
Contents

Preface	xv
Chapter 1. Fluid Ejectors and Gas Ejectors	1
1.1. General	1
1.1.1. Principle of an ejector	1
1.2. Liquid–liquid or gas–gas ejectors	2
1.2.1. Parameters of the problem.	2
1.2.2. Finding the characteristic equation.	3
1.3. Gas ejectors and thermocompressors	7
1.3.1. Parameters of the problem.	7
1.3.2. Flow and velocity of driving fluid	8
1.3.3. Flow and velocity of the suction fluid.	9
1.3.4. Specific consumption σ	10
1.3.5. Study of the mixing of two gases	10
1.3.6. Global compression ratio	14
1.4. Practical applications of ejectors and thermocompressors	17
1.4.1. Value of these devices	17
1.4.2. Compression ratio and mounting ejectors	18
1.4.3. Similarity between suction gases.	18
1.4.4. Stability and stall point	19
1.4.5. Ice formation at the exit of the ejection nozzle.	20
1.4.6. Regulation of ejectors	20
1.4.7. Simplified calculation of specific consumption of an ejector.	21
1.4.8. Conclusion.	23

Chapter 2. Pipe Dimensions, Non-Newtonian Fluids, Liquid Hammer	25
2.1. Establishing pipe diameter	25
2.1.1. Exterior diameter of metallic piping	25
2.1.2. Choice of pipe velocity	26
2.1.3. Available pressure drop	29
2.1.4. Pressure drop calculation	30
2.1.5. Expression in practical units (fluids)	31
2.1.6. Gas	32
2.1.7. Newtonian viscous fluids	33
2.1.8. Non-Newtonian fluids	35
2.2. Establishing pipe thickness	36
2.2.1. Mechanical calculation conditions	36
2.2.2. Pressure resistance	38
2.2.3. Vacuum resistance	39
2.2.4. Corrosion allowance and final thickness	40
2.3. Flanges, seals and accessories	41
2.3.1. Flanges and mounting	41
2.3.2. The choice of flanges and seals	41
2.3.3. Two types of pipe accessory	43
2.4. Sound waves in pipes	45
2.4.1. Wave celerity	45
2.4.2. Natural damping of sound waves	47
2.5. Mechanism of liquid hammer	51
2.5.1. Closure of a valve, pressure equation	51
2.5.2. Integrated pressure equation	53
2.5.3. The complete equations of the problem	54
2.6. Approximate simulation method for simple pipes (without intermediate accessories and fittings)	57
2.6.1. Assumption of mean values	57
2.6.2. Physical interpretation	59
2.6.3. Boundary conditions	60
2.6.4. Propagation diagram	62
2.6.5. Calculation procedure	64
2.7. Simplified graphic method	66
2.7.1. Preliminary	66
2.7.2. Practical procedure	67
2.8. Anti-liquid hammer chambers	71
2.8.1. Definition	71
2.8.2. Influence of the chamber on over-pressure	71

2.8.3. Fluid-level oscillations inside the tank	72
2.8.4. Pipe friction equations	75
2.8.5. Resolution of the damping equation	76
2.8.6. Weakening of a sound wave along a pipe for a single trip	78
Chapter 3. Block or Stop Valves and Control Valves	79
3.1. On valves in general.	79
3.1.1. Terminology.	79
3.1.2. The essential parts of a valve	80
3.1.3. Sealing	81
3.1.4. Protection against corrosion and abrasion	82
3.1.5. Protection against pressure and temperature	82
3.2. Different types of valves	83
3.2.1. Valve categorization and study design	83
3.2.2. Plug valves.	84
3.2.3. Angle valves.	85
3.2.4. Other plug valves	86
3.2.5. Eccentric shut-off control valve	87
3.2.6. Ball valve	87
3.2.7. Membrane valve	90
3.2.8. Pinch valve.	91
3.2.9. Butterfly valve	92
3.2.10. Gate valve	93
3.2.11. Knife valve.	93
3.2.12. Cage valve	94
3.2.13. Multipath valves.	95
3.3. Control valve choice and calculation.	98
3.3.1. Purpose of control valves	98
3.3.2. Flow in a valve	99
3.3.3. Thermodynamic approach and calculation principle	100
3.3.4. Calculation of C_V with flow in volume	100
3.3.5. The K_V in the international system of units.	101
3.3.6. Calculation of C_V with flow in mass.	103
3.3.7. Laminar flow of a liquid.	104
3.3.8. The meaning of C_V	105
3.3.9. Cavitation of a fluid in a liquid	106
3.3.10. Limiting flowrate of a liquid entering at its boiling point	107

3.3.11. Conclusion for liquids	109
3.3.12. Relaxation coefficient for gases.	109
3.3.13. Sonic regime for gases	110
3.3.14. Flow characteristic of a control valve	111
3.3.15. Operating range	113
3.3.16. Installation of a control valve	114
3.4. The process parameters of a control valve.	116
3.4.1. Variation in line pressure	116
3.4.2. Disturbances on a line	118
3.4.3. Definition of control valves (principles)	119

