

Contents

Forewordxiii

14.3 Rotodynamic pump design and application1

14.3.1 Introduction.....1

14.3.1.1 Purpose1

14.3.1.2 Scope.....1

14.3.1.3 Preferred terms, units, and symbols for pump applications1

14.3.2 Rotodynamic pump classifications4

14.3.2.1 Pump types5

14.3.3 Performance.....23

14.3.3.1 Characteristic curves23

14.3.3.2 Pump and system curve interaction.....24

14.3.3.3 Typical curve shape25

14.3.3.4 Predicting pump performance after speed of rotation or limited impeller
diameter change (affinity rules)31

14.3.3.5 Variable speed drives.....36

14.3.4 Applications38

14.3.4.1 Pump selection process.....38

14.3.4.2 Continuous, intermittent, and cyclic service.....41

14.3.4.3 System pressure limitation.....41

14.3.4.4 Operation away from the best efficiency point (BEP).....42

14.3.4.5 Liquid temperature rise in a rotodynamic pump.....44

14.3.4.6 Pump priming.....49

14.3.4.7 Viscosity.....50

14.3.4.8 Two-phase flow.....50

14.3.4.9 Pumping foaming liquids55

14.3.4.10 Pumping liquids containing solids55

14.3.4.11 NPSHA considerations for temperature and elevation.....56

14.3.4.12 Special axial flow pump application considerations – siphon system68

14.3.4.13 Pump inlet69

14.3.4.14 Self-primer features73

14.3.4.15 Losses76

14.3.4.16 Startup and shutdown77

14.3.4.17 Pump and motor speed torque curves.....79

14.3.4.18 Valve position for startup85

14.3.4.19	Shutdown	87
14.3.4.20	Self-priming pumps, startup and shutdown considerations (valve position)	87
14.3.4.21	Reverse runaway speed	87
14.3.4.22	Waterhammer (hydraulic shock)	88
14.3.4.23	Vibration and dynamic analysis	89
14.3.4.24	Sound	89
14.3.5	Hydraulic features	92
14.3.5.1	Specific speed	92
14.3.5.2	Impeller	93
14.3.5.3	Impeller configurations	95
14.3.5.4	Casing design	99
14.3.5.5	Hydraulic loading	104
14.3.6	Mechanical features	137
14.3.6.1	Casing design	137
14.3.6.2	Column design (vertical pumps)	138
14.3.6.3	Discharge head (structural element)	141
14.3.6.4	Rotor shaft design	146
14.3.6.5	Design of vertical lineshaft	157
Appendix A	Introduction to general applications	161
Appendix B	Special effects pumps	171
Appendix C	Materials	194
Appendix D	Seals	201
Appendix E	Bearings	213
Appendix F	Lubrications systems	226
Appendix G	Couplings	235
Appendix H	Baseplates and foundations	240
Appendix I	Drivers	261
Appendix J	Monitoring and controls	280
Appendix K	References	282

Figures

Figure 14.3.2	Rotodynamic pump types	5
Figure 14.3.2.1.1a	OH0 pump	5
Figure 14.3.2.1.1b	OH1 pump	6
Figure 14.3.2.1.1c	OH1h	6
Figure 14.3.2.1.1d	OH2 pump	6
Figure 14.3.2.1.1e	OH3 pump	7
Figure 14.3.2.1.1f	OH4 pump	7
Figure 14.3.2.1.1g	OH5 pump	7
Figure 14.3.2.1.1h	OH5g pump	8
Figure 14.3.2.1.1i	OH6 pump	8
Figure 14.3.2.1.1j	OH7 pump	8
Figure 14.3.2.1.1k	OH7h pump	9
Figure 14.3.2.1.1l	OH8, OH8b pumps	9
Figure 14.3.2.1.1.1a	OH1i pump	10
Figure 14.3.2.1.1.1b	OH2i pump	10
Figure 14.3.2.1.1.1c	OH3i pump	10
Figure 14.3.2.1.1.1d	OH4i pump	11
Figure 14.3.2.1.1.1e	OH5i pump	11
Figure 14.3.2.1.1.1f	OH7i pump	12
Figure 14.3.2.1.1.1g	OH13i pump	12
Figure 14.3.2.1.1.2a	OH7j pump	13
Figure 14.3.2.1.1.2b	OH1j pump	13
Figure 14.3.2.1.1.2c	OH13j pump	13
Figure 14.3.2.1.2a	BB1 pump	13
Figure 14.3.2.1.2b	BB2 pump	14
Figure 14.3.2.1.2c	BB3 pump	14
Figure 14.3.2.1.2d	BB4 pump	14
Figure 14.3.2.1.2e	BB5 pump	15
Figure 14.3.2.1.3a	VS0 pump	15

