Table of Contents

P P	Acknov About t	
٧	Vhat is	Summary
Intro	oductio	on xxvii
		Chapter • One
		Life Cycle Cost, 1
1.1	Gene	ral
1.2	Eleme	ents of Life Cycle Costs
		Initial Cost (C _{ic})
		Installation and Commissioning (Start-up) Cost (C _{in}) 4
		Energy Cost (C _e) 5
		Operating Cost (C _o)
		Maintenance and Repair Cost (C _m) 6
		Downtime and Loss of Production Cost (C _s) 8 Environmental Cost, Including Disposal of Parts and
	1.2.7	Contamination from Pumped Liquid (C _{env})
	1.2.8	Decommissioning and Disposal Cost, Including
		Restoration of the Local Environment (C _d)
13	Calcu	lating Life Cycle Costs
		General9
		Calculating Present Value (PV) 11
		Calculation Chart Using the Simplified Method 13
	1.3.4	Example Using the Manual Calculation Chart
1.4	Finan	cial Decision Methods - Payback and Internal Rate
		turn
		Simple Payback
		Discounted Payback
	1.4.3	Internal Rate of Return

Chapter • Two Pumping System Design, 22

2.1	General	22
2.2	System Design	22
2.3	Output Control	25
2.4	Pump Type Selection	25 25 34
2.5	Selecting a Driver. 2.5.1 Background	39 42 42 45 46
2.6	Auxiliary Services. 2.6.1 Cooling Services. 2.6.2 Heating. 2.6.3 Seal Flush Systems. 2.6.4 Seal Quench Systems. 2.6.5 Barrier Fluid Systems 2.6.6 Lubrication Systems for Sleeve Bearings	46 47 48 48 49 49
2.7	Power Transmission	49 49
2.8	System Effectiveness in Design and Output Control: A New Concept	50 54
2.9	Monitoring and Sustaining the System	61
	Chapter • Three	
ľ	Methods for Analyzing Existing Pumping Systems, 70)
3.1	Introduction	70
	Improving the System	
	System Components	71

	3.3.2	Pump	72	
3.4	Syste	m Loads	73	
3.5	Deter	mining the Rates of Flow	73	
3.6	Syste 3.6.1	ple of Minimizing Losses by Balancing a Branched m	74	
3.7	3.7.1	ples for Achieving Energy Savings in Existing Systems Example 1: Waste Collection System With Oversized Pumps	78	
	3.7.2	Example 2: System With a Problem Control Valve	82	
		Chapter • Four		
		Examples of LCC Analysis, 86		
4.1		Collection System Example		
4.2		em Control Valve Example		
		Chapter • Five		
		Effective Procurement Using LCC, 94		
5 1	Introd	uction	QΛ	
		ry Documentation		
	•	ycle Cost (LCC)		
		Methodology		
		act Boundaries		
5.6	Evalu	ating Tenders	96	
5.7	Inspe	ction - Performance Bonus or Penalty	96	
5.8	Exam	ple	96	
		Chapter a Circ		
D.		Chapter • Six		
не	Recommendations for Designing and Procuring Pumping Systems, 98			

Chapter • Seven References, 102

Chapter • Eight

Glossary of Terms and Symbols, 105

Appendix A

System Curves, 107

A.1	Syster A.1.1 A.1.2 A.1.3 A.1.4 A.1.5	m Curves	107 107 109 120 124 127
A.2		uter Software	128
		Appendix B	
		Pumping Output and System Control, 129	
B.1	Output B.1.1 B.1.2	t Control	129 129 130
B.2	Syster B.2.1 B.2.2 B.2.3 B.2.4 B.2.5 B.2.6	Control Control Parameters Start-Stop Control Throttling Control Variable Speed Regulation Eccentric Radius Adjustment in Vane Cell Pumps Stroke and Speed Regulation of Reciprocating Positive Displacement Pumps	133 134 136 139 140 143
B.3	Summ	ary	144
Appendix C Pump Efficiencies, 146			
C.1	C.1.1	Efficiencies	146 146 149
C.2	_	ation of the European Commission (EU) No 547/2012	150

