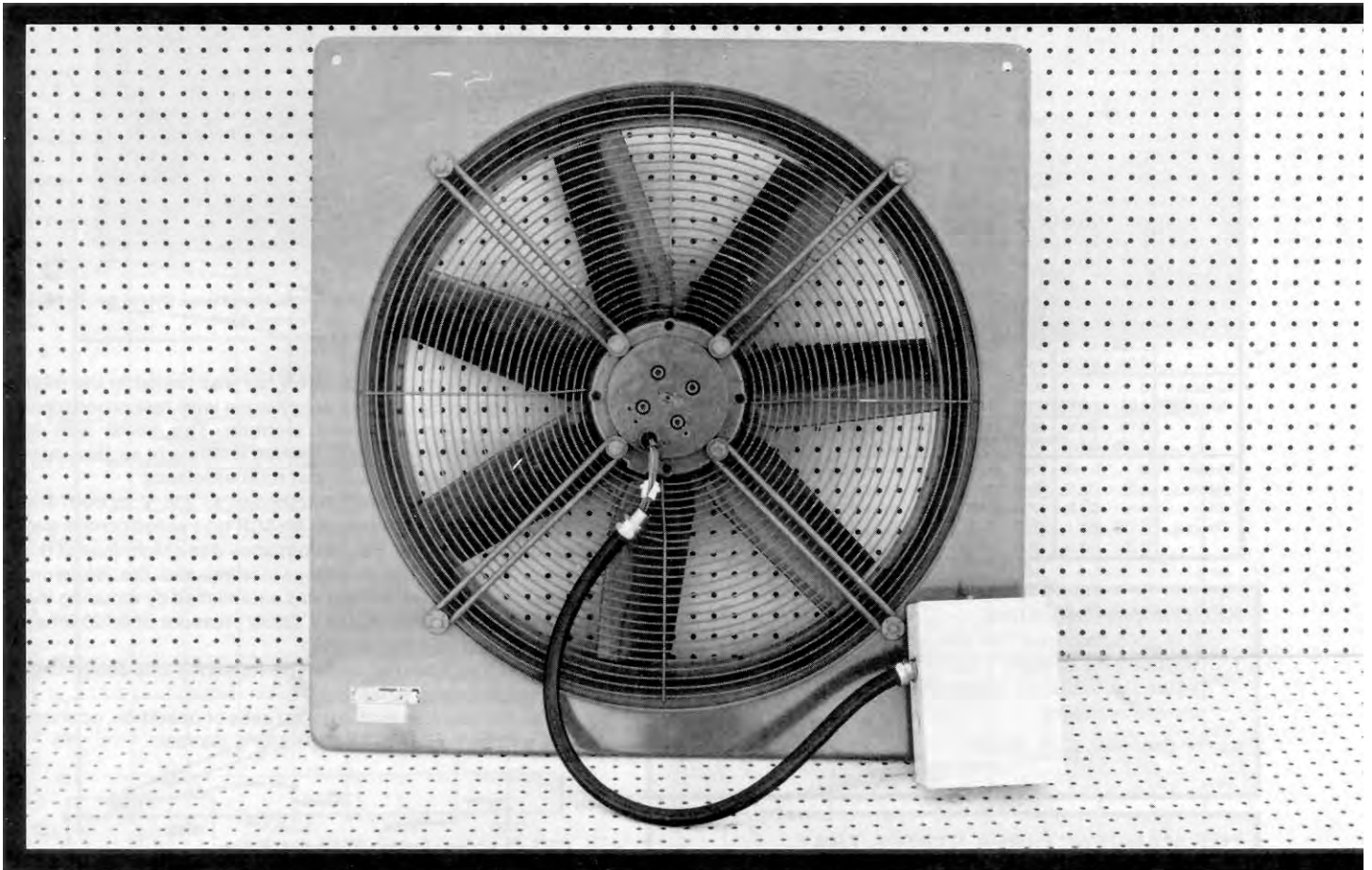


EVALUATION REPORT

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Ziehl-Abegg Model 631-6 Ventilation Fan

