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#2291

NATIONAL BUREAU OF STANDARDS REPORT

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PERFORMANCE TESTS OF CLEANABLE
IMPINGEMENT TYPE AIR FILTERS
"ALUMALOY" RP 902

manufactured by
Research Products Corporation
Madison, Wisconsin.

by

Henry E. Robinson
Thomas W. Watson

NBS

U. S. DEPARTMENT OF COMMERCE
NATIONAL BUREAU OF STANDARDS

U. S. DEPARTMENT OF COMMERCE
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NATIONAL BUREAU OF STANDARDS
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The scope of activities of the National Bureau of Standards is suggested in the following listing of the divisions and sections engaged in technical work. In general, each section is engaged in specialized research, development, and engineering in the field indicated by its title. A brief description of the activities, and of the resultant reports and publications, appears on the inside of the back cover of this report.

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Ordnance Development.
Electromechanical Ordnance.
Ordnance Electronics.
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Missile Development. Missile research and development: engineering, dynamics, intelligence, instrumentation, evaluation. Combustion in jet engines. These activities are sponsored by the Department of Defense.

- Office of Basic Instrumentation
- Office of Weights and Measures.

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NBS PROJECT **NBS REPORT**

1003-20-4715 February 17, 1953 2291

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Henry E. Robinson
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Heating and Air Conditioning Section
Building Technology Division

To

Bureau of Ships, Code 327
Department of the Navy

Reference: NPO - 15479 Index No. NSM 130-001

NBS

Performance Tests of an "Alūmaloy" Air Filter

I. INTRODUCTION

At the request of the Bureau of Ships, Code 327, Navy Department (NPO-15479, Index No. NSM 130-001) qualification tests were made to determine the performance of cleanable viscid-impingement type air filters in accordance with Section 4.5 of Military Specification MIL-F-16552 (Ships) dated 1 October 1951 as modified by Amendment 1 dated 15 April 1952.

The tests were performed on a specimen filter submitted by its manufacturer at the request of the Bureau of Ships, and included determinations of the dust-arresting efficiency, pressure drop, specific dirt load and cleanability of the specimen at three face air velocities, namely 300, 600 and 900 feet per minute.

II. DESCRIPTION OF THE FILTER SPECIMEN

The filter was manufactured by the Research Products Corporation of Madison, Wisconsin, and was of the cleanable viscid type, 20x20x2 inches in nominal size. It was identified by nameplate as an "RP 902 Alūmaloy Industrial Washable Air Filter". The filtering media was composed of many layers of expanded metal (thin aluminum sheet or foil) arranged one after the other, as follows, starting at the upstream face: One layer EM 5/16x9/16 inch mesh; one 4-1/2 inch square mesh wire grid; four layers EM 3/8x1/2 inch mesh; six layers EM 1/4x5/16 inch mesh; three layers EM 3/8x1/2 inch mesh; six layers EM 1/4x5/16 inch mesh; one 4-1/2 inch square mesh wire grid; one layer EM 5/16x9/16 inch mesh. The layers of media were slightly compressed and surrounded at the edges by an aluminum metal frame. The filter had actual outside dimensions of 19-3/4x19-5/8x1-7/8 inches, leaving a free opening 18-1/8x18-1/6 inches (2.27 ft^2 net face area) and weighed 3.9 lb. when clean, without oil.

The manufacturer submitted an undescribed oil adhesive for oiling the filter. This was done in preparation for test by immersing the filter in the liquid and letting excess oil drain off with the filter standing on edge for a minimum of 16 hours prior to the test.

III. TEST METHOD AND PROCEDURE

The dust-arresting efficiency of the filter was determined by the NBS "Dust Spot Method" using as a test dust Cottrell precipitate at a concentration of one gram per thousand cubic feet of air. The test method is described in the paper "A Test Method for Air Filters" by R. S. Dill (ASHVE Transactions, Vol. 44, p. 379, 1938).

Dirt-holding capacity was determined by supplying to the filter air in which were dispersed cotton lint and Cottrell precipitate in the approximate proportions of 4% and 96% by weight, respectively. The average rate of feed of the contaminants was not more than 25 grams per hour per square foot of net filter face area at each face velocity. The lint used for this purpose was No. 7 cotton linters ground in a Wiley mill with 4 mm screen.

The efficiency and dirt-loading tests were made at three different air velocities, namely, 300, 600 and 900 fpm.

In the tests at each velocity, the following uniform procedure was employed. The clean filter, after oiling and draining as described above, was installed in the test duct and its initial pressure drop was measured at 300, 600 and 900 fpm air velocity. The initial efficiency of the filter at the test velocity was then determined, following which the process of loading the filter with a mixture of 4 percent lint and 96 percent Cottrell precipitate by weight was started. At intervals the increasing pressure drop of the filter was recorded. At suitable periods as loading progressed, the efficiency of the filter was determined using 100 percent Cottrell precipitate. In addition, the efficiency of the filter was determined at the end of a day of loading, and at the start of the next day, to ascertain whether the rate of dirt loading was overtaxing the wetting rate of the filter adhesive. The dirt loading was continued, in general, until the rate of pressure drop rise increased to approximately 0.004 inch W.G. per gram of dirt mixture fed per square foot of filter face area.

The filter was then removed from the test duct and cleaned by means of a stream of cold water from a high-pressure hose nozzle, directed at and into the filter media. After drying, the filter was re-oiled for subsequent tests or for measurement of its initial pressure drop after the final cleaning.

IV. TEST RESULTS

The pressure drop of the clean oiled filter, in inch W.G., at 300, 600 and 900 fpm face air velocity, was measured at the start of each of the tests, and after the 900 fpm test, as shown in Table 1.

Table 1

Face Velocity, fpm	300	600	900
At start of 300 fpm test	.051	.182	.390
At start of 600 fpm test	.050	.180	.387
At start of 900 fpm test	.050	.183	.395
After 900 fpm test	.054	.200	.436
Increase in P.D. after 3 cleanings,%	6	9	12

A summary of the test data obtained in dirt-loading tests conducted at 300, 600 and 900 fpm face velocity is given in Table 2.

Table 2

Face Air Velocity fpm	Dirt Load* grams/sqft	Pressure Drop inch WG	Efficiency percent
300	0	.051	-
	3	.051	42
	6	.051	43
	57	.071	45(P)
	62	.071	45(A)
	120	.102	54
	164	.137	56(P)
	167	.134	54(A)
	182	.152	55
	221	.200	57
	252	.250	60
	284	.313	65(P)
	286	.317	64(A)
	299	.360	65
	334	.514	73

* Average mixture: 4.0% lint, 96 % Cottrell precipitate by weight.
Average rate of dirt loading: 16.9 grams per square foot per hour.

Face Air Velocity fpm	Dirt Load* grams/sqft	Pressure Drop inch WG	Efficiency percent
600	0	.180	-
	6	.180	54
	12	.181	51
	18	.182	57
	34	.204	50
	43	.220	53
	70	.254	54
	91	.288	59(P)
	97	.287	58(A)
	143	.376	57
	197	.510	61
	236	.674	66(P)
	242	.695	66(A)
	254	.790	72

* Average mixture: 4.0% lint, 96% Cottrell precipitate by weight.
Average rate of dirt loading: 20.7 grams per square foot per hour.

Table 2 - continued

Face Air Velocity	Dirt Load* grams/sqft	Pressure Drop inch WG	Efficiency percent
900	0	.395	-
	9	.397	63
	18	.400	64
	73	.543	64
	91	.598	66(P)
	101	.630	66(A)
	146	.810	68
	183	1.005	68
	193	1.060	76

* Average mixture: 4.0% lint, 96.0% Cottrell precipitate by weight.
Average rate of dirt loading: 22.2 grams per square foot per hour.
Note: Efficiencies marked (P) or (A) were determinations made at the end of a day of loading, and at the start of the next day of loading, respectively.

V. SUMMARY OF RESULTS

A. Performance

The test data are plotted in Figure 1, which shows the variation of the pressure drop and of the efficiency of the filter as it was subjected to increasing specific dirt loading at face velocities of 300,600 and 900 feet per minute.

Table 3 presents values of the pressure drop (P.D.), in inches of water, and of the approximate efficiency (Eff.), in percent, as taken from the curves of Figure 1, at various specific dirt loadings.

Table 3

Spec.Dirt Ldg. grams/sq ft	0 (Initial)		100		200		300	
Face Vel.,fpm	P.D.	Eff.	P.D.	Eff.	P.D.	Eff.	P.D.	Eff.
300	0.05	42	.09	51	.17	56	.36	65
600	.18	54	.29	58	.52	61	-	-
900	.40	63	.63	66	-	-	-	-

B. Cleanability

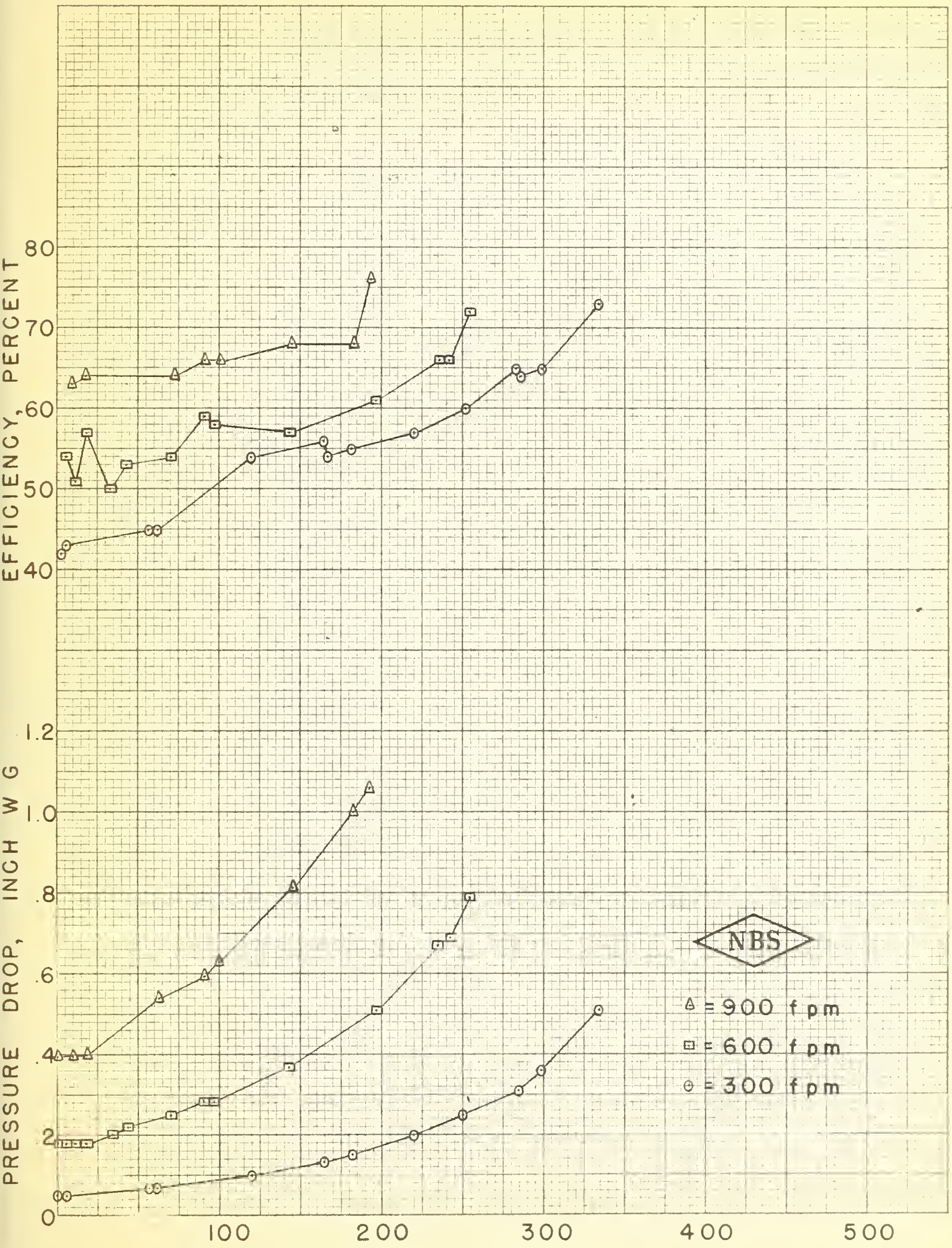
The pressure drops of the clean oiled filter at 300, 600 and 900 fpm face velocity recorded in Table 1 under Test Results indicate that after the filter had been subjected to three loadings with the dust-lint mixture and three cleanings and re-oilings, its average percentage increase in pressure drop was about 9 percent, or about 3 percent average per loading and cleaning operation. Almost all of the pres-

sure drop increase of this filter occurred following the 900 ft/min test. Examination of the media at that time indicated the cleaning operation had removed practically all observable dirt. The increase of pressure drop apparently was due to shifting or bending of the thin metal of the media as a result of the cleaning operation.

C. General

The fact that efficiencies determined at the end of a day of loading of the filter (those marked (P) in Table 2) were approximately the same as those made at the start of the next day of loading (those marked (A)) indicates that the dirt loading rate to which the filter was subjected did not overtax the wetting-rate of the filter adhesive and cause the filter surfaces to become "dry".

RESEARCH PRODUCTS "ALŪMALOY" RP902



LOAD, GRAMS PER SQUARE FOOT

FIG. 1

THE NATIONAL BUREAU OF STANDARDS

Functions and Activities

The functions of the National Bureau of Standards are set forth in the Act of Congress, March 3, 1901, as amended by Congress in Public Law 619, 1950. These include the development and maintenance of the national standards of measurement and the provision of means and methods for making measurements consistent with these standards; the determination of physical constants and properties of materials; the development of methods and instruments for testing materials, devices, and structures; advisory services to Government Agencies on scientific and technical problems; invention and development of devices to serve special needs of the Government; and the development of standard practices, codes, and specifications. The work includes basic and applied research, development, engineering, instrumentation, testing, evaluation, calibration services and various consultation and information services. A major portion of the Bureau's work is performed for other Government Agencies, particularly the Department of Defense and the Atomic Energy Commission. The scope of activities is suggested by the listing of divisions and sections on the inside of the front cover.

Reports and Publications

The results of the Bureau's work take the form of either actual equipment and devices or published papers and reports. Reports are issued to the sponsoring agency of a particular project or program. Published papers appear either in the Bureau's own series of publications or in the journals of professional and scientific societies. The Bureau itself publishes three monthly periodicals, available from the Government Printing Office: The Journal of Research, which presents complete papers reporting technical investigations; the Technical News Bulletin, which presents summary and preliminary reports on work in progress; and Basic Radio Propagation Predictions, which provides data for determining the best frequencies to use for radio communications throughout the world. There are also five series of nonperiodical publications: The Applied Mathematics Series, Circulars, Handbooks, Building Materials and Structures Reports, and Miscellaneous Publications.

Information on the Bureau's publications can be found in NBS Circular 460, Publications of the National Bureau of Standards ($1.00). Information on calibration services and fees can be found in NBS Circular 483, Testing by the National Bureau of Standards (25 cents). Both are available from the Government Printing Office. Inquiries regarding the Bureau's reports and publications should be addressed to the Office of Scientific Publications, National Bureau of Standards, Washington 25, D. C.

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