

# AMCA Publication 801-01 (R2008)

## Industrial Process/Power Generation Fans: Specification Guidelines



**AIR MOVEMENT AND CONTROL  
ASSOCIATION INTERNATIONAL, INC.**

The International Authority on Air System Components

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# Industrial Process/Power Generation Fans: Specification Guidelines



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## RELATED AMCA STANDARDS

### For Air Performance:

ANSI/AMCA Standard 210      *Laboratory Method of Testing Fans for Aerodynamic Performance Rating*

AMCA Standard 803      *Industrial Process/Power Generation Fans: Site Performance Test Standard*

### For Sound:

AMCA Standard 300      *Reverberant Room Method for Sound Testing of Fans*

AMCA Standard 301      *Methods for Calculating Fan Sound Ratings from Laboratory Test Data*

### For Balance and Vibration:

ANSI/AMCA Standard 204      *Balance Quality and Vibration Levels for Fans*

### Industrial Process / Power Generation Series:

AMCA Publication 801      *Industrial Process/Power Generation Fans: Specification Guidelines*

AMCA Publication 802      *Industrial Process/Power Generation Fans: Establishing Performance Using Laboratory Models*

AMCA Standard 803      *Industrial Process/Power Generation Fans: Site Performance Test Standard*

### Fan Application Manual:

AMCA Publication 200      *Air Systems*

AMCA Publication 201      *Fans and Systems*

AMCA Publication 202      *Troubleshooting*

AMCA Publication 203      *Field Performance Measurement of Fan Systems*

## TABLE OF CONTENTS

<b>1. Purpose</b>	.1
<b>2. Scope</b>	.1
<b>3. Terminology</b>	.1
3.1 Rating criteria	.1
3.2 Design criteria	.2
3.3 Special features	.4
3.4 Sound criteria	.5
<b>4. Testing and Rating Methods</b>	.5
4.1 Laboratory test method	.5
4.2 Effects of appurtenances on fan performance	.5
4.3 Scaling effects and fan laws	.10
4.4 Rating tolerances	.11
4.5 Performance testing techniques	.12
4.6 Mechanical tests	.13
<b>5. Operation</b>	.14
5.1 Single fan operation	.14
5.2 Parallel fan operation	.14
5.3 Balance and vibration	.17
5.4 Duct vibrations and pulsations	.19
5.5 Implosion	.20
<b>6. Erosion, Corrosion and Build-Up</b>	.20
6.1 Erosion/corrosion	.20
6.2 Build-up	.21
<b>7. Leakage</b>	.21
7.1 Introduction	.21
7.2 Locations of leakage	.21

7.3	Shaft seals	21
7.4	Designing for low leakage	22
7.5	Verifying leakage	22
7.6	Associated issues	22
<b>8.</b>	<b>Fan Sound</b>	<b>22</b>
8.1	Applicable sound publications	22
8.2	Acoustical terminology and symbols	23
8.3	Laboratory test methods	23
8.4	Sound power level conversion methods	24
8.5	Prediction of on-site sound pressure levels	24
8.6	Measurement of on-site sound pressure levels	25
8.7	Methods of sound attenuation	25
<b>9.</b>	<b>Motor Sizing Considerations</b>	<b>28</b>
9.1	Motor capability	28
9.2	Aerodynamic considerations	28
9.3	Mechanical considerations	29
<b>10.</b>	<b>Quality Assurance</b>	<b>30</b>
10.1	quality assurance manual	30
10.2	quality assurance department	30
<b>11.</b>	<b>Spare Parts</b>	<b>30</b>
<b>12.</b>	<b>Storage or Long Shutdowns</b>	<b>30</b>
<b>13.</b>	<b>Analyses Available for Fans</b>	<b>31</b>
13.1	Analysis of the fan impeller only	31
13.2	Analysis of the fan rotor and supporting structure	32
<b>14.</b>	<b>Information Necessary to Properly Select a Fan</b>	<b>32</b>
14.1	General information	32
14.2	Performance requirements	33
14.3	Construction and special requirements	33
14.4	Sound requirements	34

14.5 Test requirements . . . . .	34
14.6 Quality assurance . . . . .	34
14.7 Spare parts requirements . . . . .	34
14.8 Storage requirements . . . . .	34
<b>15. Information Necessary to Properly Evaluate a Fan Proposal . . . . .</b>	<b>36</b>
15.1 Fan rating practice . . . . .	36
15.2 Recommended fan proposal . . . . .	36
15.3 Dimensional information . . . . .	42
15.4 Typical amca configurations . . . . .	42
15.5 Economic evaluation . . . . .	42



## INDEX BY FAN APPLICATION

The following is a list of common industrial fan applications that includes types of fans typically employed, major design considerations, and corresponding sections of this document. Users of this publication can employ this table as a guideline for specific applications as well as an index to related topics.

