

# DuraTap<sup>TM</sup>

## Testing Sieve Shaker

### Operation & Set-up Manual

#### Models:

DT168

DT258

DT268

DT1612

DT2512

DT2612



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**A Product of the United States of America**





# Introduction

Thank you for selecting this high-quality piece of testing equipment. We appreciate your support and pledge to assist you in the service of your Advantech testing apparatus.

The Advantech DuraTap™ is a low maintenance, heavy duty sieve shaker that will provide consistent, reliable performance. Gone are the days of needing to buy “accessory packs” of repair parts for expected breakdowns like other sieve shakers require. The DuraTap™ does not use typical plastic and wear-surface parts. This industrial-strength unit is engineered with rugged steel and alloy materials ready to withstand the everyday, harsh duty cycles. Grease fittings are provided to ensure longer life for your bearings. Each unit is “burned-in” guaranteeing performance right out of the box.

This unit is ideal for use with aggregates, sands, cements, chemicals, powder metals, cosmetics, pharmaceuticals and many other dry components in pellet, ground, granular or powder form. **This unit is not recommended for wet sieving operation.**

Besides the physical nuts and bolts, this device is backed by a company with decades of experience in the dedicated service of users in the powder and particulate industries. We look forward to servicing you as well.

“The Leader in Sieving Technology®”

# Specifications

## Model Designations and Power Requirements

- Model DT168 ..... 110VAC/60Hz operation, 8" (203.2mm) diameter  
sieve capacity
- Model DT268 ..... 220VAC/60Hz operation, 8" (203.2mm) diameter  
sieve capacity
- Model DT258 ..... 220VAC/50Hz operation, 8" (203.2mm) diameter  
sieve capacity
- Model DT1612 ..... 110VAC/60Hz operation, 12" (304.8mm) diameter  
sieve capacity
- Model DT2612 ..... 220VAC/60Hz operation, 12" (304.8mm) diameter  
sieve capacity
- Model DT2512 ..... 220VAC/50Hz operation, 12" (304.8mm) diameter  
sieve capacity

## Timer

- 24 hours, reported accuracy +/- 2 seconds

## Dimensional Specifications

- Unit base: 28" (71.1cm) L x 21" (53.cm) W x 25" (63.5cm) H

## General Specifications

- Steel weldment base
- Durable, baked epoxy finish
- Unit capacity (8"): 7 full height sieves plus pan and cover  
14 half height sieves plus pan and cover
- Unit capacity (12"): 4 full height sieves plus pan  
6 intermediate height sieves plus pan  
8 half height sieves plus pan

# Installation & Set-up Instructions

The DuraTap™ Testing Sieve Shaker is designed to give years of trouble-free service. To assure that the device delivers optimum performance, several points must be observed before putting the device into service.

## 1) Mounting

For best results, the unit must be permanently mounted. It is recommended that unit be bolted to a steel table, heavily constructed wooden bench or other suitable structure that will be able to withstand the vibratory and hammering action of the unit. The diagram below shows the location of bolt holes provided for the mounting.

Use  $\frac{3}{8}$ " diameter bolts (purchased locally) to secure the unit. Inspect the mounting periodically for loosening due to vibration.

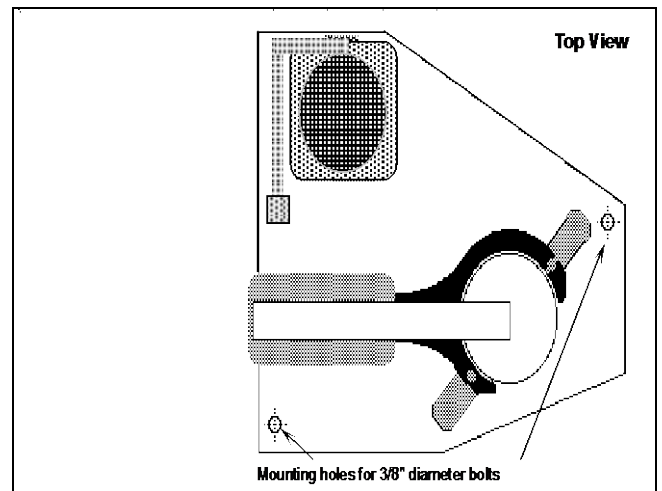
## 2) Cleaning

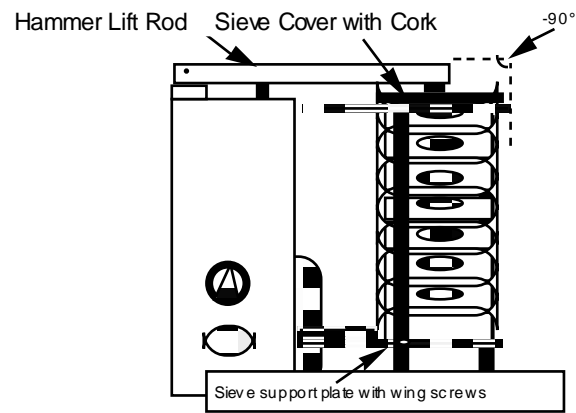
The unit is painted with a baked epoxy finish that will clean readily with a soft damp cloth. For best results, vacuum any loose particulate materials prior to wiping the machine clean.

## 3) Sieve Stack Height Adjustment

To assure repeatable and reproducible results in testing, the drop of the hammer arm has been pre-calibrated during assembly. It is essential, however, that the stack of sieves be installed at the proper height to obtain optimal results. To adjust the sieve stack height, please observe the following:

- Using a  $\frac{3}{16}$ " hex wrench, turn the top Eccentric (in direction of yellow arrow) until the hammer lift rod is at the lowest point of travel
- Load the stack of sieves, pan, cover and sieve cover with cork on to the sieve support plate
- Loosen the two nuts on the sieve support plate
- Raise the sieve support plate along with the sieve stack until the hammer arm comes to an approximately level position (see diagram)
- Tighten the wing screws and begin testing





#### 4) Lubrication Instructions

This unit requires periodic lubrication at two different points in the mechanism. After every **5 hours** of operation, apply any general-purpose grease containing graphite to the grease fitting at the rear of the top yoke. At the same time, apply grease to the bulkhead grease fitting located on the left side of the machine base. Wipe off excess grease before operating. **Do not over apply grease.**

# Performing a Sieve Analysis using the **DuraTap™** Testing Sieve Shaker

- 1) Complete installation of the DuraTap™ Testing Sieve Shaker per instructions.
- 2) Plug device into the proper power source (be sure that voltage and cycle requirements are observed).
- 3) Prepare the material sample to be tested using industry-specified sampling and preparation procedures.
- 4) Select the sieves for the analysis.
- 5) Assemble the sieve stack, (coarsest sieve at the top, finest at the bottom) with bottom pan.
- 6) Pour the sample to be tested onto the top sieve. Install a standard sieve cover to prevent sample loss.
- 7) Place the spun sieve cover with cork from the DuraTap™ on top of the assembly.
- 8) Swing the hammer arm up past vertical until it comes to rest.
- 9) Slide the sieve stack assembly into the DuraTap™.
- 10) Adjust the height of the sieve stack assembly and sieve support plate per instructions.
- 11) Bring hammer arm back down into place over the sieve cover.
- 12) Set the timer for the desired test interval.
- 13) Upon completion of the test interval, the unit will switch off automatically.
- 14) Swing the hammer arm up past vertical until it comes to rest.
- 15) Remove the sieve stack assembly, and proceed to weigh-up the retained fractions.

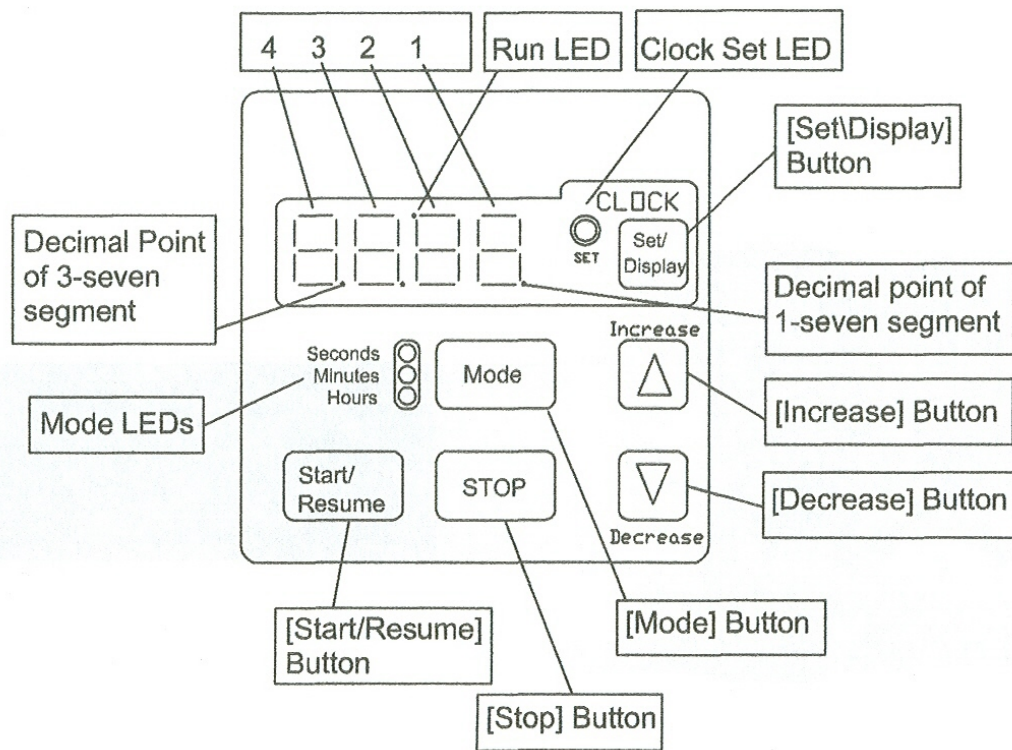
# Electronic Timer

In an effort to make our products even more responsive to needs of the users, the DuraTap™ Testing Sieve Shaker now features a digital timer, with greater reliability and precision than most conventional mechanical timers.

## Digital Timer

The timer controls the cycle time of the sieving operation, as well as functioning as a 24-hour clock. The timer and clock setting procedure are described below.

Minimum operating time is 2 seconds, maximum 99 minutes 59 seconds.



1. After applying an appropriate AC to the power input terminals, the display will be blank and the beeper will beep for  $\frac{1}{4}$  second giving the user notification that the timer is now activated. The units' default is in Minute [Mode].
2. **Setting Time of Day** - Push and hold the button [SET/DISPLAY] for 1 second, the unit will default the time to 12:00am and enter the 'Clock Set' mode. While in this mode, buttons [MODE], [STOP] & [START/RESUME] are disabled and the clock set LED will be turned ON. The user now can set the time by pressing and holding either [INCREASE] or [DECREASE] button until the desired time is achieved. If you do not wish to set the time of day, skip step number 3.



The clock mode is a 12-hour with an am/pm display element. When the clock is being displayed and the clock is in the pm time frame, the decimal point of number 1-seven segment will be ON. Once the user has achieved the proper clock value, they need to exit the clock set mode by pressing and holding the button [SET/DISPLAY] for 1 second. After the 1 second, the beeper will beep for 1 second giving the user notification that the mode is now exited. Once the clock is set, the display will go blank and the clock set LED will turn OFF.

If the clock has been set and the user presses the button [SET/DISPLAY] for less than 1 second, the display will show the current time for a 5 second period and revert back to what was previously on the display.

3. **Setting Interval Timer** - In modes 1 – 3, the device functions as a simple countdown timer. When you set the value, press the button [START/RESUME]. When the value reaches 0, the relay is turned OFF and the beeper beeps 6 sets of 2 (250ms) beeps.

Repeat Feature- the timer will remember the last time set. If you desire to change the setting from the original setting, press start switch to recall previous setting then input new setting.

To enter one of the 3 countdown modes, press and hold the button [MODE] for 1 second. Holding down this button the mode will switch every 2 seconds. Each time the mode switches, the appropriate LED of mode LEDs will be turned ON and the value displayed will change to the modes default value. An audible ¼ beep will also be heard.

