty (Foundry, Construction-like)	5 CFM/ft^2	(91.5m^3/h)/m^2

Table 2

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Rule of Thumb #4: Pressure drop is also caused by the dirt holding capacity of the element. As the element fills up with dirt, the pressure drop increases. It is important to document the pressure drop across a given filter when it is new and then clean or replace it when the pressure drop increases by 10” to 15” / 250-280mm H_2O over the original reading.

Rule of Thumb #5: The inlet connection greatly influences the overall pressure drop of the filter system. To minimize the restriction contributed by an inlet filter, a velocity of 6,000 ft/min (10200m^3/h) or less is suggested through the outlet pipe. The table below lists the suggested flows based on pipe size:

Pipe Size (inches)	Max Airflow		Pipe Size (inches)	Max Airflow	
1/2"	10 CFM	17m^3/h	2 ½"	195 CFM	332m^3/h
3/4"	20 CFM	34m^3/h	3"	300 CFM	510m^3/h
1"	35 CFM	60m^3/h	4"	520 CFM	884m^3/h
1 ¼"	60 CFM	102m^3/h	5"	800 CFM	1360m^3/h
1 ½"	80 CFM	136m^3/h	6"	1,100 CFM	1870m^3/h
2"	135 CFM	230m^3/h			

Table 3 **Note: This information is for general use only. A qualified engineer must properly design each system.*

3. Element Specifications

Temperature Range: -15° to 220°F / -26° to 105°C
Filter Change-Out Differential: 10” to 15” / 250-380mm H_2O Over Initial Delta P

Media	Micron Rating
Standard Paper	99+% @ 2 micron
Standard Polyester	99+% @ 5 micron
“S” Series Wire Mesh	Epoxy Coated Wire Mesh
“Z” Series Polyester	99+% @ 1 micron
“HE” Series HEPA	99.97% @ 0.3 microns
“U” Series Polyester	99+% @ 25 micron
“W” Series Polyester	99+% @ 100 micron
“S2” Series	Stainless Steel Wire Mesh
“AC” & “ACP” Series	N/A
“Y” Series Polypropylene	99+% @ 10 micron

Table 4

Temperature Range: -15° to 385°F / -26° to 196°C
Filter Change-Out Differential**:** 10” to 15”/ 250-380mm H_2O Over Initial Delta P

Media	Micron Rating
“MX” & “MXD” Series – Nomex Cloth	99+% @ 10 micron

Table 5

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4. Element Cleaning - Inlet Filtration

Solberg elements should be cleaned or replaced, once the pressure drop reaches 10 to 15-inches water column (250 - 380mm WC) above the initial pressure drop of the installation.

The decision to clean the element rather than replace it is left to the discretion of the operator. Any damage which results from by-pass or additional pressure drop created by element cleaning is the sole responsibility of the operator.

WARNING

The overall performance of a filter element is altered once cleaned.

The initial pressure drop after cleaning will be greater than the original, clean pressure drop of the element.

After each subsequent cleaning, the initial pressure drop will continue to increase.

Under all circumstances, the initial pressure drop of the element needs to be maintained at less than 15-inches water column (380mm WC).

Cleaned elements that exceed 15-inches water column (380mm WC) at start-up should be replaced with new elements.

With many types of equipment, the maximum pressure drop allowed will be dictated by the ability of the equipment to perform to its rated capacity. Under all circumstances, the operator should avoid exceeding the manufacturer's recommended maximum pressure drop for their specific equipment.

A. ***Polyester Element***: The polyester element may be washed in warm soapy water, vacuumed, gently blown out or replaced. The element should be dry before reinstallation. The element should be replaced after a maximum of three cleanings.
B. ***Paper Element***: The paper element may be lightly blown with low pressure air. It is disposable and in most cases should be replaced with a new element.

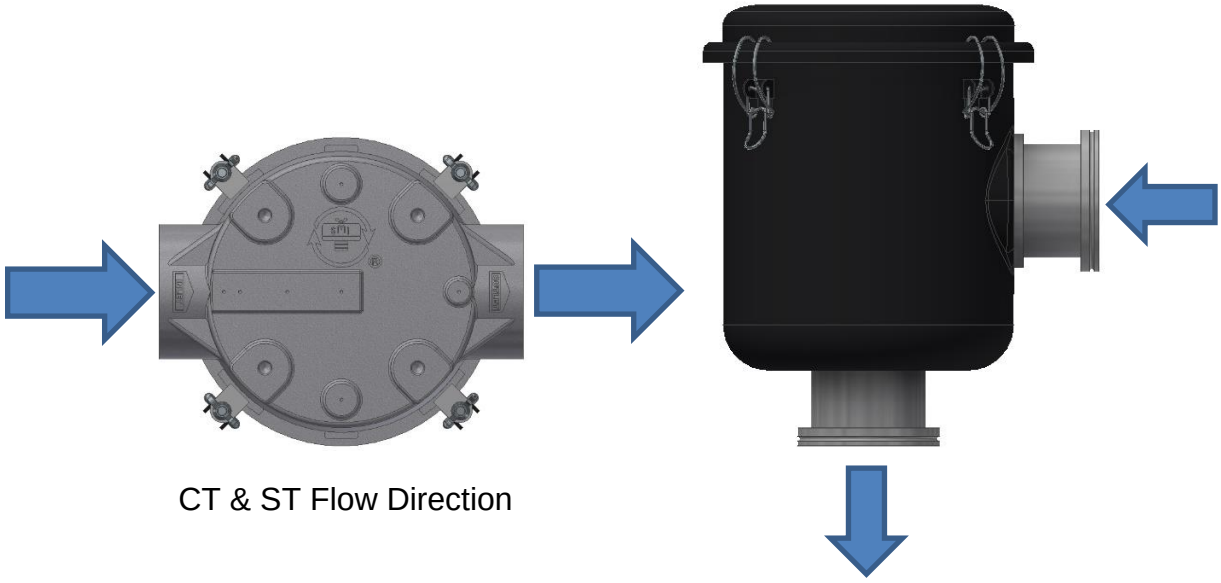
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C. ***Polyurethane Prefilter***: The prefilter may be washed as a sponge or replaced to give the element a longer service life.
D. ***Epoxy Coated Wire Mesh and Stainless Steel Wire Mesh Elements***: Cleaning instructions similar to polyester, except mild solvents may be used.
E. ***Activated Carbon Element***: Not cleanable
F. ***Polypropylene Element***: Cleaning instructions similar to polyester
G. ***Nomex Cloth Element***: Cleaning instructions similar to polyester

If you are not confident that the integrity of the element was maintained during cleaning, it is recommended that a new element be installed. Also, spare parts such as gaskets, wing nuts and washers can be supplied upon request.

5. Installation.

The drawing of the filter should be referenced before installation in order to ensure the unit is installed properly. The inlet and outlet should be identified on the unit as a label or as a physical design feature of the unit.