Chapter 4. Electric Motors: Performance and Choice of Pumps and Fans

Chapter 4. Electric Motors: Performance and Choice of Pumps and Fans	125
4.1. Choice of motor	125
4.1.1. General	125
4.1.2. Installed power	125
4.1.3. Supply voltage	126
4.1.4. Rotation velocity	126
4.2. Utilization of motors	127
4.2.1. Starting	127
4.2.2. Power consumption of an installation	129
4.3. Turbopumps	130
4.3.1. The main types of turbopump.	130
4.3.2. Centrifugal pumps	130
4.3.3. Centrifugal pump yield	135
4.3.4. Normal–emergency centrifugal pump systems	138
4.3.5. Liquid flow criteria	139
4.3.6. Safety	140
4.3.7. Drive shaft outlet seal	140
4.3.8. Cooling requirement	141
4.3.9. Dry running centrifugal pumps	141
4.3.10. Hermetically sealed centrifugal pump	142
4.3.11. Propeller pumps	143
4.3.12. Turbopump shaft power	143
4.3.13. Cavitation.	144
4.4. Volumetric pumps	146
4.4.1. Need for volumetric pumps	146
4.4.2. Piston pumps	147
4.4.3. Gear pumps	149
4.4.4. Moyno pumps	149

4.4.5. Double-screw pump	150
4.4.6. Sealed volumetric pumps (membrane)	150
4.4.7. Volumetric pumps and net suction pressure	150
4.4.8. Flow regulation of volumetric pumps	151
4.4.9. Shaft power	151
4.5. Special cases	152
4.5.1. Pumps for liquid–gas mixes.	152
4.5.2. Self-priming pumps	152
4.5.3. Slurry pumping	153
4.5.4. Sludge pumping.	153
4.5.5. The water screw.	154
4.6. Fans	156
4.6.1. Similarity laws and electrical power consumed by a fan	156
4.6.2. Fan flow calibration	157
4.6.3. Uses of fans outside of pneumatic transport	158
4.6.4. Ventilator start time	159
4.6.5. Noise caused by a ventilator	160
Chapter 5. Polymer Extruder Screw	163
5.1. Introduction of extrusion screw	163
5.1.1. Extruder principle.	163
5.1.2. Geometrical description of a screw	164
5.1.3. Screw rotation direction	167
5.1.4. Movement of fluid particles.	167
5.1.5. Preliminary studies	170
5.2. Movement of the polymer in the screw channel	171
5.2.1. Introduction	171
5.2.2. The viscosity of extruded polymers	172
5.2.3. Movement equation between two parallel plates: velocity and flowrate	173
5.2.4. Polymer friction on a solid lining	178
5.2.5. Cord movement and simulation of screw operation	180
5.2.6. Effect on the cord of the orthoaxial component of relative velocity V_R	183
5.2.7. Leak flowrate between the flight and the barrel	184
5.2.8. Friction of the barrel on the flight edge	185
5.3. Heat for polymer melting.	186
5.3.1. Melting of polymer particles	186
5.3.2. Heat dissipated by viscous friction between two parallel plates in relative movement	187

5.3.3. Thermal dissipation due to the liquid cord rotating by itself	188
5.3.4. Preliminary waiting time before fusion as described by Tadmor <i>et al.</i>	189
5.3.5. Thermal exchange in the fusion zone	190
5.4. Shaft electrical power	191
5.4.1. Shaft power of the screw	191
5.4.2. Extrapolation of power from diameter d to diameter D	191
5.5. Practical considerations and screw use.	192
5.5.1. Operating variables and dimensioning variables	192
5.5.2. Choosing of certain extruder screws.	193
5.5.3. Uses of extruders	194
5.6. Mixing and thermal transfer in the screw	194
Chapter 6. Choice and Performance of Compressors	197
6.1. About compressors	197
6.1.1. Energy loss and yields	197
6.1.2. Gas exit temperature	200
6.1.3. Energetic losses to the environment	200
6.1.4. Ideal compression power	201
6.1.5. Real gases	203
6.1.6. Protecting the machines	206
6.2. Reciprocating compressors.	206
6.2.1. Use	206
6.2.2. Dead space in reciprocating compressors.	207
6.2.3. Energy and yield	208
6.3. Open volumetric compression – screw compressors and lobe compressors.	211
6.3.1. Description.	211
6.3.2. Use	211
6.3.3. Yields.	212
6.3.4. Internal leak and volumetric yield	213
6.4. Turbo compressors	220
6.4.1. Description and use.	220
6.4.2. Flowrate regulation.	221
6.4.3. Energy equation.	221
6.4.4. Ideal gases	222
6.4.5. Real gases	224