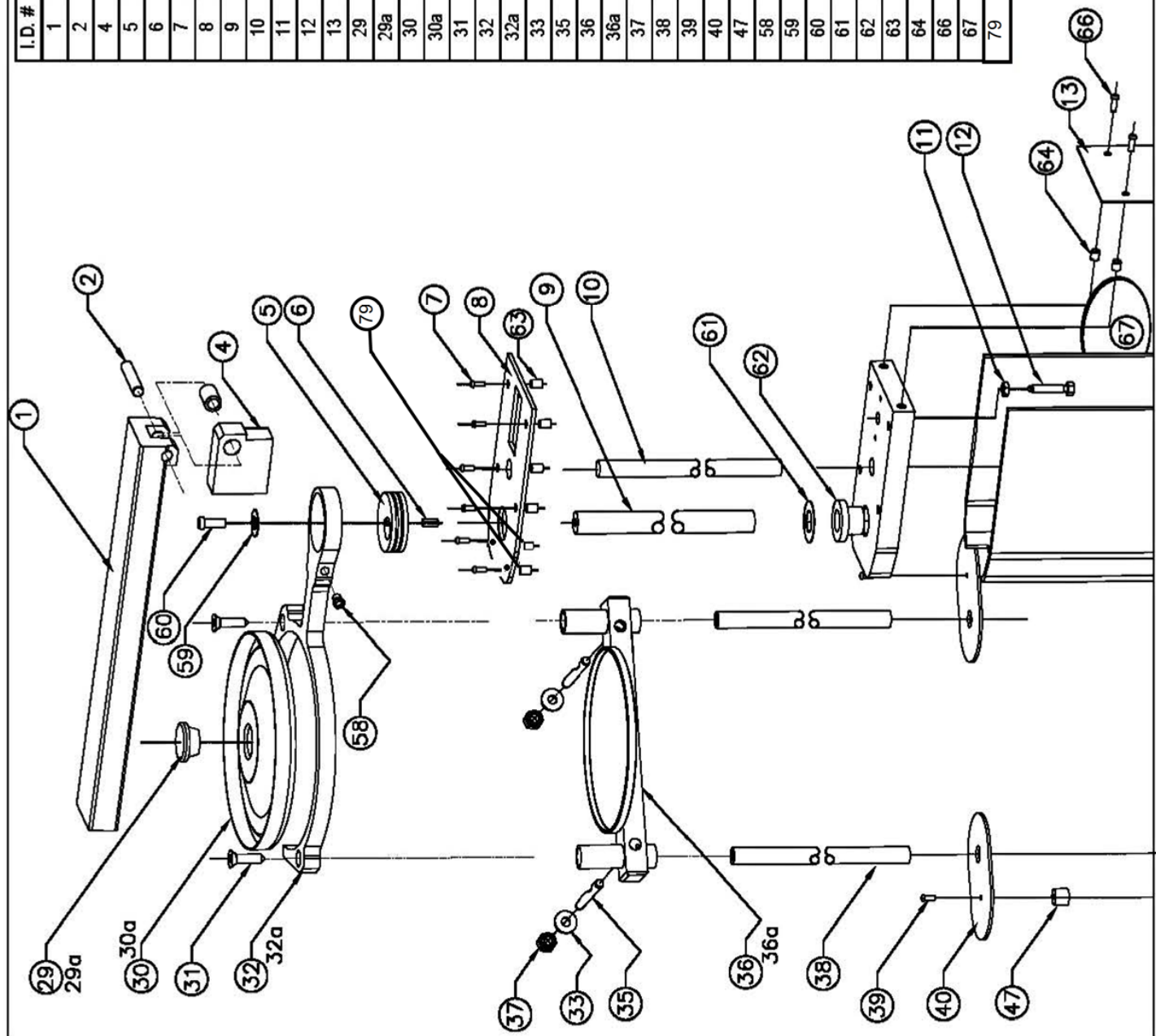
Mode 1	0 – 99 second:	DEFAULT DISPLAY = 01
Mode 2	0 – 99 minute:	DEFAULT DISPLAY = 00.00
Mode 3	0 – 99 hour:	DEFAULT DISPLAY = 00.00

Once the countdown value has been set, you can now start the timer by pressing the button [START/RESUME]. The relay is turned ON. While the timer is counting down the user can stop the event by pressing the button [STOP]. The current countdown value will remain on the display. If you want to resume the session you just need to press the start button again. Counting will proceed from the point where stopped. During this operation, the run LED is blinked at once a second.

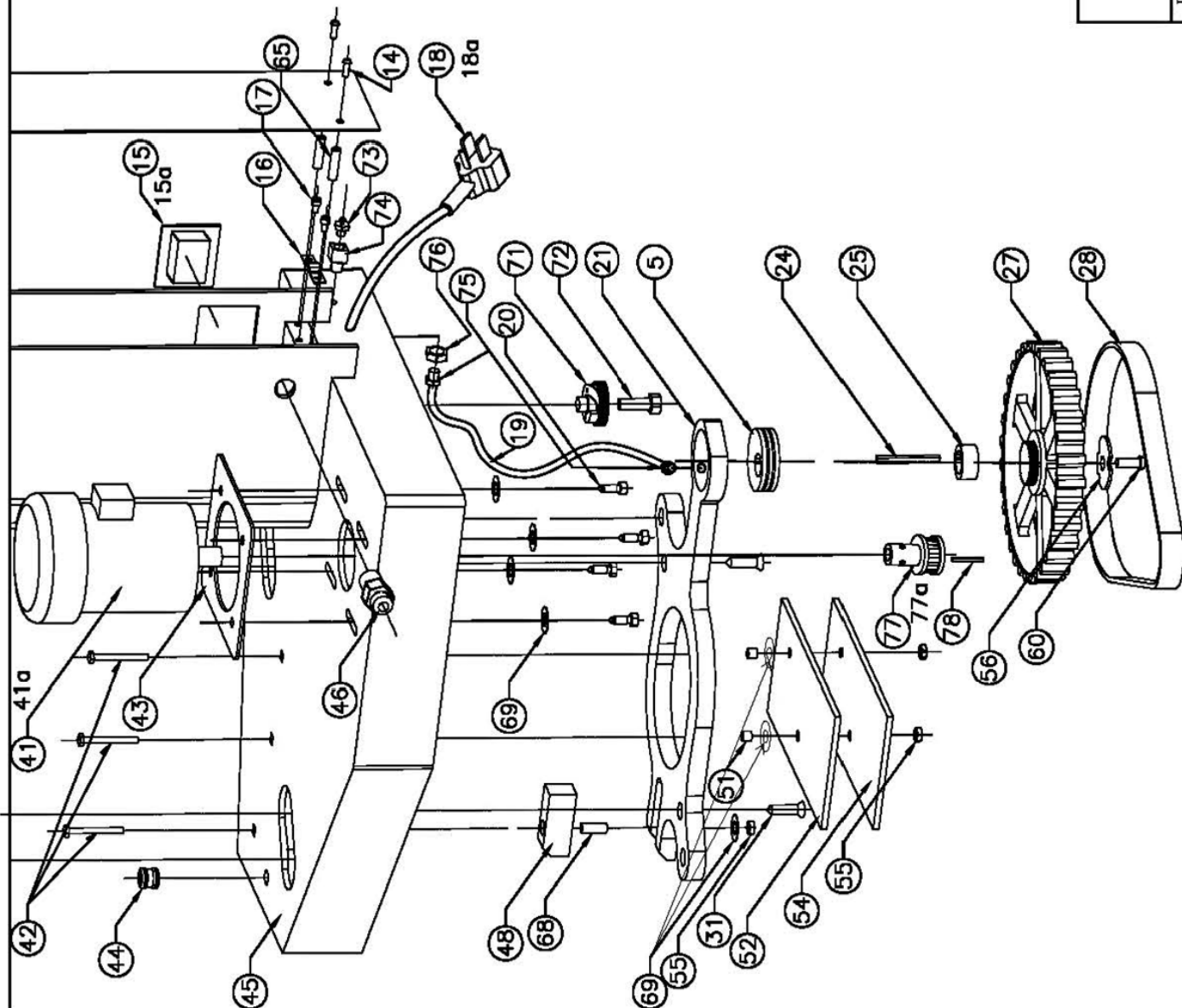
Once the timer has counted down to 0 and stopped, you can execute the same session (time value) by pressing the [START/RESUME] button again. This will recall the timer value and display it. At this point, you have two options. The first being the ability to change the value by using the [INCREASE] or [DECREASE] buttons and the second being the ability to use the same value and starting the event again by pressing the [START/RESUME] button.

#### **For More Information...**

For recommendations on sampling procedures, sample size, sieve selection, calibration, test intervals, sieve care and cleaning and related topics, please see Advantech Manufacturing publication R1986AS, *Test Sieving: Principles and Procedures*. Please contact your local Advantech Manufacturing representative, Advantech Manufacturing, or order directly from our website [www.advantechmfg.com](http://www.advantechmfg.com).



I.D. #	P/N	Description	Qty.
1	BA 103	Hammer Arm	1
2	MA426	.500" Dia. X 2.50" Dowel	1
4	BA 104	Hammer Hinge Block and Bushing	1
5	DA211	Eccentric	2
6	MA408	Keystock 1/4" x 11/16"	1
7	MA505	1/4"-20 x 1-1/2" Screw	6
8	BA 112	Top Cover Plate	1
9	DA 212	Main Shaft	1
10	DA 205	Hammer Lift Rod	1
11	MA424	1/2" Lock Washer	1
12	MA414	1/2"-13 x 1-3/4" Hex Head Cap Screw	1
13	BA 109	Rear Cover Plate	1
29	BA 115	Rubber Plug	1
29a	BA 116	Cork Plug	1
30	BA 106	Sieve Cover 8" Configuration	1
30a	BA 119	Sieve Cover 12" Configuration	1
31	MA422	3/8"-16 x 1" Flat Head Socket Cap Screw	4
32	BA 102	Yoke for 8" Configuration	1
32a	BA 120	Yoke for 12" Configuration	1
33	MA503	Washer 1-1/16"OD x 1/2" ID x .093 Thick	2
35	MA404	Sieve Support Plate Lock Screw	2
36	BA 132	Sieve Support Clamp Assembly 8" Config.	1
36a	BA 122	Sieve Support Clamp Assembly 12" Config.	1
37	MA420	1/2"-13 Nylon Insert Locknut	3
38	DA 206	Stack Carriage Upright	2
39	MA411	#10-24 x 1/2" Socket Button Cap Screw	2
40	BA 110	Base Cover Plate	2
47	MA405	Grommet	2
58	MA 103	1/4-28 Zerk Fitting (Grease Fitting)	1
59	MA402	Washer 1-1/4"OD x 5/16" ID x .060 Thick	1
60	MA410	Button Head Screw 5/16"-18 x 3/4" Long	2
61	MA430	Shim - 1.50"OD x 1.00" ID x .02 Thick	1
62	DA215	Flange Bearing	2
63	MA506	Neoprene Spacer 3/4" x 1" Ig	4
64	MA506	Neoprene Spacer 3/4" x 5/16" Ig	2
66	MA509	1/4"-20 x 1/2" Button Head Screw	2
67	ZN9980	Oval Name plate	1
79	MA510	Neoprene Spacer 1/2" x 1-1/8"	2



I.D. #	P/N	Description	Qty.
14	MA504	1/4"-20 x 2-1/4" Button Head Screw	2
15	X327631A	Timer 120V 50/60Hz	1
15a	X327631B	Timer 220V 50/60Hz	1
16	MA406	Cable Clamp	1
17	MA418	1/4"-20 x 3/8"Socket Cap Screw	2
18	EA306	Line Cord 110 Volt Configuration	1
18a	EA307	Line Cord 220 Volt Configuration	1
19	MA435	Tubing for Grease	1
20	MA415	3/8"-16 x 1" Hex Head Cap Screw Grade 5	4
21	DA201	Lower Carriage Plate	1
24	MA407	Keystock 1/4" x 2-3/4"	1
25	DA208	Timing Pulley Collar	1
27	DA203	Timing Gear Assembly	1
28	DA219	Timing Belt	1
41	EA302	Motor 60 Hz	1
41a	EA303	Motor 50 Hz	1
42	MA413	3/8"-16 x 2-3/8" Carriage Bolt	3
43	BA111	Adaptor Plate	1
44	BA114	Rubber Grommel	2
45	BA101	Tower & Base Assembly	1
46	EA305A	Conduit Fitting	1
48	BA105	Stationary Block	1
51	DA218	Spacer	2
52	DA209	Support Plate Upper	1
54	DA210	Support Plate Lower	1
55	MA419	3/8"-16 Hex Nut, Nylon	3
56	MA437	Notched Washer 1-1/4 OD x 5/16 ID x .060"	1
65	MA506	Neoprene Spacer 1-11/16" Long	2
68	DA217	Bushing -1-1/4" Long x 5/8" Diameter	1
69	MA427	Washer - 1.0"OD x 3/8" ID x .06" Thick	7
71	DA202	Cam Gear Assembly	1
72	MA401	Cam Screw	1
73	MA104	Grease Fitting 1/8" NPT	1
74	MA101	Bulkhead Fitting	1
75	MA105	Compression Fitting	2
76	MA101A	Bulkhead Fitting Nut	1
77	DA213	Drive Pulley 60 Hz	1
77a	DA214	Drive Pulley 50 Hz	1
78	MA409	Keystock, 3/16" x 1-1/2" long	1

### DuraTap Assembly

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# Test Sieving: Principles and Procedures

*A Discussion of the Uses, Capabilities, and Limitations of Testing Sieves as Analytical Tools*



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# Foreword

*Through ASTM and many industry organizations, standards have been established for particle size for powder, granular and larger sized materials. This manual has been prepared to help guide users of test sieves through the proper procedures as well as provide many additional tips that can enhance the existing procedures.*

*Our aim is to provide assistance to both the experienced and non-experienced particle technologist in developing comprehensive particle size test results, reduce test variations and enable the user to isolate and identify sources of error or variations in the data.*

*Advantech Test Sieves, manufactured in the U.S.A., are the most accurate test sieves available in the world today. The use of Advantech Test Sieves will provide more precise and reproducible data, resulting in better product control and a possible reduction of variables.*

*In preparing this manual, we have drawn from sources in the ASTM publications, ISO Standards and various papers written by some of the most renowned figures in the particle technology world. Additionally, Advantech personnel have contributed sieving technology developments after having logged numerous years of "hands-on" experience with many experts in the field. The result is a melding of standards, research and opinion to provide a solid foundation for your own particle size analysis program.*

*If additional help is desired in establishing your sieve analysis procedure, or if you desire a list of suppliers of the equipment highlighted in this manual, please contact **Advantech Manufacturing, Inc. 2450 S Commerce Dr., New Berlin, WI 53151***

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## CHAPTER 1

# WHAT IS SIEVING?

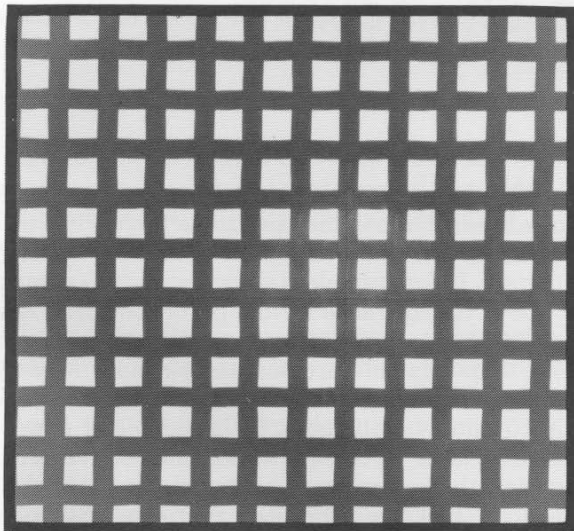
A simplistic definition of sieving is the separation of fine material from coarse material by means of a meshed or perforated vessel. Professor Terence Allen characterizes sieving as "The aperture of a sieve may be regarded as a series of gauges which reject or pass particles as they are presented to the aperture." <sup>(1)</sup> This theory was actually in practice during the early Egyptian era as grains were sized with 'sieves' of woven reeds and grasses.