C.2.1 Overview	150
C.3 U.S. DOE Conservation Standard for Certain Clean Water Pumps	
Appendix D	
Case Histories–Cost Savings Examples, 152	
D.1 Introduction Case History 1: Building services. Case History 2: Pulp and paper manufacture. Case History 3: Chemical processing. Case History 4: Water supply. Case History 5: Waste water. Case History 6: Steel making. Case History 7: Petrochemical processing. Case History 8: Domestic electrical appliance. Case History 9: Mining. Case History 10: Power plant. Case History 11: Building services. Case History 12: Building services. Case History 13: Chemical industry. Case History 14: Food industry.	155 157 159 161 163 165 167 169 171 173 175 176 178
Appendix E	00
Drivers, Transmissions, and Variable Speed Drives, 1	52
E.1 Induction Motors	182 183
E.1.4 Selecting a Motor	
E.1.4 Selecting a Motor. E.2 Considerations for Electric Motors to Improve System Efficiency. E.2.1 Motor Management Best Practices for Energy	191 192
E.1.4 Selecting a Motor	191 192 193 196
E.1.4 Selecting a Motor. E.2 Considerations for Electric Motors to Improve System Efficiency. E.2.1 Motor Management Best Practices for Energy Efficiency. E.3 Variable Frequency Drives (VFD).	191 192 193 196 196

List of Figures

і уріс	ai LCC for a medium-sized industrial pumping system	XXVI
1.1	Manual calculation chart of LCC	15
1.2	Example 4.1.b using the manual calculation chart	16
2.1	Key cost components for a pumping installation as related to pipe size	23
2.2	Typical pump performance and system curves – rotodynamic pumps	24
2.3	Typical pump performance and system curves – positive displacement pumps	24
2.4	Pump selection diagram for rotodynamic pumps with standard drivers handling clean liquids	28
2.5	Average attainable industrial pump efficiency, η_{avg} , for rotodynamic volute pumps with closed impellers and for clean cold water	29
2.6	Typical pump selection diagram for positive displacement pumps (PD pumps)	30
2.7a	Maximum attainable efficiencies for PD pumps with fluids below 100 mPa s	31
2.7b	Maximum attainable efficiencies for PD pumps with fluids below 1000 mPa s	32
2.8	Indication of the influence of viscosity on the efficiency for different types of PD pumps	33
2.9	Example of a performance curve for a rotodynamic centrifugal (rac flow) pump showing the preferred operating region 35	dial
2.10	Variations in efficiency for a 30-kW 4-pole motor	44
2.11	Efficiency curve of a typical variable frequency drive	46
2.12	Duration diagrams for two different pumping systems	51
2.13	System curve	52
2.14	Lines of constant efficiency (broken) superimposed over speed-regulated pump curves (solid)	53
2.15	The operating point on the reduced speed curve moves relatively higher on the pump curve as the speed is reduced	53
2.16	Example of specific energy as a function of static head and overall efficiency	56

2.17	Three different system curves A, B and C, all passing through the same duty point at full speed and the associated curves for specific energy	58
2.18	Throttling a valve changes the rate of flow by adding pressure drop in the valve, thus moving the duty point along the pump curve	59
2.19	Compared with regulation by throttling, variable speed drives always save on energy	59
2.20	Parallel pump operation	60
2.21	Reduced efficiency and head caused by leakage losses	61
2.22	Clearances* from left to right: semi-open impeller clearance; closed impeller radial clearance	62
2.23	Examples of clearances (s) in rotating positive displacement pumps: a) screw pump; b) gear pump	65
2.24	Pressure signals of a hydraulically acting diaphragm pump: a) healthy pressure signal; b) leakage in the hydraulic chamber (replenishing window [RW])	66
2.25	Structure-borne noise signal and pressure signal of a reciprocating PD pump: a) healthy pump; b) leaking suction valve	67
2.26	Preventive maintenance in terms of total maintenance costs	68
3.1	Branched piping system showing the rate of flow in the various paths	74
3.2	Branched system showing the differential pressure in bar across the throttle valves needed to throttle the rate of flow to the set value	75
3.3	The branched piping system with flows balanced and pump impeller trimmed to eliminate excessive differential pressure across the control valves	76
3.4	The pump curve for the larger and smaller impeller trim; rate of flow for unbalanced flow is 166 m ³ /h (720 USgpm), balanced rate of flow 120 m ³ /h (520 USgpm)	77
3.5	Pressurized forced main system pumping down the sump using on/off control; evaluating changing pumping rate for lower operating costs	78
3.6	Total head as a function of rate of flow for the sump pump system	80
3.7	Pump curve for the pump selected for 30 m ³ /h	81
3.8	Sketch of pumping system in which the control valve fails	83