CT & ST Flow Direction

CSL & WL Flow Direction

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Section C

MAINTENANCE RECOMMENDATIONS

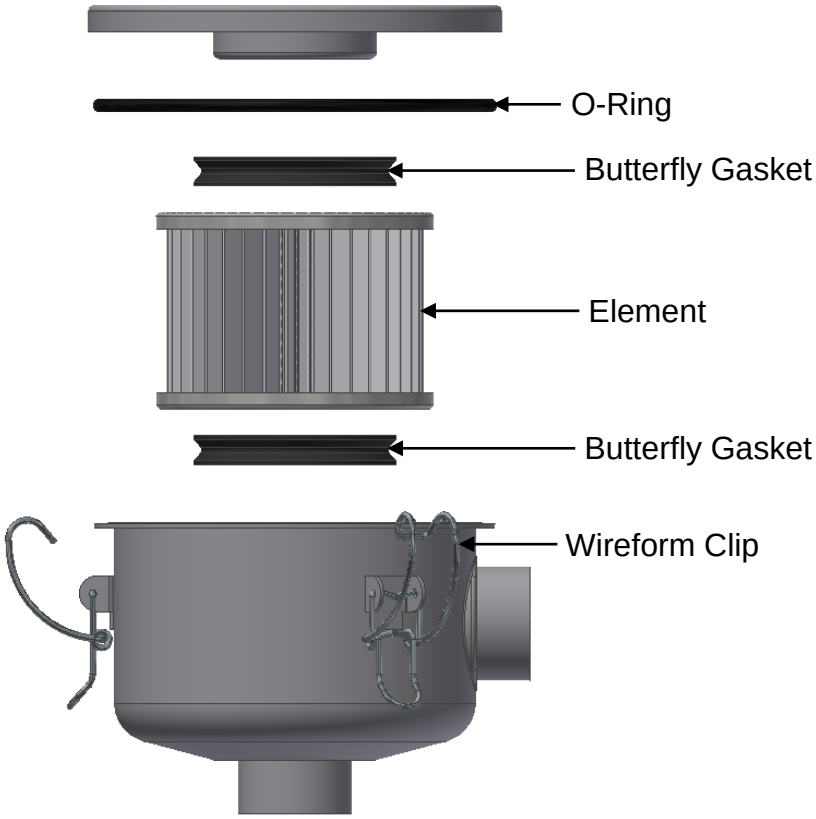
1. Pressure drop readings are recommended to have an effective vacuum filter. Always document initial pressure drop during start-up when element is clean. Replacement cartridge is needed when system experiences 10” to 15” / 250-380mm H_2O higher pressure drop above the initial reading.
2. Always check replacement cartridge gaskets to ensure they are adhered uniformly along the end caps during handling. If not, contact Solberg Manufacturing, Inc. immediately. Do not modify or change from Solberg specified parts!
3. Always check inlets/outlets, element base and its components when replacing element to ensure cleanliness. Wipe clean if necessary.
4. Operate only when a proper seal exists.

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Section D

REPLACEMENT PARTS LIST

1. CSL Series

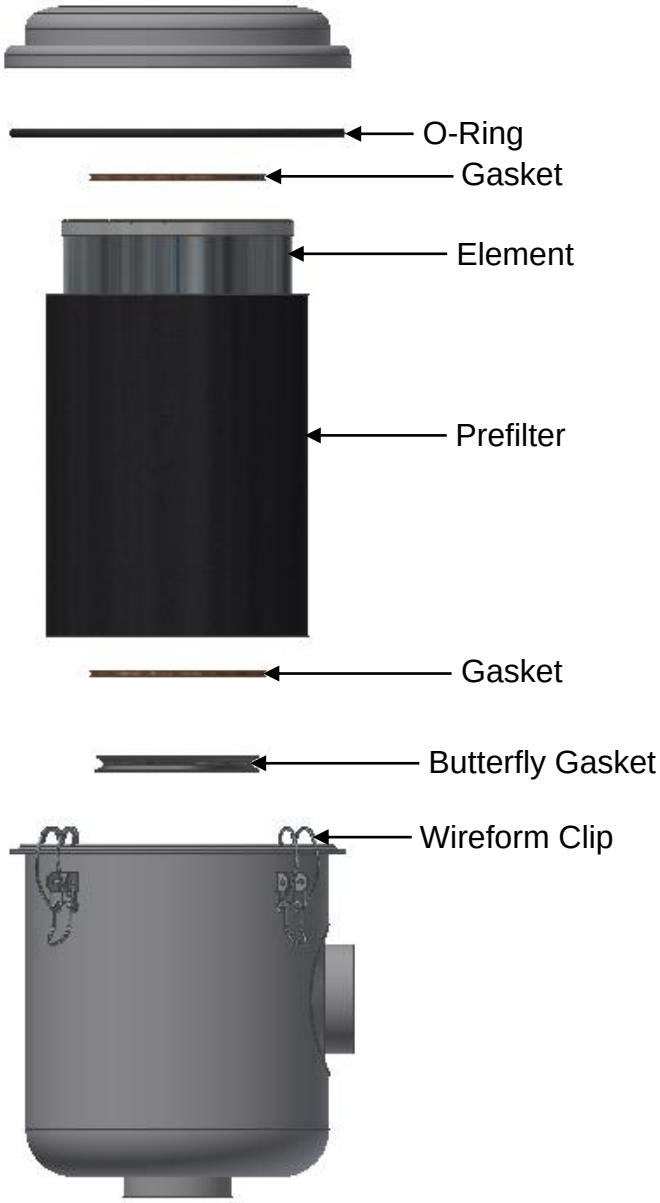


CSL Series 3/8" – 1 1/2" Compact "L" Style Vacuum Filter
Available Replacement Parts

Available Replacement Part by Product Number					
Product #	**Element****	**Prefilter**	**O-Ring**	**Butterfly Gasket**	**Wire-form Clip**
CSL-824-XXX	824	N/A	9240825	9110810	5080110+36
CSL-825-XXX	825	N/A	9240825	9110810	5080110+36
CSL-842-XXX	842	N/A	9241050	9110900	5080110+36
CSL-843-XXX	843	N/A	9241050	9110900	5080110+36
CSL-848-XXX	848	9010400	9241250	9111000	5080110+36
CSL-849-XXX	849	9010400	9241250	9111000	5080110+36

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

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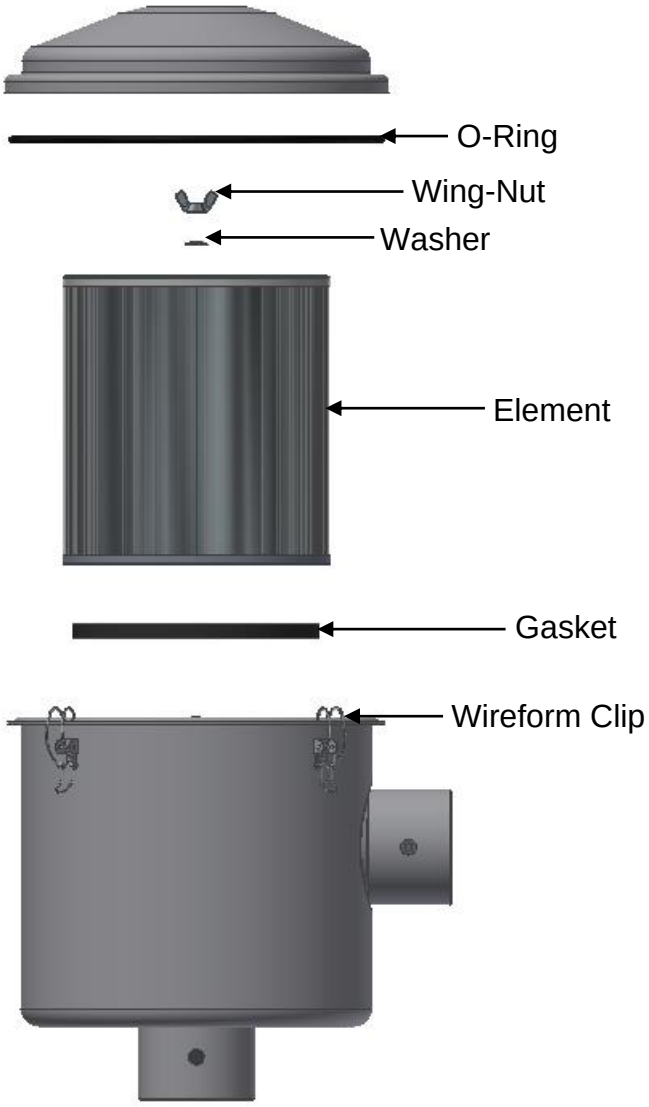


CSL Series 2” – 2 1/2” Compact “L” Style Vacuum Filter
Available Replacement Parts

Available Replacement Part by Product Number						
Product #	**Element****	**Prefilter**	**Gasket**	**O-Ring**	**Butterfly Gasket**	**Wire-form Clip**
CSL-850-XXX	850	9011560	9111200	9241400	9111100	5080110+36
CSL-851-XXX	851	9011560	9111200	9241400	9111100	5080110+36