The level of sophistication increased with the rise of the industrial revolution and the need for more sophisticated methods for classifying material by their particle size. As requirements for sized material rose, technology in producing uniform sieving media increased. Woven wire cloth was introduced as an alternative, providing greater accuracy and durability. At present, this woven cloth is available in a range of sizes from 125 mm (5") openings to 20 micrometer openings.

All mesh sizes are covered by both national and international standards.

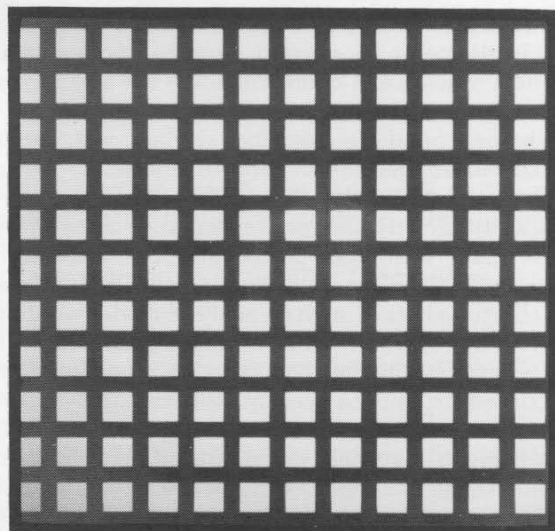
The need for particle size analysis in the finer size ranges (i.e. 38 micrometers and less) prompted the development of the electrodeposited sieve. These sieves, sometimes called electroformed or micromesh, are currently being produced with openings as fine as 3 micrometers. The mesh openings are extremely uniform in both size and shape and maintain exacting tolerances.

While the technology related to sieve analysis has come a long way since the reed sieves of ancient Egypt, few new developments have come along since the 1940's. Professor Kurt Leschonski wrote "Sieve analysis is one of the few methods of particle size analysis which has escaped modernization." <sup>(2)</sup> While the modernization has not come in the actual hardware of sieving, refinements in the application and utilization of existing equipment has proceeded.



**WOVEN SIEVE CLOTH**

*Variations in opening size and shape are common.*



**ELECTROFORMED SIEVE CLOTH**

*Electrodeposited material showing uniformity in opening size and shape.*



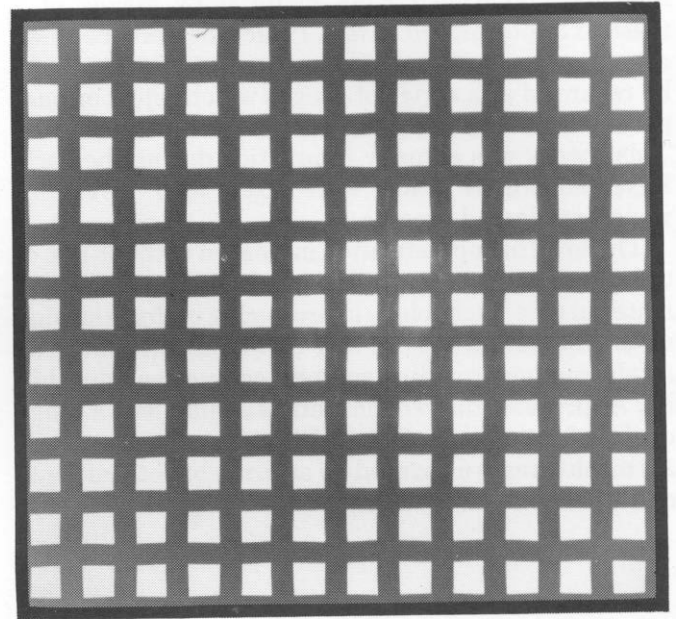
## CHAPTER 2

# USES, LIMITATIONS AND ADVANTAGES

Harold Heywood wrote "I often refer to sieving as the 'Cinderella' of particle size analysis methods; it does most of the hard work and gets little consideration."<sup>(3)</sup>

There are numerous reasons for the selection of high quality testing sieves as a first choice in particle size analysis work. Leschonski said "... because of its simplicity - everyone immediately understands the purpose of a stack of sieves and its operation -and its inexpensive- ness."<sup>(4)</sup> Standard sieve analysis is probably the fastest and most widely used quality control procedure in any powder process control industry. Used frequently as a mediating device between the production and sales divisions of a process corporation or between the sales force and the customer, test sieve analysis work enjoys the universal recognition of being the best 'quick and dirty' test procedure for rapid particle size distribution data. The outcome of the analysis is easily calculated and interpreted for comparison between laboratories. Start-up cost to institute a basic sieving quality control program is minimal, and operators at most levels of training are capable of performing a successful sieve analysis. With these factors in mind, it is easy to see why testing sieves are as ubiquitous as they are in industry. Materials from crushed ore chunks of over 114.3 mm (4 ½") in diameter to slurred alumina and porcelain powders of less than 20 micrometers are all analyzed with test sieves on a regular basis.

Whether hand or machine sieving, wet or dry preparations, analysis or production work, testing sieves have found a niche in the quality control laboratory. Given this overall acceptance of test sieves as a viable analytical device and the widespread presence of the sieve in laboratories of all industries, any shortcomings of such an analytical device would be magnified. For all of the advantages available to the test sieve user, limitations must be recognized



**CLOTH WITH WIDE MESH VARIATIONS**

*Alternating areas of narrow and wide mesh openings can significantly change sieve analysis results.*

and accounted for in the presentation and analysis data.

Test sieves are individuals. Being fabricated of a woven mesh material, variations in the weave are common. The chances of locating two sieves with an identical distribution of opening sizes are extremely remote. Due to these variations, the reproducibility of test results between sieves can be adversely affected. The stringent standards imposed by ASTM, ISO or other regulating bodies have established tolerance factors which allow for the permissible variations in the weave while striving to maintain a level of uniformity in the performance of the 'test grade' sieve cloth. (See Table 1)

With this variation of opening sizes present, some smaller than the nominal and some larger, the time interval of the sieve analysis becomes extremely important. If, for example, a sieve has several openings far above the nominal opening size for the particular mesh size,

and the test is run for 30 minutes, the probability of larger-than-nominal particles finding those oversized openings is much greater than if the test was run for only 15 minutes. Similarly, if the sample of powder contains a large percentage of elongated or needle like particles, a longer test interval would provide a greater likelihood that the elongated particles will orient themselves 'on end' and pass through the openings. If the sieving cloth has a wide range of opening sizes, the sieving of this type of material has a compounded error.

Another factor which must be considered is the reaction of the material to ambient conditions. The most accurate test sieve available would be of minimal use if the relative humidity in the test lab was 99%. Extremely dry conditions can cause fine powders to adhere to the sieve

components and each other with strong electrostatic charges. Additional types of sieving problems are discussed in the glossary section.

To minimize error caused by wire cloth variation, steps must be taken at every stage of fabrication that will assure the uniformity of the woven mesh as well as the compliance with the applicable standards. Both the weaver and the test sieve manufacturer must maintain a constant monitoring program measuring the actual opening sizes of the wire cloth as well as the uniformity of those openings. The loss to the manufacturers in rejected out of specification sieve cloth is a gain to the end-user in uniformity and compliance.



#### **COMPARATOR**

*Profile projector specially designed and built for wire cloth and sieve inspection.*

## CHAPTER 3

# GLOSSARY OF SIEVING TERMINOLOGY

Sieving terminology is frequently used and abused in writing specifications for materials. Listed below are some of the most frequently used terms and a general discussion of their meaning:

**Agglomerate:** natural tendency of materials to clump or ball together. This condition is very common in materials with high moisture, fat or oil content or those with fibrous or extremely irregular topography.

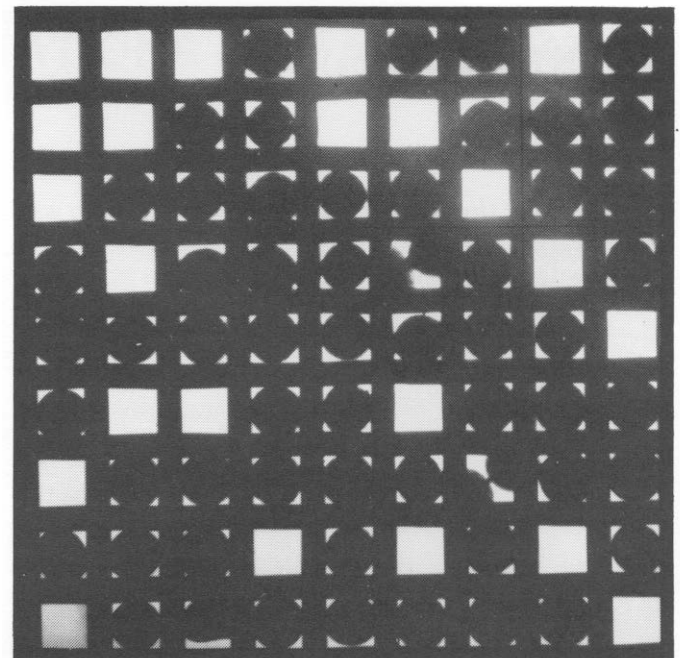
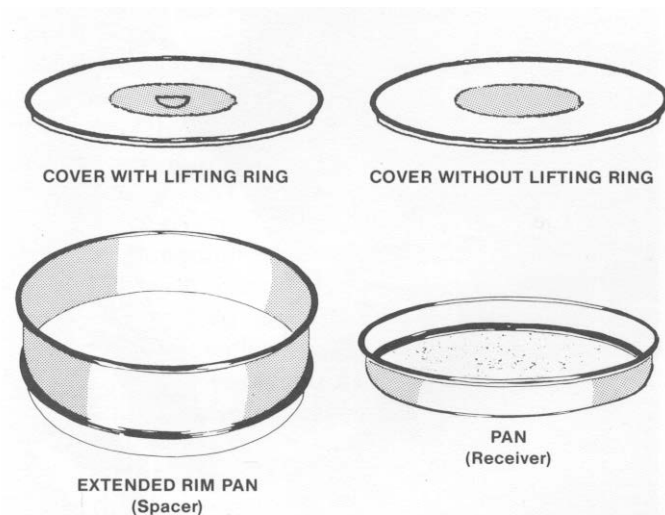
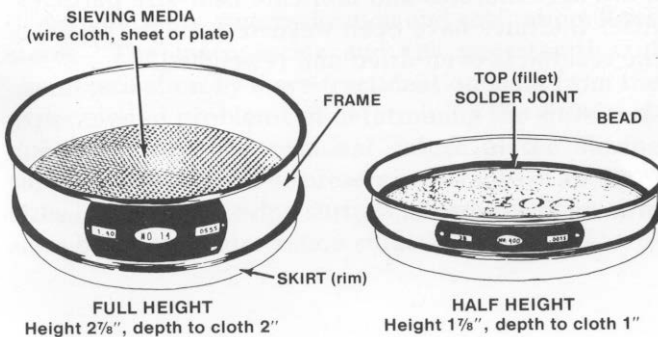
**Blinding:** plugging of the screen openings with particles either exactly the same size as the sieve opening or by fine particles

which build up on the wire mesh and eventually close off the openings. Frequently referred to as pegging. (Photo Page 4)

**Cover:** stamped or spun lid that tightly covers the top of a sieve to prevent the loss of the material sample during sifting or mechanical agitation.

**Electrostatic charges:** accumulation of electrical charges on the particles and sieve components causing clinging, agglomeration or blinding. This condition is frequently seen in hydrocarbon-based materials, plastics, reactive metals, paint pigments and powders with a large fraction finer than 20 micrometers.

**Extended rim pan:** a sieving pan with a skirt designed to nest within a sieve stack, allowing multiple tests to be performed simultaneously. Frequently called a nesting pan or spacer.



**BLINDED SIEVE**

*Spherical and near-size particles can blind or peg in the sieve openings.*

**Flow additive:** powdered substance added to the sample to reduce agglomeration, neutralize static charges and improve the flow characteristics of the sample. Common additives are fine silica, activated charcoal, talc, and other commercially produced natural or synthetic substances. Generally, the additive is pre- screened to a known average particle size, blended with the sample (approximately 1% additive by weight) and then screened with the additives value removed from the reported data.

**Frame:** a rigid sidewall used to form the body of the testing sieve. Common depths are 50.8 mm (2" full height) for 8" sieves and 25.4 mm (1" half height). Special application sieves of other depths are also in use.

**Mesh:** screening medium with openings of uniform size and shape made of woven, punched or electrodeposited material.

**Pan:** stamped or spun receiver of materials passing through the finest sieve.

**Skirt:** section of test sieve below the sieve mesh that allows for mating or nesting of the sieves in a test stack.

**Support mesh:** coarse sieve cloth mounted under fine sieve cloth in a test sieve to provide extra strength. This is widely used in wet sieving operations to protect the fragile fine sieve cloth. Frequently called backing cloth or rolled backing cloth.

**Test Sieve:** screening medium (mesh) with openings of uniform size and shape mounted on a rigid frame, usually for laboratory testing or small scale production applications. The frames can be made of various materials, the most common of which are brass and stainless steel in a cylindrical configuration, having a diameter of 3", 5", 6", 8", 10", 12" or larger.

