Water & Wastewater Treatment

www.mon-environmental.com

Liquid Clarification & Air/Gas Cleaning Systems

www.mon-env.com
Reduce suspended solids (TSS), dissolved solids (TDS), grit, metals, and oils

Monroe Environmental designs and manufactures a wide range of water and wastewater clarifiers for industrial and municipal use. Our equipment utilizes conventional gravitational settling technology, and each system can be customized to meet the specific needs of your application.

We’ve been in the water and wastewater treatment business for over 40 years, so we know that all water streams are unique. Monroe can provide jar-testing, analysis, and ultimately recommend the correct system to properly treat your specific water or wastewater stream.

Clarifier Design

Laminar Flow Principle — The design of Monroe Clarifiers creates laminar flow conditions and allows gravitational forces to separate the lighter and heavier elements from the fluid.

Chemical Treatment — Monroe Clarifiers can include pre-treatment processes as an integral part of the system. This aids in the separation of the dissolved solids, fine particles, and emulsified oils that tend to remain suspended in water and process fluids.

Separated Solids Removal — Monroe offers a wide variety of sludge collection options for all clarifier designs, carefully selected for each application.

Oil Recovery — Separated oils, process fluids, and other floating materials are guided to an accumulation area for easy removal and reclamation.

Construction Materials — Monroe’s manufacturing flexibility includes fabricating with a variety of materials:

- Mild and stainless steel
- High-density polyethylene (HDPE)
- Polypropylene
- FRP
- PVC and CPVC
- And many others
Monroe Systems and Services

Monroe offers a variety of engineering, assessment, evaluation, and design services to help engineers, operators, and plant personnel get the most out of their wastewater treatment systems.

- Design and manufacture clarifiers
- Retrofit existing tanks and clarifiers to improve:
  - Settling efficiency
  - Throughput
  - Sludge collection systems
  - Oil recovery capability
  - Chemical treatment
- Rebuild worn-out clarifier internals to extend the life of existing units
- Municipal and industrial applications
- Turnkey systems available

The Monroe Method

The Monroe Method is our superior way of doing business that saves our customers time, money, and hassle. It’s based upon three main components:

- Design and fabrication
- Shop assembly and testing
- Ongoing support for the life of your equipment
New, rebuild, and retrofit designs for nearly all clarifier and thickener applications

Monroe Environmental offers nearly every circular clarifier design preferred by engineers and plant operators for municipal and industrial applications. We will evaluate existing clarifiers and recommend improvements to influent and effluent arrangements, feedwell/EDI design, weir and launder geometry, skimming and scum baffles, sludge removal systems, and drive equipment, as well as a variety of site-specific design requirements.

Our experienced staff will design high efficiency, low maintenance systems that will provide the highest return on investment.

- Customized designs for municipal and industrial applications
- Tank diameter 5 to 250 feet and larger
- Full and half-bridge designs
- Steel or concrete tanks
- Chemical feed system available
- Flocculators available when required
- Energy Dissipating Inlet (EDI) designs available
- Thickener mechanism available
- Skimmer mechanisms
- Corrosion resistant materials and coatings
  - Epoxy coated steel
  - Stainless steel
  - Galvanization
  - And many others
- Custom built replacement parts for all manufacturers
- Clarifier rebuilds
Clarifier Features

**Mechanism Support** — Bridge supported or center column supported clarifiers and thickeners are available.

**Influent** — Center feed or peripheral feed, energy-dissipating inlet, and flocculating feed well are available.

**Sludge Removal Systems**
- Standard scraper
- Spiral scraper
- Hydraulic suction tube header
- Hydraulic suction riser pipes

**Skimming Systems** — Floating scum and other material can be removed by a traditional rotating skimmer arm and scum removal box or by a ducking skimmer that feeds a radial scum trough. A scum baffle prevents floating matter from entering the effluent launder.

**Launder** — Inboard, outboard, or radial launders available for effluent collection.

**Weirs** — A V-notch adjustable weir will be designed to ensure steady overflow rates, even in windy conditions. FRP, stainless steel, and other materials can be used for weir construction.

