

**STUDIES IN MECHANICAL ENGINEERING, 7**

# **Fundamentals of Hydraulic Power Transmission**

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**IMRE KRÖELL DULAY**

**FERENC FÜRÉSZ and GÁBOR HARKAY**

**and**

**JANOS LUKÁCS**

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**ELSEVIER**

**Amsterdam—Oxford—New York—Tokyo 1988**

This work was originally published as  
*"Hidraulikus rendszerek"*  
by Műszaki Könyvkiadó, Budapest, Hungary

Revised by Lajos Lugosi

English translation by E. Darabant

Published in co-edition with Akadémiai Kiadó, Budapest, Hungary

Distribution of this book is being handled by the following publishers  
for the U.S.A. and Canada

Elsevier Science Publishing Co., Inc.  
52 Vanderbilt Avenue  
New York, New York 10017, U.S.A.

for the East European Countries, North Korea, Cuba, Vietnam and Mongolia

Kultura Hungarian Foreign Trading Company  
P.O. Box 149, H-1289 Budapest 62, Hungary

for all remaining areas

Elsevier Science Publishers  
25 Sara Burgerhartstraat  
P.O. Box 211, 1000 AE Amsterdam, The Netherlands

Library of Congress Cataloging-in-Publication Data

[Hidraulikus rendszerek. English.]

Fundamentals of hydraulic power transmission.

(Studies in mechanical engineering; v. 7)

Bibliography: p.

Includes index.

1. Hydraulic control. 2. Oil hydraulic machinery.

I. Króell Dulay, Imre. II. Title. III. Series.

TJ843.H5313 1988 821.2'6 86-29266

ISBN 0-444-98973-0 (U.S.)

ISBN 0-444-98973-0 (Vol. 7)

ISBN 0-444-41872-5 (Series)

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Printed in Hungary

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## PREFACE

Rapid mechanization and automation of production processes, coupled with the complexity of the kinematic systems of machines and the rising power transmitted, impose ever more demanding requirements on the power transmission and control systems. The liquid hydraulic system has advantages such as simple control of the characteristic parameters (speed, force and torque) of the transmission, simple protection against overload and easy distribution of the flow, which enable it to meet the increasing requirements.

A wide range of hydraulic energy converters are now manufactured, to standard dimensions, at the large development and production centres. Thus machine designers are relieved of problems related to the design and construction of the elements, and can concentrate on system planning.

In this book, we aim to provide a methodical summary of the fundamental transmission types and a description of their main characteristics. Hydraulic control devices are discussed according to the requirements of the transmission, but as the various products operate on the same principle, no detailed description of them is given. The systematic development and operational characteristics of the various hydraulic control devices are demonstrated.

The actuators of the energy converters of variable specific volume, such as the pressure-controlled and proportional control devices now generally used, are discussed in a similar way.

The theoretical fundamentals of alternating current transmissions, as a special province of the hydraulic transmission technique are described in a separate chapter.

Understanding of the theory is facilitated by examples given in each chapter. The last chapter of the book, in line with the preceding theoretical part, deals with the design of the hydraulic circuits of practical machines. Some basic knowledge of control techniques is required for the understanding of parts of the text.

The most frequently used symbols, and the relations between the SI (System International) and other measuring units, are listed in tabular form.

*Ferenc Fűrész  
Gábor Harkay  
Imre Kröell Dukay  
János Lukács*



Table 0-1.