### KEY TO FAN TYPES:

AF = airfoil  
 BC = backward curved  
 BI = backward inclined  
 FC = forward curved  
 PW = paddle wheel  
 RT = radial tip  
 VA = vaneaxial

### INDUSTRIAL PROCESS FANS

Application	Typical Fan Employed	Usual Major Consideration	Applicable 801 Section
A. CLEAN AIR, SUPPLY, and GENERAL VENTILATION	BI/BC AF VA FC Radial blade	Sound Efficiency Means of control Indoor, outdoor	4.2.8; 8 (all) 5 (all) 4.2.2-5
B. CONVEYING MATERIAL	Radial blade PW	Durability-impact on impeller, shaft, bearings Capture velocities, Entrainment velocity, Equivalent density, (includes material conveyed) Wear  Build up Leakage from housing & around shaft	3.2 (all)  3.1.9-10 3.3.6-12; 4.2.7; 6 (all) 6 (all); esp. 6.2  3.3.3; 7 (all)
C. HOT GAS RECIRCULATION "DRYERS" <540°C (1000°F)	All	Spark resistance, dependent upon material Temperature Rate of temperature change Sealing and leakage Bearing cooling & lubrication Insulation Durability Method of support & materials of construction	3.2.13; 3.3.2 3.2.13; 3.3.2 3.3.3; 7 (all)       3.3.2; 7.3.8; 7.6.4

### INDUSTRIAL PROCESS FANS

Application	Typical Fan Employed	Usual Major Consideration	Applicable 801 Section
D. GENERAL EXHAUST HOODS	All	Wear Corrosion Sealing Noise Temperature Toxicity	3.3.6-12; 4.2.7; 6 (all) 6 (all) 7 (all) 4.2.8; 8 (all) 3.2.13; 3.3.2 6.1
E. CORROSIVE FUME/GAS/ODOR CONTROL	All	Corrosion Seal Material Paint Coatings Spark resistance Explosion resistance Air density High tip speed Noise Build-up	6.1 3.3.3; 7.3 6.1-2  7.6.1  3.1.9-10  8 (all) 6.2
F. AIR CLEANING SCRUBBER BOOSTER FAN BAG HOUSE FAN	AF, BI/BC (clean air) RT, PW (dirty gas)	Air density High tip speed Noise Build-up High pressure Wear & corrosion	3.1.9-10  8 (all) 6.2  3.3.6-12; 6.1
G. PELLETIZING/ SINTERING	BI/BC (limited appl.) Radial blade RT VA (sinter cooling)	Wear (severe) High temperature Rate of temperature change Build up Vibration	3.3.6-12; 6.1 3.2.13 3.2.13 6.2 3.2.11

**INDUSTRIAL PROCESS FANS**

Application	Typical Fan Employed	Usual Major Consideration	Applicable 801 Section
H. MINING AND TUNNEL	VA AF BI/BC	Efficiency Sound Reliability Flow reversal Explosion resistance Spark resistance Corrosion Wear Mine safety & government reg.	4.2.8; 8 (all)     7.6.1 6.1 3.3.6-12; 6.2
I. EXPLOSIVE GAS	All	Spark resistance Explosion doors and protection Leakage-housing & shaft Corrosion	7.6.1  7.1-5 6.1
J. INCINERATION	Radial blade BI/BC AF (Depends on material being burned)	Air composition Wear Toxic gas High Temperature Rate of temperature change Sound (residential areas) High tip speed construction Leakage Sealing Reliability	3.3.6-12; 4.2.7; 6.1   3.2.13; 3.3.2 3.2.13; 3.3.2 4.2.8; 8 (all)  7.1-7.6 7.1-7.6
K. BASIC OXYGEN (System operates at shut off and periodically goes to full flow)	Radial blade BI/BC	Non-surge & stability over range of operation Gas tightness High tip speed construction Starts and stops Wear (water erosion) Build up Corrosion	5 (all) 7.1-7.6  9.3.6 3.3.6-12; 4.2.7; 6.1 6.2 6.1