**Wet sieving:** the separation of fines from the coarse portion of a sample while suspended in an aqueous solution introduced to a testing sieve. The liquid medium is used to negate static charges, break down agglomerates and lubricate near-size particles. After the fines have been washed through the sieve, the residue is oven-dried and re-weighed.

## CHAPTER 4

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### SIEVE SPECIFICATIONS

#### -Domestic and International

The U.S. Standard Sieve Series is a metric system based series first suggested by the American Society for Testing and Materials in 1913. The opening sizes in this sieve series are in the ratio of the fourth root of two. This numerical relationship was first suggested by Professor P .R. Rittinger, a German researcher, in 1867.

In the fourth root of two series, every opening size is 1.189 times the opening size of the next smaller sieve. This

relationship continues into sieve opening area measurement. The U. S. Sieve Series provides that the area of each sieve opening size is 1 1/2 times the area of the preceding sieve size.

By using every other sieve in this number series, the relationship becomes based on the square root of two (1.414), with the area of the opening being twice that of the preceding sieve size. Thus, by skipping two sizes, you create an area ratio

of 3 to 1, or by skipping three sizes, you create a ratio of 4 to 1.

When selecting sieves from this series, any number of sieves can be used for an analysis. Care must be taken in selecting each sieve between two points, every other sieve, every fourth sieve, etc., to keep within the mathematical progression of the series.

After World War II, the International Standards Organization (ISO) was formed in an attempt to establish world standards. Though the U.S. Sieve Series had proven to be effective and was in use throughout the world, members of the ISO would not accept the U.S. Sieve Series as a world standard. The ISO chose to adopt the Preferred Number Series based on the roots of ten. The Preferred Number Series

was suggested by Charles Renard of France in 1879. His system is based on the tenth, twentieth and fortieth roots of ten (designated R-10, R-20 and R-40). See Table 2.

A compromise was reached between the ISO and the proponents of the U.S. Sieve Series when it was discovered that every third value in the R-40/3 table is in a step ratio of 1.1885, sufficiently close to the fourth root of two (1.1892) used in the U.S. Sieve Series. In 1970, slight adjustments were made in the U.S. Sieve Series to align the series perfectly with the ISO specifications.

Copies of these tables of specifications can be found in Table 3.

## CHAPTER 5

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### SIEVE CALIBRATION PROCEDURES

Quantifying and accounting for variations in test sieve results have become two of the most important topics in particle technology today. Once again, the ubiquitous nature of stacks of test sieves in powder labs around the world has contributed to the scope of the dilemma in sieve standardization and calibration. Kaye states "The inaccuracies and the uncertainties of characterization by sieve fractionation arise from the experimental problems of determining the sieve residues and from the non-ideal nature of the sieving surfaces." Further, "The presence of a range of aperture sizes in any real sieving surface is a source of error in sieve based characterization studies since the theoretical or nominal size of the sieve is taken to be the boundary limit for the sieve residue." <sup>(5)</sup>

Not only is the test sieve user plagued with variations in the weave of the cloth, but also confronted with the effects of

particle shape on sieving results. Nearly 50 years ago, A.M. Gaudin wrote, "Powders with identical size distributions, densities and chemical composition may behave quite differently as a result of variations in particle shape between samples. For example, powders consisting solely of spherical particles are likely to have good flow properties, while powders containing needlelike particles will not." Further, "In addition, it is impossible to isolate the concepts of particle size and shape, since the method of size measurement will influence the particle size which is determined." (6)

Numerous approaches have been tried to compensate for the effects of variations in wire cloth and particle shape. The methods have fallen into 3 basic categories: 1) inspection of the mesh to determine opening size, 2) material testing of the sieves to determine if sieves fall within performance specifications, and 3) a

combination of methods 1 and 2, assuring compliance with both opening size and performance specifications.

Probably the most elementary of the inspection methods is the use of the etched glass slide. This procedure relies on what is referred to as the 'Moire Effect', which compares the number of wires per inch in the wire cloth sample to the number of lines per inch etched on the glass slide. By microscopically measuring the wire diameters, a rough estimate of the opening size can be approximated. One major short-coming of this procedure is the assumption that all wire diameters within the sample are the same. A slight variation in wire diameter can translate to a significant change in opening size.

An alternative to this measurement approach is the use of a high-powered optical comparator or profile projector. In this method, powerful light sources illuminate the mesh from both above and below and project the image onto a glass screen. Calibrated micrometer stages move the mesh sample in relation to a reference point allowing measurements with an accuracy of 1 micrometer to be made on both the opening and wire diameter. The results are displayed on a numerical readout. The broad field of view of the comparator allows for the scanning of a large number of sieve openings, facilitating a more comprehensive picture of the nature of the sieve cloth.

In the material testing of sieves, powder samples are run on subject sieves and the residue calculated. These values are then compared with other sieves in selecting what are often referred to as 'matched' sieves. There are a number of shortcomings in this procedure also. The first and foremost problem encountered is that of compliance. Conceivably, it is possible to find hundreds of sieves that will provide the same performance data when tested with a reference material and still not meet ASTM standards.

While the sieves perform comparably, they do not meet the basic criteria of ASTM

specifications, which should disqualify them from use as a U.S. Standard Testing sieve. Another problem encountered with material matching is the use of reference samples that are different in shape, size or density than the users' products. For example, a manufacturer of spherical steel shot would yield significantly different results on a sieve that had been matched with an angular ground silica material. In this case, both shape and density are considerably different. The key to proper matching is using the end-users own product or a material that approximates the product most closely.

The final approach is a combination of the first two methods. First, the sieve is inspected optically for compliance with all applicable standards. Openings and wire diameters are measured, not averaged. After the sieve opening distribution has been characterized and evaluated, actual material testing can begin. During the material testing, samples of the user's product are used for the standardization procedure. All tests are run for repeatability and the variation between test results calculated. This procedure yields a testing sieve with known values in the two most essential parameters compliance with specifications and performance under duplicate test conditions.

An alternative that has been used with some success is the use of correction factors between sieves. Once a 'master set' of sieves has been established, a reference sample is tested on the stack. The values are calculated and retained. As new sieves are acquired, the original reference sample is tested on the new set and the values calculated. Any variations between the sieve stacks can be compensated for with correction factors or multipliers. For example, a sieve in stack 3 may retain more or less than the comparable sieve in the master set. A multiplier of magnitude greater than or less than 1 is necessary to calculate the comparable retention value on that sieve when compared to the master set. In this way, every sieve in use can be compared to the master set to standardize

sieving results. Whatever method you use, it is essential that your starting point is based on ASTM specifications. This

compliance is necessary to assure uniformity between and within industries.

## CHAPTER 6

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# PERFORMING THE SIEVE ANALYSIS

In obtaining meaningful sieve analysis data, six major steps are recommended. 1) Obtain a representative sample of the material to be evaluated. 2) Prepare the sample for evaluation; this may involve washing and/or drying the sample. 3) Reduce the sample to a size suitable for the sieve analysis procedure. 4) Perform the actual sieve analysis procedure. 5) Compute the data and convert the data into a usable format. 6) Organize the data and assemble the information for presentation.

Granular and powder materials are prone to segregation during movement and storage of the products. This segregation can be due to the disparity of the particle sizes and the varied densities for blended products. When forming a stockpile of material, the larger, coarser particles are heavier and tend to roll to the lowest portion and outer perimeter of the cone. The finer particles are lighter and more angular and remain concentrated at the top and through the vertical center of the cone. Obtaining samples from only the outer perimeter or from the top of the cone would not provide a sample which would be representative of the entire batch.

Sample extraction and preparation is the most commonly overlooked variable in sieve standardization programs. Testing bias can be added at many places along the progression from the raw materials received from a supplier, samples taken at each stage of production, sample reduction procedures and samples when the product is ready for shipment to the customer. The way the samples are extracted from the original bulk volume varies with the way the materials are received, produced or stored. The ideal sampling method is one which provides the most representative sample with the least amount of material required.

The following paragraphs were first published in the ASTM technical publication STP 447 A. The collaborative efforts of the authors have produced a section on sampling technique which will aid in obtaining representative test samples from larger test sources...<sup>(7)</sup>

### Sampling from a chute or belt

Accuracy in sampling is obtained where material is flowing from a chute or belt conveyor. The ideal place to collect the sample is where the material drops from the chute or belt. If the material stream is small enough, use a pail or other suitable receptacle which can be swung completely across the flowing stream in a brief interval of time and with uniform movement. The sampling receptacle should not be allowed to overflow, because the overflow would tend to reject a higher proportion of the larger particles that exist in a representative sample. Mechanical sampling devices are available for selecting samples automatically from a stream at uniform time intervals.

### Sampling from carload shipments of coarse bulk material

For coarse materials, such as crushed stone and gravel, shipped in railroad cars, a recommended method is to dig three or more trenches at least 30.48 cm (1 foot) deep and approximately 30.48 cm (1 foot) wide at the bottom. Equal portions are taken at seven equally spaced points along the bottom of the trench by pushing a shovel downward into the material and not by scraping horizontally. Samples from trucks, barges, or boats should be taken in the same manner as from railroad cars, except that the number of trenches should be adjusted to the size of the transportation unit and tonnage involved.

### **Sampling from carload shipments of fine bulk materials**

One established method for sampling a carload of bulk granular material is to take eight equal samples, (approximately 700 to 1000 grams each) from the bottom of a 30.48 cm (1 foot)) conical excavation. Samples should be suitably spaced to represent the length and width of the car and then combined into a single gross sample.

### **Sampling bulk shipments of fine material with a sampling tube**

An alternate and simpler method of sampling a carload, or other bulk quantity of fine or granular material is by use of a sampling tube which, for this purpose, should be 38.1 mm (1 1/2 inches ) by approximately 1.829 m (6 feet ). Five or six insertions of the tube will produce approximately, a 2 pound (907g) sample.

### **Sampling from a carload of bagged material**

One method of sampling a carload of material shipped in bags is to select, at random, a number of bags equal to the cube root of the total number of bags in the car and to take suitable portions (800 to 1000 grams for minus 6 mm material) from each of the selected bags for a combined gross sample.

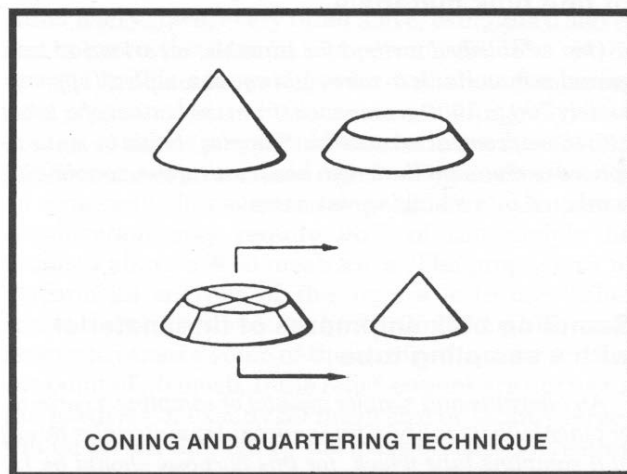
### **Sampling from a pile**

In sampling from a pile, particularly material like crushed stone or coal containing large particles, it is extremely difficult to secure samples that are truly representative. At the apex of a conical pile, the proportion of fines will be greater, while at the base; the percentage of coarse particles will be greater. Therefore, neither location will be representative of the whole. In a shoveling process, every fifth or tenth shovel, etc., should be taken depending on the amount of the sample desired. The sample should consist of small quantities taken at random from as many parts of the pile as are accessible and taken in a

manner that the composite will have the same grading as the larger amount.

### **Reduction of gross sample to test size for sieve analysis**

After the gross sample has been properly obtained, the next step is to reduce it to a suitable size for sieve analysis without impairing in any way the particle size distribution characteristics of the original sample. This phase of the operation should follow the applicable procedures described in the succeeding sections and should be performed with as much care as was used in the collection of the gross sample and in performing the sieve test.



### **Coning and quartering**

Pile the gross sample in a cone, place each shovel full at the apex of the cone, and allow it to run down equally in all directions. This will mix the sample. Then spread the sample in a circle and walk around the pile, gradually widening the circle with a shovel until the material is spread to a uniform thickness.

Mark the flat pile into quarters, and reject two opposite quarters. Mix again into a conical pile, taking alternate shovel-fulls from the two quarters saved. Continue the process of piling, flattening, and rejecting two quarters until the sample is reduced to the required size.