A Co-operative Program Between



ALBERTA
FARM
MACHINERY
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CENTRE



PRAIRIE AGRICULTURAL MACHINERY INSTITUTE

ZIEHL-ABEGG MODEL 631-6 VENTILATION FAN

MANUFACTURER:

Ziehl-Abegg GmbH & Co. KG
 Postfach 1165, Zeppelinstrasse 28
 D-71118 Kunzelsau
 West Germany

DISTRIBUTOR:

Aston Industries Inc.
 P.O. Box 220
 St. Leonard d'Aston, Quebec
 J0C 1M0

RETAIL PRICE:

\$548.00 (June, 1984, f.o.b. Lethbridge, Alberta complete with optional louvres).

SUMMARY OF RESULTS

TABLE 1. Ziehl-Abegg Model 631-6 Fan Performance at Typical Levels of Operation.

SETTING	STATIC PRESSURE in wg (Pa)	AIR FLOW RATE cfm (L/s)	INPUT POWER hp (W)	TOTAL EFFICIENCY %	FAN SPEED rpm
Single Speed	0 (0)	8090 (3820)	1.27 (945)	33	1038
	0.05 (12.5)	7920 (3740)	1.28 (957)	34	1032
	0.10 (24.9)	7690 (3630)	1.30 (972)	35	1025
	0.125 (31.1)	7570 (3570)	1.31 (978)	36	1023
Variable Maximum	0 (0)	7970 (3760)	1.26 (939)	31	1021
	0.05 (12.5)	7760 (3660)	1.28 (954)	32	1012
	0.10 (24.9)	7530 (3550)	1.29 (962)	33	1010
	0.125 (31.1)	7410 (3500)	1.30 (972)	34	999
Variable Mid Range	0 (0)	6450 (3040)	1.08 (808)	19	818
	0.05 (12.5)	6100 (2880)	1.09 (816)	20	800
	0.10 (24.9)	5660 (2670)	1.10 (822)	20	788
	0.125 (31.1)	5470 (2580)	1.11 (829)	20	783
Variable Minimum	0 (0)	4030 (1900)	0.68 (510)	7	511
	0.05 (12.5)	3500 (1650)	0.69 (511)	8	495
	0.10 (24.9)	2600 (1230)	0.69 (512)	7	486
	0.125 (31.1)	1870 (884)	0.68 (510)	5	534
Single Speed With Louvres	0 (0)	7150 (3370)	1.32 (988)	22	1011
	0.05 (12.5)	6980 (3290)	1.34 (997)	23	1010
	0.10 (24.9)	6700 (3160)	1.35 (1010)	24	1010
	0.125 (31.1)	6550 (3090)	1.35 (1010)	25	1011
	0.25 (62.3)	5800 (2740)	1.36 (1020)	26	1005

RECOMMENDATIONS

It is recommended that the manufacturer consider:

- Updating the operator's manual to include the model 631-6 as well as including information on fan maintenance and trouble shooting.

Senior Engineer: E. H. Wiens

Project Engineer: R. P. Atkins

THE MANUFACTURER STATES THAT

With regard to recommendation number:

- Due to the compactness and high quality of the motor fabrication, this piece of equipment is maintenance free in all mounting positions. Because of the in-stream, air-cooled design, our motor has long life at very low noise levels. The only care or attention to be given our fan is to keep the grating free of any foreign matter at all times. The same attention should also be given to the venturi casing and cradle mounting. In case of motor stoppage, contact the company's maintenance official or send it back to the supplier for replacement or capacitor replacement procedures.

GENERAL DESCRIPTION

The Ziehl-Abegg model 631-6 ventilation fan is a 24.5 in (622 mm) diameter variable speed, direct drive, propeller type axial flow fan. It is primarily used in livestock and poultry barns as

an exhaust fan located in the wall or ceiling.