### Industrial Process Fans

Application	Typical Fan Employed	Usual Major Consideration	Applicable 801 Section
L. HOT GAS EXHAUST (Coal Drying Kiln)	All	Duty cycle Build up Wear High temperature Rate of temperature change	6.2 3.3.6-12; 4.2.7; 6.1 3.2.13; 3.3.2 3.2.13; 3.3.2
M. HIGH PRESSURE BLOWERS (Combustion air)	Radial blade BI/BC AF	High tip speed construction Bearing thrust & max. bearing speed Leakage and seals Air Dynamics: Mach number, compressibility, regain, noise Stability-turn down ratio	3.3.5 7.1-6 5 (all)
N. HIGH TEMPERATURE FANS >540°C (1000°F)	All	Thermal expansion Structural integrity Bearings-cooling & lubrication Materials of construction Insulation Corrosion	3.2.13; 3.3.2 3.3.5 6.1
O. BRAKE FAN (Power absorption fan) Absorb power in spillways, etc. when dropping gates.	BI/BC (running backwards) FC	High power (for volume and pressure)	
P. FOOD & TEXTILE (Smooth finish fan)	AF BI/BC Radial blade	Super smooth finish Stainless construction	7.6.2

**POWER GENERATION FANS**

Application	Typical Fan Employed	Usual Major Consideration	Applicable 801 Section
<b>A. FORCED DRAFT (FD)</b>	AF	Efficiency & operating point	3.1.13-16
1. Supplies combustion air to a boiler	BI/BC FC VA	Means of control- turndown & leakage Indoor/outdoor operation	4.2 9.3.6
2. Provides excess air for complete combustion.		Sound Reliability (mechanical) Stress analysis &	8.4.2.8 3.2 (all); 13 (all)
3. Overcomes losses from fan to balance draft point in boiler.		structural specs Quality assurance programs	3.2 (all); 13 (all) 10; (all)
<b>B. INDUCED DRAFT (ID)</b>	AF	Same as FD +	See A, above, plus:
1. Exhausts products of combustion	BI/BC FC VA RT	Air analysis & density Corrosion Wear	3.1.9-10 6 (all) 3.3.6-12; 4.2.7; 6 (all)
2. Exhausts excess air		Turning gear	3.3.1
3. Provides necessary draft at fire and overcomes losses to the end of the system minus any natural draft.		Maximum temperature Rate of temperature change Leakage-housing & seals Means of support for thermal expansion	3.2.13; 3.3.2 3.2.13; 3.3.2 3.3.3; 7 (all) 3.3.2; 7.6.4; 9.3.8
<b>C. PRIMARY AIR HOT</b>	AF	Same as FD +	See A, above, plus:
1. Transports powdered fuel from pulverizer to burner.	BI/BC Radial blade	Temperature Wear Leakage-housing & seals	3.2.13 6 (all) 7 (all)
2. Provides some combustion air.			
3. Makes up for some leakage out of the boiler.			
4. Takes air after air heater and fan overcomes losses in transporting fuel plus air losses minus energy from the FD fan.			
<b>COLD</b>			
1. Air is taken from ambient sources.	VA		
2. See HOT #1 through #3 above.			

**POWER GENERATION FANS**

Application	Typical Fan Employed	Usual Major Consideration	Applicable 801 Section
D. FLUIDIZED BED BOILER 1. Provides some combustion air. 2. Floats bed	AF BI/BC Radial blade	Very high pressure High stress High fixed resistance	5 (all) 3.2 (all) 5 (all)
E. GAS RECIRCULATION 1. Redirects boiler gases increasing mass flow through various parts of the furnace, superheaters, reheaters, economizers. 2. Tempers hot gases in the boiler to 1040°C (1900°F). 3. Overcomes losses though boiler passages & the recirculation ductwork.	AF BI/BC RT	Same as I.D. + Shut off pressure considerations Leakage-housing & seals	See B, above, plus:  5 (all) 3.3.3; 7 (all)
F. OVERFIRE AIR 1. Delivers air over the fire to improve combustion and reduce smoking. 2. Reduced FD requirements, overcomes piping losses and provides turbulent mixing action.	AF BI/BC	Same as FD	See A, above