**Walkways, Railing, and Stairways** — Designed and built according to OSHA, API, and other applicable standards.

**Drives** — Monroe Environmental uses only the highest quality drives that are conservatively selected to handle even the most demanding loads.
- Fabricated steel precision gear
- Cast iron worm gear
- Lift mechanisms available

Applications

- Steel processing
- Oil refineries
- Food processing
- Mining wastewater
- Chemical and petrochemical processing
- Automotive plant wastewater
- Plastics manufacturing
- Municipal treatment plants
- Power plant wastewater
- General water and wastewater treatment
- And many others
Primary Clarifier

Monroe Environmental’s primary Circular Clarifiers are designed to receive raw wastewater after it has been pre-screened to remove large objects and grit. This primary sedimentation tank will produce a homogeneous liquid capable of being treated biologically and a sludge that can be separately treated or processed.

Secondary (Final) Clarifier

Monroe Environmental’s secondary Circular Clarifiers for wastewater are designed to provide a high quality effluent suitable for discharge to the environment or further treatment. The Monroe Environmental secondary clarifier effectively separates the biological floc and colloidal solids to produce wastewater with very low levels of organic material and suspended matter.

Sludge Removal Designs

Scraper

Scraper type clarifiers are the most common and widely used for wastewater applications. These units are straightforward and simple, utilizing a series of adjustable, angled scraper plows to draw the settled sludge toward the center of the unit and into the sludge collection pit.

This design is most commonly used for primary treatment, thickening, and general use industrial clarifiers, however, they can be used for secondary (biological) treatment and/or flocculated solids collection.

Spiral Scraper

Spiral scraper type clarifiers utilize long-sweeping, curved scraper blades to move solids across a basin floor. They are similar to scraper-type clarifiers in that they drag settled solids to the collection area, however, they can more quickly remove these solids and thus maintain lower sludge blankets in some applications.

This design can be utilized in primary, secondary, and industrial wastewater applications.
**Solids Contact, Flocculating, and Water Treatment Clarifiers**

Monroe Environmental manufactures several types of water treatment clarifiers that combine chemical treatment, flocculation, and sedimentation.

Designs include Flocculating Clarifiers and Solids Contact Clarifiers, and these units are heavily utilized in both industrial and municipal processes for treating groundwater, surface water, and process water.

**Thickeners**

Circular Thickeners are a crucial step between upstream process clarifiers/separators and downstream de-watering and sludge conditioning processes. A well designed thickener provides storage and equalization, and reduces the costs associated with de-watering.

Thickeners are similar to other circular clarifiers in appearance and operation, but typically require higher operating torque and alternate sludge collection designs for optimal performance.

**Riser Pipe**

Riser pipe clarifiers rely on differential head pressure to collect settled solids from the tank floor. Each riser pipe is situated at the intersection of a v-plow and receives a continuous feed of sludge that returns to a sludge collection box near the center of the clarifier.

This design is intended for secondary, biological, or flocculated solids which are more fluidized and have lower densities than primary wastewater and heavy industrial sludge.

**Suction Header**

Suction header clarifiers rely on differential head pressure to collect settled solids from the tank floor. These units have a long, tapered collection arm with multiple orifices sized to stabilize and maintain optimum sludge transfer velocities through the header.

This design is intended for secondary, biological, or flocculated solids which are more fluidized and have lower densities than primary wastewater and heavy industrial sludge.
Applications

• Chemical processing
• Coolant systems
• Filter backwash clarification
• Food processing
• Foundry operations
• Glass plant operations
• Industrial waste management
• Metal working
• Oil refining
• Paper making
• Plastic manufacturing
• Plating and coating processes
• Process water treatment
• Steel processing
• Storm water systems

Inclined Plate Clarifier for increased flow and reduced footprint

The Monroe Environmental Vertical Clarifier is designed to provide low cost, efficient solids removal from a wide range of waste and process liquids. The inclined plate design allows the total gravity settling area to be as much as ten times more than the actual floor space occupied by the clarifier. Integral chemical mixing and flocculation tanks are available, as well as options for enhanced sludge thickening.