The Ziehl-Abegg 631-6 is a flush mounted unit equipped with an inlet guard grill, an inlet bell and optional shutters. A two speed control, a variable speed control and a thermostat are available as options, but were not supplied with the fan. The seven blade propeller and hub are made of cast aluminum. The external rotor of the motor forms the hub of the fan. A 1.61 hp (1200 W), single phase, 240 V external rotor motor, with external terminal box for electrical hook-up, is used. The galvanized sheet metal housing and steel motor mounts are coated with a heavy enamel for corrosion protection.

FIGURE 1 shows the location of major components while detailed specifications are given in APPENDIX I.

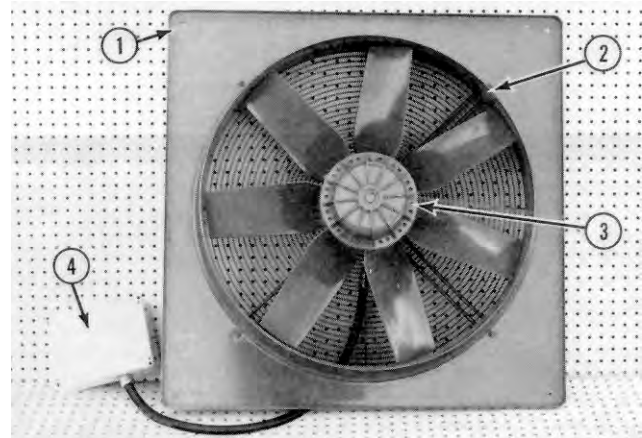


FIGURE 1. Ziehl-Abegg Model 631-6 Fan: (1) Mounting Flange, (2) Inlet Bell, (3) External Rotor & Hub Assembly, (4) External Terminal Box.

SCOPE OF TEST

The Ziehl-Abegg model 631-6 fan was tested in the inlet chamber setup (Figure 2) in accordance with test procedures developed by the Machinery Institute. The intent was to determine the performance of the fan in terms of air flow rate, static pressure, input power and total efficiency.

Fan performance was determined at 230 V in both the variable and single speed mode. An SCR type speed control was used to vary the speed. Fan performance was determined at the maximum setting, the mid-range setting and the minimum setting. The minimum setting was established by reducing the fan speed to the point where a static pressure of 0.125 in wg (31.1 Pa) could still be obtained.

The effect of louvres on fan performance was determined in the single speed mode only.

The fan was also evaluated for ease of operation, operator safety and suitability of the operator's manual.

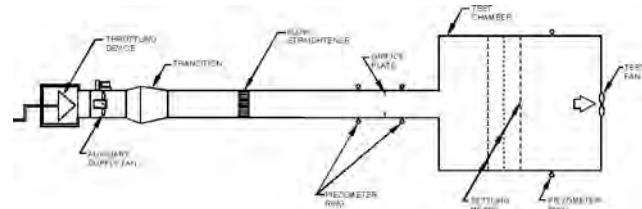


FIGURE 2. Schematic of Fan Test Apparatus - Inlet Chamber Setup.

RESULTS AND DISCUSSION

FAN PERFORMANCE

All fan performance results in this report are given at standard air¹ conditions so that direct comparisons can be made with other fan test reports. Fan performance under actual operating conditions could differ from these results by up to 10%, depending on such things as temperature, barometric pressure, humidity and elevation above sea level.

Air Flow Rate: Fan output in both the single speed mode and at the maximum setting on the variable speed control were

¹Standard air is air with a density of 0.075 lbm/ft³ (1.2 kg/m³) which occurs at 68°F (20°C), 50% relative humidity and a barometric pressure of 29.92 in Hg (101.325 kPa).

similar (FIGURE 3). Reducing the fan speed, greatly reduced the air flow rate for a given static pressure². For example, at a static pressure of 0.125 in wg (31.1 Pa), reducing the speed from maximum to mid range to minimum setting, reduced the air flow rate from 7410 cfm (3550 L/s) to 5470 cfm (2580 L/s) to 1870 cfm (884 L/s) respectively. At higher static pressures the reductions were even larger.

