



Replacing the Internal Oil Filter Elements for HS85 and OS 85 Screw Compressors

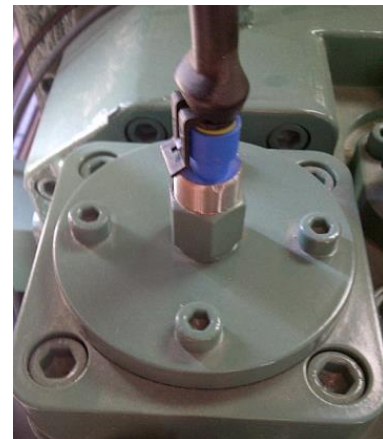
The internal oil filter elements are recommended to be changed on new systems after 2-4 days of operation (50 to 100 hours) and/or on replacement compressors.

The filters are also recommended to be changed on an annual basis during routine service of the compressor and system maintenance.

If a dirty oil filter alarm is triggered, the element must be replaced. The alarm occurs when the differential pressure is greater than 25psi. Another symptom of a dirty filter element can be nuisance tripping of the compressor due to low oil flow via the oil flow switch.

Part Number: 362204-06

The Oil Filter Element and Oil Filter Housing is shown to the right.



The Following Procedure will provide the general guidelines for replacing the oil filter element:

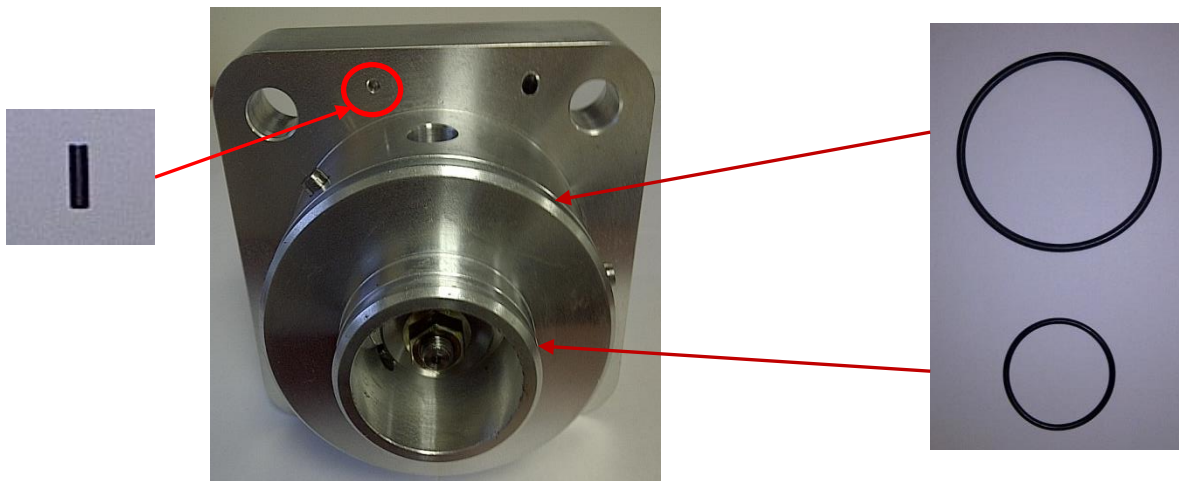
Warning!

- **Oil filter chamber and compressor are independent pressure chambers and are under pressure.**
 - **Serious injuries possible. Wear Safety Glasses.**
 - **Relieve pressure in compressor and oil filter chambers prior to performing any filter change and/or repairs.**
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- All normal field practices and guidelines must be followed for refrigerant handling and oil disposal.
 - All normal field practices for personnel safety and equipment should be observed.
 - Please also review additional information in SB-110 Operating Instructions.