3.9	System resistance curve and pump curve showing the operation of the system	84
3.10	Pump curves and system curves showing the operation of the original system and the modified pump impeller	84
4.1	LCC comparison for the waste collection system	88
4.2	LCC comparison for the problem control valve system	91
4.3	LCC comparison for the problem control valve system	93
6.1	New pumping system	99
6.2	Existing pump systems	100
A.1a	Operating duty point at H _{pump} = H _{syst} for a rotodynamic pump	108
A.1b	Operating duty point at H _{pump} = H _{syst} for a positive displacement pump	108
A.2	Example of simple piping system	109
A.3	System curve	111
A.4	Piping systems with the same static head	111
A.5	Piping system with $H_{stat} \approx 0$; $H_{syst} = H_j \dots$	112
A.6	System with H _j ≈ 0	112
A.7	Resultant pump curve for series operation	113
A.8	Parallel pump operation	113
A.9	Parallel operation of two similar pumps with different system curves.	114
A.10	Pumping systems with different static heads	115
A.11	System curve with varying static head	116
A.12	Consequences of incorrectly calculated pipe losses	117
A.13	The effect of deposits (scale, rust, etc.) on pipelines	118
A.14	The effect of varying levels	119
A.15	The effect of adding margins to calculated system curve	119
A.16	Branched circulation system	121
A.17	Branched piping system, H _{stat} = 0	121
A.18	Branched pipe system with different static head	122
A.19	Branched piping system with positive suction static head	123
A.20	Pump performance by reduced impeller diameter	124
A.21	Pump performance by variable speed	125
A.22	Variable pitch propeller pumps	126

A.23	Mixed-flow pumps with adjustable inlet guide vanes	126
A.24	Pump and system curves for more viscous liquids as compared with water	127
A.25	Pump and system curves for water and pulp suspension	128
B.1	The duty point is the intersection between the pump and system curves: rotodynamic pump (RD); positive displacement pump (PD)	130
B.2	Flow as a function of time – operating curve	131
B.3	Duration curve of the flow	131
B.4	Graphical integration method to determine mean rates of flow	132
B.5	Illustration of Equations B-1 and B-2	133
B.6	Control at (a) constant pressure, (b) constant flow, and (c) proportional level control	137
B.7	Pump and drive system	140
B.8a	Examples of performance curves for a speed regulated rotodynamic pump	142
B.8b	Performance curves for PD-pumps with speed regulation	142
B.9	Pump power requirement for speed-regulated rotodynamic pump with hydraulic coupling transmission	143
B.10	Typical stroke adjustable drive element of a reciprocating positive displacement pump	144
B.11	Power requirement for single stage rotodynamic pumps with flow control using various methods, in a system with a low ratio: H _{stat} /H ₀	145
C.1	Typical single-stage, single-suction volute casing pump	147
C.2	Maximum attainable efficiencies, η_{max} , of single-stage, single-suction volute casing pumps dependent on specific speeds and rates of flow	148
C.3	Average attainable industrial pump efficiencies, η_{avg} , of single-stage, single-suction volute casing pumps dependent on specific speeds and rates of flow	149
E.1	Major features of an electric motor that affects efficiency	184
E.2	Motor efficiency versus load EPAct and NEMA premium comparison	191
E.3	Life cycle cost of an industrial AC induction motor	193
E.4	75 kW (100 hp) motor efficiency and power factor as a function of load	

E.5	VFD block diagram	197
E.6	VFD operator interface (OI)/user interface (UI)	197
E.7	VFD with optional bypass	199
E.8	Pump system components	200
E.9	Constant torque and variable torque pump load as a function of frequency or speed	201
E.10	A constant torque V/Hz ratio supplied to the motor	202
E.11	A variable torque V/Hz ratio supplied to the motor	202
	List of Tables	
1.1 F	Factor C _p /C _n for a single cost element after <i>n</i> years	12
1.2 [Discount factor (df) for constant yearly expenditures	14
1.3 S	Simple Payback	17
1.4 [Discounted payback (Net Present Value)	18
1.5 lı	nternal Rate of Return by trial and error	20
1.6 lı	nternal Rate of Return by Excel Function	20
2.1	Control methods – applications and limitations	26
2.2 A	Application ranges of positive displacement pumps	38
	Properties of commercially available PD pumps; PH/PS = hydraulic power /shaft power	40
2.4 F	Positive and negative aspects of specific transmissions	50
	Operation and annual operating cost of the three-branched biping system in the various operating modes	77
	Nork sheets (a) and (b) showing how the rate of flow s calculated by pumping down and filling a sump	79
	Cost comparison for energy cost for the 60 m ³ /h (260 USgpm) and 30 m ³ /h (130 USgpm) pumps	82
	Cost comparison for Options A through D in the system vith a failing control valve	85
B.1 C	Control methods – applications and limitations	134
B.2 S	Some control parameters used for pumps	136
D.1 S	Summary of Case Histories	153
E.1 II	EC 60034-30 compared to NEMA MG-1	191
E.2 N	Motor energy cost comparison	193