Figure 14.3.2.1.3b	VS1 pump	16
Figure 14.3.2.1.3c	VS2 pump	16
Figure 14.3.2.1.3d	VS3 pump	16
Figure 14.3.2.1.3e	VS4 pump	17
Figure 14.3.2.1.3f	VS5 pump	17
Figure 14.3.2.1.3g	VS6 pump	18
Figure 14.3.2.1.3h	VS7 pump	18
Figure 14.3.2.1.3j	VS8 pump	18
Figure 14.3.2.1.3.1a	VS4i pump	19
Figure 14.3.2.1.3.1b	VS5i pump	19
Figure 14.3.2.1.4a	RT1 pump: overhung, close-coupled, side channel design	20
Figure 14.3.2.1.4b	RT2 pump: overhung, close-coupled, peripheral design	20
Figure 14.3.2.1.4c	RT3 pump: between-bearing, flexibly coupled, side channel design	20
Figure 14.3.2.1.4d	RT4 pump: between-bearing, flexibly coupled, peripheral design	21
Figure 14.3.2.1.5	OH0d Pitot tube pump	21
Figure 14.3.2.1.6.1a	CP1 close-coupled circulator pump	22
Figure 14.3.2.1.6.1b	CP2 close-coupled circulator pump	22
Figure 14.3.2.1.6.2	CP3 flexibly coupled circulator pump	22
Figure 14.3.3.1.1	Specific speed (n_s) examples	23
Figure 14.3.3.2	Simple system and pump performance curves	24
Figure 14.3.3.2.1	Operating point	24
Figure 14.3.3.3.1	Typical system curve shape	25
Figure 14.3.3.3.2	Head versus rate of flow of various specific speed pumps	26
Figure 14.3.3.3.2.4a	Curve with dip	27
Figure 14.3.3.3.2.4b	Dip occurring at trimming of Impeller	27
Figure 14.3.3.3.2.4c	Dip occurring with increase in pitch angle	27
Figure 14.3.3.3.2.5	Dip with hysteresis	28
Figure 14.3.3.3.3	Power versus rate of flow of various specific speed pumps	29
Figure 14.3.3.3.4	Efficiency versus rate of flow for various specific speed pumps	29
Figure 14.3.3.3.5a	NPSHR versus rate of flow for various specific speed pumps	30