Air flow rates at typical levels of operation (i.e. static pressure) are given in TABLE 1. Ventilation fans are often rated on their output at a static pressure of 0.125 in wg (31.1 Pa). The manufacturer's rated air flow rate at 0.125 in wg (31.1 Pa), in the single speed mode, was 7200 cfm (3400 L/s). PAMI's measured flow rate at the same conditions was 7570 cfm (3570 L/s) or 5% higher than the manufacturer's rating.

The manufacturer provided fan performance information at other levels of operation in the form of a performance curve. The graph provided was not easily interpreted and there was difficulty in accurately determining air flow rates for various static pressures. The manufacturer is encouraged to modify their sales literature such that the fan performance information given can be used to its full advantage.

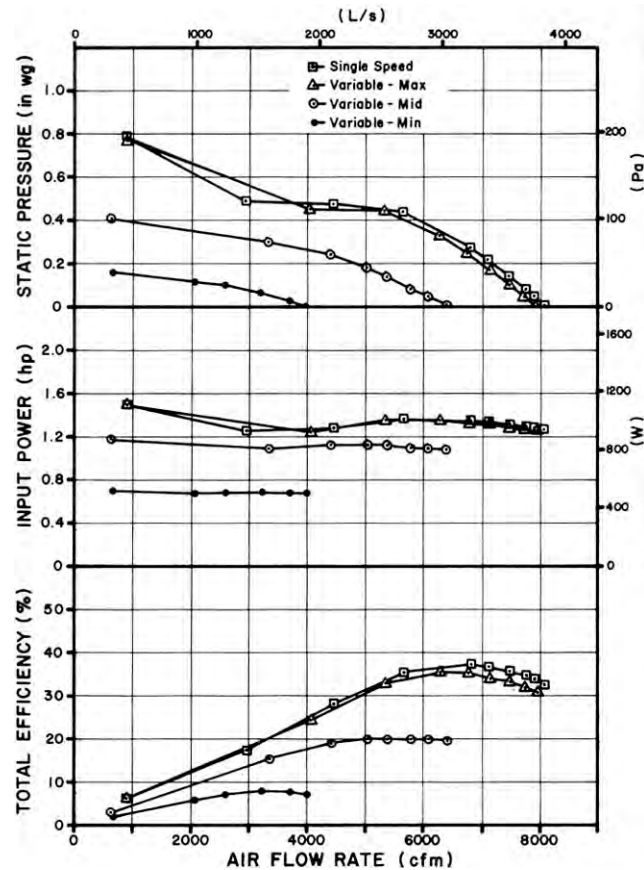


FIGURE 3. Ziehl-Abegg 631-6 Fan Performance Curves in the Single Speed Mode and at Three Speed Settings in the Variable Speed Mode.

Power Requirements: The power required to run the fan depended on fan speed. For typical levels of static pressure (TABLE 1), the input power varied from 1.26 to 1.33 hp (939 to 994 W) at maximum speed, from 1.08 to 1.12 hp (808 to 835 W) at mid range and from 0.68 to 0.69 hp (510 to 512 W) at minimum speed. The maximum amperage drawn by the motor was 5.0 amps, which was the same as the rated motor amperage.

Total Efficiency: Total efficiency is the ratio of air horsepower over the input power. Air horsepower is dependent upon the air flow rate and corresponding total pressure. For typical levels of operation, the total efficiency (TABLE 1) ranged from 31 to 35% at maximum speed, 19 to 20% at mid range and

²Static pressure is a measure of the pressure difference between the pressure inside the building and the pressure on the outside of the building. Static pressure is usually expressed in inches of water gauge (in wg) or Pascals (Pa).

5 to 8% at minimum speed. The total efficiency at maximum fan speed and a static pressure of 0.125 in wg (31.1 Pa) was 34%.

Effect of Louvres: The optional louvres were installed on the outlet side of the fan (FIGURE 4) to determine their effect on fan output. The fan was tested under these conditions in the single speed mode only. Using the louvres reduced the air flow rate by 12 to 17% (FIGURE 5) over the typical range of operation. For example, at a static pressure of 0.125 in wg (31.1 Pa), the louvres reduced the air flow rate by 13%, from 7570 cfm (3570 L/s) to 6550 cfm (3090 L/s) (TABLE 1). The efficiency was in turn reduced from 36 to 25%. The use of other control devices such as shutters, dampers, screens, and hoods would also reduce air flow rates by varying amounts. The use of such control devices have to be taken into consideration when designing a ventilation system.