This unit is typically used to remove solids from industrial waste and process waters. For municipal treatment plants, it is often used to clarify and remove solids from sand filter backwash water and other filtration processes.

Optional equipment includes skimmer, access platform, chemical treatment, flocculator, thickener, and control panel.

• Inclined plate separator
• Efficient removal of solids and metals from liquids
• Extremely low space requirements
• Minimum maintenance
• Low installed costs
• No moving parts in settling area
• Capacities from 1 to 2,000 GPM

The unique, modular design of the Monroe Vertical Plate Clarifier allows for easy removal of individual laminar plate modules from the clarifier for inspection.

Designed for Your Specific Clarifier Application

While many installations provide adequate solids removal without influent pre-treatment, optional mixers and flocculator tanks are available to enhance efficiency when required. Some solids must be flocculated to achieve adequate mass to be effectively removed. Monroe Environmental can provide jar testing and analysis to determine your flocculation requirements.

Sludge Removal Designs

Pyramid Hopper
Sludge Thickener

Installation of Vertical Clarifier for disc filter backwash with chemical mix tanks, access platform, ladder, and support structure
**Special Features**

**Customized covers**, access ladders, and platforms are available in a variety of materials including stainless steel, FRP, aluminum, and many others.

**Wide range of construction materials.** Mild steel, special coatings, stainless steel, fiberglass, plastics, and other materials are available to meet specific needs.

**The unique, modular design** of the Monroe Vertical Clarifier allows easy removal of individual laminar plate modules from the clarifier for inspection.

A flash mixer and flocculator tank are available pretreatment options.

A rake thickener with geared drive is available for the bottom of the separator tank to increase solids concentration.

**Complete electrical controls** are available to meet customer requirements.
**Horizontal Plate Clarifiers**

**Solids separation AND oil recovery**

The Monroe Parallel Plate Horizontal Clarifier is one of the most versatile clarifiers available on the market. Because the unique Monroe parallel separator plate design effectively separates both settleable solids and floating materials, the Horizontal Clarifier can be used in place of a circular clarifier for nearly any application. This allows for significant cost savings and reduced space requirements versus traditional clarifiers. These advantages have made the Horizontal Clarifier the best-selling clarifier offered by Monroe over the past 40+ years.

**Broad Range of Capabilities**

**Oil Recovery** — Separated oils, process fluids, and other floatable materials are guided to an accumulation area for easy removal and reclamation. An adjustable overflow weir or a Monroe Oil Recovery Unit can be included to remove these elements.

**Separated Solids Removal** — Where the dirt load is heavy, a drag conveyor or screw conveyor may be included to provide continuous removal of settled solids from the bottom of the clarifier.

**Chemical Treatment** — The Monroe Horizontal Clarifier can include a pretreatment process as an integral part of the basic clarifier. This aids in the separation of dissolved solids, very fine particles, and emulsified oils that tend to remain suspended in water or process fluids. A chemical treatment tank and/or flocculation chamber can be added to allow pH control and mixing of emulsion breakers and coagulants into the influent before the laminar flow process.

**Laminar Flow Principle**

The unique design of the Monroe Horizontal Clarifier creates laminar flow conditions and allows gravitational forces to separate the lighter and heavier elements from the fluid.

Normally, industrial laminar flow separation requires settling areas beyond practical space availability in typical manufacturing plants. Monroe’s design engineers, however, have eliminated this problem through the unique capabilities of the Horizontal Clarifier.

**Applications**

- Chemical processing
- Coolant systems
- Filter backwash clarification
- Food processing
- Foundry operations
- Glass plant operations
- Hydraulic fracturing
- Industrial waste management
- Metal working
- Oil refining
- Oil/water separation
- Plant run-off
- Plastic manufacturing
- Plating and coating processes
- Steel processing
- Storm water systems
- Wash water

In the Monroe Horizontal Clarifier separated particles are required to move only a few inches before reaching an uninterrupted and protected free fall or rise to collection areas.
Special Features

**Wide range of construction materials.** Mild steel, special coatings, stainless steel, fiberglass, plastics, and other materials are available to meet specific needs.