Figure 14.3.3.3.5b	Datum plane for various pump designs at eye of first-stage impeller	30
Figure 14.3.3.4a	Impeller with straight outside diameter	32
Figure 14.3.3.4b	Impeller with angled outside diameter	33
Figure 14.3.3.4c	Impeller vane diameter reduction of a radial diffuser pump	33
Figure 14.3.3.4d	Vane overlap, radial flow impeller.	34
Figure 14.3.3.4.1	Mixed flow impeller trim	35
Figure 14.3.3.4.2	Typical axial flow pump impeller pitch angle	36
Figure 14.3.3.5.1a	Power consumption by discharge throttling	37
Figure 14.3.3.5.1b	Power consumption using a VSD	37
Figure 14.3.3.5.1c	Potential savings flat pump curve	38
Figure 14.3.3.5.1d	Potential savings steep pump curve	38
Figure 14.3.4.1.1.1a	Series operation.	39
Figure 14.3.4.1.1.1b	Pumps operating in series.	39
Figure 14.3.4.1.1.3	Pumps operating in parallel	40
Figure 14.3.4.1.1.3.1	H(Q) of different pumps in parallel operation	41
Figure 14.3.4.4.1	Typical preferred operating region (POR)	42
Figure 14.3.4.8	Two-phase pumping applications.	51
Figure 14.3.4.8.2	Effect of gas on pump performance	52
Figure 14.3.4.8.3a	Venting the eye of the impeller	53
Figure 14.3.4.8.3b	Top inlet impeller.	53
Figure 14.3.4.8.4a	Self-priming pump – construction industry	54
Figure 14.3.4.8.4b	Self-priming pump – chemical industry.	54
Figure 14.3.4.8.4c	Helico-axial multiphase pump	55
Figure 14.3.4.11.3.1–	Schematic of NPSHA calculation example in metric units (simple)	58
Figure 14.3.4.11.3.2	Schematic of NPSHA calculation example in metric units (complex)	59
Figure 14.3.4.11.3.3	Schematic of NPSHA calculation example in US customary units (simple)	61
Figure 14.3.4.11.3.4	Schematic of NPSHA calculation example in US customary units (complex)	62
Figure 14.3.4.11.6a	Vapor to liquid saturated volume ratio for water in degrees Celsi	65
Figure 14.3.4.11.6b	NPSHR reduction for pumps handling hydrocarbon liquids and high-temperature water (metric units).	66

Figure 14.3.4.11.6c	NPSHR reduction for pumps handling hydrocarbon liquids and high-temperature water (US customary units)	67
Figure 14.3.4.12	Siphon system	69
Figure 14.3.4.13a	Inlet configurations	70
Figure 14.3.4.13b	Tailpipe and float control	71
Figure 14.3.4.13c	Rate of flow versus minimum submergence	72
Figure 14.3.4.13.1	Suction cans with vents	73
Figure 14.3.4.14	Typical self-priming installation	74
Figure 14.3.4.17a	Torque versus speed template (metric units)	80
Figure 14.3.4.17b	Torque versus speed template (US customary units)	81
Figure 14.3.4.17c	Torque curve	81
Figure 14.3.4.17d	Plotting torque versus speed (metric units)	84
Figure 14.3.4.17e	Plotting torque versus speed (US customary units)	85
Figure 14.3.4.18.1	Axial pump with low system head	86
Figure 14.3.4.21	Reverse runaway speed versus specific speed when head equals pump head at BEP	88
Figure 14.3.4.24.2a	Combining sound pressure	91
Figure 14.3.4.24.2b	dBA correction for impeller trim and percent BEP operation	91
Figure 14.3.5.1	General impeller types	93
Figure 14.3.5.2.1.1	Single suction impeller	94
Figure 14.3.5.2.1.2	Single-stage, horizontal, double suction pump	95
Figure 14.3.5.3.1	Enclosed impeller	96
Figure 14.3.5.3.2a	Open impeller	97
Figure 14.3.5.3.2b	Semi-open impeller with a full back shroud	97
Figure 14.3.5.3.2c	Semi-open impeller with a scalloped back shroud	97
Figure 14.3.5.3.3	Typical Barske impeller	98
Figure 14.3.5.3.4	Typical vortex impellers	98
Figure 14.3.5.3.5a	Inducer, end suction pump	99
Figure 14.3.5.3.5b	Inducer, vertically suspended pump	99
Figure 14.3.5.4.1	Single volute casing	100
Figure 14.3.5.4.2	Double volute casing	100
Figure 14.3.5.4.3	Circular (concentric) casing	101