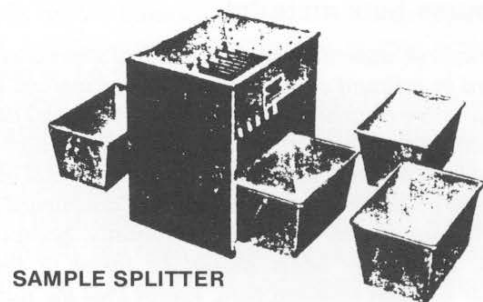
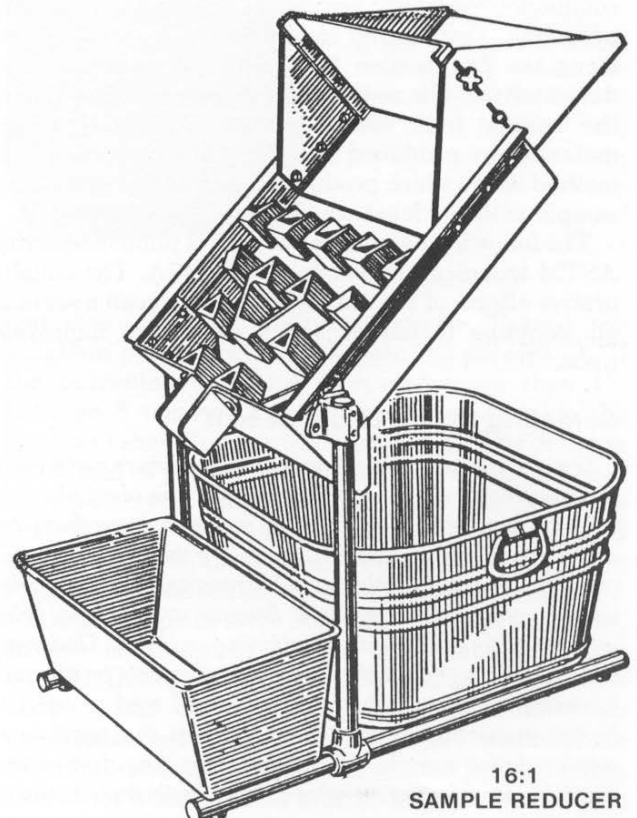
## Sample splitters and reducers

Gross samples, if not too large, may be reduced to test sample size by one or more passes through a sample splitter or Jones type riffle, which will divide a sample in half while maintaining the particle size distribution of the original sample. By repeated passes, the sample can be split into quarters, eighths, and so on until the size of the sample desired is obtained. For larger gross samples, sample reducers are available which will select a representative 1/16 part with a single pass. After just two passes through such a unit, a representative one pound sample can be obtained from an original 256 pounds. Three passes will give a one pound sample from two tons of material. Always make sure that the passages in the splitter or reducer are at least three times the size of the largest particle in the sample. Do not attempt to arrive at exactly the amount of material specified for the test. If a 50 gram sample is desired, arrive as near to this amount as practicable, because it will make no difference in the test percentage results whether the sample is slightly larger or smaller. In attempting to arrive at an exact weight, the tendency is to discriminate by the removal of sizes that are not representative of the whole, thus destroying the representative quality of the sample.

## Size of Sample in the Test

There is a natural tendency, although incorrect, to use an excessively large sample in the test. In most cases, a smaller sample will provide a more accurate analysis. Beware, however, that the more you split, the greater the chance of error. Testing sieves are a go or no go gauge; if the sample is too large it will not permit each of the particles an opportunity to present themselves to the screen surface. Often the limiting factor for reducing the sample size is the accuracy of the weighing device used to determine the amount of material retained on the sieve.

Generally a 25 to 100 gram sample is recommended. However, if it is necessary to establish the correct sample size, utilize the following procedure: Using a sample splitter, reduce samples to weights (i.e. 25, 50, 100, 200 grams). Analyze these



various sample sizes on a selected nest of sieves for a period of five minutes preferably using a mechanical sieve shaker. If the test with the 100 gram sample shows approximately the same percentage passing the finest sieve as the 50 gram sample, whereas the 200 gram sample shows a lower percentage, this would indicate that the 200 gram sample is too large and the 100 gram samples would be satisfactory. Then run the 100 gram sample on the same set of sieves for the same time period to see if repetitive results are obtainable.

A useful table of recommended sample sizes for tests with 200 mm or 8" diameter sieves is presented in Table 4. Note that the table gives sample sizes listed by volume. Recommended sample weights in grams can be determined by multiplying the values in Column 3 and 4 by the bulk density (grams per cubic centimeter) of the material to be tested rounded out within a reasonable tolerance. If the actual bulk density of a certain material is not known, the typical density factor for the most nearly similar material listed in Table 5 may be used.

To perform the actual sieve analysis, sieves should be chosen in a sequence as described earlier. Use every sieve, every other sieve, or every third sieve, etc. between the desired size parameters. The use of sieves in this sequential order will allow for better data presentation and a more meaningful analysis of the test results. Care should also be taken in selecting the proper sieves to avoid overloading any sieve with an especially large material peak. For example, a specification may require 96% of the sample be retained above a #50 mesh sieve. The proper way to perform an analysis of this nature is to use 'relief screen', that is, sieves in the 30, 35, 40 and 45 mesh ranges to remove some of the burden from the critical cut point of 50 mesh. If the relief sieves are not used, the particles of exactly 50 mesh size or slightly larger may become wedged in or forced through the sieve openings by the mass of material resting above them. Large concentrations of material on one sieve reduce the opportunity for near sized material to pass through the sieve resulting in a larger portion of the material retained on the test sieve. The sieve cut point would be inaccurate and the sample would not meet the specifications for the test.

The selected sieves should be assembled with the coarsest sieve at the top of the stack and the balance of the stack in increasing magnitude of fineness (increasing sieve numbers with smaller openings). The stack should include a cover on the top sieve and a pan below the finest sieve. The sieve stack can be shaken then rapped by hand or mounted in a sieve shaker with a motorized or electrostatic drive mechanism.



While many applications still use the hand-shaken method for sieving, motor driven shakers have proven to be much more consistent, minimizing variations related to operator procedures. In powder analysis below the 100 mesh range, the sieve shaker should be equipped with a device to impart a shock wave to the sieve stack at regular intervals. This hammer or rapping device is necessary to reorient the particles on the sieve and impart some shear forces to near-sized particles blocking the sieve openings.

### **Recommended Time Intervals**

The duration of the sieving interval is usually regulated by industry standards, or by in-house control specifications. Commonly, 10, 15 or 20 minute tests are used as arbitrary sieving intervals. To determine the best interval for a new material, or to double check the accuracy of existing specifications, the following procedure can be used. Select the desired sieves for the analysis. 1) Weigh up a sample of the material to be tested and introduce it to the complete sieve stack. 2) Shake the sieve stack for a period of 5 minutes. 3) Weigh the residue in the pan and calculate the percentage in relation to the starting weight. 4) Reassemble the stack and shake for one additional minute. 5) Repeat the weigh-up procedure and calculate the percentage. If the percentage of fines increased more than 1% between 5 minutes and 6 minutes, reassemble the stack and shake for an additional minute. The data can be plotted as percentage throughput versus time for each data point you calculate. When the change in the percentage of fines passing in the 1 minute period drops below 1%, the

test can be considered complete. Record the total testing time for subsequent analyses.

Another type of sieve analysis is the wet sieve test. In this method, the sample is weighed and then washed through the finest sieve in the stack with water, a wetting agent (water based), or some other compatible solvent. After thoroughly washing the fines from the raw sample, the residue is dried either over a hot plate or in an oven. The temperature of the sieve should be maintained below 149°C (300°F)<sup>1</sup> to avoid loosening of the sieve cloth or failure of the solder joint. After drying, the residue is then sieved normally on the balance of the sieve stack. The loss in weight not accounted for on the coarse screens is assumed to be fines or soluble material.

Wet sieve analysis is especially helpful when working with naturally agglomerated materials, ultra-fine powders with severe static changes and in samples where fine particles tend to cling to the coarse fractions in the blend. The disadvantages associated with wet sieving are primarily the time period required to perform the analysis due to the additional washing and drying time and the possible damage to the sieve mesh by overloading. A common practice with wet sieving operations is brushing or forcing the sample through the mesh while the liquid medium is directed on the sieve. This pressure can distort the sieve openings or tear the mesh at the solder joint through stress. Therefore, this procedure is not recommended. Once the sieving interval is complete, whether dry or wet sieving is used, the residue on each sieve is removed by pouring the residue into a suitable weighing vessel. To remove material wedged in the sieve's openings, the sieve is inverted over a sheet of paper or suitable collector and the underside of the wire cloth brushed **gently** with a nylon paint brush with bristles cut to a 25.4 mm (1") length. The side of the sieve frame may be tapped gently with the handle of the brush to dislodge the particles between brush strokes. At no time should a needle or other sharp object be used to remove the particles lodged in the wire cloth.

Special care should be taken when brushing sieves finer than 80 mesh. Brushing can cause distortions and irregularities in the sieve openings. The procedure is repeated for each sieve in the stack and contents of the pan.

The individual weights retained on the sieves should be added and compared to the starting sample weight. Wide variations or sample losses should be determined immediately. If the finished sample weight varies more than 2% from the initial weight, the analysis and sample should be discarded and the test performed another sample. If the sample weights are acceptable, complete the calculations and report the individual weights retained on each sieve.

Presentation and analysis of the resulting data is frequently made easier by plotting on one of a number of graph formats. The most common graphic presentation is the plotting of the cumulative percentage of material retained on a sieve (plotted on a logarithmic scale) versus percentage (plotted on a linear scale). The resulting curve allows a quick approximation of the sieve size at the fifty-percentile point of accumulation. The curve also shows the smoothness of the distribution by revealing the presence of bimodal blends in the sample. Other plotting techniques include log-log and direct plotting of micron size versus percentage retained.



<sup>1</sup> Advantech metal framed sieves should not exceed 261° F (127° C). Solder will begin to soften at this point.

Care should be exercised in the analyzing the data in relation to the length of time the test was run. If the sample contains a large amount of elongated or near-size particles, the test results can be misleading. The longer the sieving interval, the greater the opportunity for these problem particles to pass through the sieve's openings. Ideally each fraction

should be inspected microscopically after sieving to determine the integrity of the sieve cut point.

Table 6 lists many of the ASTM published standards on sieve analysis procedures for specific materials or industries.

## CHAPTER 7

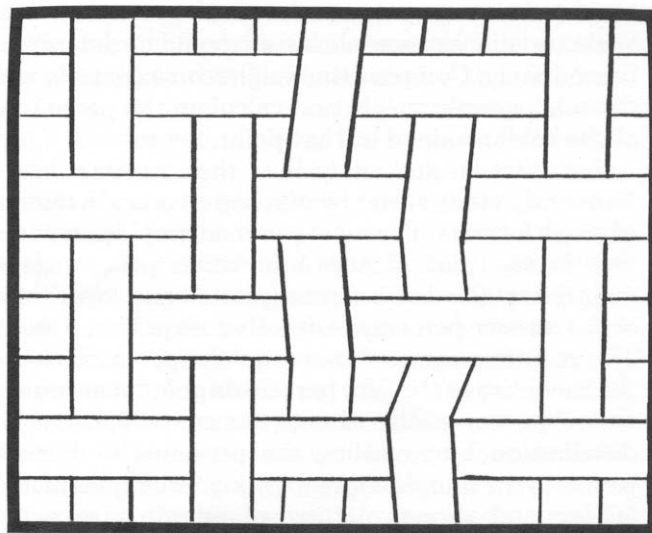
# SIEVE CARE AND CLEANING

Test sieves, like any other piece of analytical laboratory equipment, require regular care to maintain their performance standards. Sieves should be kept clean and dry at all times, and stored either in the cardboard carton provided or in a suitable cabinet. The wire cloth must be taut and free from variations in opening size. For this reason, cleaning procedures must be clearly delineated as part of a comprehensive sieving program.

<sup>2</sup> Test sieves should be cleaned ultrasonically on a regular basis.\* For some installations, this may be done at the end of a shift or at the end of a week, but must be done regularly to assure accurate sieving results. The sieves should be immersed in an ultrasonic cleaner filled with a solution of a mild detergent and water. Prior to reuse, ensure that the test sieves are dried thoroughly. Ultrasonic cleaning prevents the buildup of particles trapped in the sieve openings and prolongs the useful life of the sieve. Between test clean-up, brushing of the mesh, sizes 100 and coarser, is recommended. For best results, use a nylon bristle paint brush with the bristles cut to a length of approximately 25.4 mm (1"). The sieve openings should be brushed from the **underside only** with a gentle circular

motion. Vigorous brushing will distort the sieve openings and reduce the effective life of the sieve. Particles lodged in the sieve openings should never be removed with a sharp object. These particles should be removed in an ultrasonic cleaner only. Brushing should be avoided on sieves finer than 100 mesh, as the fine wires are more likely to bend, distort or even break. Brushing can often loosen the wire cloth; the finer mesh sizes are most susceptible to this damage.

Similarly, cleaning sieves with a compressed air jet is common, but this can



**WIRE CLOTH DAMAGED BY IMPROPER BRUSHING**

*Note the irregularities in both opening size and shape.*

<sup>2</sup> \*Do **NOT** ultrasonically clean precision electroformed test sieves. Refer to the Handling and Use Instructions on the sieve jewel case.

damage the sieve openings on the finer mesh sieves. The concentrated jet of air can cause severe 'local' damage to the wire cloth, and significantly reduce the accuracy of the sieve mesh.

With proper care, sieves will perform accurately for many years. Typical wear does not usually change the opening sizes, but can abrade the 'knuckles' or crimps of the wire. A sieve with noticeable sagging of the cloth should be replaced. Fine mesh sieves that are torn should not be re-soldered, as the localized heat of the soldering iron can distort the openings. Epoxies have been used for repairs, but

tend to block a large percentage of the openings reducing the opportunity for particles to pass through the openings in the allotted agitation time. Epoxies may become too brittle for the flexing of the wire cloth and can fracture with use.

Good general laboratory procedures should be observed with testing sieves as with any other piece of test equipment. Testing should be performed with clean, uncontaminated sieves, especially when using a sieve for the first time. With proper care and cleaning coupled with a good calibration procedure, any test sieve should provide many years of consistent service.