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

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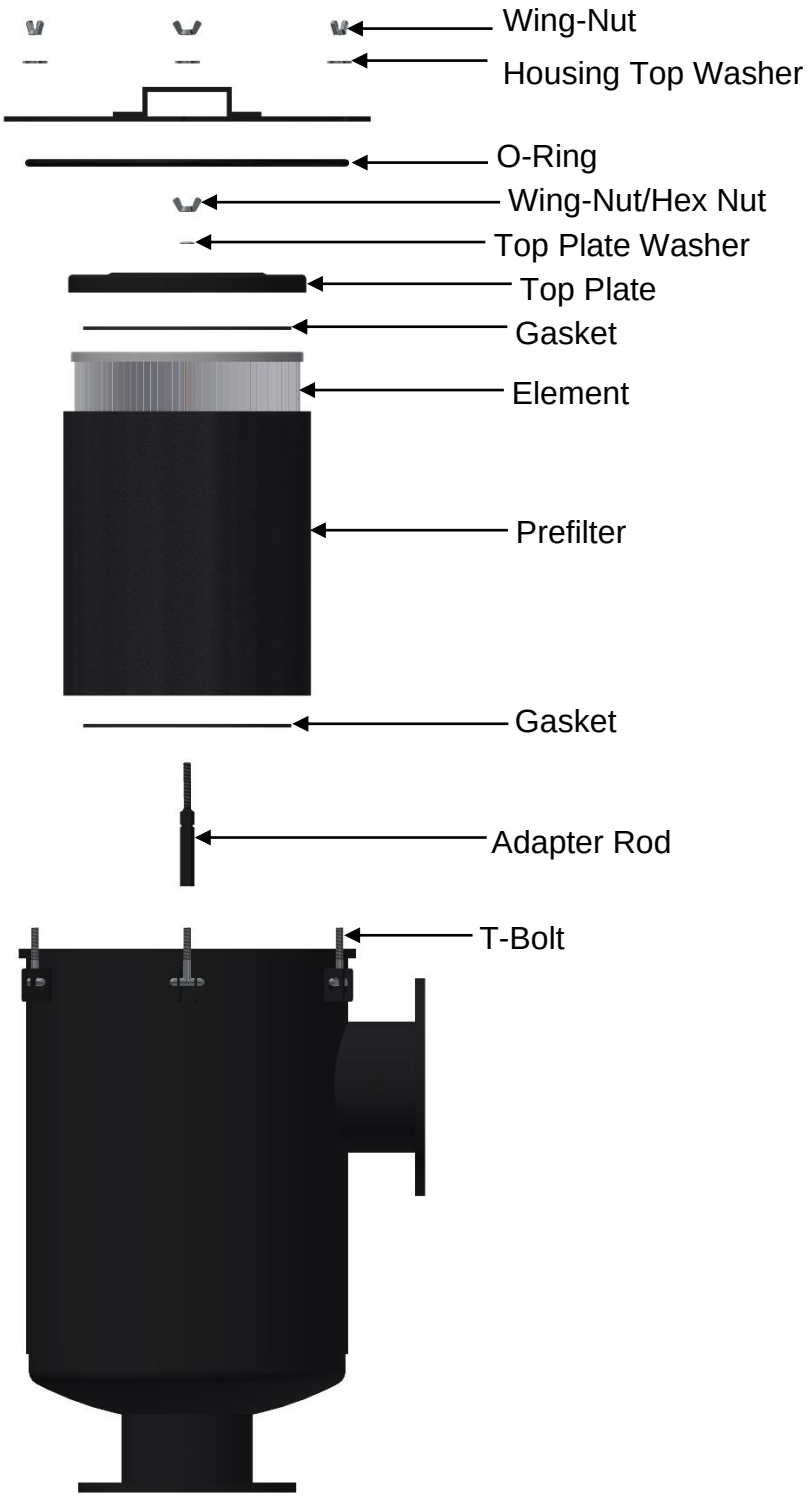


CSL Series 3” – 4” Compact “L” Style Vacuum Filter
Available Replacement Parts

Available Replacement Part by Product Number							
Product #	**Element****	**Prefilter**	**Gasket**	**Washer**	**Wing-Nut**	**O-Ring**	**Wire-form Clip**
CSL-238-XXX	238	***	9110155	5020150	5030600	9241610	5080110+36
CSL-239-XXX	239	***	9110155	5020150	5030600	9241610	5080110+36

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*
****Consult Solberg Manufacturing regarding prefilter information for the 238 and 239 elements.*

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CSL Series “L” Style Vacuum Filter
Available Replacement Parts

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Available Replacement Part by Product Number					
Product #	**Element****	**Prefilter**	**Gasket**	**O-Ring**	**Top Plate**
CSL-234P-XXX	234	9010800	N/A	9241500	1030700+10
CSL-235P-XXX	235	9010800	N/A	9241500	1030700+10
CSL-334P-XXX	334	9011150	N/A	9241500	1030700+10
CSL-335P-XXX	335	9011150	N/A	9241500	1030700+10
CSL-244P-XXX	244	9010900	N/A	9241750	1030900+10
CSL-245P-XXX	245	9010900	9110100	9241750	1030900+10
CSL-274P-XXX	274	9011000	9110200	9241750	1031000+10
CSL-275P-XXX	275	9011000	9110200	9241750	1031000+10
CSL-374P-XXX	374	9011100	9110200	9241750	1031000+10
CSL-375P-XXX	375	9011100	9110200	9241750	1031000+10
CSL-376P-XXX	376	9011200	9110400	9241900	1031100+10
CSL-377P-XXX	377	9011200	9110400	9241900	1031100+10
CSL-384P(2)-XXX	384(2)	9011300	9110500	9242000	1031300+10
CSL-685P-XXX	685	9011500	9110500	9242000	1031300+10
CSL-484P(2)-XXX	484(2)	9011400	9110500	9242000	1031300+10
CSL-485P(2)-XXX	485(2)	9011400	9110500	9242000	1031300+10

