MAKE A CHANGE TO THE BETTER

Can’t think of a good reason to change your brand of bag filters? Donaldson Torit just provided the reason—Dura-Life bag filters that outlast, outperform and outvalue standard polyester.

DURA-LIFE™ BAG FILTERS

- Breakthrough technology only from Donaldson Torit®
- Dura-Life bag filters last 2 - 3 times longer than standard 16 oz. (453.6 g) polyester bags
- Energy savings due to lower pressure drop
- 30% fewer emissions based on EPA test procedure
- Dura-Life bag filters are standard on all Donaldson Torit baghouses
- Dura-Life bag filters are available as replacements for all brands of baghouse collectors

LASTS 2 TO 3 TIMES LONGER
THE PROVEN PERFORMANCE OF DURA-LIFE™

DURA-LIFE – A TECHNOLOGY BREAKTHROUGH FOR BAG USERS

Polyester bag filters have historically been produced with a needling process that creates large pores where dust can embed into the fabric, inhibiting cleaning and reducing bag life. Dura-Life bag filters are engineered with a unique hydroentanglement process that uses water to blend the fibers, resulting in:

- More uniform material with smaller pore size
- Better surface loading of dust that prevents penetration deep into the media
- Improved pulse cleaning and lower operating pressure drop
- Bags with longer life and greater value
- Available in polyester, oleophobic, anti-static, and anti-static oleophobic
- FDA compliant versions available

These photos were taken with a scanning electron microscope of bag media used in a collector that was filtering fly ash. The bags were removed after 2,700 hours of use. Air-to-media ratio was 4.5 to 1. Pressure drop after 2,700 hours of operation was 6 in. (152.4 mm) on polyester bags and 2 in. (50.8 mm) on Dura-Life.
DURA-LIFE™ IMPROVES THE BOTTOM LINE

DURA-LIFE BAGS LAST 2–3 TIMES LONGER THAN STANDARD POLYESTER

Pressure drop increases at a faster rate with needled polyester bag filters due to dust embedding in the media, shortening bag life and forcing more frequent bag changes. Dura-Life filter bags, with surface loading of dust and better pulse cleaning, perform far longer than needled polyester filter bags when replacing due to excessive pressure drop.

![Better Surface Loading Results in Longer Bag Life](image)

These results were derived in accelerated lab tests, which correlate to field tests results, showing that Dura-Life will provide 2-3 times more life than standard 16 oz. (453.6 g) polyester bag filters when replacing due to pressure drop.

DURA-LIFE CLEARS THE AIR BETTER

Dura-Life bag filter media has been shown to produce lower emissions than the 16 oz. (453.6 g) needled polyester material used in most standard bags. Dura-Life media is more efficient at capturing dust, even 2.5 micron or smaller particles, reducing the amount of dust that escapes into the air. This helps to keep the workplace and environment cleaner.

![Dura-Life Media Provides Lower Emissions Than Standard Polyester](image)

These flat sheet results are based on independent lab tests using ASTM D 6830-02 per EPA PM 2.5 performance verification.
DURA-LIFE BAGS ARE THE CLEAR CHOICE FOR SAVINGS

With Dura-Life, there are fewer bag changes, resulting in labor and replacement bag savings and less production downtime. Unique Dura-Life technology traps dust on the surface of the bag, allowing dust to be easily pulsed off during cleaning resulting in lower pressure drop and annual energy savings.

### ANNUAL ENERGY SAVINGS DUE TO REDUCED PRESSURE DROP

<table>
<thead>
<tr>
<th></th>
<th>Standard Polyester Bags</th>
<th>Dura-Life Bags</th>
</tr>
</thead>
<tbody>
<tr>
<td>Bag Filters</td>
<td>484</td>
<td>484</td>
</tr>
<tr>
<td>Operating Delta P</td>
<td>5” (127.0 mm)</td>
<td>3” (76.2 mm)</td>
</tr>
<tr>
<td>ACFM</td>
<td>57,000</td>
<td>57,000</td>
</tr>
<tr>
<td>Motor</td>
<td>125 HP</td>
<td>125 HP</td>
</tr>
<tr>
<td>Break HP</td>
<td>55.4</td>
<td>33.2</td>
</tr>
<tr>
<td>Annual Energy Use</td>
<td>$16,687</td>
<td>$10,000</td>
</tr>
</tbody>
</table>

This is one example; energy savings can further increase with larger collectors. These energy savings are calculated based on the following assumptions: Baghouse collector runs 2 shifts per day, 5 days a week (4,000 hours per year) and energy costs are 10.7 cents per kilowatt hour with Variable Frequency Drive and an EISA compliant motor.

