

## OPTOFORM® 40 - Changing Compressed Air Filters

The elements in both the main filter and mist separator should be replaced after each year of use. The main filter element is a SMC 111585 and the mist separator element is a SMC 630617. Both filters are mounted inside the pneumatic cabinet and each has a metal bowl with a sight glass and an automatic drain.

New filter elements are stocked by PRECITECH, INC. and should be ordered using the following part numbers.

Filter	PRECITECH #	SMC#
Main	131-0057	111585
Mist	131-0058	630617

### Procedure

1. Disconnect air supply from machine.
2. Open the Pneumatic Cabinet for access to the filter bowls.
3. Disconnect the drain tubes from the push-lock fittings at the bottom of each bowl. Push the red release ring and pull the tubing out of the fitting.
4. Grasp the mist separator filter bowl (or use the strap wrench) and rotate it counterclockwise to expose the filter element. Rotate the element counterclockwise and note which is at the top before removing it.
5. Replace the element and rotate it clockwise with finger pressure until it is seated snugly. Do not over tighten.
6. Empty the filter bowl and clean out any residue.
7. Remount the filter bowl and hand tighten clockwise so the sight-glass faces front. If the sight-glass faces back, loosen the bowl counterclockwise until the threads disengage and continue to rotate it 180° more to engage the next set of starting threads. Retighten the bowl clockwise and confirm the sight-glass faces front.
8. Repeat steps #4 through #6 for the main filter.
9. Push the drain tubes back into the "push-lock" fittings.
10. Connect air supply to machine.
11. Close and latch the Pneumatic Cabinet and dispose of the old filter elements properly.