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

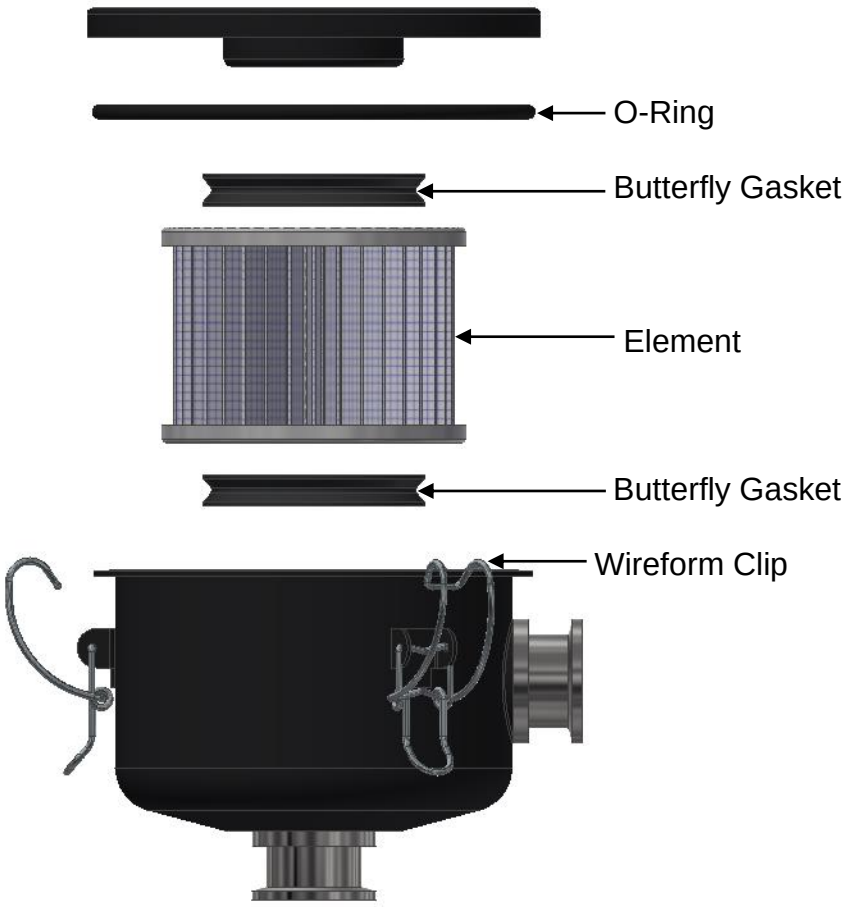
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Available Replacement Part by Product Number Continued						
Product #	**Adapter Rod**	**Housing Top Washer**	**Top Plate Washer**	**Wing-Nut**	**T-Bolt**	**Hex Nut**
CSL-234P-XXX	N/A	5040350	5020150	5030600	5011725	N/A
CSL-235P-XXX	N/A	5040350	5020150	5030600	5011725	N/A
CSL-334P-XXX	2511701+30	5040350	5020150	5030600	5011725	N/A
CSL-335P-XXX	2511701+30	5040350	5020150	5030600	5011725	N/A
CSL-244P-XXX	N/A	5040350	5020150	5030600	5011725	N/A
CSL-245P-XXX	N/A	5040350	5020150	5030600	5011725	N/A
CSL-274P-XXX	N/A	5040350	5020150	5030600	5011725	N/A
CSL-275P-XXX	N/A	5040350	5020150	5030600	5011725	N/A
CSL-374P-XXX	2511701+30	5040350	5020150	5030600	5011725	N/A
CSL-375P-XXX	2511701+30	5040350	5020150	5030600	5011725	N/A
CSL-376P-XXX	N/A	5040350	5020200	5030600	5011725	5011401
CSL-377P-XXX	N/A	5040350	5020200	5030600	5011725	5011401
CSL-384P(2)-XXX	N/A	5040350	5020200	5030600	5011725	5011401
CSL-685P-XXX	N/A	5040350	5020200	5030600	5011725	5011401
CSL-484P(2)-XXX	N/A	5040350	5020200	5030600	5011725	5011401
CSL-485P(2)-XXX	N/A	5040350	5020200	5030600	5011725	5011401

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2. WL Series

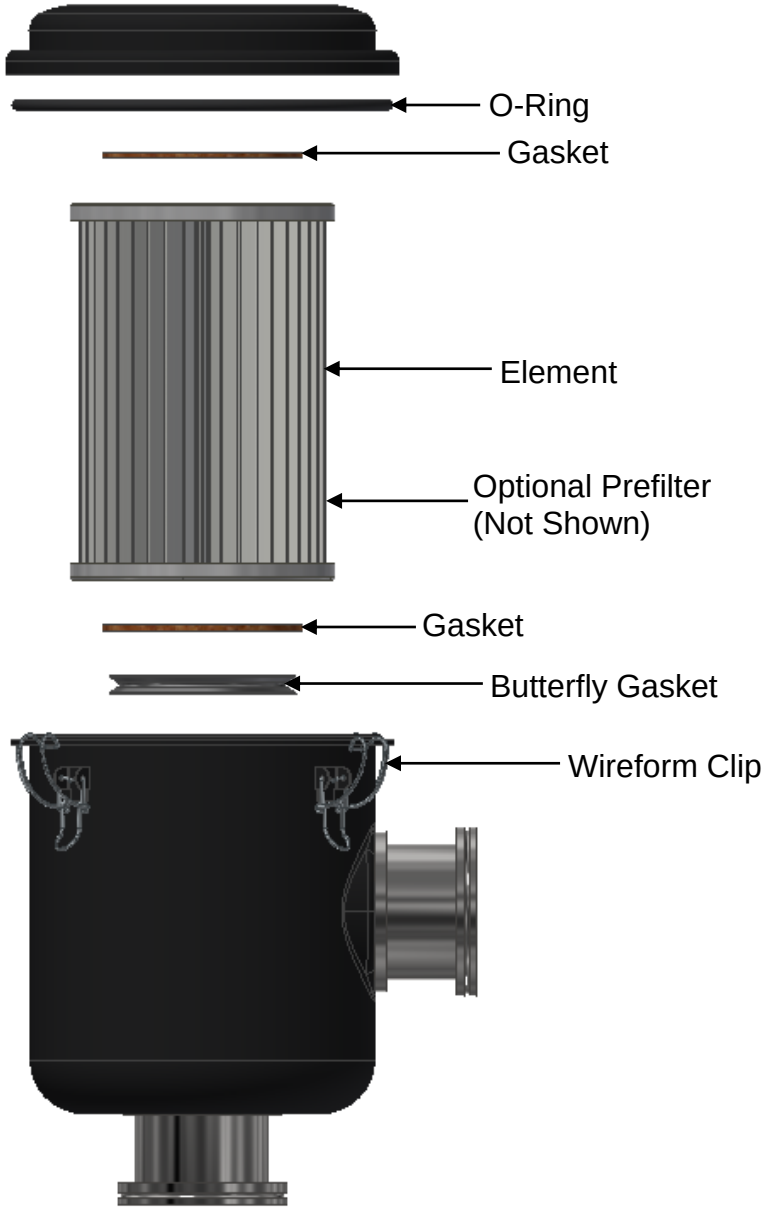


WL Series 824, 825, 842, 843, 848, and 849 Compact “L” Style Vacuum Filter
Available Replacement Parts

Available Replacement Part by Product Number					
Product #	**Element****	**Prefilter**	**O-Ring**	**Butterfly Gasket**	**Wire-form Clip**
WL-824-XXX	824	N/A	9240825	9110810	5080110+36
WL-825-XXX	825	N/A	9240825	9110810	5080110+36
WL-842-XXX	842	N/A	9241050	9110900	5080110+36
WL-843-XXX	843	N/A	9241050	9110900	5080110+36
WL-848-XXX	848	9010400	9241250	9111000	5080110+36
WL-849-XXX	849	9010400	9241250	9111000	5080110+36

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

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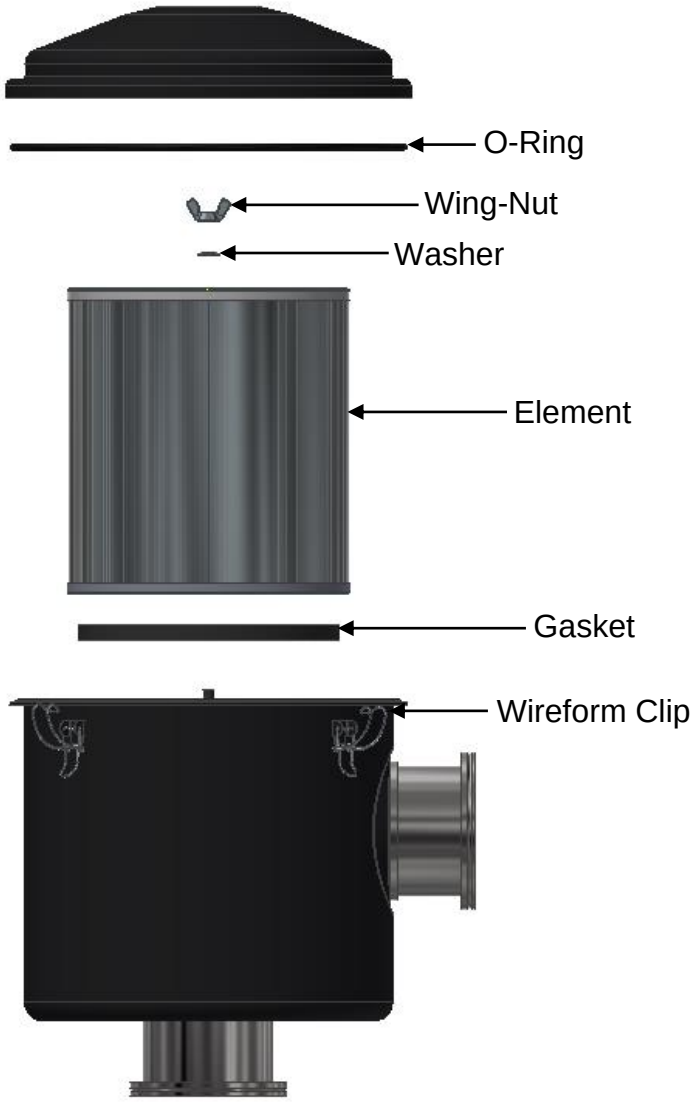