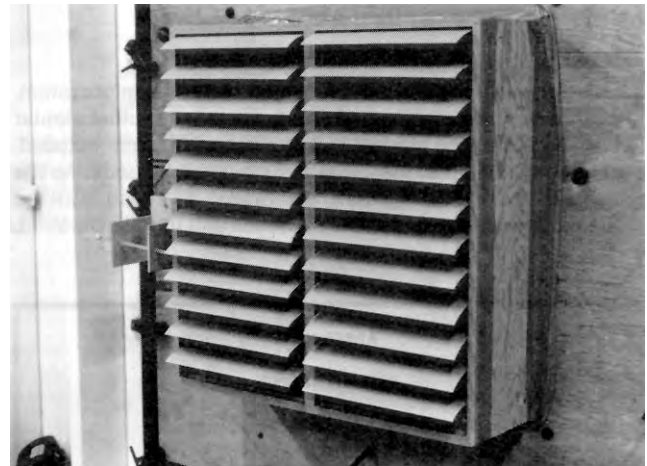


FIGURE 4. Louvres Located on Fan Discharge.

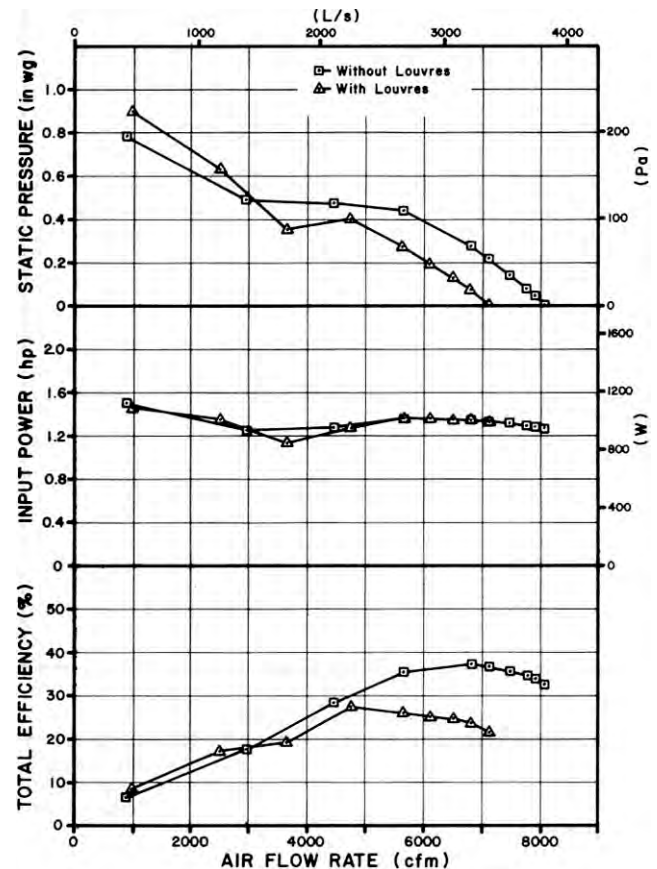


FIGURE 5. Effect of Louvres on Fan Performance.

EASE OF OPERATION

Maintenance: No maintenance instructions were supplied. The removable inlet guard grill allowed easy access for fan

cleaning. Regularly scheduled cleaning and maintenance will ensure longer motor life and optimum performance.

OPERATOR SAFETY

The inlet guard grill provided adequate protection from the fan blades. The motor was a totally enclosed unit and presented no safety hazards. The Ziehl-Abegg 631-6 was CSA approved.