**No moving parts in the clarifier section** reduces equipment cost and practically eliminates operating cost when compared with a centrifuge separator.

**Easily removable laminar plates.** The unique, modular design of the Monroe Horizontal Clarifier allows easy removal of individual laminar plate modules from the clarifier for inspection.

**Complete electrical controls** to meet customer requirements are available if required.

**Sludge Removal Designs**

- **Pyramid Hopper**
- **Drag Conveyor**
- **Screw Conveyor**
Removal of free oils and solids from wastewater at refineries, petrochemical, and other heavy industrial plants

Monroe Environmental is the leading source for API Separator design, engineering, and manufacturing services. A well designed, properly functioning API Separator is a tremendous piece of wastewater process equipment. Unfortunately, the API Separator has earned a bad reputation among plant personnel and operators due to common engineering and design mistakes that can be avoided. Monroe Environmental understands the shortfalls common with competitive API Separator designs, and continues to lead the way with innovative engineering and continuous design improvements.

**Applications**
- Oil/water separation
- Solids/grit removal
- Refinery wastewater
- Petrochemical plants
- Terminal and barge wastewater
- Power plant operations
- Remove oil from wastewater

Monroe Environmental utilizes API 421 design specifications while incorporating the latest technological improvements to maximize performance and efficiency for each oil/water separation application. In many cases, we also custom design specialty oil/water separators with process features and site specific configurations to suit your needs. We are clarification and separation experts, and you can count on our experience, quality of fabrication, and ongoing support to ensure you have a successful system over the long term.

**API Separator Design**

The basic components of the Monroe API Separator include an inlet section with flow diffusion, a separator channel, an oil retention baffle, and an outlet section. Depending on your requirements, additional options can include trash screens, a slotted pipe skimmer, surface conveyors, and a bottom drag or screw conveyor for solids handling.

Complete covers of various materials are available with necessary environmental and safety features. These provisions may include a nitrogen blanketing system, carbon filtering to remove hydrocarbons from the blanket gas, exhaust flares, pressure relief valves, and access doors.
Circular Separators

Monroe Environmental also provides Circular Oil/Water Separators that can take the place of rectangular API Separators in some cases. These units are equipped with enhanced oil skimming mechanisms, high torque drives, and sludge collection rakes for handling the heaviest oil and solids loading applications.

A Monroe Environmental Applications Engineer can best advise on the pros and cons of each system design based on your project’s specific requirements.

API Retrofits

Existing API Separators can be upgraded with new internal components to improve separation, oil reclamation, or any other operational or maintenance problem. In addition, Monroe parallel plate packs can be added to existing API Separators to increase the effective surface area which will provide increased oil removal and wastewater flow capacity.

Monroe Environmental has experience retrofitting existing in ground concrete tanks as well as above ground steel separators.

Available Options

- Mechanical surface skimmer and pipe skimmer
- Mechanical drag conveyor, screw conveyor, and trash screens
- Vapor covers with environmental and safety equipment
- Retrofit components to upgrade existing separators
- Monroe Parallel Plate packs to improve oil removal in existing separators

Left: Diffusion chamber with reaction jet baffles, screw conveyor for solids removal, and chain and flight drag conveyor. Middle: Chain and flight surface skimmer and drag conveyor in separation and settling zone. Right: Automated oil roll, adjustable pipe skimmer, underflow baffle, and adjustable overflow weir.
Sludge Collectors

The Monroe Environmental Sludge Collector is a hoseless, hydraulic suction collector designed to uniformly remove settled solids from the floor of a rectangular sedimentation basin. Monroe’s patent-pending design improves the flow of sludge through the collector and reduces the chance for in-pipe clogging.

The hoseless-type collector offered by Monroe is a more efficient design for collecting settled solids from sedimentation basins versus flexible hose collectors, fixed grid collectors, and chain and flight scrapers.

The Monroe Sludge Collector is the perfect compliment to the highly efficient Monroe Plate Settlers for potable water treatment. The unit can also be provided separately should your plant only require a more efficient settled solids removal system.

Chain and flight collectors are also available when required.

Parallel Plate Settlers

Monroe Environmental Parallel Plate Settlers can greatly increase the effective surface area of the existing clarifiers and sedimentation basins at water treatment facilities. New tanks can be greatly reduced in size when designed to include plate settlers as well. This is because suspended solids removal in gravity separators and clarifiers depends primarily on the surface area for settling and the multiple parallel plates provide a large surface area in a small space.

Monroe features a variety of design improvements over competitive plate settlers. These patent-pending designs provide a more equalized flow through the plate sections and also incorporate several features that make inspection, cleaning, and maintenance much easier for plant operators.

Plate Settler Design

- 304 stainless steel
- Increases throughput and capacity
- Reduces solids loading on final filtration processes
- Easy to see and clean the faces of plates without draining tank
- Variably sized influent flow distributors promote better flow across the face of the plates
- Effluent is collected uniformly at the top of the plates through orifices
Oil Recovery Units
The Monroe Environmental Oil Recovery Unit is heavily constructed for industrial applications and consists of an endless belt, an electric motor drive unit, and a complete enclosure. The belt is suspended from a specially designed driven pulley, with the lower portion immersed in an oil supporting liquid. The Monroe Oil Recovery Unit operates unattended in any area of tranquil oil accumulation. It will continuously recover floating oil in a condition that permits disposal or reclaiming for other industrial purposes.

Many different industries can prevent water pollution by recovering oily waste with a Monroe Oil Recovery Unit. Even the lightest oils from food processing can be easily removed.

Air Strippers
Monroe Environmental designs and manufactures high-efficiency air strippers for industrial and municipal applications. An air stripper removes volatile gaseous compounds dissolved in a contaminated water stream and transfers them to an air stream. Clean water from the Monroe stripper may then be sent to a sump or drain as required.

Monroe manufactures Packed Tower Air Strippers as well as a complete line of scrubbers and gas adsorbers that may be used to treat the resulting contaminated air before it is emitted to the atmosphere.

Applications
- Removal of Volatile Organic Compounds (VOCs) and other compounds with high vapor pressure and low aqueous solubility including: BTX, ethylbenzene, PCE, TCE, DCE, MTBE, ethylenes, and ammonia
- Removal of groundwater contaminants from petroleum fuel leakage
- Water treatment plant removal of VOCs from potable water

X-Flo Mobile Clarifier
The Monroe X-Flo™ Mobile Clarifier is a completely integrated mobile clarification solution for temporary job sites and/or bypass operations. The system can be utilized as a stand-alone clarifier or as a retrofit to improve the performance of existing mobile storage tanks.

The Monroe X-Flo Mobile Clarifier is designed to be a combination of traditional clarification technologies with standard mobile water storage tanks to produce an economic means of solids separation, oil removal, and waste stream clarification on a job site.

The truly unique design of the X-Flo Cartridge allows for the removal of settle-able solids as well as floating solids/oils from your wastewater and process liquids — something that cannot be achieved with other mobile treatment tanks or plate clarifier systems!
Monroe Environmental has the experience and expertise to offer custom designed treatment systems for non-standard, site, and process specific applications. These systems typically afford the end user lower maintenance and operational costs than standard equipment which may not be optimized for the application.

Our ability to offer these systems comes from flexible and experienced application and mechanical design capabilities not possessed by other environmental system providers. That’s why Monroe Environmental is truly a “solutions” provider.

We also offer other traditional water and wastewater process equipment such as CPI Separators, DAFs, aeration tanks, oil/water separators, and many others.

What is a ‘Custom Clarifier or Separator’?

A custom clarifier or separator is any type of equipment that is specially designed to meet a specific water treatment requirement not found among conventional equipment designs. Often these needs arise from changing manufacturing processes, batch irregularities, specialized production processes, new discharge requirements, space limitations, or maintenance reduction plans.

Monroe Environmental has the capability to help assess a treatment process and respond with innovative, targeted solutions to fill the gaps in these areas.

Contact a Monroe Applications Engineer today to review your requirements.

Applications

- Solids removal
- Oil separation and recovery
- Scum/foam removal
- Dissolved air flotation
- Aeration processes
- Metals reduction
- Process water recycle
- Filtration
- pH adjustment
- Flocculation
- Skimmers and conveyors
- CPI separators
- Tube settlers
- And many more

Water Treatment Experience and Expertise

Grit Separator

Custom separator with skimmer for vacuum pump seal ring water treatment

Insulated, steam heated tanks for oil separation/reclamation and solids settling
Monroe Environmental Pilot Systems are an excellent option for testing a technology’s performance capability and suitability for a particular application. This is a cost-effective way to evaluate an environmental solution before making a capital investment in a full scale system. Monroe has several Pilot Systems available for rent as well as the support services required to install, operate, and evaluate performance.

- Pilot clarifiers and separators available for rent
- Installation and operation services
- On-site support
- System optimization
- Data and analysis reports

Upon completion of a Pilot System test, Monroe Environmental can evaluate and analyze the system’s performance and present a written report summarizing the results and recommendations in order to properly scale up for a full system. We work with your operators, engineers, and maintenance personnel to design a true solution that will meet the needs of your plant and application.

Please contact a Monroe Environmental Applications Engineer to learn more about our pilot system capabilities.
Clarifier Rebuild Services

- Site visit and clarifier evaluation
- Exact replacement or modified designs to improve performance
- Variety of construction materials and coatings available
- Demolition and installation
- Bypass services to keep plant online during replacement

Rebuild and replace clarifier internals for long term performance

Rebuilding and replacing the internals of a concrete or steel tank clarifier is a quick, cost-effective solution versus constructing an entirely new system. The clarifier tanks often maintain a suitable operating condition while the skimmer arm, center well, drive assembly, and sludge rakes corrode and wear beyond an acceptable level.

The benefits of a Monroe Environmental Clarifier Rebuild are straightforward and simple:

- Faster installations with minimal clarifier downtime
- Reduces total cost
- Improves performance
- Reduces future maintenance costs

In most cases, a Monroe Environmental Clarifier Rebuild is the perfect solution to restore the clarifier to its peak operating performance level, ensuring several decades of future use.

Vertical Clarifier: Plating Company

*Refurbished Plate Clarifier Tank & Internals*

**Before (Photo 1 & 2):** Existing Vertical Clarifier at a plating company. **After (Photo 3):** Refurbished Vertical Clarifier in Monroe Shop.
Primary Clarifier: Municipal Wastewater Treatment

Conversion to Spiral Scrapers

Before (Photos 1 & 2): Upgrade of four 250 ft. Primary Clarifiers. The project included converting the sludge rakes to higher efficiency spiral scrapers and rehabilitating existing drive units, as well as replacing influent wells, column supports, weirs, baffles, and launders with a combination of mild, coated steel and non-corrosive stainless steel members. After (Photo 3): One of the new Primary Clarifiers ready to return to operation.

Circular Clarifier: Chemical Manufacturing Plant

Exact Replacement of Clarifier Internals

Before (Photo 1): Existing 55 ft. diameter Scraper Clarifier at chemical manufacturing plant. Photo 2: New Clarifier internals completely assembled in Monroe shop. After (Photo 3): Installation of new internals as well as drive, bridge, and walkway.
### Air Pollution Control Systems

Monroe Environmental® provides air pollution control technologies for a variety of air/gas treatment processes at nearly every type of industrial manufacturing plant and municipal treatment works, including those in the following fields:

**Automotive Manufacturing | Chemical Processing | Food Processing | Glass & Plastics**

**Mining & Metals | Oil & Gas | Pulp & Paper | Steel Processing | Utilities/Energy | Waste Management**

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### Michigan HQ
810 West Front St.
Monroe, Michigan 48161 USA
Office: 734-242-7654
Toll Free: 800-992-7707
Fax: 734-242-5275
sales@mon-env.com

### Texas Office
110 Cypress Station Drive, Suite 135
Houston, Texas 77090 USA
Office: 281-942-6700
Toll Free: 844-465-6700
texas@mon-env.com

www.mon-env.com