**POWER GENERATION FANS**

Application	Typical Fan Employed	Usual Major Consideration	Applicable 801 Section
G. FLUE GAS DESULFURIZATION (FGD) BOOSTER In series with ID fan to provide added pressure capability to overcome air pollution devices in retrofit application.	Same as ID fan lower temperature	Same as ID but at	Same as B, above
H. INDIRECT REHEAT Adds clean heated air to system	Same as FD	Same as FD	Same as A, above.
I. SECONDARY AIR Provides additional combustion air	Same as FD	Same as FD	Same as A, above
J. CYCLONE BURNER Provides combustion air plus energy to produce cyclonic action in burner and furnace.	Same as FD	Same as FD	Same as A, above
K. SEAL AIR 1. Provides clean air to chamber surrounding furnace 2. Creates pressure large enough to prevent the escape of dirty gas from the furnace and any auxiliary (dampers, etc.)	AF, BI/BC	Same as FD	Similar to those listed under A
L. WASTE ENERGY FAN 1. Takes hot gases including waste from waste heat boiler.	Same as ID	Build up Clogging of parts	6 (all)

# Industrial Process/Power Generation Fans: Specification Guidelines

## 1. Purpose

The purpose of this publication is to familiarize the reader with the practices fan manufacturers follow in the specification of fan equipment, and to provide application information. Good communication will be ensured if recommendations given herein are followed.

There are numerous fan manufacturers supplying equipment to industry throughout the world. Due to differences in rating and proposal practices among fan manufacturers, it is vitally important that the consulting engineer, system designer, and the user thoroughly understand all fan-related concepts. Conversely, it is the responsibility of the fan manufacturers to explain these practices and, if possible, develop a common method of presenting information that will aid in making a proper equipment evaluation. This will ensure a more systematic approach to the testing, rating, specification, and construction of industrial process and power generation fans.

## 2. Scope

This publication provides information on testing and rating industrial process and power generation fans, and covers construction features and related appurtenances. Sample equipment specifications are included which outline information a fan manufacturer requires to select the best fan for an application. Common fan industry practices are also defined and explained.

## 3. Terminology

The following list of terms and their related symbols will be applied to testing, rating, specifications, and construction of industrial process and power generation fans. To avoid confusion and misunderstanding, this terminology should be used.

### 3.1 Rating criteria

**3.1.1 Fan.** A fan is a device that utilizes a power-driven rotating impeller for moving air and has at least one inlet opening and one outlet opening. The

openings may or may not have elements for connection to ductwork. A fan may have various appurtenances that affect aerodynamic performance. It is necessary to establish which appurtenances are to be considered part of the fan.

**3.1.2 Fan inlet.** The plane perpendicular to the airstream where it first meets the inlet cone, the inlet box or other appurtenances furnished by the fan manufacturer. In this publication, the fan inlet is indicated by "Plane 1". (See Figures 15.4 and 15.5.)

**3.1.3 Fan outlet.** The plane perpendicular to the airstream at the outlet opening of the fan, the outlet opening at the evasé or diffuser or other appurtenances furnished by the fan manufacturer. In this publication, the fan outlet is indicated by "Plane 2". (See Figures 15.4 and 15.5.)

**3.1.4 Air.** A mixture of gases; also, a term commonly used to denote any gaseous medium measured, moved or controlled and which may include solid or liquid particulate.

**3.1.5 Fan airflow rate.** The volumetric airflow rate at fan air density at the fan inlet.

**3.1.6 Total pressure.** The air pressure that exists by virtue of the degree of compression and the rate of motion. It is the algebraic sum of the velocity pressure and the static pressure at a point.

**3.1.7 Velocity pressure.** The portion of the air pressure that exists by virtue of the rate of motion only. It is always positive.

**3.1.8 Static pressure.** The portion of the air pressure that exists by virtue of the degree of compression only. It may be positive or negative relative to the ambient atmospheric pressure.

**3.1.9 Fan pressure relationships and interpretations.** The definitions of total pressure, velocity pressure, and static pressure are presented in Sections 3.1.6 to 3.1.8. However, when applying these definitions to fan performance, there are distinct relationships that exist between each variable. This section describes these relationships.

**3.1.9.1 Fan total pressure ( $P_t$ ).** The difference between the total pressure at the fan outlet and the total pressure at the fan inlet.

$$P_t = P_{t2} - P_{t1}$$