

Return-Suction Filters

## RST-308

Tank top mounting · Connection up to 1" (ISO 6162-1/-2) · Nominal flow rate up to 300 l/min / 79.3 gpm



Return-Suction-Filter RST-308

### Description

#### Application

For operation in units with hydrostatic drives (closed loop) and working hydraulics (open loop), when the return flow is under all operating conditions higher than the oil flow of the feed pump.

#### Performance features

##### *Protection against wear:*

By means of filter elements that even in full-flow filtration meet the highest demands regarding cleanliness classes.

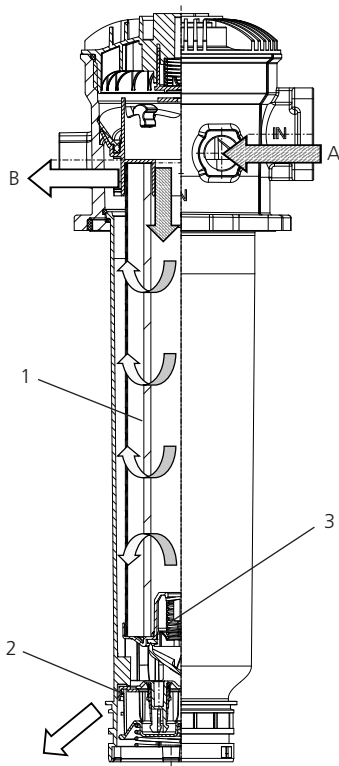
##### *Suction filter function:*

Because of the 100%-filtration of the suction flow, no dirt can get into the feed pump.

##### *Return filter function:*

By means of full-flow filtration in the system return, the pumps above all are protected from dirt particles remaining in the system after assembly, repairs, or which are generated by wear or enter the system from outside.

## Function (schematic):



### Functional characteristics

The hydraulic oil returning from the circuit (A) passes the filter element (1), is pressurized by a 0.5 bar / 7.3 psi check valve (2) and supplied to the feed pump (B). The surplus oil flows filtered over the integral check valve into the reservoir.

As the feed pump is always fed with pressurized oil, the risk of cavitation is minimized, and full performance is available even during the critical cold start phase.

An integral pressure relief valve (3) prevents too high back pressure and protects the shaft seals against damages. As this valve leads the oil into the tank there is no direct connection between the return line (A) and the connection of the feed pump (B) (no by-pass valve function).

The emergency-suction valve (4) with 125 µm protection strainer (5) supplies the feed pump in case of a short term of lack of oil. In normal operation, a lack of oil must be ruled out (see section Layout), i.e. there should be a minimum surplus between the return flow and suction flow.

### Start-up / De-aeration

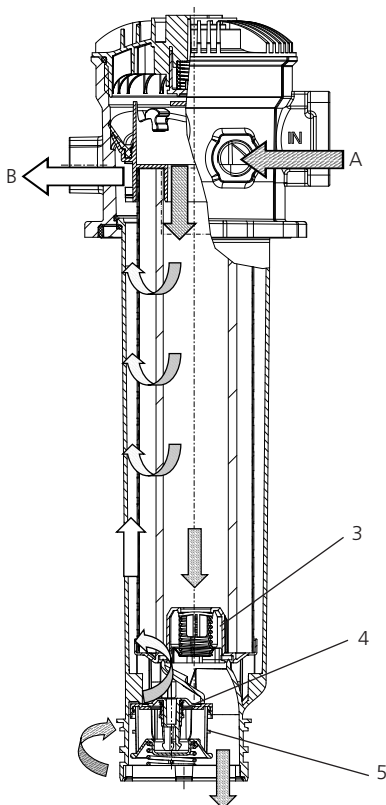
A bleed screw (for connection P1) is available under order no. SV 0112.15 for professional bleeding during initial commissioning or recommissioning after repair of the hydraulic system. This ensures an immediate oil supply for the filling pump of the hydrostatic drive.

Furthermore, the bleeding instructions of the hydrostatic drive manufacturer must be observed.