WL Series 850 & 851 Compact “L” Style Vacuum Filter
Available Replacement Parts

Available Replacement Part by Product Number						
Product #	**Element****	**Prefilter**	**Gasket**	**O-Ring**	**Butterfly Gasket**	**Wire-form Clip**
WL-850-XXX	850	9011560	9111200	9241400	9111100	5080110+36
WL-851-XXX	851	9011560	9111200	9241400	9111100	5080110+36

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

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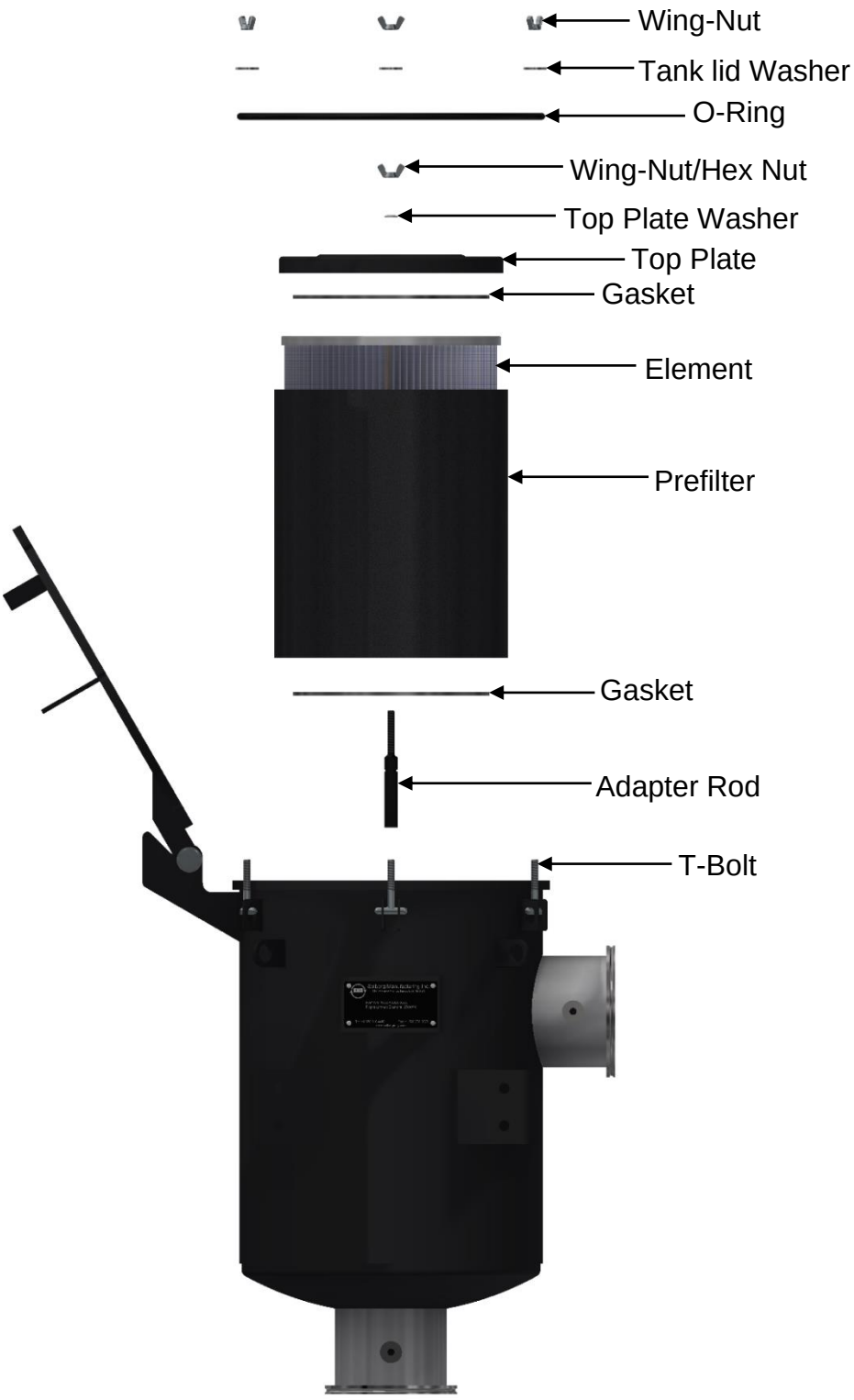


WL Series 238 & 239 Compact “L” Style Vacuum Filter
Available Replacement Parts

Available Replacement Part by Product Number							
Product #	**Element****	**Prefilter**	**Gasket**	**Washer**	**Wing-Nut**	**O-Ring**	**Wire-form Clip**
WL-238-XXX	238	***	9110155	5020150	5030600	9241610	0003453+36
WL-239-XXX	239	***	9110155	5020150	5030600	9241610	0003453+36

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*
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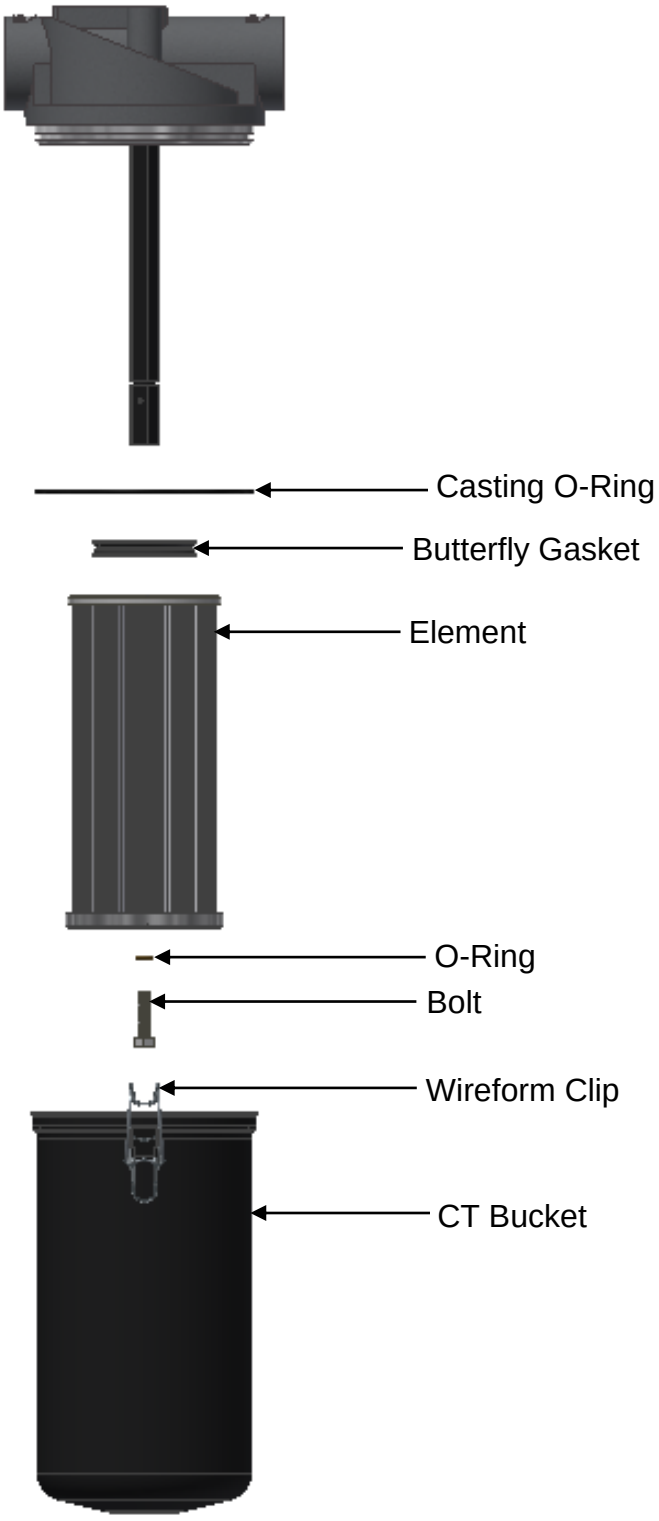
Available Replacement Part by Product Number					
Product #	**Element****	**Prefilter**	**Gasket**	**O-Ring**	**Top Plate**
WL-274P-XXX	274	9011000	9110200	9241750	1031000+10
WL-275P-XXX	275	9011000	9110200	9241750	1031000+10
WL-374P-XXX	374	9011100	9110200	9241750	1031000+10
WL-375P-XXX	375	9011100	9110200	9241750	1031000+10
WL-376P-XXX	376	9011200	9110400	9241900	1031100+10
WL-377P-XXX	377	9011200	9110400	9241900	1031100+10
WL-384P-XXX	384	9011300	9110500	9242000	1031300+10
WL-385P-XXX	385	9011300	9110500	9242000	1031300+10