Figure 14.3.5.4.4	Diffuser casing	101
Figure 14.3.5.4.7	Typical bowl and stage casing	102
Figure 14.3.5.4.8	Self-primer casing.	103
Figure 14.3.5.4.9	Double suction casing – horizontal split case.	103
Figure 14.3.5.4.10	Double suction casing – vertically suspended	104
Figure 14.3.5.5.1.1.1	Approximate boundaries of radial thrust direction, single volute pump.	105
Figure 14.3.5.5.2a	Radial thrust factor for single volute with various specific speeds	107
Figure 14.3.5.5.2b	Radial thrust factor for double volute with various specific speeds.	107
Figure 14.3.5.5.2c	Sketch to illustrate D_2 and b_2	108
Figure 14.3.5.5.2d	Radial thrust factor for circular (concentric) casing typical for specific speed 20 (1,000)	109
Figure 14.3.5.5.3.2.1	Typical thrust profile	110
Figure 14.3.5.5.3.2.4	Alternate thrust balancing methods	111
Figure 14.3.5.5.3.3.1a	Pressure distribution on enclosed impeller.	112
Figure 14.3.5.5.3.3.1b	Enclosed impeller thrust factors for various specific speeds	114
Figure 14.3.5.5.3.3.1c	Average values of K_{Bal} , pressure reduction factor as a function of total balance hole area and rear wear ring clearance area.	115
Figure 14.3.5.5.3.3.1d	Enclosed impeller with plain back shroud.	116
Figure 14.3.5.5.3.3.1e	Enclosed impeller with back ring	119
Figure 14.3.5.5.3.3.2	Cross section of semi-open impeller showing diameter locations	125
Figure 14.3.5.5.3.3.3	Axial flow pump impeller dimensions	126
Figure 14.3.5.5.3.3.4a	Enclosed impeller plain top shroud, vertically suspended pump	127
Figure 14.3.5.5.3.3.4b	Semi-open impeller, vertically suspended pump	127
Figure 14.3.5.5.3.3.4c	Enclosed impeller with back ring and balance holes, vertically suspended pump	127
Figure 14.3.5.5.3.3.4d	Enclosed end of shaft at suction.	128
Figure 14.3.5.5.3.3.4e	Shaft sleeve through packing or mechanical seal.	128
Figure 14.3.5.5.3.3.4f	Shaft sleeve through pressure breakdown bushing.	128
Figure 14.3.5.5.3.3.5	Experimental thrust coefficient $C^{1,2}$	130
Figure 14.3.5.5.3.3.7	Axial thrust versus rate of flow curves	136
Figure 14.3.6.2.3a	Open lineshaft.	140
Figure 14.3.6.2.3b	Enclosed lineshaft.	140

Figure 14.3.6.3.2	Cast discharge head	141
Figure 14.3.6.3.3	Fabricated discharge head	142
Figure 14.3.6.3.4	Subsurface discharge head	143
Figure 14.3.6.3.5	Separate discharge types VS4 and VS5.	143
Figure 14.3.6.3.8a	Internal seal arrangement.	145
Figure 14.3.6.3.8b	Special seal arrangement.	146
Figure 14.3.6.4.1.1	Horizontal, between-bearings, axially split, multistage pump	147
Figure 14.3.6.4.2.1	Overhung impeller	149
Figure 14.3.6.4.2.2	Between-bearings, single-stage pump	150
Figure A.1	Turbine characteristics.	163
Figure A.2	Turbine performance	165
Figure A.3	Dry-pit pump, overhung, flexibly coupled, vertical, end suction.	166
Figure A.4	Dry-pit pump, overhung, close-coupled, vertical, end suction.	167
Figure A.5	Dry-pit pump, overhung, foot-mounted, flexibly coupled, horizontal, end suction	167
Figure A.6	Self-priming pump, construction industry	170
Figure A.7	Self-priming pump, chemical industry	170
Figure B.1	Regenerative turbine pump types and classifications	171
Figure B.2	Regenerative turbine, impeller between bearings, two-stage	172
Figure B.3	Regenerative turbine flow path	173
Figure B.4	Regenerative turbine pump performance	175
Figure B.5	Pitot tube pump	177
Figure B.6	Pitot tube pump rotating assembly (5).	178
Figure B.7	Pitot tube pump performance	181
Figure B.8	Vortex pump	183
Figure B.9	Screw centrifugal pump.	185
Figure B.10	Screw centrifugal pump impeller	186
Figure B.11	High-solidity (left) versus low-solidity (right) straight radial vane impeller common in gear driven high-speed pumps	188
Figure B.12	Solids-reduction pump.	191
Figure D.1	Stuffing box without lantern ring	202
Figure D.2	Stuffing box with lantern ring.	203