### LABOR AND BAG COST SAVINGS DUE TO FEWER BAG CHANGES

<table>
<thead>
<tr>
<th>Number of Dura-Life Bags</th>
<th>Maintenance &amp; Bag Cost Savings</th>
</tr>
</thead>
<tbody>
<tr>
<td>484</td>
<td>$3,708</td>
</tr>
<tr>
<td>376</td>
<td>$2,881</td>
</tr>
<tr>
<td>276</td>
<td>$2,114</td>
</tr>
<tr>
<td>232</td>
<td>$1,777</td>
</tr>
<tr>
<td>156</td>
<td>$1,195</td>
</tr>
<tr>
<td>124</td>
<td>$950</td>
</tr>
<tr>
<td>72</td>
<td>$551</td>
</tr>
</tbody>
</table>

These calculations are based on the following assumptions: standard polyester bag filters are replaced annually. Dura-Life bag filters provide twice the life of standard polyester bag filters, time-and-a-half labor rate equals $45/hr, including benefits, and a three-person crew can replace 40 bags/hr. Labor and bag cost savings can further increase with larger collectors.
DURA-LIFE™ FILTER BAGS CONQUER SOY PROTEIN WITH MUSCLE

INDUSTRY: Grain – soy protein conveyor

PROBLEM: Oily & agglomerative dust caused short filter life and high emissions

SOLUTION: Donaldson® Torit® Dura-Life bag filters last 3x longer and exceed EPA emission standards

A Midwestern soybean processing plant uses a Donaldson Torit RF baghouse dust collector on a pneumatic receiver that regularly processes between 3 and 4 tons per hour of soy protein dust.

Soy protein tends to be oily and agglomerative, so it often builds up and blinds off conventional polyester bag filters early. The maintenance team had to replace their conventional polyester filter bags every 6 months. Now, after installing Donaldson Torit Dura-Life™ filter bags, they find filters last about 18 months—3x longer.

One of the company’s biggest concerns was their ability to meet EPA emissions standards of 0.05 gr/dscf*. After testing Dura-Life, the company was pleased to discover that emissions are well below the EPA requirements — just 0.0028 gr/dscf. The maintenance supervisor reports that visual inspections of the ducts also appear much cleaner with Dura-Life, and ΔP measured 2-4” lower than with non-Dura-Life bags.

Longer filter life AND lower emissions? Now that’s tackling protein dust with muscle.

PROJECT STATISTICS

<table>
<thead>
<tr>
<th>Dust/Contaminant</th>
<th>Soy Protein</th>
</tr>
</thead>
<tbody>
<tr>
<td>Application</td>
<td>Pneumatic conveying</td>
</tr>
<tr>
<td>Dust Collector</td>
<td>Donaldson Torit RF Baghouse, with 324 bag filters, Model 324RFW10</td>
</tr>
<tr>
<td>Air Volume</td>
<td>35,000 cfm (59,453 m³/h)</td>
</tr>
<tr>
<td>Dust Loading</td>
<td>5-8 grains/dscf</td>
</tr>
<tr>
<td>Air-to-Media Ratio</td>
<td>7:1</td>
</tr>
<tr>
<td>Hours of Operation</td>
<td>4-5 days/week, 24 hrs/day</td>
</tr>
<tr>
<td>Polyester Bag Life</td>
<td>6 months @ 6.5” – 8.5” ΔP</td>
</tr>
<tr>
<td>Dura-Life Bag Filter Life</td>
<td>1½ years @ 4.5” ΔP</td>
</tr>
<tr>
<td>Emission Test Results</td>
<td>0.0028 gr/dscf (well below EPA 0.05 gr/dscf requirement)</td>
</tr>
</tbody>
</table>

* Grains/dscf = Grains per dry standard cubic foot. There are 7,000 grains in one pound.
Dura-Life filters ship in 24 hours and are available for all popular collectors.

- AZO™
- Buhler
- Carter Day
- DCE
- Flex-Kleen
- Golfetto
- Kice
- MAC
- MikroPul
- Murphy
- Pneumafil
- Steelcraft®
- Wheelabrator
- + Many others

To learn more about Dura-Life bag filters, Call 800-365-1331 or visit DonaldsonTorit.com
Industry-Leading Technology
• Advanced filtration technology for optimal performance
• Reduced energy consumption and cost of ownership
• Advanced design and testing capabilities

The Most Filters and Parts
• For every brand and style of collector
• Wide range of filtration media for any application
• 90,000 filters and parts in stock and ready to ship

Unparalleled Support
• Live technical specialists
• Comprehensive pre- and post-sale support
• 40 manufacturing plants and 14 distribution centers worldwide

Significantly improve the performance of your collector with genuine Donaldson Torit replacement filters and parts. Call Donaldson Torit at 800-365-1331.

Important Notice
Many factors beyond the control of Donaldson can affect the use and performance of Donaldson products in a particular application, including the conditions under which the product is used. Since these factors are uniquely within the user’s knowledge and control, it is essential the user evaluate the products to determine whether the product is fit for the particular purpose and suitable for the user’s application.

All products, product specifications, availability and data are subject to change without notice, and may vary by region or country.