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

Available Replacement Part by Product Number Continued						
Product #	**Adapter Rod**	**Tank lid Washer**	**Top Plate Washer**	**Wing-Nut**	**T-Bolt**	**Hex Nut**
WL-274P-XXX	N/A	5040350	5020150	5030600	5011725	N/A
WL-275P-XXX	N/A	5040350	5020150	5030600	5011725	N/A
WL-374P-XXX	2511701+30	5040350	5020150	5030600	5011725	N/A
WL-375P-XXX	2511701+30	5040350	5020150	5030600	5011725	N/A
WL-376P-XXX	N/A	5040350	5020200	5030600	5011702	5011401
WL-377P-XXX	N/A	5040350	5020200	5030600	5011702	5011401
WL-384P-XXX	N/A	5040350	5020200	5030600	5011725	5011401
WL-385P-XXX	N/A	5040350	5020200	5030600	5011725	5011401

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3. CT Series



CT Series 1” – 1 1/2” “T” Style Vacuum Filter
Available Replacement Parts

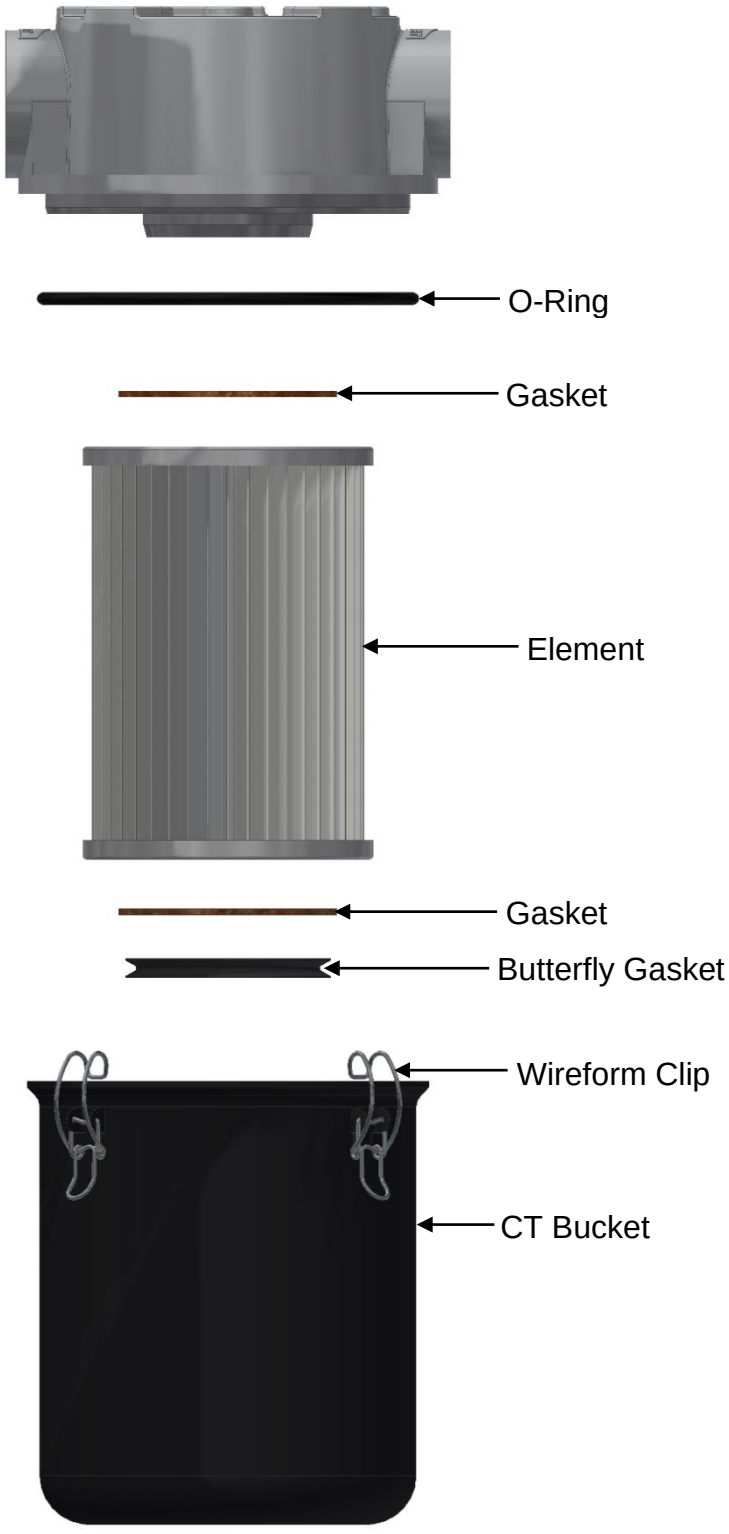
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Available Replacement Part by Product Number				
Product #	**Element****	**Butterfly Gasket**	**O-Ring**	**Bolt**
CT-896-XXX	896	9110900	9240030	5060250
CT-897-XXX	897	9110900	9240030	5060250

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

Available Replacement Part by Product Number			
Product #	**Casting O-Ring**	**CT Bucket**	**Wireform Clip**
CT-896-XXX	9262K375	300-1050241+10	5080110+36
CT-897-XXX	9262K375	300-1050241+10	5080110+36

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CT Series 2” – 2 1/2” “T” Style Vacuum Filter
Available Replacement Parts