6.5. Fans	227
6.5.1. Use	227
6.5.2. Compression power	227
6.6. Liquid ring pumps	229
6.6.1. Principle and use	229
6.6.2. Shaft power	229
6.6.3. Liquid consumption	231
Chapter 7. Free Gas Expansion	233
7.1. Types of expansion: one-dimensional flow equations	233
7.1.1. Types of expansion and starting hypotheses	233
7.1.2. Free expansion and energy	233
7.1.3. Mach number	237
7.1.4. Pipe friction	237
7.1.5. General equations of adiabatic flow	238
7.1.6. Flow without friction but with variable cross-section	240
7.1.7. Isentropic flow and critical values	243
7.1.8. Flow at constant cross-section with friction (gas pipelines).	245
7.1.9. Equation of the stationary shock wave	248
7.1.10. Singular pressure drop	250
7.2. Theoretical study of control valves, safety valves and gas pipelines	253
7.2.1. Modeling control valves	253
7.2.2. Modeling valves	256
7.2.3. Conclusions	260
7.2.4. Pressure drop in a gas pipeline	261
7.2.5. Overall conclusions.	263
Chapter 8. Safety Valves and Rupture Disks	265
8.1. Pressure around a safety valve.	265
8.1.1. Operating pressure of a protected device	265
8.1.2. Maximum operating pressure	265
8.1.3. Pressure calculation	266
8.1.4. Set pressure	266
8.1.5. Pressure upstream of the safety valve	267
8.1.6. Closing differential (drop).	268
8.1.7. Counter-pressure downstream of the valve.	268

8.2. Choice between two types of safety valves	269
8.2.1. Usual valves	269
8.2.2. Balanced plugs	270
8.2.3. Choosing a safety valve type	271
8.2.4. Inlet cross-section norms	271
8.3. Relationship between flowrate and pressure	271
8.3.1. Gases	271
8.3.2. Liquids	274
8.3.3. Viscous liquids	275
8.3.4. Flow through valves	277
8.4. Upstream and downstream connections	279
8.4.1. Connection between valve and protected device	279
8.4.2. Exhaust pipe	279
8.4.3. Reaction force on the structure	283
8.5. Various applications.	284
8.5.1. Vacuum-breaking valves	284
8.5.2. Breathing of reservoirs under atmospheric pressure.	286
8.5.3. Liquid escaping without free surface (low vapor pressure)	286
8.6. Rupture disks.	287
8.6.1. Rupture pressure	287
8.6.2. Operating ratio	288
8.6.3. Relationship between pressure and flow	289
8.6.4. Conventional disks	290
8.6.5. Composite disks.	291
8.6.6. Thick disks.	291
8.6.7. Graphite disks	292
8.6.8. Rupture indicators	292
8.6.9. Association of a disk with a safety valve	293
Chapter 9. Breathing, Inerting, Gas Losses and Circulation between Reservoirs, Tanks and Vats	295
9.1. Breather valve specifications: reservoir filling ratio limitations	295
9.1.1. Types of temperature fluctuations	295
9.1.2. Set pressure of exhalation valve	296
9.1.3. Range of filling ratio for operations	298

9.1.4. Outlet valve flow	300
9.1.5. Pressure reducers and overflow valves	304
9.1.6. Possible mounting for use of inert gas under pressure	304
9.2. Assessment of losses to the atmosphere	305
9.2.1. Preliminaries.	305
9.2.2. Possible scenarios.	306
9.2.3. Raw material storage.	306
9.2.4. Product storage	307
9.2.5. Losses on overheating	310
9.3. Circulation of liquid between reservoirs	312
9.3.1. Transfer by gravity from one reservoir to another.	312

**Chapter 10. Flow in Pipes: Rarified Gas,
Non-Newtonian Liquids, Events, Gas–Liquid Flow** 317

10.1. Rarified gas	317
10.1.1. Viscosity of gas under low pressure	317
10.1.2. Quadratic mean velocity	318
10.1.3. Mean free path.	319
10.1.4. Gas flow (low-pressure pipe)	319
10.2. Consistent or plastic products	322
10.2.1. Pipe flow laws	322
10.3. Vents	324
10.3.1. General	324
10.3.2. Explosion vents	324
10.3.3. Ambient vents	325
10.4. Nature of gas–liquid flows	330
10.4.1. Horizontal flow or slightly sloping flow at angle α	330
10.4.2. Vertical rising flow	331
10.4.3. Vertical descending flow.	331
10.4.4. Sloping ascending or descending flow from horizontal to vertical	332
10.5. Pressure drop in gas–liquid flows	332
10.5.1. The pipe is strictly horizontal	332
10.5.2. The pipe is inclined, ascending or descending	333
10.5.3. Hold-ups and pressure drop on ascent	333
10.6. Critical biphasic flow	334
10.6.1. Hypothesis	334
10.6.2. Speed of sound.	334
10.6.3. Critical flow without friction	336
10.6.4. Flow equations.	336

Appendix	339
Bibliography	341
Index	347