# EPILOG

*We hope that the characterization of testing sieves and their uses presented in this manual will serve as an enhancement to your current particle size analysis program. By maximizing the analytical advantage potential of testing sieves while minimizing and compensating for shortcomings and inaccuracies, the testing sieve can be a viable and precise testing tool. Care, maintenance and proper test procedures are as critical with a testing sieve as they are with other, more sophisticated particle size analyzers.*

*Compliance with applicable industry, national and international specifications is essential. The intent of these regulating bodies is the formulation of general standards to assure uniformity in testing standards observed by both the buyer and producer. The accepted specification should be the foundation for the in-house testing procedure.*

*Testing accuracy is highly dependent on the technique of the operators. Interpretation of data should be neither overstated nor understated in terms of importance. The effects of variables must be understood, accepted and factored into final data analysis to avoid these shortcomings.*

*NOTE: To aid in making this manual as understandable and comprehensive as possible, minor changes in spelling and grammar have been made to some of the quoted references. These changes have not altered the statements made but have aided in clarifying the thoughts of the authors.*

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# STANDARD SPECIFICATION FOR WOVEN WIRE TEST SIEVE CLOTH AND TEST SIEVES

## ASTM E11 - 15

### Nominal Dimensions and Permissible Variations for Sieve Cloth and Compliance, Inspection and Calibration Test Sieves

(1)	(2)	(3)	(4)	(5)	(6)	(13)	(14)	(15)
Sieve Designation		Nominal Sieve Opening (in.)	± Y Variation for Average Opening	+ X Maximum Variation for Opening	Resulting Maximum Individual Opening	Typical Wire Diameter	Permissible Range of Choice	
Standard	Alternative						Min	Max
millimeter		inches	millimeter	millimeter	millimeter	millimeter		
125	5 in.	5	3.66	4.51	129.51	8	6.8	9.2
106	4.24 in.	4.24	3.12	3.99	109.99	6.3	5.4	7.2
100	4 in.	4	2.94	3.82	103.82	6.3	5.4	7.2
90	3 1/2 in.	3.5	2.65	3.53	93.53	6.3	5.4	7.2
75	3 in.	3	2.22	3.09	78.09	6.3	5.4	7.2
63	2 1/2 in.	2.5	1.87	2.71	65.71	5.6	4.8	6.4
53	2.12 in.	2.12	1.58	2.39	55.39	5	4.3	5.8
50	2 in.	2	1.49	2.29	52.29	5	4.3	5.8
45	1 3/4 in.	1.75	1.35	2.12	47.12	4.5	3.8	5.2
37.5	1 1/2 in.	1.5	1.13	1.85	39.35	4.5	3.8	5.2
31.5	1 1/4 in.	1.25	0.95	1.63	33.13	4	3.4	4.6
26.5	1.06 in.	1.06	0.802	1.44	27.94	3.55	3	4.1
25	1.00 in.	1	0.758	1.38	26.38	3.55	3	4.1
22.4	7/8 in.	0.875	0.681	1.27	23.67	3.55	3	4.1
19	3/4 in.	0.750	0.579	1.13	20.13	3.15	2.7	3.5
16	5/8 in.	0.625	0.490	0.99	16.99	3.15	2.7	3.6
13.2	0.530 in.	0.530	0.406	0.86	14.06	2.8	2.4	3.2
12.5	1/2 in.	0.500	0.385	0.83	13.33	2.5	2.1	2.9
11.2	7/16 in.	0.438	0.346	0.77	11.97	2.5	2.1	2.9
9.5	3/8 in.	0.375	0.295	0.68	10.18	2.24	1.9	2.6
8	5/16 in.	0.312	0.249	0.60	8.60	2	1.7	2.3
6.7	0.265 in.	0.265	0.210	0.53	7.23	1.8	1.5	2.1
6.3	1/4 in.	0.250	0.197	0.51	6.81	1.8	1.5	2.1
5.6	No. 3 1/2	0.223	0.176	0.47	6.07	1.6	1.3	1.9
4.75	No. 4	0.187	0.150	0.41	5.16	1.6	1.3	1.9
4	No. 5	0.157	0.127	0.37	4.37	1.4	1.2	1.7
3.35	No. 6	0.132	0.107	0.32	3.67	1.25	1.06	1.5
2.8	No. 7	0.110	0.090	0.29	3.09	1.12	0.95	1.3
2.36	No. 8	0.0937	0.076	0.25	2.61	1	0.85	1.15
2	No. 10	0.0787	0.065	0.23	2.23	0.9	0.77	1.04
1.7	No. 12	0.0661	0.056	0.20	1.90	0.8	0.68	0.92
1.4	No. 14	0.0555	0.046	0.18	1.58	0.71	0.6	0.82
1.18	No. 16	0.0469	0.040	0.16	1.34	0.63	0.54	0.72
1	No. 18	0.0394	0.034	0.14	1.14	0.56	0.48	0.64
micrometer		inches	micrometer	micrometer	micrometer	millimeter		
850	No. 20	0.0331	29.1	127	977	0.5	0.43	0.58
710	No. 25	0.0278	24.7	112	822	0.45	0.38	0.52
600	No. 30	0.0234	21.2	101	701	0.4	0.34	0.46
500	No. 35	0.0197	18.0	89	589	0.315	0.27	0.36
425	No. 40	0.0165	15.5	81	506	0.28	0.24	0.32
355	No. 45	0.0139	13.3	72	427	0.224	0.19	0.26
300	No. 50	0.0117	11.5	65	365	0.2	0.17	0.23
250	No. 60	0.0098	9.9	58	308	0.16	0.13	0.19
212	No. 70	0.0083	8.7	52	264	0.14	0.12	0.17
180	No. 80	0.0070	7.6	47	227	0.125	0.106	0.15
150	No. 100	0.0059	6.6	43	193	0.1	0.085	0.115
125	No. 120	0.0049	5.8	38	163	0.09	0.077	0.104
106	No. 140	0.0041	5.2	35	141	0.071	0.06	0.082
90	No. 170	0.0035	4.6	32	122	0.063	0.054	0.072
75	No. 200	0.0029	4.1	29	104	0.05	0.043	0.058
63	No. 230	0.0025	3.7	26	89	0.045	0.038	0.052
53	No. 270	0.0021	3.4	24	77	0.036	0.031	0.041
45	No. 325	0.0017	3.1	22	67	0.032	0.027	0.037
38	No. 400	0.0015	2.9	20	58	0.03	0.024	0.035
32	No. 450	0.0012	2.7	18	50	0.028	0.023	0.033
25	No. 500	0.0010	2.5	16	41	0.025	0.021	0.029
20	No. 635	0.0008	2.3	15	35	0.02	0.017	0.023

Column 3 - These numbers are only approximate but are in use for reference; the sieve shall be identified by the standard designation in millimeters or micrometers.

**Table 1**



**INTERNATIONAL STANDARDS ORGANIZATION (ISO)  
PREFERRED NUMBER SERIES**

Values in millimeters unless specified as micron ( $\mu$ ).

R 20/3	R 20	* R 40/3	Equivalent in inches	R 20/3	R 20	* R 40/3	Equivalent in inches
125	125	125	4.921			1.7	0.0669
	112		4.409		1.6		0.0630
		106	4.173	1.4	1.4	1.4	0.0551
	100		3.937		1.25		0.0492
90	90	90	3.543			1.18	0.0465
	80		3.150		1.12		0.0441
		75	2.953	1	1	1	0.0394
	71		2.795		900 $\mu$		0.0354
63	63	63	2.480			850 $\mu$	0.0335
	56		2.205		800 $\mu$		0.0315
		53	2.087	710 $\mu$	710 $\mu$	710 $\mu$	0.0280
	50		1.969		630 $\mu$		0.0248
45	45	45	1.772			600 $\mu$	0.0236
	40		1.575		560 $\mu$		0.0220
		37.5	1.476	500 $\mu$	500 $\mu$	500 $\mu$	0.0197
	35.5		1.398		450 $\mu$		0.0177
31.5	31.5	31.5	1.240			425 $\mu$	0.0167
	28		1.102		400 $\mu$		0.0157
		26.5	1.043	355 $\mu$	355 $\mu$	355 $\mu$	0.0140
	25		0.984		315 $\mu$		0.0124
22.4	22.4	22.4	0.882			300 $\mu$	0.0118
	20		0.787		280 $\mu$		0.0110
		19	0.748	250 $\mu$	250 $\mu$	250 $\mu$	0.0098
	18		0.709		224 $\mu$		0.0088
16	16	16	0.630			212 $\mu$	0.0083
	14		0.551		200 $\mu$		0.0079
		13.2	0.520	180 $\mu$	180 $\mu$	180 $\mu$	0.0071
	12.5		0.492		160 $\mu$		0.0063
11.2	11.2	11.2	0.441			150 $\mu$	0.0059
	10		0.394		140 $\mu$		0.0055
		9.5	0.374	125 $\mu$	125 $\mu$	125 $\mu$	0.0049
	9		0.354		112 $\mu$		0.0044
8	8	8	0.315			106 $\mu$	0.0042
	7.1		0.280		100 $\mu$		0.0039
		6.7	0.264	90 $\mu$	90 $\mu$	90 $\mu$	0.0035
	6.3		0.248		80 $\mu$		0.0031
5.6	5.6	5.6	0.220			75 $\mu$	0.0030
	5		0.197		71 $\mu$		0.0028
		4.75	0.187	63 $\mu$	63 $\mu$	63 $\mu$	0.0025
	4.5		0.177		56 $\mu$		0.0022
4	4	4	0.157			53 $\mu$	0.0021
	3.55		0.140		50 $\mu$		0.0020
		3.35	0.132	45 $\mu$	45 $\mu$	45 $\mu$	0.0018
	3.15		0.124		40 $\mu$		0.0016
2.8	2.8	2.8	0.110			38 $\mu$	0.0015
	2.5		0.098	R*10	36 $\mu$		0.0014
		2.36	0.093	32 $\mu$			0.0013
	2.24		0.088	25 $\mu$			0.0010
2	2	2	0.079	20 $\mu$			0.0008
	1.8		0.071				

\* Same as ASTM E 11 USA Standard Sieve Series

R\*10 = Tenth root of ten ratio

R 20 = Twentieth root of ten

R 20/3 = Every third number of R 20 Series

R 40/3 = Every third number of fortieth root of ten series

**Table 2**

**COMPARISON TABLE  
INTERNATIONAL TEST SIEVE SERIES**

<b>INTERNATIONAL ISO 3310-1:2000</b>	<b>AMERICAN ASTM E 11-01</b>		<b>BRITISH BS410:2000</b>		<b>CANADA CGSB-8.2-M88</b>	<b>FRANCE AFNOR NFX11-501</b>		<b>GERMANY DIN (ISO) 3310-1:2000</b>		<b>JAPAN JIS</b>
Aperture mm	Opening mm	Equiv. inch/No.	Aperture mm	Equiv. BS Mesh	Aperture mm	Aperture mm	Tamis No.	Aperture mm	Approx. DIN No.	Aperture mm
125.00	125.00	5"	125.00							
112.00			112.00							
106.00	106.00	4.24"	106.00							
100.00	100.00	4"	100.00		100.00	100.00		100.00		
90.00	90.00	3 1/2"	90.00		90.00	90.00		90.00		
80.00			80.00							
75.00	75.00	3"	75.00							
71.00			71.00		71.00	71.00		71.00		71.00
63.00	63.00	2 1/2"	63.00		63.00	63.00		63.00		
56.00			56.00							
53.00	53.00	2.12"	53.00		53.00	53.00		53.00		
50.00	50.00	2"	50.00		50.00	50.00		50.00		50.00
45.00	45.00	1 3/4"	45.00		45.00	45.00		45.00		
40.00			40.00							
37.50	37.50	1 1/2"	37.50							
35.50			35.50							
31.50	31.50	1 1/4"	31.50		31.50	31.50		31.50		
28.00			28.00		28.00	28.00		28.00		
26.50	26.50	1.06"	26.50							26.50
25.00	25.00	1.00"	25.00		25.00	25.00		25.00		
22.40	22.40	7/8"	22.40		22.40	22.40		22.40		22.40
20.00			20.00		20.00	20.00		20.00		
19.00	19.00	3/4"	19.00							19.00
18.00			18.00			18.00		18.00		
16.00	16.00	5/8"	16.00		16.00	16.00		16.00		16.00
14.00			14.00		14.00	14.00		14.00		
13.20	13.20	.530"	13.20							
12.50	12.50	1/2"	12.50		12.50	12.50		12.50		12.50
11.20	11.20	7/16"	11.20		11.20	11.20		11.20		11.20
10.00			10.00		10.00	10.00		10.00		
9.50	9.50	3/8"	9.50							9.50
9.00			9.00			9.00		9.00		
8.00	8.00	5/16"	8.00		8.00	8.00		8.00		8.00
7.10			7.10		7.10	7.10		7.10		
6.70	6.70	.265"	6.70							6.70
6.30	6.30	1/4"	6.30		6.30	6.30		6.30		
5.60	5.60	No.3 1/2	5.60	3	5.60	5.60		5.60		
5.00			5.00			5.00	38	5.00		5.00
4.75	4.75	No.4	4.75	3 1/2						
4.50			4.50			4.50		4.50		
4.00	4.00	No.5	4.00	4	4.00	4.00	37	4.00	2E	
3.55			3.55	5		3.55		3.55		
3.35	3.35	No.6	3.35							
3.15			3.15		3.15	3.15	36	3.15		
2.80	2.80	No.7	2.80	6	2.80	2.80		2.80		
2.50			2.50		2.50	2.50	35.00	2.50		
2.36	2.36	No.8	2.36	7						
2.24			2.24			2.24		2.24		
2.00	2.00	No.10	2.00	8	2.00	2.00	34	2.00	3E	
1.80			1.80			1.80		1.80		
1.70	1.70	No.12	1.70	10						
1.60			1.60		1.60	1.60	33	1.60		
1.40	1.40	No.14	1.40	12	1.40	1.40		1.40		1.40
1.25			1.25			1.25	32	1.25		
1.18	1.18	No.16	1.18	14				1.20	5	
1.12			1.12		1.12	1.12		1.12		
1.00	1.00	No.18	1.00	16	1.00	1.00	31	1.00	6	
900μ			900μ			900μ		900μ		
850μ	850μ	No.20	850μ	18						850μ
800μ			800μ		800μ	800μ	30	800μ		
710μ	710μ	No.25	710μ	22	710μ	710μ		710μ		710μ

