

**DETAILED ENGINEERING DESCRIPTION AND MECHANICAL  
FEATURES OF CONTINENTAL INDUSTRIE MULTISTAGE CENTRIFUGAL  
BLOWER MODEL 020**

## **I - BLOWER HOUSING**

The centrifugal blower housing consists of an inlet head with special feature to direct air to inlet of first impeller and outlet head of special design to eliminate friction and multiple intermediate sections. These parts are made in cast aluminium according to rigid Continental Industrie specifications, extreme care to be exercised in assembly of interlocking cast aluminium intermediate sections and annular diffusers (baffles).

The entire assembly is securely held together actually with multiple tension rods which bind the entire housing into a solid integral unit.

### **1.0 Inlet head**

- 1.1 Flange connection DN 150, PN 10 (6")
- 1.2 Cast aluminium EN-AC-42000 (ASTM 360.1)
- 1.3 Minimum wall thickness: 5 mm (0.20")
- 1.4 Can be supplied in various flange positions relative to the vertical centre line in increments of 90° (option)

### **2.0 Outlet head**

- 2.1 Flange connection DN 125, PN 10 (5").
- 2.2 Cast aluminium EN-AC-42000 (ASTM 360.1)
- 2.3 Minimum wall thickness: 5 mm (0.20")
- 2.4 Can be supplied in various flange positions relative to the vertical centre line in increments of 90° (option)

### **3.0 Intermediate section**

- 3.1 Cast aluminium EN-AC-42000 (ASTM 360.1).
- 3.2 Each intermediate section is cast in one piece

### **4.0 Bearing housing**

The outboard bearing housings are cast aluminium and bolted to the outside of the head sections insuring cool operation of bearings.

- 4.1 Cast aluminium EN-AC-42000 (ASTM 360.1).
- 4.2 Has cast fins to improve rigidity and increase heat dissipation
- 4.3 Felt joint seal.
- 4.4 Provided with 2 tapped holes in the housing flange to act as bearing puller.

**N.B.:** When the inlet air or gas temperature is too high, we can adapt as option special bearing housings with a water or air cooling system (technical drawing on request).

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## 5.0 Bearings

- 5.1 The rotor assembly is supported by 2 heavy duty grease lubricated ball bearings, single row, sized to withstand the thrust load also type SKF or FAG.
- 5.2 Sized for minimum 10 years of operation (Direct Drive only), following SKF L10 bearing life calculation method.
- 5.3 Bearings are mounted in outboard type bearing housings and located so that bearings may be serviced without disassembling the blower casing or piping.

## 6.0 Shaft

- 6.1 C35 (AISI 1035) carbon steel shaft, straightened and stressrelieved
- 6.2 Shaft is ground all over
- 6.3 Stiff shaft design to minimize vibration
- 6.4 The diameter of the shaft end is 38 mm (1.5")

## 7.0 Shaft seals

- 7.1 Shaft sealing is accomplished using graphite ring seals or carbon ring seals.

## 8.0 Impellers

- 8.1 The impellers are in cast aluminium, in EN AC-43100 (AISI 360.1).
- 8.2 For minimum corrosion all aluminium alloys are non copper alloys
- 8.3 The outer diameter of the impeller is 409 mm (16")
- 8.4 Each impeller is automatically sanded or shotted when leaving the foundry before the machining
- 8.5 Each impeller is statically balanced.
- 8.6 Impeller tip speed: 75 m/sec (246 FPS) at 3600 rpm.
- 8.7 First critical speed (10 stages) 4620 rpm.
- 8.8 Impeller assembly: to consist of a heavy steel shaft accurately machined and one or more aluminium alloy cast impeller(s), statically balanced, securely keyed to shaft and held in place by lock washers and locknuts.



## 9.0 Casing assembly

- 9.1 Vertically split assembly
- 9.2 Heads and sections have machined male and female joints to maintain concentricity
- 9.3 Entire casing is retained together with  $\varnothing$  14 mm O.D.
- 9.4 Joints are made gas tight with silicone sealant with following characteristics:

Viscosity	pasty mastic glue
max. space [mm]	6
Setting time	10 mn - 24 h
Shearing's resistance [DAN/cm <sup>2</sup> ]	33
Break's resistance [DAN/cm <sup>2</sup> ]	8
Max. temperature of use [°C]	-60 +260
Specific weight	1,06 at 25 °C
Hardness	35 SHA
Extension	460 %

## 10.0 Rotor assembly

- 10.1 Impellers, spacer are assembled on the shaft with a push to light press fit requiring little or no heat
- 10.2 Impellers, spacers are held together axially by a conventional locknut assembly
- 10.3 All impellers are keyed to shaft using a staggered key arrangement.
- 10.4 The impeller hub is fitted with a shrunk to pre-stress the bore and minimize rubbing. This also eliminates the relative thermal expansion and contraction since hubs and shaft are manufactured with different materials.
- 10.5 The rotor assembly is dynamically balanced on a computerized balancing machine

## 11.0 Lubrication system

- 11.1 The bearing housings are grease lubricated (see detailed description in installation, use & maintenance manual).

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## 12.0 Recommended maximum allowable Piping forces and moments on blower connections

### 12.1 Inlet flange

<b>FX = 30 KG</b>	<b>FY = 75 Kg</b>	<b>FZ = 60 Kg</b>
<b>MX = 30 kgm</b>	<b>MY = 15 kgm</b>	<b>MZ = 15 kgm</b>

### 12.2 Outlet flange

<b>FX = 25 KG</b>	<b>FY = 65 Kg</b>	<b>FZ = 50 Kg</b>
<b>MX = 36 kgm</b>	<b>MY = 18 kgm</b>	<b>MZ = 18 kgm</b>

where :

**F** = force

**M** = moment

**X** = Axial - parallel to rotor centre line

**Y** = Vertical

**Z** = Horizontal - normal to rotor centre line.

## 13.0 Vibration and noise

Vibration tolerance: 4,5 mm/s RMS

Vibration shall not exceed 4,5 mm/s RMS when measured in the vertical plane at the bearing housings with the blower operating at the design speed.

Sound level: please refer to the calculation data sheet

## **II - PERFORMANCES**

1. All tests if required are in conformity with ASME Power Test Code.

2. For constant speed blowers:

- The head shall be within the range of 100% - 105% of the normal head at design capacity,
- The horsepower based on measured head shall not exceed 107% of the value at the specified normal operating point.

3. For variable speed machines:

- through the rotational speed, the head shall be adjusted as close as possible to the design point, with zero negative tolerance,
- the horsepower at that point shall not exceed 104% of the predicted shaft power value.

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