The noise level³ of the Ziehl-Abegg 631-6, at a distance of 4.9 ft (1.5 m) from the centre of the fan discharge, while operating at a 0.125 in wg (31.1 Pa) static pressure, was 77 dB(A). Higher noise levels could be expected if the fan was operated in the vicinity of other buildings. The Ziehl-Abegg 631-6 falls within range 3 of the PAMI noise level range classification (APPENDIX II). The noise level produced by this fan can be considered annoying and detrimental to hearing and operator performance under continuous exposure. Ear protection should be considered if working near the fan for prolonged periods.

OPERATOR'S MANUAL

The operator's manual contained information on operation, specifications, installation and safety aspects for other similar Ziehl-Abegg fans. The model 631-6 was not specifically included. It is recommended that the manufacturer consider updating the operator's manual to include the model 631-6 as well as including information on fan maintenance and trouble shooting.

APPENDIX I	
SPECIFICATIONS	
MAKE:	Ziehl-Abegg
MODEL:	ECDQ 631-6 SPTP
SERIAL NUMBER:	H365057
MANUFACTURER:	Ziehl-Abegg GmbH & Co. KG Postfach 1165, Zeppelinstrasse 28 D-71118 Kunzelsau West Germany
OVERALL DIMENSIONS:	
- housing width	31.75 in (806 mm)
- housing height	31.75 in (806 mm)
- housing depth	8.75 in (222 mm)
- housing diameter	25 in (635 mm)
- guard grill diameter	26.75 in (679 mm)
- grill opening	0.09 in (2 mm) diameter spaced at 0.4 in (10 mm) in a circular pattern.
PROPELLER:	
- diameter	24.5 in (622 mm)
- hub diameter	7.5 in (190 mm)
- number of blades	7
- blade angle	variable - 30 degrees at tip to 40 degrees at hub
WEIGHT:	71.1 lb (32.3 kg)
MOTOR NAMEPLATE DATA:	
- make	Ziehl-Abegg
- class	B
- rpm	1050
- ambient temperature rise	40°C
- volts	240
- amps	5
- phase	1
- cycles	60 Hz
- horsepower	1.61 hp (1.2 kw)

APPENDIX II		
NOISE LEVEL RANGES		
RANGE	SOUND LEVEL (dBA)	COMMENTS
1	Up to 45	Tolerable, low level background noise.
2	45 to 60	Dominating background noise that would interfere with normal conversation.
3	60 to 85	Could be annoying and be detrimental to hearing and operator performance under long-term continuous exposure. Ear protection should be considered.
4	over 85	Could damage hearing, depending on level and exposure time. Ear protection is definitely recommended.

APPENDIX III	
CONVERSION TABLE	
cubic feet/minute (cfm) x 0.472	= litres/second (L/s)
horsepower (hp) x 745.7	= watts (W)
inches (in) x 25.4	= millimetres (mm)
inches water gauge (in wg) x 249.1	= pascals (Pa)
pounds (lb) x 0.45	= kilograms (kg)

SUMMARY CHART ZIEHL-ABEGG MODEL 631-6 VENTILATION FAN

RETAIL PRICE:	\$548.00 (June, 1984, f.o.b. Lethbridge)
FAN DESCRIPTION:	24.5 in (622 mm) propeller fan, variable speed, direct drive, 1.61 hp (1200W) external rotor electric motor
FAN SPEED:	
- single speed	1017 to 1038 rpm
- variable speed	486 to 1021 rpm
EFFICIENCY RANGE:	
- without louvres	33 to 37%
- with louvres	22 to 26%
EFFICIENCY AT 0.125 in wg (31.1 Pa):	
- without louvres	36%
- with louvres	25%
AIR FLOW RATE:	
- range	1870 to 8090 cfm (884 to 3820 L/s)
- at 0.125 in wg (31.1 Pa)	7570 cfm (3570 L/s) without louvres and 6550 cfm (3090 L/s) with louvres
INPUT POWER:	0.68 to 1.34 hp (510 to 1000W)
OPERATOR SAFETY:	inlet guard provided CSA approved noise level: 77 dB(A) at 4.9 ft (1.5 m) from fan discharge
OPERATOR'S MANUAL:	requires updating

³PAMI Test Procedure for Determining Fan Noise Level.



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