Symbols and measuring units of the main technical and physical quantities

Name	Symbol	Measuring units	
		SI	other
Pressure	$p, P$	Pa, N/m <sup>2</sup>	MN/m <sup>2</sup> , daN/cm <sup>2</sup> , bar
Flow rate	$Q$	m <sup>3</sup> /s	dm <sup>3</sup> /min, cm <sup>3</sup> /s
Length	$l, L, h$	m	cm, mm
Diameter	$d, D$	m	cm, mm
Surface, area	$A$	m <sup>2</sup>	cm <sup>2</sup>
Volume	$V$	m <sup>3</sup>	dm <sup>3</sup> , cm <sup>3</sup>
Specific capacity (geometric)	$V_g$	m <sup>3</sup> /rad	cm <sup>3</sup> /rad
Mass	$m, M$	kg	—
Density	$\rho$	kg/m <sup>3</sup>	—
Velocity	$v, c$	m/s	cm/s
Gravitational acceleration	$g$	m/s <sup>2</sup>	—
Angular frequency	$\omega$	1/s	—
Kinetic frequency, frequency	$f$	1/s, Hz	—
Angular speed (r.p.m.)	$n$	1/s	1/min
Force	$F$	N	daN
Weight	$G$	N	daN
Moment (torque)	$M$	Nm	daNm
Energy	$E$	J	kJ
Work	$W$	J	kJ
Power	$P$	W	kW
Moment of inertia	$\Theta$	kg m <sup>2</sup>	—
Moment of inertia	$I$	m <sup>4</sup>	cm <sup>4</sup>
Momentum	$I$	kg m/s	—
Damping factor	$B$	N s/m	—
Spring stiffness	$c_r$	N/m	—
Modulus of elasticity	$E$	Pa	—
Bulk modulus of elasticity	$K$	Pa	daN/cm <sup>2</sup>
Compressibility	$\beta$	1/Pa	cm <sup>2</sup> /daN
Dynamic viscosity	$\eta$	Pas	Ns/m <sup>2</sup>
Kinematic viscosity	$\nu$	m <sup>2</sup> /s	mm <sup>2</sup> /s
Laminar friction resistance	$R_L$	N s/m <sup>5</sup>	—
Turbulent friction resistance	$R_T$	N s <sup>2</sup> /m <sup>8</sup>	—
Hydraulic inductivity	$L$	N s <sup>2</sup> /m <sup>5</sup>	—
Hydraulic capacity	$C$	N/m <sup>5</sup>	—
Inductance	$X_L$	N s/m <sup>5</sup>	—
Capacitance	$X_C$	N s/m <sup>5</sup>	—
Hydraulic impedance	$Z$	N s/m <sup>5</sup>	—
Force constant	$K_F$	m <sup>2</sup>	cm <sup>2</sup>
Torque constant	$K_M$	m <sup>3</sup> /rad	cm <sup>3</sup> /rad
Velocity constant	$K_v$	l/m <sup>2</sup>	l/cm <sup>2</sup>
Angular velocity constant	$K_\omega$	rad/m <sup>3</sup>	rad/cm <sup>3</sup>
Valve constant	$K_T, K_N$	N s/m <sup>5</sup>	—
Hydraulic control sensitivity	$\psi_Q$	m <sup>2</sup> /s	cm <sup>2</sup> /s
Hydraulic conductivity	$G_Q$	m <sup>5</sup> /Ns	—
Static compliance	$z_h$	m/N	—
	$z_\phi$	rad/Nm	—
Dynamic compliance	$z_v$	1/Ns	—
	$z_\omega$	1/Nms	—
Time	$t, \tau$	s	min

(Table 0-1 cont.)

Name	Symbol	Measuring units	
		SI	other
Time constant	$T$	s	h
Temperature	$\vartheta$	K	°C
Heat	$W$	J	kJ
Heat transfer coefficient	$\kappa$	J/m <sup>2</sup> s K	kJ/m <sup>2</sup> h°C
Linear thermal expansion	$\alpha$	1/K	1/°C
Efficiency	$\eta$	—	—
Power transmissibility	$G$	—	—
Degree of irregularity	$\delta$	—	—
Ratio of piston areas	$\varphi$	—	—

Table 0-2.

Basic units of SI

Basic physical quantity	Symbol
Length	m
Mass	kg
Time	s
Current intensity	A
Thermodynamic temperature	K
Luminous intensity	cd
Mass volume	mol

Table 0-3.

Interpretation of indices used with the symbols

$a$	accumulator, counter force, apparent
$av$	average
$ax$	axial
$b$	switching on, internal, inlet, input, tilting
$C$	capacity, controllability
$c$	control
$cl$	clamping, compressive
$cr$	critical
$d$	depression, draining, piston
$D$	piston
$dyn$	dynamic
$e$	forward, lifting, resultant, even, empty weight
$eff$	effective
$f$	phase, fluid, main, filter
$F$	restriction, restrictor
$g$	gas, geometric, generator
$h$	backward, hydraulic, linear displacement, cylinder
$id$	ideal
$i, j, k, \dots, z$	operative indices
$k$	mixture, switching off, outlet, ambient, external

(Table 0-3. cont.)

<i>l</i>	apparent, air, load
<i>L</i>	inductivity, laminar
<i>m</i>	motor, reactive, actuating force
<i>mean</i>	mean
<i>M</i>	torque, operating position
<i>nec</i>	necessary, required
<i>nl</i>	no-load
<i>o</i>	oil
odd	odd
<i>op</i>	operating, opening
<i>p</i>	power, pump, pipeline
<i>r</i>	radian, spring
<i>red</i>	reduced
<i>R</i>	friction resistance
<i>s</i>	auxiliary, friction, lowering
<i>st</i>	static
<i>sup</i>	supporting
<i>t</i>	time, charge
tank	tank
<i>T</i>	turbulent, overflow
<i>tot</i>	total
<i>Q</i>	flow rate
<i>v</i>	linear motion, loss, return, line
<i>vol</i>	volumetric
<i>W</i>	work
<i>z</i>	closing
<i>x, y, z</i>	in direction x, y, z
$\varphi$	angular displacement
max	maximum
<i>mech</i>	mechanical
<i>perm</i>	permissible
min	minimum
<i>n</i>	nominal, rated
<i>N</i>	pressure reducing
$\Delta$	difference, change
$\omega$	rotary motion
<i>A, B</i>	between points A and B
<i>0</i>	barometric, theoretical value, series development position
1, 2, 3	in position 1, 2, 3
1-2	between positions 1 and 2

Table 0-4.

Relationship between the technical and SI system

	Technical system	SI system
Force	1 kp = 9.80665 N	1 N = 0.101972 kp
Work, energy	1 kpm = 9.80665 J	1 J = 0.101972 kpm
Power	1 kpm/s = 9.80665 W	1 W = 0.101972 kpm/s

Note: 1 daN = 10 N

(Table 0-4 cont.)

## Conversion of work and energy units

	J	kWh	kcal	kpm
1 J	1	$2.77778 \times 10^{-7}$	$2.38846 \times 10^{-4}$	0.101972
1 kWh	$3.6 \times 10^6$	1	859.845	$3.67098 \times 10^5$
1 kcal	4186.8	$1.163 \times 10^{-3}$	1	426.935
1 kpm	9.80665	$2.72407 \times 10^{-6}$	$2.34225 \times 10^{-3}$	1

Note: The basic unit of energy in the SI system is the joule (J), power = watt (W)

$$1 \text{ J} = 1 \text{ kg m}^2/\text{s}^2 = 1 \text{ W s} = 1 \text{ N m} = 10^7 \text{ erg.}$$

## Conversion of power units

	kW	kpm/s	LE	kcal/h
1 kW	1	101.972	1.3596	859.845
1 kpm/s	$9.80665 \times 10^{-3}$	1	0.013333	8.4324
1 LE	0.735499	75	1	632.44
1 kcal/h	$1.163 \times 10^{-3}$	0.118594	$1.58125 \times 10^{-3}$	1

Note:  $1 \text{ LE} = 75 \text{ kp m/s} = 75 \times 9.80665 = 735.4987 \text{ N m/s} = 735.499 \text{ W.}$

## Units of pressure and their relationships

	N/m <sup>2</sup>	at	torr	bar	atm
1 N/m <sup>2</sup>	1	$1.01972 \times 10^{-6}$	$7.50062 \times 10^{-6}$	$10^{-5}$	$0.986923 \times 10^{-5}$
1 at	$9.80665 \times 10^4$	1.0	735.559	0.980665	0.967841
1 torr	133.3224	$1.35951 \times 10^{-3}$	1.0	$1.333224 \times 10^{-3}$	$1.3158 \times 10^{-3}$
1 bar	$10^5$	1.01972	750.062	1.0	0.986923
1 atm	$1.01325 \times 10^5$	1.033227	760.0	1.01325	1.0

Note:  $1 \text{ Pa} = 1 \text{ N/m}^2$ ;  $1 \text{ at} = 1 \text{ kp/cm}^2 \approx 1 \text{ daN/cm}^2 = 10 \text{ N/cm}^2$ ;  $1 \text{ bar} = 10^5 \text{ mbar} = 10^6 \text{ } \mu\text{bar.}$

## CHAPTER 1

# HYDRAULIC CALCULATIONS (BASIC FORMULAE). MECHANICAL PROPERTIES OF THE HYDRAULIC FLUID

### 1.1 UNIT SYSTEMS. INTERPRETATION OF THE FLOW RATE

The power transmitting medium of hydraulic systems is a fluid. The measurement units for the systems operating with higher power are derived from the energy per unit volume of the fluid participating in the power transmission:

$$\frac{E}{V} \frac{\text{ML}^2\text{T}^{-2}}{\text{L}^3} = P \text{ML}^{-1}\text{T}^{-2}.$$

This quantity is called the total pressure. Its units which frequently occur are: Pa (Pascal),  $\text{N m}^{-2}$ ,  $\text{MN m}^{-2}$ , bar,  $\text{daN cm}^{-2}$ .

Relationships between the units:

$$1 \text{ Pa} = 1 \text{ N m}^{-2} = 10^{-6} \text{ MN m}^{-2},$$

$$1 \text{ bar} = 1 \text{ daN cm}^{-2} = 10^5 \text{ N m}^{-2} = 0.1 \text{ MN m}^{-2}.$$

Derivation of the total pressure reveals the fact that it contains all the components of the Bernoulli equation, thus in the case of  $\rho = \text{constant}$ , the formula for a given part of the flow is:

$$P_t = p_t + \gamma h_t + \frac{\rho}{2} v_k^2.$$

The potential energy term is usually negligible in mechanical engineering relative to the other two, and thus the formula for total pressure is the following:

$$P_t = p_t + \frac{\rho}{2} v_k^2.$$

The first component is the hydrostatic pressure, and the second is the hydrodynamic pressure.

Variation of the pressure components is shown in Fig. 1-1. for different flow sectional areas.

Apart from the pressure the most frequently occurring parameter in hydraulic calculations is the fluid volume passing during unit time, which is called the flow rate:

$$Q = \frac{\partial V}{\partial t} = \frac{\Delta V}{\Delta t} \text{L}^3\text{T}^{-1}. \quad (1.1)$$

Usual units:  $\text{m}^3\text{h}^{-1}$ ,  $\text{dm}^3\text{min}^{-1}$ ,  $\text{m}^3\text{s}^{-1}$ ,  $\text{cm}^3\text{s}^{-1}$ .



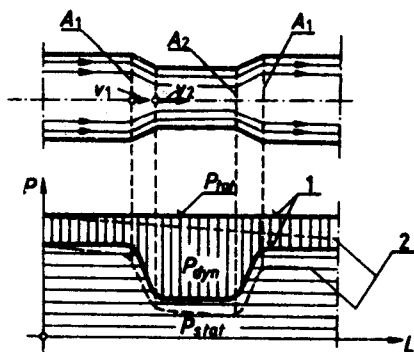


Fig. 1-1. Variation of the total pressure components in cases of different flow sectional areas  
1 ideal fluid; 2 actual fluid

The fluid volume expresses the intensity of the flow, which in the case of stationary flow can also be calculated from the continuity equation

$$Q = A_i v_{ik} = \text{constant}. \quad (1.2)$$

According to the formula (1.2) the fluid volume passing through any sectional area of the flow during unit time is constant, provided that the density of the fluid is regarded as constant.

## 1.2 HYDRAULIC RESISTANCE, INDUCTIVITY, CAPACITY

The terms resistance, inductivity and capacity in hydraulic power transmission can be used analogously to electrical practice, since the static pressure can be regarded as corresponding to the voltage and the flow rate to the electric current.

### 1.2.1 PRESSURE LOSS ARISING FROM HYDRAULIC RESISTANCE. FRICTIONAL (VISCOUS) RESISTANCE

The total pressures measured in two sectional areas during steady flow of the fluid are generally different, i.e.:

$$P = P_1 - P_2 = (p_1 - p_2) + \frac{\rho}{2} (v_1^2 - v_2^2).$$

If the two sectional areas of the flow analysed are equal, then the difference of the total pressures equals the difference of the static pressures. The pressure difference is required for compensation of the force produced by the friction of the fluid particles. The frictional force depends on the characteristics of the fluid, the type of flow and on the flow sectional area.

Since power transmission losses decrease the hydrostatic pressure component in every case (as measurable with a manometer), each hydraulic resistance can be calculated