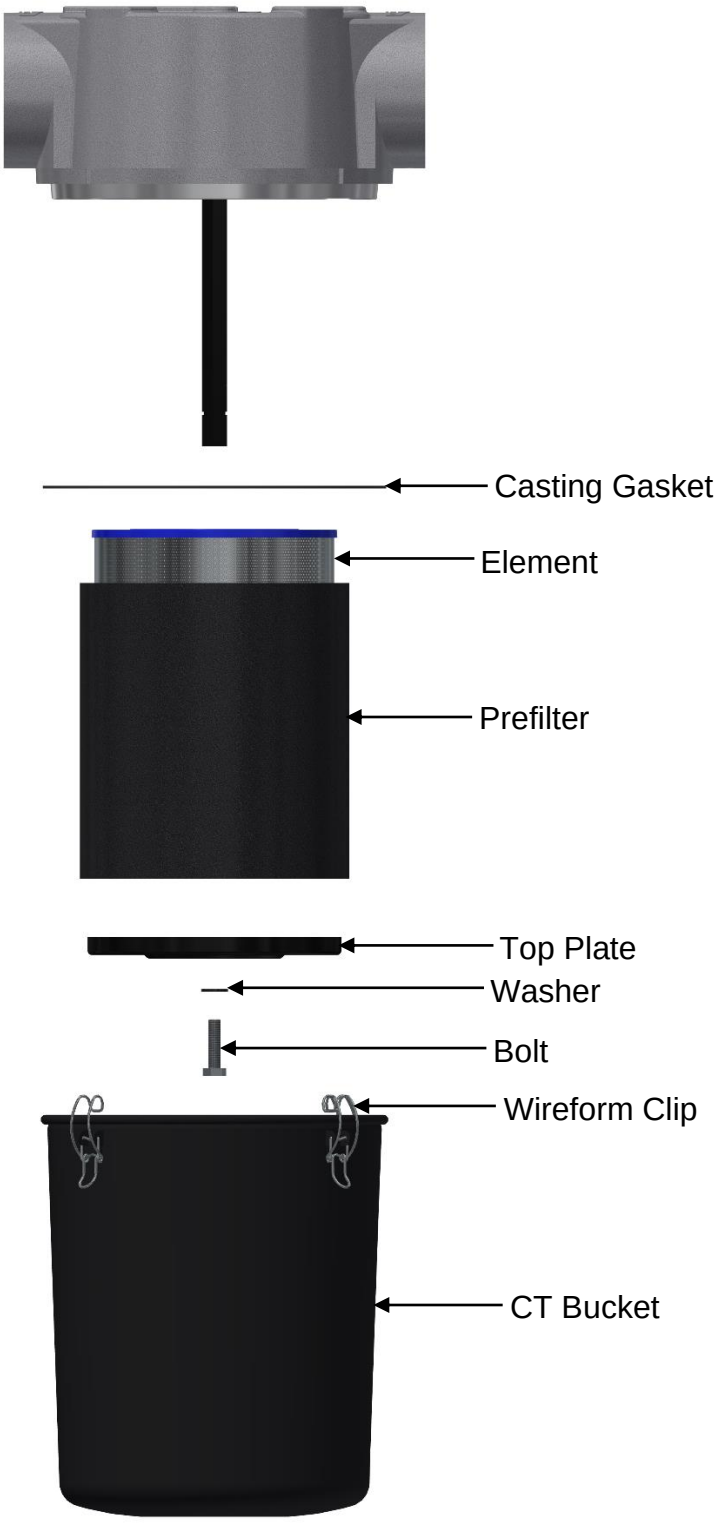
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Available Replacement Part by Product Number			
Product #	**Element****	**Gasket**	**Butterfly Gasket**
CT-850-XXX	850	9111200	9111100
CT-851-XXX	851	9111200	9111100

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

Available Replacement Part by Product Number			
Product #	**Casting O-Ring**	**CT Bucket**	**Wireform Clip**
CT-850-XXX	9241260	200-1050800+10	5080110+36
CT-851-XXX	9241260	200-1050800+10	5080110+36

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CT Series 3” – 4” “T” Style Vacuum Filter
Available Replacement Parts

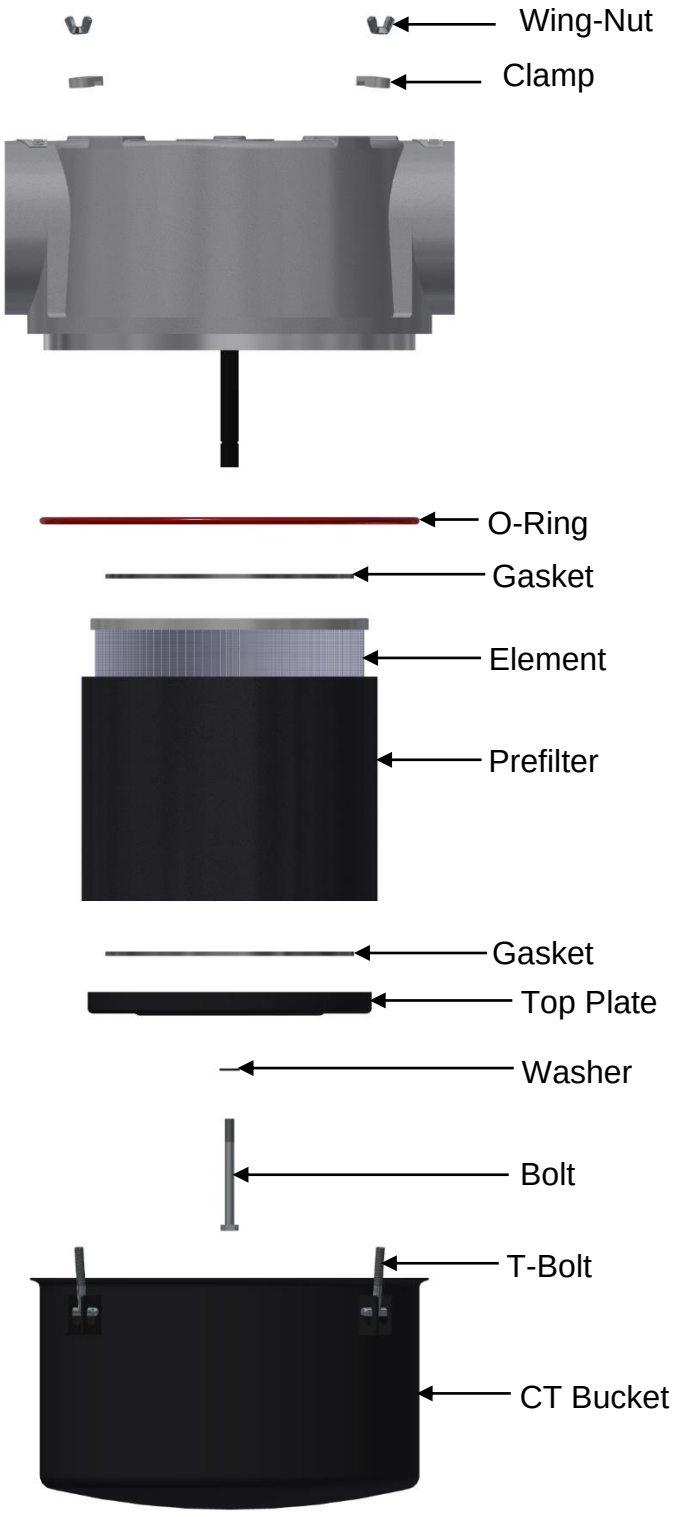
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Available Replacement Part by Product Number				
Product #	**Element****	**Prefilter**	**Top Plate**	**Washer**
CT-234-XXX	234	9010800	1030700+10	5010445
CT-235-XXX	235	9010800	1030700+10	5010445

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

Available Replacement Part by Product Number				
Product #	**Bolt**	**Casting Gasket**	**CT Bucket**	**Wireform Clip**
CT-234-XXX	5011330	9112900	200-1051800+10	5080110+36
CT-235-XXX	5011330	9112900	200-1051800+10	5080110+36

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CT Series 6" "T" Style Vacuum Filter
Available Replacement Parts