### Filter maintenance

By using a clogging indicator, the correct moment for maintenance is indicated and guarantees therefore the optimum utilization of the filter elements.

## Emergency-suction (schematic)



### Filter elements

Flow direction from center to the outside.

The star-shaped pleating of the filter material results in:

- › large filter surfaces
- › low pressure drop
- › high dirt-holding capacities
- › particularly long service life

Dirt deposits are entirely removed when the element is changed and cannot re-enter the tank.

### Accessories

Electrical and / or optical clogging indicators are available. Dimensions and technical data see catalog sheet 60.20.

**General**

In machines with a hydrostatic drive and combined working hydraulic system, return-suction filters replace the suction or pressure filters previously required for the feed pump of the closed-loop hydrostatic drive circuit as well as the return filter for the open-loop working hydraulic circuit.

While each circuit operates independently with separate filters, the combination of the two circuits via the return-suction filter causes interaction between the circuits.

If the design criteria described below are taken into account, you can take full advantage of the benefits provided by the return-suction filter concept, thus making sure that your system performs reliably even under extreme operating conditions.

**Required return flow in the system**

In order to maintain a pre-charge pressure of approx. 0.5 bar / 7.3 psi at the intake of the feed pump, the return flow must slightly exceed the suction flow under any operating condition.

**Permitted feed pump flow rate**

- › at operating temperature  
( $v < 60 \text{ mm}^2/\text{s} / 280 \text{ SUS}$ , rpm=max):  
feed pump flow rate  $\leq 0.5 \times$  rated return flow according to column 2 of selection table
- › at cold start-up  
( $v < 1000 \text{ mm}^2/\text{s} / 4635 \text{ SUS}$ , rpm = 1000 min<sup>-1</sup>):  
feed pump flow rate  $\leq 0.2 \times$  rated return flow according to column of selection table

Please contact us if your system operates with higher flow rates than stated above.

**Flow velocity in the connecting lines**

- › Flow velocity in the return lines  $\leq 4.5 \text{ m/s} / 14.8 \text{ ft/s}$
- › Flow velocity in the suction lines  $\leq 1.5 \text{ m/s} / 4.9 \text{ ft/s}$

**Permitted pressure in the suction lines**

At cold start up  
( $v < 1000 \text{ mm}^2/\text{s} / 4635 \text{ SUS}$ , rpm = 1.000 min<sup>-1</sup>):  
feed pump flow rate  $\leq 0.2 \times$  rated return flow. The pressure loss in the suction lines must not exceed 0.4 bar / 5.8 psi.

**Backpressures in system return lines**

If drain oil from the hydrostatic drive is routed across the filter in addition to the flow of the open-loop circuit, the following has to be observed in order to protect the shaft seals:

- › permitted leakage oil pressure for a given viscosity and speed (manufacturer's specifications!)
- › pressure loss caused by the leakage oil pipes
- › pressure loss caused by the oil cooler used
- › backpressure of the filter for a given flow rate or kinematic viscosity (refer to Diagrams section  $\Delta p$ -curves)

Depending on the application, the use of a cooler by-pass valve is recommended.  
Generously sized drain oil pipes are also of advantage.

**Filter fineness grades**

With the filter fineness grades available, the following oil cleanliness according to ISO 4406 can be achieved:

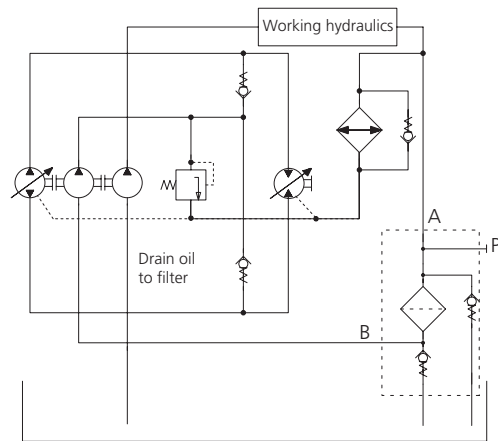
- › 10EX3: 18/15/11 ... 14/11/7
- › 16EX3: 20/17/12 ... 17/14/10

Even with the 16EX3 fineness grade, the requirements specified by manufacturers of hydrostatic drives are sometimes exceeded significantly.