Figure D.3	Classification by Arrangement and Configuration	203
Figure D.4	Mechanical seal classification by design	204
Figure D.6	Seal chamber for internal cartridge seal	207
Figure D.7	Seal chamber for external component seal	207
Figure D.8	Types of bearing housing shaft seals	209
Figure D.9	Lip Seal	210
Figure D.10	Lip seal with secondary V-ring	210
Figure D.11	Bearing isolator	212
Figure E.1	Cylindrical-type radial journal (sleeve) bearing	217
Figure E.2	Pivot-shoe-type thrust bearing feed lubrication	217
Figure E.3	Pivot-shoe-type thrust bearing – complete with shaft-driven oil pump arranged for force-feed lubrication	218
Figure E.4	Type OH arrangement	219
Figure E.5	Type BB arrangement	219
Figure E.6	Vertical turbine and vertical sump pump	220
Figure F.1	Oil bath lubrication system with constant level oiler	230
Figure F.2	Slinger ring installation using a bearing cartridge for ease of installation	231
Figure F.3	Typical oil mist bearing construction	232
Figure F.4	Dry-start running times at different shaft speeds when applied to PTFE bearings	233
Figure F.5	Conversion example from enclosed lineshaft vertical pump (left) to open lineshaft (right)	234
Figure G.1	Head shaft coupling, rigid style, for hollow-shaft motor	238
Figure G.2	Flanged adjustable coupling, rigid style	239
Figure G.3	Flanged adjustable spacer coupling, rigid style	239
Figure H.1	Typical horizontal pump anchor bolt, leveling jack bolt, and grout design	242
Figure H.2	Grouted baseplate, fabricated steel	245
Figure H.3	- Grouted baseplate, cast iron	245
Figure H.4	Nongrout baseplate	246
Figure H.5	PregROUTED baseplate	247
Figure H.6	Soleplate	248
Figure H.7	Freestanding baseplate	249
Figure H.8	Baseplate mounting springs with slide bearing	249

Figure H.9 ASME B73.1 pump and baseplate250

Figure H.10 ISO pump and baseplate250

Figure H.11 Formed polymer baseplate251

Figure H.12 solid (polymer concrete) baseplate252

Figure H.13 Pedestal baseplate252

Figure H.14 Oil pipeline skid type baseplate.253

Figure H.15 Offshore skid type baseplate.254

Figure H.16 Three-point mount type baseplate.254

Figure H.17 Underside of the three-point mount baseplate (O, P, and Q show
the mounting points)255

Figure H.18 Typical vertical pump anchor bolt, leveling jack bolt, and grout design258

Figure I.1 Motor speed torque curve.267

Figure I.2 Design A, B, C, and D for AC motors268

Figure I.3 Outline of an internal combustion engine278

Tables

Table 14.3.1.3 Principal symbols.1

Table 14.3.4.5.3 Guidelines for minimum and maximum liquid temperature for gray iron, ductile iron,
carbon steel, chrome steel, austenitic stainless and duplex stainless steel pumps (°C)48

Table 14.3.4.11.6 Vapor to liquid saturated volume ratio for water at different temperatures64

Table 14.3.4.24.2 Multistage pump sound pressure reductions92

Table 14.3.5.5.3.3.1 Distance ratio from the casing wall to the impeller shroud to maximum
impeller diameter for various specific speeds.115

Table 14.3.6.2.1 Consideration for threaded versus flanged column138

Table C.1 Typical pump materials of construction194

Table E.1 Rolling element bearing types.214

Table E.2 Sleeve bearings materials.216

Table G.1 Shaft couplings - functions and parameters for selection235

Table H.1 Functions of a baseplate and parameters for selection243

Table I.1 Common motor enclosures263

Table I.2 IP classification system264

Table I.3 Drivers’ functions and parameters for selection267