**Table 3 . . .**

**COMPARISON TABLE  
INTERNATIONAL TEST SIEVE SERIES**

<b>INTERNATIONAL ISO 3310-1:2000</b>	<b>AMERICAN ASTM E 11-01</b>		<b>BRITISH BS410:2000</b>		<b>CANADA CGSB-8.2-M88</b>	<b>FRANCE AFNOR NFX11-501</b>		<b>GERMANY DIN (ISO) 3310-1:2000</b>		<b>JAPAN JIS</b>
Aperture mm	Opening mm	Equiv. inch/No.	Aperture mm	Equiv. BS Mesh	Aperture mm	Aperture mm	Tamis No.	Aperture mm	Approx. DIN No.	Aperture mm
630µ 600µ 560µ 500µ	600µ  500µ	No.30  No.35	630µ 600µ 560µ 500µ	25  30	  500µ	630µ  560µ 500µ	29  28	630µ 600µ 560µ 500µ	10  12	600µ  500µ
450µ 425µ 400µ 355µ 315µ	425µ  355µ	No.40  No.45	450µ 425µ 400µ 355µ 315µ	36  44	 400µ 355µ 315µ	450µ  400µ 355µ 315µ	 27 26	450µ 430µ 400µ 355µ 315µ	14 16	425µ  355µ
300µ 280µ 250µ 224µ 212µ	300µ  250µ 212µ	No.50  No.60 No.70	300µ 280µ 250µ 224µ 212µ	52  60 72	  250µ	280µ 250µ 224µ	 25	300µ 280µ 250µ 224µ	20 24	300µ  250µ 212µ
200µ 180µ 160µ 150µ 140µ	180µ  150µ	No.80  No.100	200µ 180µ 160µ 150µ 140µ	85  100	200µ 180µ  140µ	200µ 180µ 160µ 140µ	24 23	200µ 180µ 160µ 150µ 140µ	30 40	180µ  150µ
125µ 112µ 106µ 100µ 90µ	125µ  106µ 90µ	No.120  No.140 No.170	125µ 112µ 106µ 100µ 90µ	120  150 170	125µ  100µ 90µ	125µ 112µ 100µ 90µ	22  21	125µ 112µ 100µ 90µ	50 60 70	125µ  106µ 90µ
80µ 75µ 71µ 63µ 56µ	75µ  63µ	No.200  No.230	80µ 75µ 71µ 63µ 56µ	200  240	 71µ 63µ 56µ	80µ  71µ 63µ 56µ	20 19	80µ 75µ 71µ 63µ 56µ	80 110	75µ  63µ
53µ 50µ 45µ 40µ 38µ	53µ  45µ 38µ	No.270  No.325 No.400	53µ 50µ 45µ 40µ 38µ	300  350 400	 45µ	50µ 45µ 40µ	18 17	50µ 45µ 40µ	120	53µ  45µ 38µ
36µ 32µ 25µ 20µ	 32µ 25µ 20µ	 No.450 No.500 No.635	36µ 32µ 25µ 20µ	 440	36µ	36µ 32µ 25µ 20µ		36µ 32µ 25µ 20µ	130 200	 32µ

**Table 3, cont'd.**

**RECOMMENDED REPRESENTATIVE  
BULK VOLUMES OF TEST SAMPLES**  
Used in 8" (203mm) Testing Sieves

Standard Sieve Designation		Bulk Volume of Material	
Standard	Alternate	Recommended Volume of Material for Test Sample	Maximum Permitted Volume on Sieve on Completion of Sieving
25.0mm	1.00"	1800cm <sup>3</sup>	900cm <sup>3</sup>
22.4mm	7/8"	1600cm <sup>3</sup>	800cm <sup>3</sup>
19.0mm	3/4"	1400cm <sup>3</sup>	700cm <sup>3</sup>
16.0mm	5/8"	1000cm <sup>3</sup>	500cm <sup>3</sup>
12.5mm	1/2"	800cm <sup>3</sup>	400cm <sup>3</sup>
11.2mm	7/16"	800cm <sup>3</sup>	400cm <sup>3</sup>
9.50mm	3/8"	600cm <sup>3</sup>	300cm <sup>3</sup>
8.00mm	5/16"	500cm <sup>3</sup>	250cm <sup>3</sup>
6.30mm	1/4"	400cm <sup>3</sup>	200cm <sup>3</sup>
5.60mm	No. 3 1/2	400cm <sup>3</sup>	200cm <sup>3</sup>
4.00mm	No. 5	350cm <sup>3</sup>	150cm <sup>3</sup>
2.80mm	No. 7	240cm <sup>3</sup>	120cm <sup>3</sup>
2.00mm	No. 10	200cm <sup>3</sup>	100cm <sup>3</sup>
1.40mm	No. 14	160cm <sup>3</sup>	80cm <sup>3</sup>
1.00mm	No. 18	140cm <sup>3</sup>	70cm <sup>3</sup>
710μ	No. 25	120cm <sup>3</sup>	60cm <sup>3</sup>
500μ	No. 35	100cm <sup>3</sup>	50cm <sup>3</sup>
355μ	No. 45	80cm <sup>3</sup>	40cm <sup>3</sup>
250μ	No. 60	70cm <sup>3</sup>	35cm <sup>3</sup>
180μ	No. 80	60cm <sup>3</sup>	30cm <sup>3</sup>
125μ	No. 120	50cm <sup>3</sup>	25cm <sup>3</sup>
90μ	No. 170	40cm <sup>3</sup>	20cm <sup>3</sup>
63μ	No. 230	35cm <sup>3</sup>	17cm <sup>3</sup>
45μ	No. 325	30cm <sup>3</sup>	15cm <sup>3</sup>
38μ	No. 400	25cm <sup>3</sup>	12cm <sup>3</sup>

The recommended weight of material for a sieve test sample is calculated by multiplying the bulk volume figure in Column 3 by the particular bulk density in grams per cubic centimeter of the material, rounded out within a tolerance of ±25 percent.

**Table 4**

**BULK DENSITY OF PULVERIZED MATERIALS IN FREELY POURED CONDITION<sup>a</sup>**

Material	Average Weight lbs./ft. <sup>3</sup> g/cm <sup>3</sup>		Material	Average Weight lbs./ft. <sup>3</sup> g/cm <sup>3</sup>		Material	Average Weight lbs./ft. <sup>3</sup> g/cm <sup>3</sup>	
Alumina	44	1.23	Fullers earth	30 to 40	0.48 to 1.04	Rubber, chopped	36	0.58
Aluminum, calcined	128	2.05	Garnet	168	2.69	Rubber, ground	20	0.32
Aluminum oxide	122	1.96	Glass beads	76	1.22	Phosphate rock	75 to 85	1.20 to 1.36
Aluminum shot	96	1.54	Glass, crushed	66	1.06	Salt, flake	61	0.98
Ammonium nitrate	48	0.77	Glass cullet	93	1.49	Salt, rock	66	1.06
Ammonium - sulfate	61	0.98	Granite, crushed	95 to 100	1.52 to 1.60	Salt, table	75	1.20
Bauxite ore	75 to 85	1.20 to 1.36	Gravel	90 to 100	1.44 to 1.60	Sand	90 to 100	1.44 to 1.60
Bentonite	50 to 65	0.80 to 1.04	Gypsum, calcined	58	0.93	Sand, silica	90 to 100	1.44 to 1.60
Bicarbonate of soda	57	0.91	Gypsum, crushed	90 to 100	1.44 to 1.60	Sawdust	18	0.29
Borax	50 to 61	0.80 to 0.98	Iron ore	120 to 150	1.92 to 2.40	Seacoal	42	0.67
Boric acid	58	0.93	Kaolin	160	2.56	Shale	100	1.60
Calcite	90	1.44 to 1.68	Kyanite	68	1.09	Shot, metal	230	3.69
Calcium carbide	75	1.20	Lime, ground	60	0.96	Silica, flour	27	0.43
Calcium carbonate	49	0.79	Lime, hydrated	25	0.40	Silica, gel	45	0.72
Calcium chloride	64	1.03	Limestone, crushed	85 to 100	1.36 to 1.60	Soapstone, pulverized	40	0.64
Calcium phosphate	57	0.91	Limestone, agricultural	70	1.12	Soda ash, light	25 to 35	0.40 to 0.56
Carbon black	24	0.33	Magnesite	106	1.70	Soda ash, heavy	55 to 65	0.88 to 1.04
Cellulose powder	16	0.26	Magnetite	155	2.49	Soda, bicarbonate	57	0.91
Cement, portland	90 to 100	1.44 to 1.60	Manganese ore	120 to 136	1.92 to 2.18	Sodium nitrate	78	1.25
Cement clinker	75 to 80	1.20 to 1.28	Marble, crushed	90 to 95	1.44 to 1.52	Sodium phosphate	43	0.69
Chrome ore	140	2.25	Metals, powdered			Sodium sulfate	96	1.54
Clay	30 to 75	0.48 to 1.20	Aluminum	80	1.28	Steel grit	228	3.66
Coal, anthracite	55	0.88	Copper	169	2.71	Stone, crushed	85 to 95	1.36 to 1.52
Coal, bituminous	50	0.88	Copper-lead	364	5.84	Sugar, granulated	5	0.80
Coke breeze	25 to 35	0.40	Iron	243	3.90	Sugar, powdered	37	0.59
Coke, petroleum	25 to 40	0.40 to 0.64	Nickel	263	4.22	Sulphur, crushed	50 to 65	0.80 to 1.04
Copper ore	100 to 150	1.60 to 2.40	Stainless steel	240	3.85	Talc, powder	34	0.55
Coquina shell	80	1.28	Tantalum	300	4.80	Talc, granular	44	0.71
Corn starch	40	0.64	Mica	42	0.67	Traprock, crushed	105 to 110	1.68 to 1.76
Diatomaceous earth	31	0.50	Ore, sintered	144	1.83	Triple superphosphate,		
Dicalcium phosphate	64	1.03	Oyster shells, ground	29	0.47	granular	64	1.03
Dolomite, crushed	90 to 100	1.44 to 1.60	Perlite ore	65 to 75	1.04 to 1.20	Tungsten carbide	550	8.82
Feldspar, crushed	65 to 84	1.04 to 1.35	Plaster, calcined	64	1.03	Urea prills	43	0.69
Ferrophosphorous	196	3.14	Polyethylene pellets	36	0.58	Vermiculite ore	80	1.28
Fire clay	80	1.28	Polyethylene powder	18	0.29	Wood chips	13	0.21
Flour, wheat	24	0.38	Poly vinyl chloride	30	0.48	Zinc dust	144	2.31
Flour, maize	37	0.59	Potash	77	1.23	Zirconium oxide	200	3.22
Fluorspar	90 to 120	1.44 to 1.92	Potassium carbonate	79	1.27	Zirconium sand	162	2.60
Fly ash	49	0.79	Pumice	40	0.64			

<sup>a</sup> - Where a single figure is given, it represents an actual weight of a typical average sample of the material recorded by a research laboratory; therefore, the figure can be expected to vary from sample to sample of the same material.

**Table 5**

**LIST OF ASTM PUBLISHED STANDARDS ON SIEVE ANALYSIS PROCEDURES  
FOR SPECIFIC MATERIAL OR INDUSTRIES**

Material	ASTM Designation	Title of Standard	Sieve No. or Size Range
Aggregates	C117-95	Standard Test Method for Materials Finer Than 75- $\mu$ m (No.200) Sieve in Mineral Aggregates by Washing	No.200
	C136-01	Standard Test Method for Sieve Analysis of Fine and Coarse Aggregates	3½ in. - No.200
	C142-97	Standard Test Method for Clay Lumps and Friable Particles in Aggregates	1½ in. - No.20
	C330-00	Standard Specifications for Lightweight Aggregates for Structural Concrete	1 in. - No.100
	C331-01	Standard Specifications for Lightweight Aggregates for Concrete Masonry Units	¾ in. - No.100
	D4791-99	Standard Test Method for Flat Particles, Elongated Particles, or Flat and Elongated Particles in Coarse Aggregate	
	D5821-01	Standard Test Method for Determining the Percentage of Fractured Particles in Coarse Aggregate	
Asbestos	D2589-88 (1997)	Standard Test Method for McNett Wet Classification of Duel Asbestos Fiber	No.4 - No.325
	D2947-88 (1997)	Standard Test Method for Screen Analysis of Asbestos Fibers	
Carbon black	D1508-99	Standard Test Method for Carbon Black, Pelleted-Fines and Attrition	No.100
	D1511-00	Standard Test Method for Carbon Black-Pellet Size Distribution	No.10 - No.120
	D1514-00	Standard Test Method for Carbon Black-Sieve Residue	No.30 - No.325
Cement	C184-94	Standard Test Method for Fineness of Hydraulic Cement by the 150- $\mu$ m (No.100) and 75- $\mu$ m (No.200) Sieves	No.100 & No.200
	C430-96	Standard Test Method for Fineness of Hydraulic Cement by the 45- $\mu$ m (No.325) Sieve	No. 325
	C786-96	Standard Test Method for Fineness of Hydraulic Cement and Raw Materials by the 300- $\mu$ m (No.50), 150- $\mu$ m (No.100), and 75- $\mu$ m (No.200) Sieves by Wet Methods	No.50 - No.200
Ceramic	C325-81 (1997)	Standard Test Method for Wet Sieve Analysis of Ceramic Whiteware Clays	No.100 - No.325
	C371-89 (1999)	Standard Test Method for Wire-Cloth Sieve Analysis of Nonplastic Ceramic Powders	No.70 - No.325
Coal	D197-87 (1994)	Standard Test Method for Sampling and Fineness Test of Pulverized Coal	No.16 - No.200
	D4749-87 (1994)	Standard Test Method for Performing the Sieve Analysis of Coal and Designating Coal Size	5 in. - No.400
Coatings	D3214-96	Standard Test Methods for Coating Powders and Their Coatings Used for Electrical Insulation	
	D3451-01	Standard Guide for Testing Coating Powders and Powder Coatings	
Coke	D293-93 (1999)	Standard Test Method for the Sieve Analysis of Coke	4 in. - No.200
	D5709-95 (2000)	Standard Test Method for Sieve Analysis of Petroleum Coke	3 in. - No.200
Enamel	C285-88 (1999)	Standard Test Methods for Sieve Analysis of Wet-Milled and Dry-Milled Porcelain Enamel	No.40 - No.325
Glass	C429-01	Method for Sieve Analysis of Raw Materials for Glass Manufacture	No.8 - No.200
Magnesium	D1214-89 (1994)	Test for Sieve Analysis of Glass Spheres	
	D2772-90 (1997)	Standard Test Method for Sieve Analysis of Electrical Grade Magnesium Oxide	
Metal Bearing ores	E276-98	Standard Test Method for Particle Size or Screen Analysis at No.4 (4.75-mm) Sieve and Finer for Metal-Bearing Ores and Related Materials	No.4 - No.200
		Test for Sieve Analysis of Metal Powders	No.80 - No.325
Metal Powders	B214-99	Standard Test Method for Sieve Analysis of Granular Mineral Surfacing for Asphalt Roofing Products	No.6 - No.100
	D451-91 (1996)	Standard Test Method for Sieve Analysis of Surfacing for Asphalt Products	No.12 - No.200
	D452-91 (1997)	Standard Test Method for Sieve Analysis of Mineral Filler for Bituminous Paving Mixtures	
Perlite	D546-99	Standard Test Method for Sieve Analysis of Mineral Filler for Bituminous Paving Mixtures	
	C549-81 (1995)	Standard Specification for Perlite Loose Fill Insulation	
	D185-84 (1999)	Standard Test Methods for Coarse Particles in Pigments, Pastes and Paints	No.325
Pigments and paint	D480-88 (1999)	Standard Test Methods for Sampling and Testing of Flaked Aluminum Powders and Pastes	No.100 - No.325
	D1921-01	Standard Test Method for Particle Size (Sieve Analysis) of Plastic Materials	down to No.400
	C285-88 (1999)	Standard Test Methods for Sieve Analysis of Wet-Milled and Dry-Milled Porcelain Enamel	No.40 - No.325
Refractories	C92-95 (1999)	Tests for Sieve Analysis and Water Content of Refractory Materials	3 in. - No.200
	D2187-94 (1998)	Standard Test Methods for Physical and Chemical Properties of Particulate Ion-Exchange Resins	No.8 - No.100
Rubber additives	D5461-93 (1998)	Standard Test Method for Rubber Additives-Wet Sieve Analysis of Powdered Rubber Chemicals	
Soap	D502-89 (1995)	Standard Test Method for Particle Size of Soaps and Other Detergents	No.12 - No.100
Soda ash	E359-00	Standard Test Methods for Analysis of Soda Ash (Sodium Carbonate)	
Soil	D421-85 (1998)	Standard Practice for Dry Preparation of Soil Samples for Particle-Size Analysis and Determination of Soil Constants	No.4 - No.40
	D422-63 (1998)	Standard Test Method for Particle-Size Analysis of Soils	3 in. - No.200
	D1140-00	Standard Test Methods for Amount of Material in Soils Finer Than the No.200 (75- $\mu$ m) Sieve	No.40 - No.200
	D2217-85 (1998)	Standard Practice for Wet Preparation of Soil Samples for Particle-Size Analysis and Determination of Soil Constants	No.10 - No.40
Vermiculite	C516-80 (1996)	Standard Specification for Vermiculite Loose Fill Insulation	¾ in. - No.100

**Table 6**



# DuraTap

## Frequently Asked Questions

For specific sieving procedures, please refer to [Test Sieving: Principles and Procedures](#) located in the User's Manual. For added reference, a [DuraTap Parts Diagram](#) is located in the front portion of the User's Manual.

1. **What is the oscillation displacement on the DuraTap and how many oscillations and taps per minute does the DuraTap produce?**

The DuraTap's oscillation displacement is 1-1/8" x 3/4". The oscillations and taps per minute will be dictated by the model DuraTap you have. Please see the chart below for approximate oscillations and taps per model.

**Chart 1A**

Model	Voltage	Hertz	*OPM	*TPM
DT158	110	50	267	150
DT168	110	60	278	154
DT258	220	50	268	154
DT268	220	60	278	152
DT1612	110	60	278	154
DT2612	220	60	278	152
DT2512	220	50	268	154

*\*These are approximate oscillations and taps per minute.*

2. **What sort of maintenance is required for the DuraTap?**

The DuraTap for the most part just needs to be kept clean. There are two grease fittings on the DuraTap which require service after every five hours of operation. (Please refer to the [DuraTap Parts Diagram](#) in the front portion of the User's Manual.) One port is on top of the unit in the [BA106/BA119 Yoke \(30/30a\)](#). This fitting feeds the [DA211 Eccentric \(5\)](#) housed in the [BA102/BA120 Yoke \(30/30a\)](#). The second port is on the lower rear part of the [BA101 Tower & Base Assembly \(45\)](#). This fitting feeds the [DA211 Eccentric \(5\)](#) housed by the [DA201 Lower Carriage Plate \(21\)](#). The [BA105 Stationary Block \(48\)](#) should also be periodically greased. A Moly EP (extreme pressure) multi-purpose grease is recommended.

3. **Does the DuraTap have to be calibrated?**

The DuraTap is not a calibrated machine. The taps and oscillations can be verified to make sure the machine is still operating at manufacturer's specification. (Please refer to **Chart 1A**). The oscillations and taps per minute are basically a product of motor rpm, line-in voltage and the hertz of that voltage.

Test sieves, however, can be certified using Advantech's [Centerline® Premium Sieve Certification](#). Utilizing our sophisticated image analyzer traceable to NIST, your sieve may be tested to any of the following:

- **ASTM E 11 Inspection Certification:** Sieves measured to this standard will have a percentage of openings and 10 wire dimension measured. This certificate provides a confidence level of 99% that the sieve is within the specifications.
- **ASTM E 11 Calibration Certification:** Sieves measured to this standard will have at least twice as many apertures measured than inspection sieves, thereby providing an increased confidence level of 99.73%
- Please contact our Customer Service Team at (262) 786-1600 or [sales@advantechmfg.com](mailto:sales@advantechmfg.com) for instructions on how to send sieves in for service.

**4. Does Advantech calibrate/certify test sieves for the DuraTap?**

Yes. Test sieves can be certified using Advantech's [Centerline® Premium Sieve Certification](#). Please see the answer to question three for specifics on the varied levels of certification service Advantech offers. For a [suggested re-certification schedule](#), please contact our Customer Service Team at (262) 786-1600 or [sales@advantechmfg.com](mailto:sales@advantechmfg.com).

**5. How many sieves can I fit in my DuraTap?**

Please refer to **Chart 5A** for details on the DuraTap's sieve capacity. Fewer sieves may be used by loosening the nuts and adjusting the height of the [BA132/BA122 Sieve Support Clamp Assembly \(36/36a\)](#) to the level necessary to securely hold the sieve stack. See **Figure 6A** for an example of a properly constructed and inserted sieve stack.

**Chart 5A**

**DuraTap Sieve Capacity**

	Half Height	Intermediate Height	Full Height	Pan	Cover
8" or 203.1 mm	14	N/A	7	1	1
12" or 304.8 mm	8	6	4	1	1

**6. My DuraTap is making a lot of noise and the sieve stack seems unstable in the machine. What is wrong?**

The sieve stack may have been improperly constructed and inserted.



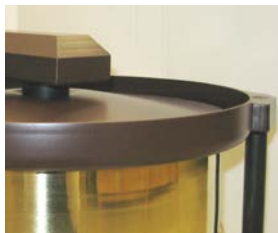


Figure 6A



Figure 6B

- Start the sieve stack with the pan at the very bottom.
- Load the sieves on top of the pan. An extended rim pan may be inserted within the stack to run multiple samples. See **Figure 12A** for an example of the extended rim pan. Bear in mind the overall height of the sieve stack may not exceed the capacities as shown in **Chart 5A**.
- Introduce the sample and place the [BA106/BA119 DuraTap Sieve Cover \(30/30a\)](#) on top of the sieve stack as shown in **Figure 6A**. **Figure 6B** illustrates an *improperly* installed DuraTap Sieve Cover.
- Place the sieve stack onto the [BA132/BA122 Sieve Support Clamp Assembly \(36/36a\)](#)
- Adjust the [BA132/BA122 Sieve Support Clamp Assembly \(36/36a\)](#) up far enough that the sieves will be securely held in place as shown in **Figure 6C**. Be certain you have the [BA106/BA119 DuraTap Sieve Cover \(30/30a\)](#) situated so the dimple in the center can receive the cork or rubber plug as shown in **Figure 6A**. If the cover is upside-down, the sieves will not be properly held in place and the [BA103 Hammer Arm \(1\)](#) will fall on metal rather than the plug; causing the “sloshing” of the sieves in the assembly and the very noisy tapping.



Figure 6C

**7. My DuraTap is making a slapping noise and the oscillation displacement seem to be off. What is happening?**

The [BA105 Stationary Block \(48\)](#) is manufactured out of a bronze alloy so that if any wear from heavy or extended use does occur, this block will wear out before the more expensive [DA201 Lower Carriage Plate \(21\)](#) is damaged. If this part becomes worn, the oscillations may change and a slapping noise will be heard.

- Unplug the DuraTap from the power source.
- Turn the unit over and wear on the [BA105 Stationary Block \(48\)](#) may be found.
- Replace the [BA105 Stationary Block \(48\)](#) before damage to the [DA201 Lower Carriage Plate \(21\)](#) occurs.
- Routine greasing of the [BA105 Stationary Block \(48\)](#) will ensure long life. See question 2 for locations of grease fittings.

**8. I want to convert my 8” DuraTap to work with 12” sieves. Can I do that?**

[Conversion Kits](#) are available for users who want to convert their existing unit to accept either 8” or 12” sieves. No need to incur the expense of another shaker. Simply unscrew 4 bolts and loosen 2 hex nuts.

- PA8 – converts your 12” unit to accept 8” sieves.
- PA12 – converts your 8” unit to accept 12” sieves.

**9. Can the direction of the motor be changed?**

No. **WARNING:** Do **NOT** attempt to change the direction of the motor. Doing so will cause damage to the DuraTap and will void the warranty.

**10. What is the grade of stainless steel used in the manufacture of Advantech's test sieves?**

- ASTM #8 and coarser sieves use a 304 grade wire cloth
- ASTM #10 and finer use a 316 grade.
- Stainless steel frames are manufactured with 304 grade stainless steel.

**11. What is the warranty on the DuraTap?**

The DuraTap carries a one year limited warranty against defective material and workmanship.

**12. What is an extended rim pan? Do I need this for my test?**

An extended rim pan is manufactured with a skirt around the bottom so it can be received by a sieve below it. This will allow the user to run multiple samples in one stack. The extended rim pan can be inserted mid-stack to collect fines of sample one and the bottom pan will collect fines from sample two. See **Figure 12A** for an example.



**Figure 12A**

**13. Does Advantech have a repair facility nearby?**

Advantech is pleased to offer telephone repair support for DuraTaps. Contact a member of our Tech Support Team at (262) 786-1600. Alternatively, machines may be sent in to our location in New Berlin, WI for extensive repair or refurbishing. Contact us for information on how to prepare your machine for receipt and service by our Repair Department.

**14. My questions have still not been answered.**

For further technical support, please contact our Tech Support Team at (262) 786-1600 or at [sales@advantechmfg.com](mailto:sales@advantechmfg.com). We'd be glad to assist.

# Terms

**Stationary Block (BA105):** The brass rectangle block that is under the unit. This is the wear point.

**Lower Carriage Plate (DA201):** The large steel oscillating part under the unit that supports the uprights. It has additional holes to convert the unit from 8" to 12". An allen wrench is needed for conversions.

**Timing Belt (DA219):** It is a cogged belt (grooves in it). This is a non-slip belt that keeps the timing.

**Timing Pulley (DA203):** This is a large grooved metal pulley on the bottom of the unit that the belt runs on.

**Hammer Arm (BA103):** The hinged arm on top of the unit. It does the tapping.

**Cam Gear (DA202):** The fiber gear that drives the lift rod.

**Yolk (BA102, BA120):** The C shaped metal cover retainer.

**Uprights (DA206):** The uprights are the vertical rods, which the sieve support plate mounts to. **NOTE:** The sieve support plate is adjustable to accommodate the desired number of sieves.

**Eccentric (DA211):** These are the main drive bearings. One is located on the top of the drive shaft and the other is on the lower drive shaft held in place by a ¼" square key.

**Hammer lift rod (DA205):** This is the drive rod located under the hammer arm.

# Troubleshooting

<u>Problem</u>	<u>Possible Cause</u>
Carton damaged when delivered	Please note with shipper so that a claim can be made if necessary. All units are in operating condition when they leave the factory.
Unit is plugged in and timer display shows a time but the unit won't operate.	Call for technical support
Unit hums and timer shows indicated set time.	The unit might be out of alignment. Call for technical support.
Unit is plugged in and the timer is set to desired time but nothing happens.	Make sure unit is unplugged. Flip unit on the side. Make sure the timing pulley is turning freely. If this is not the case, there could be a bearing problem. It could also be motor damage. Call for technical support.
Hammer Arm does not lift properly.	Unplug unit, check lift rod for wear at each end. The lift rod can be removed by lifting the hammer to the open position, grasping the rod and lifting straight up. To re-install the lift rod, make sure it passes through all guides. If the rod is not put in straight it will not go all the way down.

# Notes

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