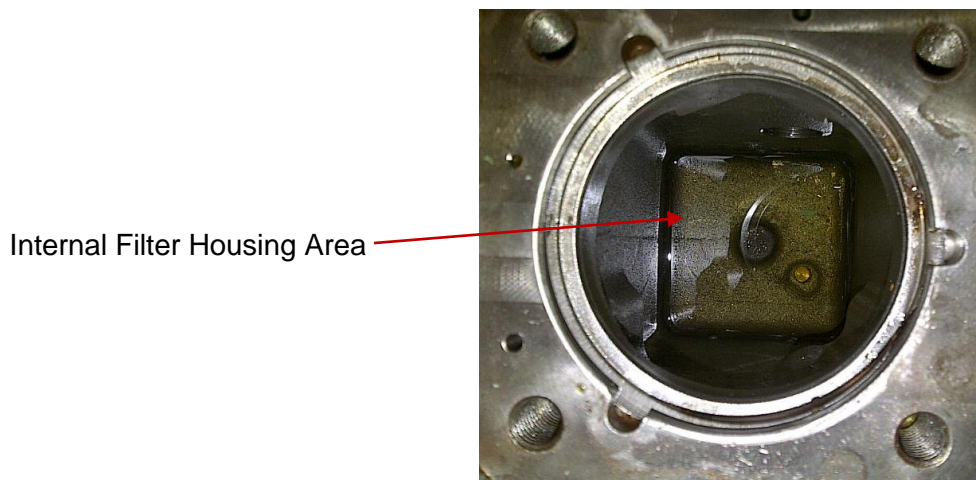
- Ensure the compressor is isolated including the eco circuit and/or liquid injection inlets, if used and all power is de-energized.
- Close the inlet oil supply isolation valve on the compressor's oil circuit.
- The oil circuit supplying oil from the oil separator and/or the oil header supply must be isolated.
- Recover the pressure from the compressor and the oil filter housing areas.
- When all pressure has been removed, the oil filter element can be removed.
- It is also recommended to obtain an oil sample from the oil separator for analysis when changing filter elements.

Replacing the filter element:

- Remove the four 12mm screws from the square flange. **NOTE: DO NOT REMOVE THE CIRCULAR FLANGE.**
- Pull the flange upwards @ 1/2" and turn it 20 degrees clockwise. There is an alignment pin.



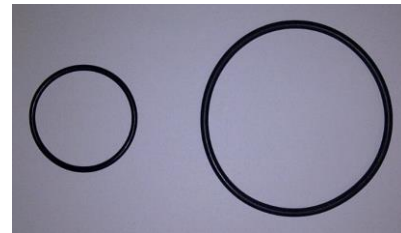
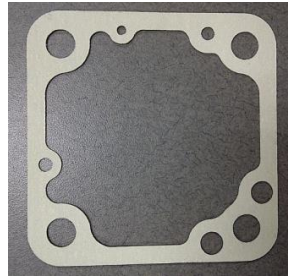
- Pull out the entire assembly and remove the existing oil filter element.
- Remove two o-rings from the internal base of the oil filter housing.
- Inspect filter housing area for any system debris. Clean as required.



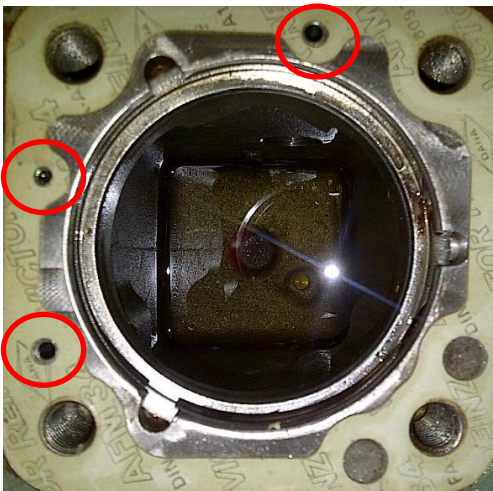
- Install the new flat gasket and o-rings. **CAUTION:** the gasket must be installed correctly.



