

## Cleanliness Weighting Process

### 1) Operating Pressure and Duty Cycle Weighting

Duty	Examples	Operating Pressure Bar					
		0 – 60	>60–160	>160–250	>250–400	>400	
Light	Continuous operation at or below rated pressure	1	1	2	3	4	
Medium	Medium pressure changes up to rated pressure	2	3	4	5	6	
Heavy	Zero to full pressure	3	4	5	6	7	
Severe	Zero to full pressure with transients at high frequency e.g. Power presses	4	5	6	7	8	

### 2) Component Sensitivity Weighting

Sensitivity	Examples	Weighting
MINIMAL	Ram pumps	1
BELOW AVERAGE	Low performance gear pumps manual and poppet valves	2
AVERAGE	Vane pumps, electro hydraulic spool valves, high performance gear pumps	3
ABOVE AVERAGE	Piston pumps, proportional valves	4
HIGH	Industrial servo valves, high performance proportional valves	6
EXTRA HIGH	High performance servo valves	8

### 3) Life Expectance Weighting

Life Expectance ( Hours)	Weighting
0 – 1,000	0
1,000 – 5,000	1
5,000 – 10,000	2
10,000 – 20,000	3
20,000 – 40,000	4
40,000 +	5

**4) Cost of Component Weighting**

<b>Cost of Component Replacement</b>	<b>Examples</b>	<b>Weighting</b>
Low	Manifold mounted valves, inexpensive pumps	<b>1</b>
Average	Line mounted and modular valves	<b>2</b>
High	Cylinders, proportional valves	<b>4</b>
Very High	Larger piston pumps, large high torque low speed motors, high performance servo components	<b>6</b>

**5) Down Time Weighting**

<b>Downtime Cost</b>	<b>Examples</b>	<b>Weighting</b>
Low	Equipment not critical to production or operation	<b>1</b>
Average	Small to medium production plant	<b>2</b>
High	High Volume production plant	<b>4</b>
Very High	Very Expensive downtime e.g. Flow lines	<b>6</b>

**6) Safety Liabilities Weighting**

<b>Safety Liability</b>	<b>Examples</b>	<b>Weighting</b>
Low	Where failure is unlikely to cause a hazard	<b>1</b>
Average	Where failure is likely to cause a hazard	<b>3</b>
High	Mine winding gear breaking systems, leisure rides	<b>6</b>

**7) Environmental Weighting**

<b>Environmental</b>	<b>Examples</b>	<b>Weighting</b>
Good	Clean areas, laboratories, few ingress points, filtered filling and appropriate air breathers	<b>0</b>
Fair	General machine shops, lifts, filtered filling and appropriate air breathers	<b>1</b>
Poor	General machine shops with minimal control	<b>3</b>
Hostile	Foundries and places where ingress of contaminate is expected e.g. concrete plant, quarries, component test rigs	<b>5</b>