If components requiring a still better oil purity are used, we recommend the 10EX3 filter fineness grade.

**Suggested circuit layouts**

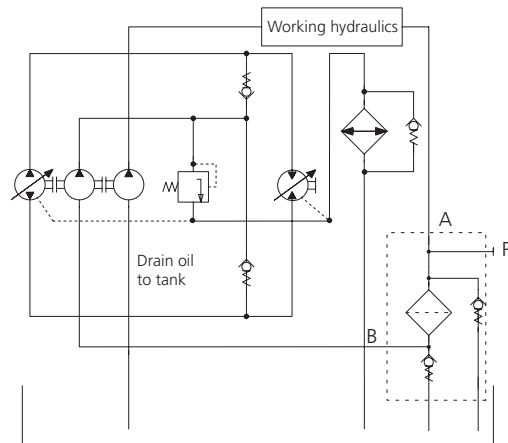
A) The leakage oil of the hydrostatic drive is routed across the filter.



The entire dirt produced in the hydrostatic drive by abrasion is filtered out immediately and is thus not taken in by the pump of the open-loop circuit.

This circuit layout is always recommended if the return flow only slightly exceeds the suction flow, i.e. if there is a risk that the 0.5 bar / 7.3 psi pre-charge pressure cannot be maintained.

B) The drain oil of the hydrostatic drive is not routed across the filter but is discharged directly into the tank.



This circuit layout has the advantage that drain oil pressures are comparatively low.

### Nominal flow rate

Up to 300 l/min / 79.3 gpm in return line  
(see Ordering Code).

Up to 150 l/min / 39.6 gpm feed pump flow rate (see Layout).

The nominal flow rates indicated by ARGO-HYTOS are based on the following features:

- › closed by-pass valve at  $v \leq 200 \text{ mm}^2/\text{s}$  / 927 SUS
- › element service life > 1000 operating hours at an average fluid contamination of 0.07 g per l/min / 0.27 g per gpm flow volume
- › flow velocity in the return lines  $\leq 4.5 \text{ m/s}$  / 14.8 ft/s
- › flow velocity in the suction lines  $\leq 1.5 \text{ m/s}$  / 4.9 ft/s

### Connection

Hose fitting DN 50 and threaded ports according to

- › ISO 6149
- › SAE (based on J518)

Sizes see Ordering Code

(other port threads on request).

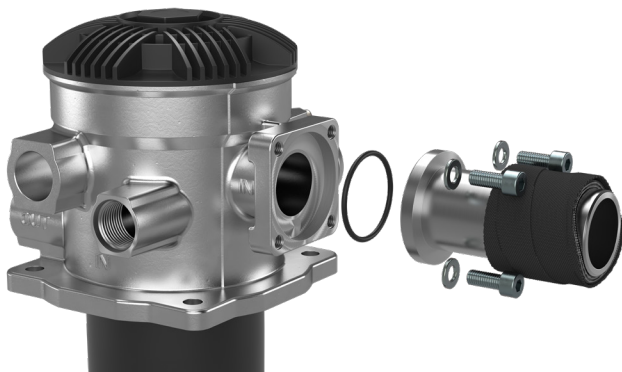
For installation recommendations, see info sheet 00.325.

### Innovative main return connection

This connection is based on ISO 6162-1/2 (SAE J518) to significantly simplify pipe installation. This means that the flanged head of the return line can be fitted directly to the filter head section. Split flanges are not needed.

Installation is carried out with just four screws (M8).

See the following illustration



### Filter fineness

10  $\mu\text{m(c)}$  ... 16  $\mu\text{m(c)}$

$\beta$ -values according to ISO 16889

(see Diagram Dx).