Flat gasket and o-rings



CORRECT

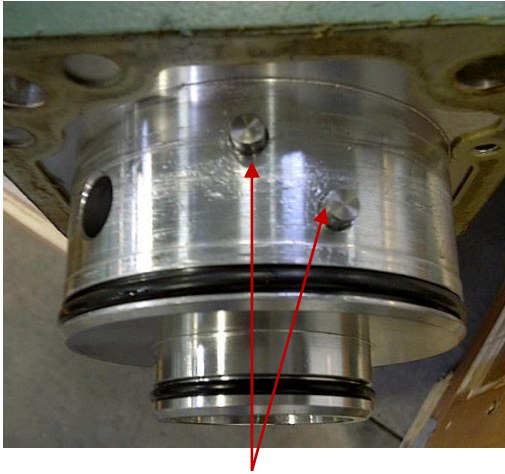


Example of Incorrect Gasket Installation



ENSURE the new gasket is installed correctly and does not block any holes

- Insert the new oil filter onto the chamber flange.
- Re-install the assembly by aligning the position pins with the channels in the compressor housing, turn the assembly counterclockwise and gently push downwards until sealed.

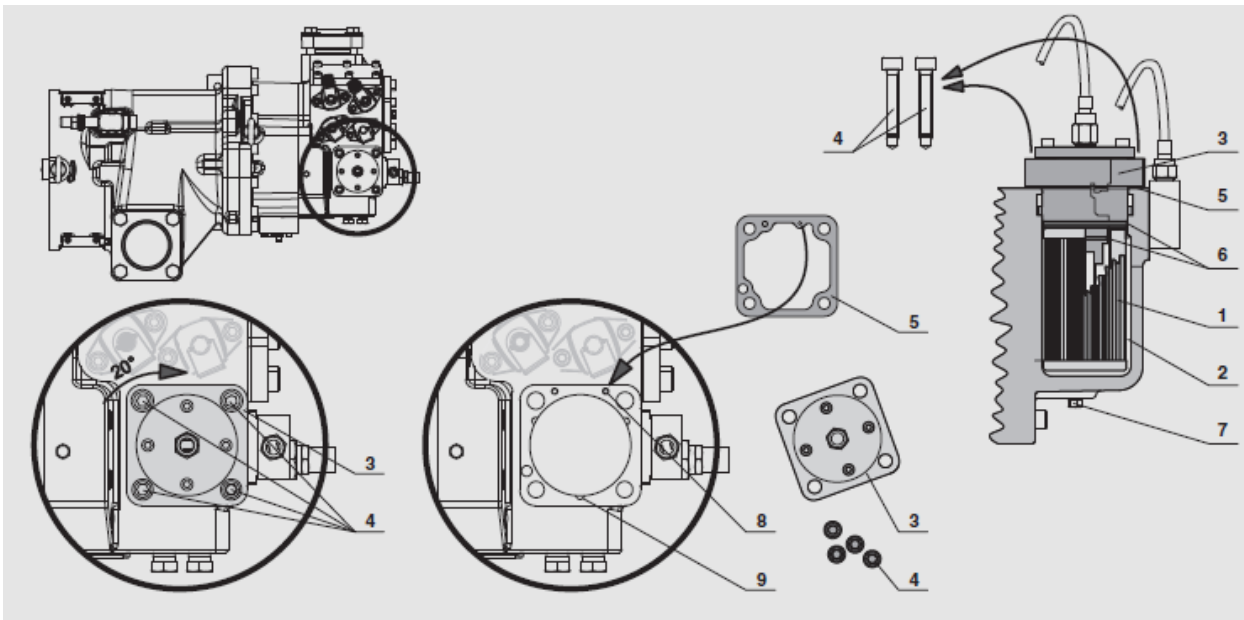


Alignment Pins
(2 shown)



Alignment Pin Grooves

- Re-install the 4 bolts removed earlier and tighten in a clockwise manner to 59 ft/lbs (80 Nm).



- 1: Oil Filter**
2: Oil Filter Chamber
3: Oil Filter Chamber Flange
4: (4xM12 Screws)
5: Flat Gasket

- 6: O-ring**
7: Oil Drain Plug
8: Position Pin
9: Groove

NOTES: