MANN+HUMMEL EDM filters
For wire and sink erosion
Modern, high performance vehicles, machines, devices and engines require filters and components with a correspondingly high performance. This documentation gives you an overview of our range of EDM filters for wire and cavity sinking EDM machines and the respective accessories – naturally in the renowned MANN+HUMMEL OEM quality. Since our customers operate in many varied fields, such as

- construction machines
- agricultural machines
- compressors
- mechanical engineering
- engines and gear units
- commercial and customised vehicles, etc.

MANN+HUMMEL has extensive experience elaborating individual concepts and solutions for your special field of application.

The MANN+HUMMEL Group is an international company with its headquarters in Ludwigsburg, Germany. The group employs more than 10,000 people worldwide at more than 41 locations.

The company develops, produces and sells technically complex components and systems for the automotive industry and many other fields. A key area is high quality filtration products for vehicles, engines and industrial applications. The OEM business with global market leaders and producers of vehicles, machines and installations defines the quality and performance of the products. Filters for the international aftermarket are sold under a variety of international brands as well as under the MANN-FILTER brand.

MANN+HUMMEL Industrial Filters

The Industrial Filters Business Unit has its headquarters in Speyer, Germany. The business unit is specialized in meeting the special requirements of off-highway vehicles and engine applications, compressed air and vacuum technology, mechanical engineering and plant construction.

MANN+HUMMEL Industrial Filters offers high performance for these fields and other fields which have a requirement for the filtration and separation of air, gas and liquids.
Our development engineers work closely together with machine producers to fine tune the filters to the respective EDM machine. This guarantees best possible running of the system. Therefore when servicing you should also opt for MANN+HUMMEL original parts. Efficient filtration provides high quality for the processed workpiece and also for economic running costs. Quality defects with filters can become expensive. These defects can be identified through the following effects:

- Bad surface quality and accuracy on the processed workpiece
- Blocked rinsing nozzles
- Increasing resin consumption
- Sediment in the cooler and supply system
- Increased corrosion deposits

The results are increased running costs and extensive wear on your EDM machine. So choose MANN+HUMMEL products for security. Through a specified filter fineness and selection of first class materials you will gain:

- Process reliability
- Excellent machining quality of workpiece
- Smooth running of the EDM machine
- Long filter service life
- Leading to greater efficiency
- Cleaniness of dielectricum as claimed by the producer

Apart from that opting for MANN+HUMMEL filters also offer you the following advantages:

- We can supply quickly and flexibly to your specifications, also for large volumes.

The MANN-FILTER brand name is established and recognized with the producers and operators of EDM machines.

Be on the safe side with MANN+HUMMEL
EDM filters up to ø 150 mm
Recommendations / Standards

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Respective MANN+HUMMEL EDM filters</th>
</tr>
</thead>
<tbody>
<tr>
<td>AEG</td>
<td>H 15 135 N, H 15 135 PN, H 15 190, H 15 190/10</td>
</tr>
<tr>
<td>Agema</td>
<td>H 15 190, H 15 190/10</td>
</tr>
<tr>
<td>Agemaspark</td>
<td>H 1096</td>
</tr>
<tr>
<td>Agie + Charmilles</td>
<td>H 15 190/1, H 15 190/16, H 15 190/25, H 15 475/1, H 15 190/10, E-Line, H 15 190/6, H 15 190, H 15 190/12</td>
</tr>
<tr>
<td>BES</td>
<td>H 15 190, H 15 190/10</td>
</tr>
<tr>
<td>Deckel</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>EMV Erodiermaschinen</td>
<td>H 15 190, H 15 190/10</td>
</tr>
<tr>
<td>Hostek</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>OPS-Ingersoll</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>Japax</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>Jiten</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>Multiform</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>Nassovia</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>Sintron</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>Seibu-Walter</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
<tr>
<td>Zimmer+Kreim</td>
<td>H 15 190, H 15 190/10, H 15 190/16, E-Line</td>
</tr>
</tbody>
</table>
## EDM filters up to ø 150 mm

<table>
<thead>
<tr>
<th></th>
<th></th>
<th></th>
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<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>H 1096 ¹</td>
<td>A</td>
<td>9 300 [10]</td>
<td>100 [3.9]</td>
<td>22 [0.9]</td>
<td>202 [8.0]</td>
</tr>
<tr>
<td>H 15 135 PN</td>
<td>B</td>
<td>21 200 [23]</td>
<td>150 [5.9]</td>
<td>32 [0.9]</td>
<td>252 [9.9]</td>
</tr>
<tr>
<td>H 15 190</td>
<td>B</td>
<td>20 500 [22]</td>
<td>150 [5.9]</td>
<td>32 [0.9]</td>
<td>364 [14.3]</td>
</tr>
<tr>
<td>H 15 190/12</td>
<td>B</td>
<td>21 600 [23]</td>
<td>150 [5.9]</td>
<td>32 [0.9]</td>
<td>364 [14.3]</td>
</tr>
<tr>
<td>H 15 190/16</td>
<td>C</td>
<td>31 000 [33]</td>
<td>150 [5.9]</td>
<td>32 [0.9]</td>
<td>375 [14.8]</td>
</tr>
<tr>
<td>E-Line</td>
<td>C</td>
<td>27 000 [29]</td>
<td>150 [5.9]</td>
<td>32 [0.9]</td>
<td>375 [14.8]</td>
</tr>
<tr>
<td>H 15 475</td>
<td>B</td>
<td>47 000 [51]</td>
<td>150 [5.9]</td>
<td>32 [0.9]</td>
<td>364 [14.3]</td>
</tr>
<tr>
<td>H 15 475/1</td>
<td>C</td>
<td>45 320 [49]</td>
<td>150 [5.9]</td>
<td>32 [0.9]</td>
<td>375 [14.8]</td>
</tr>
</tbody>
</table>

¹) Connection dimension according to D N EN 10 305  
²) with handle
# EDM filters from ø 260 mm

## Recommendations / Standards

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Conventional paper filters 3 – 5 µm</th>
<th>Long-life filters 3 – 5 µm</th>
<th>Triple layer filters 1 – 2 µm</th>
</tr>
</thead>
<tbody>
<tr>
<td>Brother</td>
<td>H 31 967/1</td>
<td>H 34 1790/2</td>
<td>H 34 1070/1</td>
</tr>
<tr>
<td>Charmilles</td>
<td>H 34 1158/8</td>
<td>H 34 2090</td>
<td>H 34 1390/1</td>
</tr>
<tr>
<td></td>
<td>H 34 1790/3</td>
<td>H 34 2240</td>
<td></td>
</tr>
<tr>
<td>Exeron</td>
<td>H 31 967/1</td>
<td>H 34 1290/3</td>
<td>H 34 1070/1</td>
</tr>
<tr>
<td>Fanuc</td>
<td>H 34 1070/9</td>
<td>H 34 1390</td>
<td>H 34 1390/1</td>
</tr>
<tr>
<td></td>
<td>H 34 1158/8</td>
<td>H 34 1390</td>
<td></td>
</tr>
<tr>
<td></td>
<td>H 34 1790/3 1)</td>
<td>H 34 1790/2 1)</td>
<td></td>
</tr>
<tr>
<td>Hitachi</td>
<td>–</td>
<td>H 31 1680/1</td>
<td>H 34 1390/1</td>
</tr>
<tr>
<td>Makino</td>
<td>H 26 644/1</td>
<td>H 31 1680/1</td>
<td>H 34 1390/1</td>
</tr>
<tr>
<td>Mitsubishi Electric</td>
<td>H 31 967/1</td>
<td>H 34 1390</td>
<td>H 34 1390/1</td>
</tr>
<tr>
<td>Nassovia</td>
<td>H 31 967/1</td>
<td>–</td>
<td>–</td>
</tr>
<tr>
<td>OPS-Ingersoll</td>
<td>H 31 1033/3</td>
<td>H 31 1680</td>
<td>–</td>
</tr>
<tr>
<td>Seibu</td>
<td>–</td>
<td>H 34 1390</td>
<td>H 34 1390/1</td>
</tr>
<tr>
<td>Sodick</td>
<td>H 34 1070/9</td>
<td>H 34 1290/3</td>
<td>H 34 1070/1</td>
</tr>
<tr>
<td></td>
<td>H 34 1158/8</td>
<td>H 34 1790</td>
<td></td>
</tr>
</tbody>
</table>

1) Service kit (order no 67 000 50 900) required
### Conventional paper filters from 3 – 5 µm

<table>
<thead>
<tr>
<th>Order no.</th>
<th>Design</th>
<th>Filter surface area [in cm²]</th>
<th>Dimensions in mm [dimensions in inches]</th>
<th>Flow direction</th>
</tr>
</thead>
<tbody>
<tr>
<td>H 26 644/1 ¹)</td>
<td>E</td>
<td>53 700 [58]</td>
<td>d₁: 261 [10.3], d₂: 46 [1.8], d₃: --</td>
<td>outside to inside</td>
</tr>
<tr>
<td>H 31 967</td>
<td>A</td>
<td>95 300 [103]</td>
<td>d₁: 302 [11.9], d₂: 29 [1.1], d₃: --</td>
<td>inside to outside</td>
</tr>
<tr>
<td>H 31 967/1 ²)</td>
<td>A</td>
<td>95 300 [103]</td>
<td>d₁: 302 [11.9], d₂: 29 [1.1], d₃: --</td>
<td>inside to outside</td>
</tr>
<tr>
<td>H 31 1033/3</td>
<td>F</td>
<td>99 125 [107]</td>
<td>d₁: 302 [11.9], d₂: 54 [2.1], d₃: --</td>
<td>inside to outside</td>
</tr>
<tr>
<td>H 34 1070</td>
<td>D</td>
<td>107 000 [115]</td>
<td>d₁: 340 [13.4], d₂: 45.5 [1.8], d₃: --</td>
<td>inside to outside</td>
</tr>
<tr>
<td>H 34 1070/9 ³)</td>
<td>D</td>
<td>107 000 [115]</td>
<td>d₁: 340 [13.4], d₂: 45.5 [1.8], d₃: --</td>
<td>inside to outside</td>
</tr>
<tr>
<td>H 34 1158/4</td>
<td>C</td>
<td>145 000 [156]</td>
<td>d₁: 340 [13.4], d₂: 45.5 [1.8], d₃: --</td>
<td>inside to outside</td>
</tr>
<tr>
<td>H 34 1158/8 ³)</td>
<td>C</td>
<td>145 000 [156]</td>
<td>d₁: 340 [13.4], d₂: 45.5 [1.8], d₃: --</td>
<td>inside to outside</td>
</tr>
<tr>
<td>H 34 1790/3 ²)</td>
<td>B</td>
<td>145 000 [156]</td>
<td>d₁: 340 [13.4], d₂: 47.5 [1.9], d₃: 404 [15.9],</td>
<td>inside to outside</td>
</tr>
</tbody>
</table>

¹) with handle  
²) plastic  
³) painted in black, corrosion resistant
Long-life filters from 3 – 5 µm, 10 µm, 25 µm

<table>
<thead>
<tr>
<th>Order no.</th>
<th>Design</th>
<th>Filter surface area in cm² [in ft²]</th>
<th>Filter fineness in µm</th>
<th>Dimensions in mm [dimensions in inches]</th>
<th>Flow direction</th>
<th>Connection thread</th>
</tr>
</thead>
</table>

¹) painted in black corrosion resistant
²) plastic
**Triple layer filters from 1 – 2 µm**

<table>
<thead>
<tr>
<th>Order no.</th>
<th>Design</th>
<th>Filter surface area in cm² [in ft²]</th>
<th>Dimensions in mm [dimensions in inches]</th>
<th>Flow direction</th>
<th>Connection thread</th>
</tr>
</thead>
<tbody>
<tr>
<td>H 34 1070/1 ¹)</td>
<td>B</td>
<td>92 000 [99]</td>
<td>d₁ = 340 [13.4], d₂ = 47.5 [1.8], d₃ = –, h = 300 [11.8]</td>
<td>inside to outside</td>
<td>–</td>
</tr>
</tbody>
</table>

¹) painted in black, corrosion resistant  
²) plastic
Flexibility through ...

Connections

For filters with threaded connections MANN+HUMMEL supplies reusable connectors. This allows one filter type to be used with different types of EDM machines. Whether for OPS-Ingersoll, Fanuc, Mitsubishi Electric, Makino or Hitachi – it always fits!

Advantages:

- Reusable nipples
- Connections in various materials selectable
- Easy filter logistics
- Economic

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Connection nipple Material</th>
<th>Connection thread</th>
<th>Order no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>Makino, Mitsubishi Electric, Seibu</td>
<td>Brass</td>
<td>G 3/4”</td>
<td>21 027 15 181</td>
</tr>
<tr>
<td>Hitachi</td>
<td>Brass</td>
<td>G 3/4”</td>
<td>21 027 15 175</td>
</tr>
<tr>
<td>OPS-Ingersoll</td>
<td>Aluminium</td>
<td>G 3/4”</td>
<td>21 027 15 171</td>
</tr>
<tr>
<td>Fanuc</td>
<td>Brass</td>
<td>G 3/4”</td>
<td>21 027 15 174</td>
</tr>
</tbody>
</table>
### Handles

Separate reusable handles can now be ordered for all MANN+HUMMEL EDM filters. The handles simplify the removal and fitting of the filter.

<table>
<thead>
<tr>
<th>Manufacturer</th>
<th>Connection nipple Material</th>
<th>Connection thread</th>
<th>Order no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>OPS-Ingersoll</td>
<td>Plastic</td>
<td>G 3/4”</td>
<td>21 027 15 213</td>
</tr>
<tr>
<td>Makino</td>
<td>Plastic</td>
<td>G 3/4”</td>
<td>21 027 15 211</td>
</tr>
<tr>
<td>Mitsubishi Electric Seibu</td>
<td>Plastic</td>
<td>G 3/4”</td>
<td>21 027 15 212</td>
</tr>
<tr>
<td>Fanuc</td>
<td>Plastic</td>
<td>G 3/4”</td>
<td>01 901 20 027</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>Suitable seal</th>
<th>Connection nipple Material</th>
<th>Connection thread</th>
<th>Order no.</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Copper</td>
<td>G 3/4”</td>
<td>01 901 20 027</td>
</tr>
</tbody>
</table>

**Suitable for**
- H 31/.. and H 34/.. metal
- H 15 serie plastic E-Line

**Design**

<table>
<thead>
<tr>
<th>Suitable for filter series</th>
<th>Design</th>
<th>Order no.</th>
</tr>
</thead>
<tbody>
<tr>
<td>H 31/.. and H 34/.. metal</td>
<td><img src="image1" alt="Handle Design" /></td>
<td>67 092 49 001 1)</td>
</tr>
<tr>
<td>H 15 serie plastic E-Line</td>
<td><img src="image2" alt="Handle Design" /></td>
<td>67 830 49 001 2)</td>
</tr>
</tbody>
</table>

1) Packaged set with 20 pieces  
2) Packaged set with 50 pieces
Summary – EDM filters – Metal *

- H 31 1680/1 3-5 µm
- H 34 1070 3-5 µm
- H 34 1070/1 1-2 µm
- H 34 1070/9 3-5 µm
- H 34 1158/4 3-5 µm
- H 34 1158/8 3-5 µm
- H 34 1380 3-5 µm
- H 34 1380/1 1-2 µm
- H 34 2240 3-5 µm

*not to scale*
Summary – EDM filters – Plastic *

- H 15 190/1
  1-2 µm

- H 15 190/10
  10 µm

- H 15 190/16
  3-5 µm

- E-Line
  3-5 µm

- H 15 190/25
  25 µm

- H 15 475/1
  3-5 µm

- H 34 1290
  3-5 µm

- H 34 1290/3
  3-5 µm

- H 34 1390
  3-5 µm

- H 34 1390/1
  1-2 µm

- H 34 1390/2
  10 µm

- H 34 1390/3
  25 µm
Summary – EDM filters – Plastic *

H 34 1790
3-5 µm

H 34 1790/2
3-5 µm

H 34 1790/3
3-5 µm

H 34 2090
3-5 µm
MANN+HUMMEL has launched a filter series especially for the fine filtration of dielectric fluid in wire-EDM and start-hole drilling machines. It can be used in OEM products and also used as a replacement product – of course in the usual first class MANN+HUMMEL quality.

The range offers excellent flexibility for OEM products – new types are quickly generated by varying:
- Housing lengths and element sizes
- Pressure stability values
- Connection threads

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**Order no.**

<table>
<thead>
<tr>
<th>Housing Design</th>
<th>Order no. Housing</th>
<th>Order no. Element</th>
<th>Housing dimensions in mm [dimensions in inches]</th>
<th>Element dimensions in mm [dimensions in inches]</th>
</tr>
</thead>
</table>

1) for Agie machines
Summary – Fine filters *

* not to scale

63 400 62 211
63 400 62 221
63 400 62 231
63 400 51 141

63 400 62 201
63 400 51 131

63 400 51 121
for Age machines

* not to scale
MANN+HUMMEL – Top quality EDM filters

MANN+HUMMEL is a development partner and series supplier to leading manufacturers of EDM machines. Our technical expertise ensures that the products are perfectly matched to the respective application.

Independent of whether the filtration is for the dielectric fluid of a wire EDM or cavity sinking EDM machine, the filtration result and the process reliability has to be correct. This means that with EDM filters from MANN+HUMMEL you are on the safe side.

MANN+HUMMEL EDM filters: The sum of high quality components.

In the development of new filters priority is given to the components such as the filter medium, the external casing and the end cap.

Filter medium

The most important part of an EDM filter is the filter medium. This is individually matched to the high requirements of the EDM process in the MANN+HUMMEL development laboratories.

At the beginning of the development of the medium a special MANN+HUMMEL test process examines the dirt particles from an EDM machine. This test quickly indicates whether a medium is suitable for the respective EDM application in respect of the dirt holding capacity, filter fineness and service life.

The MANN+HUMMEL range of media for EDM filters covers a filter fineness range from 1 to 25 µm.

MANN+HUMMEL always offers the right medium – whether the material to be machined is tool steel or aluminium. The MANN+HUMMEL expertise in the field of impregnation and consistent curing of the medium ensures the pressure stability of the filter paper.
External casing and end caps

Important quality factors for the external casing and the end caps are the pressure stability, resistance to corrosion and chemical stability in connection with the dielectric fluid. In addition, the material must not allow any undesirable ions to enter the dielectric fluid. A low housing weight is a further aspect which provides lower transportation and disposal costs. Light filters offer advantages to operators for machine maintenance. The development and testing laboratories of MANN+HUMMEL are comprehensively equipped with testing facilities and an EDM machine to enable tests to be made under field conditions.

The choice of the right medium is the basic requirement for the deactivation function of the filter. MANN+HUMMEL determines the correct choice of medium in the company's own testing laboratory.
The development of high performance filter media is the first step in production and just as crucial for the performance of the filter in the field is the quality of the processing. In the production the filter medium is pleated, pressed into a special structure and cured.

Star-pleated filters can be manufactured with different pleat heights. In order to maximise service life and best utilise the available installation space, MANN+HUMMEL uses macro pleating and double-bellows technology.

Macro-pleating technology is a special production process enabling higher pleats which do not prematurely stick together during operation. These paper pleats are impregnated and given a special structure which separates the pleats and enables high stability. The result is high operational reliability over the whole life of the filter.

The double-bellows technology also provides a longer service life. Utilising advanced pleating geometry, MANN+HUMMEL is able to maximise the amount of filtration surface area in a given size.

A filter as good as its filter medium. Therefore the development of modern, high performance materials is a top priority for MANN+HUMMEL.
MANN+HUMMEL – Innovative production

The production processes and technology used at MANN+HUMMEL are proven and reliable. The result is an absolutely consistent and high product quality. In addition, processes are rationalised. For example, the adhesive dosing is computer-controlled and at the end of the production process the products are stacked on a pallet using a robot.

Innovative: butt-welding to ensure an adhesive-free connection of the paper bellows and filter end cap.

The MANN+HUMMEL Marklkofen production location in Germany is the largest plant in the world producing filter elements. Here production engineers are working to improve and perfect processes. A number of innovative examples are the butt-welding process which enables the adhesive-free connection of the paper bellow and filter end cap or the laser welding used to realise a pressure resistant assembly of metal filter housings.

At the end of the product on process a v sua nspect on ensures that on y perfect y produced f ters are de vered to the customer.

The MANN+HUMMEL product on ocat on at Mark kkofen n Germany.
MANN+HUMMEL Industrial Filters worldwide

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The MANN+HUMMEL Group is an international company with its headquarters in Ludwigsburg, Germany. The group employs more than 10,000 people worldwide at more than 41 locations.

The company develops, produces and sells technically complex components and systems for the automotive industry and many other fields. A key area is high quality filtration products for vehicles, engines and industrial applications. The OEM business with global market leaders and producers of vehicles, machines and installations defines the quality and performance of the products. Filters for the international aftermarket are sold under a variety of international brands as well as under the MANN-FILTER brand.

MANN+HUMMEL Industrial Filters

The Industrial Filters Business Unit has its headquarters in Speyer, Germany. The business unit is specialized in meeting the special requirements of off-highway vehicles and engine applications, compressed air and vacuum technology, mechanical engineering and plant construction.

MANN+HUMMEL Industrial Filters offers high performance for these fields and other fields which have a requirement for the filtration and separation of air, gas and liquids.