### Dirt-holding capacity

Values in g test dust ISO MTD according to ISO 16889

(see Ordering Code).

### Hydraulic fluids

Mineral oil and biodegradable fluids

(HEES and HETG, see info-service 00.20).

### Temperature range

-30 °C ... +100 °C (temporary -40 °C ... +120 °C)

-22 °F ... +212 °F (temporary -40 °F ... +248 °F)

### Viscosity at nominal flow rate

- › at operating temperature:  $v < 60 \text{ mm}^2/\text{s}$  / 280 SUS

- › as starting viscosity:  $v_{\text{max}} = 1000 \text{ mm}^2/\text{s}$  / 4635 SUS

- › at initial operation:

The recommended starting viscosity can be read from the diagram D (pressure drop as a function of the kinematic viscosity) as follows: Find the 70%  $\Delta p$  of the cracking pressure of the pressure relief valve on the vertical axis. Draw a horizontal line so that it intersects the  $\Delta p$  curve at a point. Read this point on the horizontal axis for the viscosity.

### Operating pressure

Max. 10 bar / 145 psi

### Materials

Screw-on cap:	Polyamide, CF-reinforced
Filter head:	Aluminum alloy
Filter bowl:	Polyamide, GF-reinforced
Seals:	NBR (FPM on request)
Filter media:	EXAPOR®MAX 3 - inorganic multi-layer microfiber web

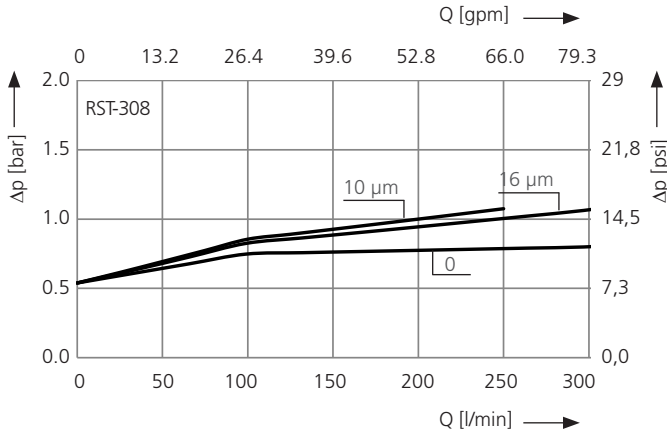
### Fitting position

- › Preferably vertical,  
axis of symmetry deviating up to 15° from the vertical

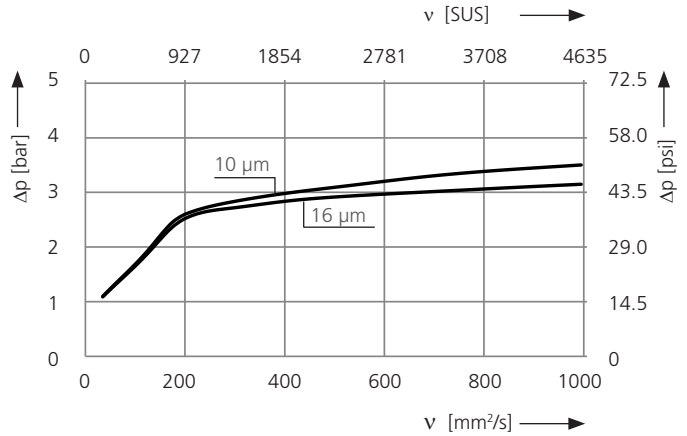
Even under unfavorable operating conditions (min. oil level, max. sloping) the oil outlet resp. emergency suction has to be below the oil level.

**Δp-curves for complete filters**  
**(50% of the nominal flow volume via connection B)**

**D1** Pressure drop as a function of the **flow volume**  
 at  $v = 35 \text{ mm}^2/\text{s} / 162 \text{ SUS}$   
 (0 = casing empty)

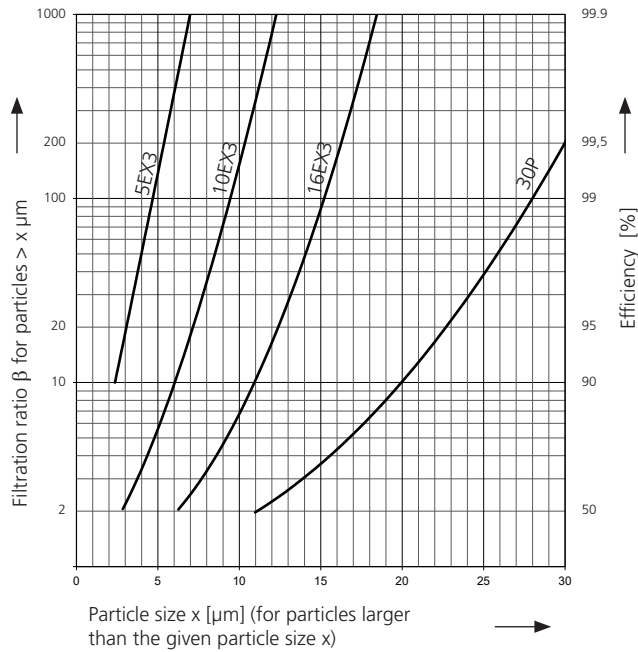


Pressure drop as a function of the **kinematic viscosity** at nominal flow



**Filter fineness curves in Selection Chart, column 4**

**Dx** Filtration ratio  $\beta$  as a function of particle size  $x$  obtained by the Multi-Pass-Test according to ISO 16889



The abbreviations represent the following  $\beta$ -values resp. finenesses:

**For EXAPOR<sup>®</sup>MAX 3 and Paper elements:**

- 5EX3 =  $\bar{\beta}_{5(c)} = 200$  EXAPOR<sup>®</sup>MAX 3
- 10EX3 =  $\bar{\beta}_{10(c)} = 200$  EXAPOR<sup>®</sup>MAX 3
- 16EX3 =  $\bar{\beta}_{16(c)} = 200$  EXAPOR<sup>®</sup>MAX 3
- 30P =  $\bar{\beta}_{30(c)} = 200$  Paper

Based on the structure of the filter media of the 30P paper elements, deviations from the printed curves are quite probable.

For special applications, finenesses differing from these curves are also available by using special composed filter material.

Complete filter

RST - 308 - SD - - OMA - 111

Order example:

RST - 308 - SD - I1 - OMA - 111

Type of filter	Code
Return-Suction Filter, tank top mounting	RST
Flow rate <sup>1</sup> , max.	Code
300 l/min / 79.3 gpm	308
Connection thread	Code
Main (return) port 1". Simplified flange connection, size 1", according to ISO 6162-1/-2 (SAE J518). No split flanges required (metric fastening screws 4 x M8)	SD

Features	Code
NBR gaskets, with CV <sup>2</sup> , PRV <sup>3</sup> , SV <sup>4</sup> and 125 µm protection strainer	111
PRV <sup>3</sup> response pressure	Code
2.5 bar / 36 psi	OMA
Filter fineness	Code
10 µm (10 EX3) dirt holding capacity 100 g	G1
16 µm (16 EX3) dirt holding capacity 100 g	I1

<sup>2</sup> Check valve (0.5 bar)  
<sup>3</sup> Pressure relief valve  
<sup>4</sup> Emergency suction valve

Second return port: M27x2 (ISO 6149)  
 Suction port: Hose fitting DN 50  
 Other or additional connections on request

<sup>1</sup> for filter fineness  
 10 µm: 230 l/min / 50.8 gpm  
 16 µm: 300 l/min / 79.3 gpm  
 Volume flows according to the nominal volume flow criteria (see section Characteristics)

All filters are delivered with a plugged clogging indicator connection M12 x 1.5 mm (connection P<sub>1</sub>). As clogging indicators either manometers or electrical pressure switches can be used.