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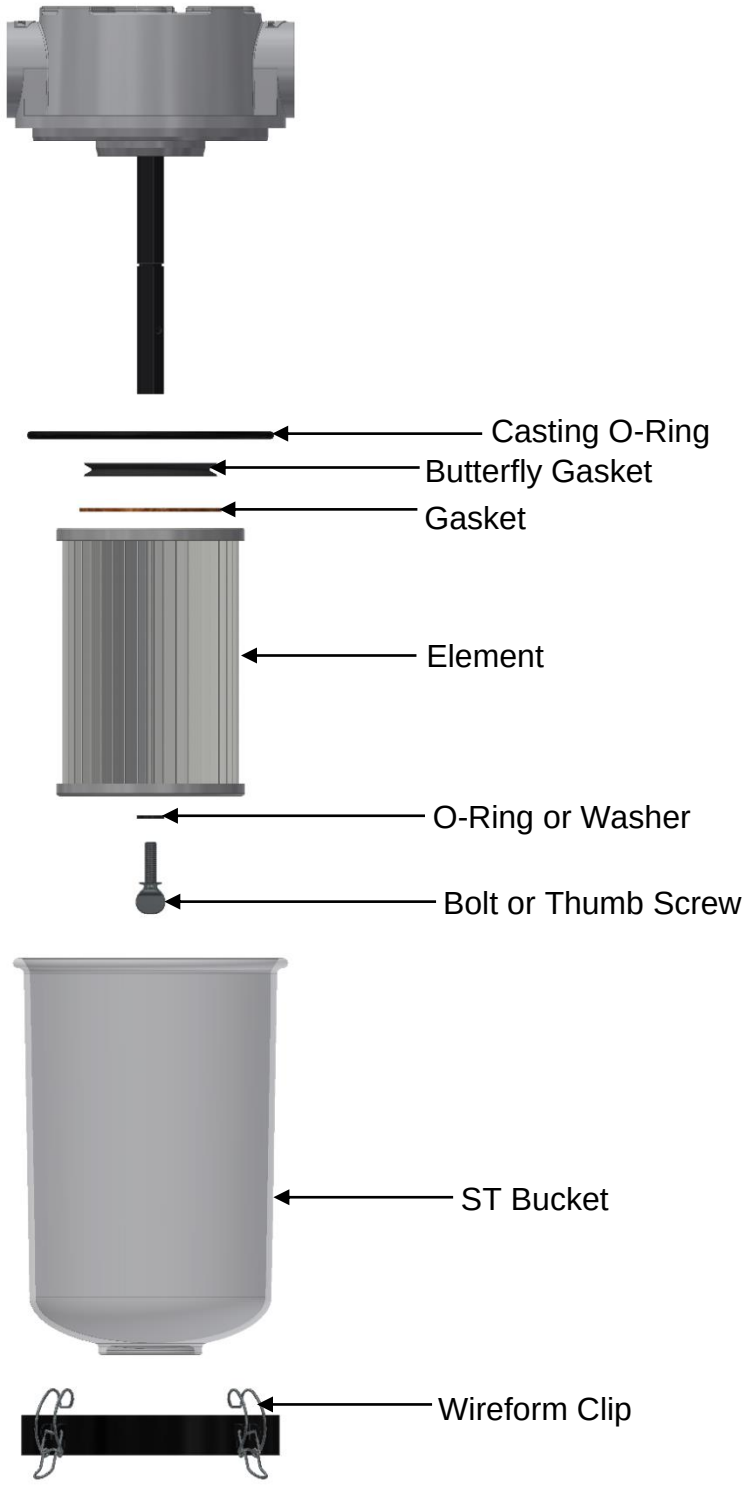
Available Replacement Part by Product Number						
Product #	**Element****	**Prefilter**	**Gasket**	**Top Plate**	**Washer**	**Bolt**
CT-274-XXX	274	9011000	9110200	1031000+10	5010445	5070285
CT-275-XXX	275	9011000	9110200	1031000+10	5010445	5070285

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

Available Replacement Part by Product Number					
Product #	**O-Ring**	**CT Bucket**	**T-Bolt**	**Clamp**	**Wing-Nut**
CT-274-XXX	9241700	200-1071725-1+10	5011725	5081500	5030600
CT-275-XXX	9241700	200-1071725-1+10	5011725	5081500	5030600

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4. ST Series



ST Series 1” – 2 1/2” “T” Style Vacuum Filter
Available Replacement Parts

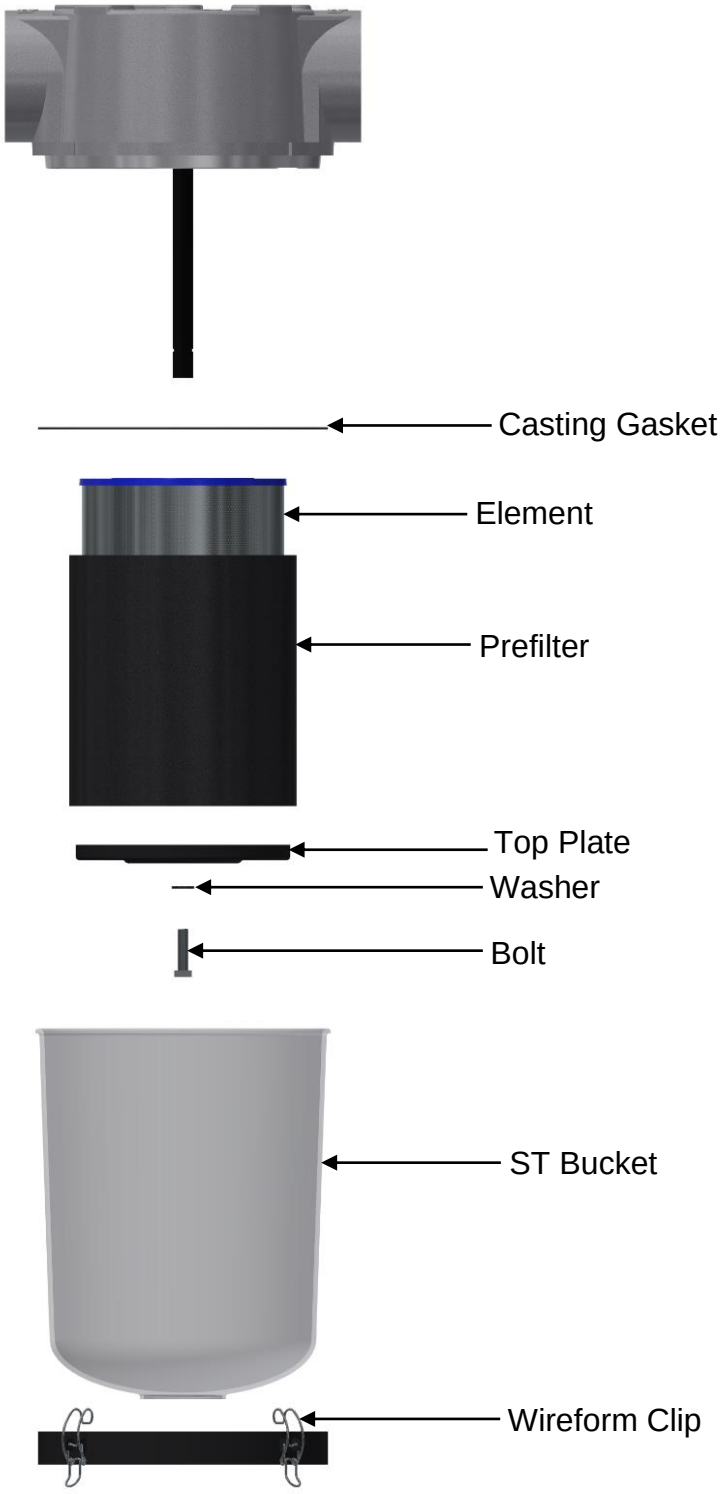
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Available Replacement Part by Product Number				
Product #	**Element****	**Butterfly Gasket**	**O-Ring or Washer**	**Bolt or Thumb Screw**
ST-896-XXX	896	9110900	9240030	5060250
ST-897-XXX	897	9110900	9240030	5060250
ST-850/1-XXX	850/1	9111100	5010445	5060300
ST-851/1-XXX	851/1	9111100	5010445	5060300

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

Available Replacement Part by Product Number				
Product #	**Gasket**	**Casting O-Ring**	**ST Bucket**	**Wireform Clip**
ST-896-XXX	N/A	9262K375	1050250	5080110+36
ST-897-XXX	N/A	9262K375	1050250	5080110+36
ST-850/1-XXX	9111200	9241260	1050810	5080110+36
ST-851/1-XXX	9111200	9241260	1050810	5080110+36

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ST Series 3” – 4” “T” Style Vacuum Filter
Available Replacement Parts

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Available Replacement Part by Product Number				
Product #	**Element****	**Prefilter**	**Top Plate**	**Washer**
ST-234-XXX	234	9010800	1030700+10	5010445
ST-235-XXX	235	9010800	1030700+10	5010445

**Note: *Even element numbers are Paper elements and odd element numbers are Polyester elements.*

Available Replacement Part by Product Number				
Product #	**Bolt**	**Casting Gasket**	**ST Bucket**	**Wireform Clip**
ST-234-XXX	5011330	9112900	1051850	5080110+36
ST-235-XXX	5011330	9112900	1051850	5080110+36

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