For the appropriate clogging indicators see catalog sheet 60.20.

Remarks:

- › The start of the red area respectively the switching pressure of the electrical pressure switch has always to be lower than the cracking pressure of the pressure relief valve (see above).
- › Clogging indicators are optional and always delivered detached from the filter.
- › The filters listed above are standard filters. If you require other versions, e.g. with other or additional connections or other filter finenesses, we kindly ask for your request.
- › For de-aeration a bleed screw (for connection P<sub>1</sub>) with Part No. SV 0112.15 is available.

Spare filter element

V9. 1241 - 5

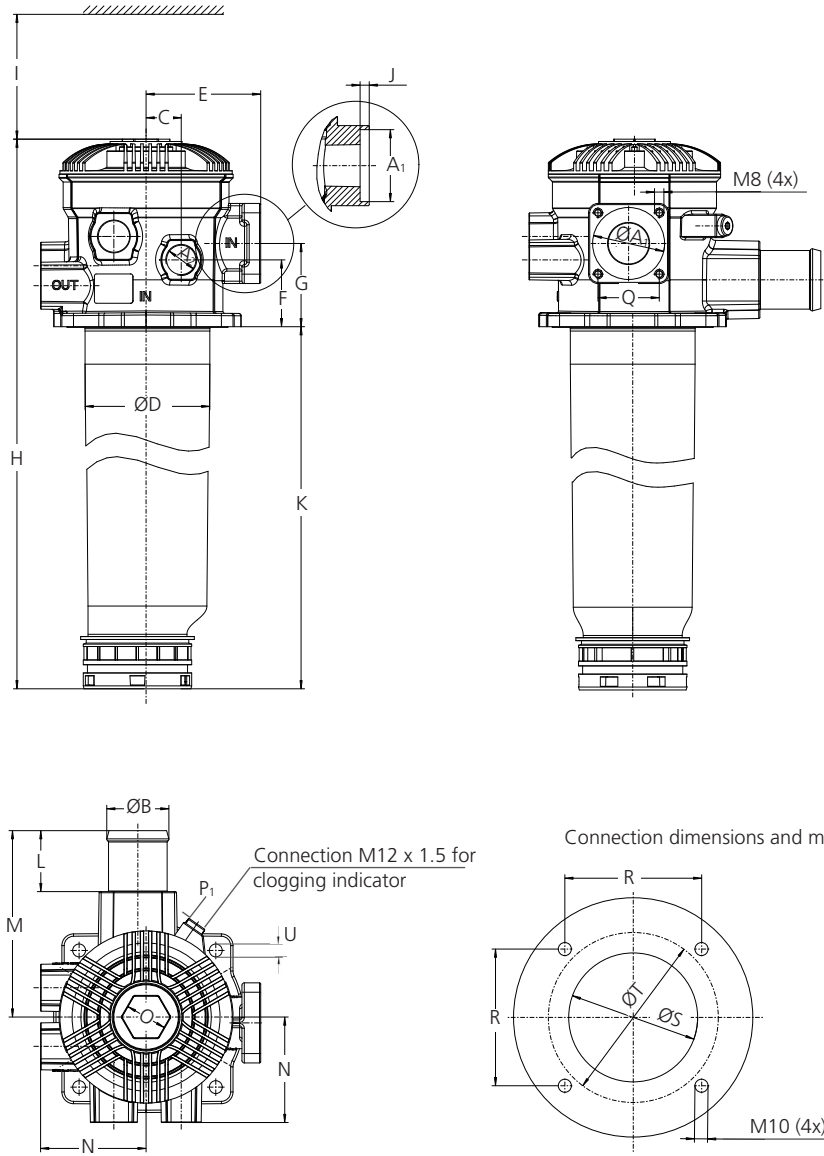
Order example:

V9.1241-58

Filter media	Code
EXAPOR®MAX 3	V9
Length	Code
with RST-308	1241

Filter fineness	Code
10 µm (10 EX3)	6
16 µm (16 EX3)	8

## Dimensions



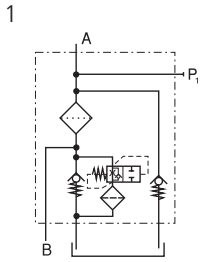
## Measurements in mm

Type	A <sub>1</sub>	A <sub>2</sub>	B	C	D	E	F	G	H	I	J	K	L
RST-308	61.1	M27x2	53	30	106.5	98	57	71	552	380	7.8	392	52
Type	M	N	O	Q	R	S	T	U					
RST-308	159	90	AF36	52.3	116.6	110	145	11					

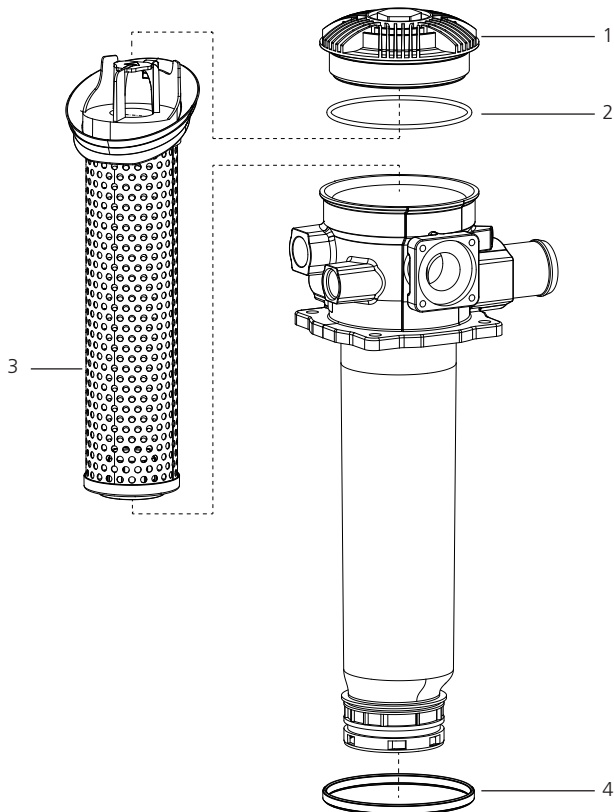
## Measurements in inch

Type	A <sub>1</sub>	A <sub>2</sub>	B	C	D	E	F	G	H	I	J	K	L
RST-308	2.41	M27x2	2.09	1.18	4.19	3.86	2.24	2.8	21.73	14.96	0.31	15.43	2.05
Type	M	N	O mm	Q	R	S	T	U					
RST-308	6.26	3.54	AF36	2.06	4.59	4.33	5.71	0.43					

## Symbols



## Spare Parts



Pos.	Designation	Part No.
1	Cover complete (incl. pos. 2)	RST 308.1100
2	O-ring 126 x 4 mm 4.96 x 0.16 inch	N007.1264
3	Replacement filter element	see Ordering Code
4	Molded seal	RST 308.0701

The functions of the complete filters as well as the outstanding features of the filter elements assured by ARGO-HYTOS can only be guaranteed if original ARGO-HYTOS spare parts are used.

## Quality Assurance

### Quality management according to DIN EN ISO 9001

To ensure constant quality in production and operation, ARGO-HYTOS filter elements undergo strict controls and tests according to the following ISO standards:

- ISO 2941 Verification of collapse / burst pressure rating
- ISO 2942 Verification of fabrication integrity (Bubble Point Test)
- ISO 2943 Verification of material compatibility with fluids
- ISO 3968 Evaluation of pressure drop versus flow characteristics
- ISO 16889 Multi-Pass-Test (evaluation of filter fineness and dirt-holding capacity)
- ISO 23181 Determination of resistance to flow fatigue using high viscosity fluid

**Various quality controls during the production process guarantee the leakfree function and solidity of our filters.**

Illustrations may sometimes differ from the original. ARGO-HYTOS is not responsible for any unintentional mistake in this specification sheet.