Proceedings of the

1986 INTERNATIONAL COMPRESSOR ENGINEERING CONFERENCE — AT PURDUE VOLUME I

August 4-7, 1986
West Lafayette, Indiana

Sponsored by

Ray W. Herrick Laboratories, School of Mechanical Engineering, Purdue University, West Lafayette, Indiana 47907 U.S.A.

In cooperation with....

Air Conditioning and Refrigeration Institute (ARI)

American Society of Heating, Refrigerating, and Air-Conditioning Engineers (ASHRAE)

The American Society of Mechanical Engineers (ASME)
Design Engineering Division, and

Fluids Engineering Division, an

The Compressed Air and Gas Institute (CAGI)

Deutscher Kalte- und Klimatechnischer Verein (DKV)

The Institute of Engineers (India), Mechanical Engineers Division

Japanese Association of Refrigeration (JAR)

The Japan Society of Mechanical Engineers (JSME)

Royal Institute of Engineers in the Netherlands (KlvI)

Refrigeration and Fluid Machinery Associations of China

Edited by James F. Hamilton Raymond Cohen

PROCEEDINGS

OF THE

1986 INTERNATIONAL COMPRESSOR ENGINEERING CONFERENCE - AT PURDUE

VOLUME I OF THREE VOLUMES

August 4-7, 1986

West Lafayette, Indiana

Sponsored by.

Ray W. Herrick Laboratories, School of mechanical Engineering, Purdue University, West Lafayette, Indiana 47907 U.S.A.

In cooperation with

Air Conditioning and Refrigeration Institute (ARI) American Society of Heating, Refrigerating, and Air-Conditioning Engineers (ASHRAE) The American Society of Mechanical Engineers (ASME) Design Engineering Division, and Fluids Engineering Division The Compressed Air and Gas Institute (CAGI) Deutscher Kalte- und Klimatechnischer Verein (DKV) The Institute of Engineers (India), Mechanical Engineers Divison Japanese Association of Refrigeration (JAR) The Japan Society of Mechanical Engineers (JSME) Royal Institute of Engineers in The Netherlands (KIVI) Refrigeration and Fluid Machinery Associations of China

Edited by

James F. Hamilton Raymond Cohen

ORGANIZING COMMITTEE

James F. Hamilton (conference chairman), Professor of Mechanical Engineering, Purdue University

Raymond Cohen, Professor of Mechanical Engineering and Director of the Ray W. Herrick Laboratories, Purdue University

Werner Soedel, Professor of Mechanical Engineering, Purdue University

SOCIETY REPRESENTATIVES AND CONTACT PERSONS

- R. Sweetser, ASHRAE Technical Committee 8.1, Postive Displacement Compressors
- D.A. Beaty, ASME Design Engineering Division
- K.E. Hickman, ASME Fluids Engineering Division
- J.P. Hansen, Chairman, CAGI Educational and Promotional Committee
- H. Kruse, Deputy President, DKV
- C. Youjiun, Chairman, Refrigeration and Fluid Machinery Associations of China
- H. Phillips, Air Conditioning and Refrigeration Institute (ARI)
- S. Dutta, Chairman, Mechanical Engineering Division, The Institution of Engineers (India).
- S. Hotani, President, Japanese Association of Refrigeration (JAR)
- Y. Fujita, A. Futakawa, and H. Okatsuka, The Japan Society of Mechanical Engineers (JSME)
- D. van Moorsel, General Secretary, Royal Institution of Engineers in the Netherlands (KIvI)

Purdue University sponsors this conference to provide a forum for the free exchange of ideas on the engineering state-of-the-art in the compressor field. The ideas expressed are those of the author(s), and do not necessarily represent the opinions or policies of the University or the cooperating organizations. The papers are not subject to the formal review procedures of the separate cooperating organizations as they would be if they were to be published by the cooperating societies. Instead they are subject to the review procedures of the Organizing Committee.

ADVISORY COMMITTEE

- T.R. Barratt, Vice President, Design Engineering, Rotorex Company
- J. Crespin, Director, Marketing and Development, L'Unite Hermetique S.A. France
- B.F. Dittman, Senior Vice President, Engineering and Research, Copeland Corporation
- R. Dusil, Vice President, Technique and Marketing, J.N. Eberle & Cie. GmbH, West Germany
- E. Eisele, Staff Vice President, Engineering Research, Whirlpool Corporation
- Y. Fujita, Group Manager, Air-Conditioning and Refrigeration Machinery Division, Mitsubishi Heavy Industries, Ltd., Japan
- A. Futakawa, Manager, Mechanical Systems and Technology Department, Mitsubishi Electric Corporation, Japan
- J. Jacobs, Director, Carlyle Compressor Engineering, Carrier Corporation
- N.J. Josiassen, Manager, Advanced Engineering, Compressor Group, Danfoss A/S, Denmark
- H. Kruse, Professor, Universitat Hannover, Germany
- Y. Kuramitsu, Chief Engineer, Air Conditioning and Compressor Division, Toshiba Electric Appliances Co., Ltd., Japan
- A. Lundberg, Vice President, Marketing and Engineering, STAL Refrigeration, Sweden
- R.J.L. McLaren, Engineering Director, Prestcold Limited, England
- H. Nordberg, Head of Steel Research, Uddeholm AB, Sweden
- G. Persson, Quality Assurance Manager, Steel Products, Sandvik AB, Sweden
- H. Phillips, Vice President of Engineering, Air Conditioning and Refrigeration Institute
- C.K. Powell, Director, Reciprocating Technology, Ingersoll Rand Company

- F.D. Randall, Vice President, Tecumseh Products Company
- C.R. Slayton, Manager, HL/DW/RAC Product Design Engineering, General Electric Company
- R.L. Swadner, Staff Engineer, Harrison Radiator, Division of General Motors Corporation
- S. Touber, Professor, University of Technology, Delft, Netherlands
- A.B. Tramschek, University of Strathclyde, Glasgow, Scotland
- W.W. von Nimitz, Director, Industrial Applications, Southwest Research Institute
- D. Woollatt, Chief Scientist, Worthington Division, Dresser Industries, Inc.
- J.R. Wright, Director of Technology, ASHRAE
- M.R. Young, President and c.e.o., Bristol Corporation

FOREWORD

This is a collection of papers to be presented at the (eighth) biennial International Compressor Engineering Conference at Purdue University in West Lafayette Indiana August 4-7, 1986. The 1986 International Institute of Refrigeration (IIR) Commissions B1, B2, E1, and E2 Meeting on "Progress in the Design and Construction of Refrigeration Systems" is to be held on August 5-8, 1986 also at Purdue University. The two conferences are presented to attendees as a package such that registration at one gives all privileges to both. Papers which were primarily directed at compressors were arbitrarily assigned to the compressor conference.

The number of papers in the 1986 compressor conference require three simultaneous sessions. The 1986 IIR conference requires only one session at a time. Together there are about 120 papers from 20 different countries.

Additional copies of the three volume set of this 1986 compressor conference are available from the Office of Publications, South Campus Courts - D, Purdue University, West Lafayette, IN 47907, USA. Copies of the Proceedings of the IIR conference will be available from the IIR Paris office -- Institut International du Froid, 177, Bd Malesherbes, F 75017 Paris.

Since the first Purdue compressor conference in 1972 was organized, attendees have had an opportunity to meet practitioners and researchers to exchange current information and to discuss future trends primarily in positive displacement compressors. The Proceedings from these conferences have been used by compressor designers and others as one of the best collections of technical compressor papers available. The organizers of this 1986 conference hope that this collection will have as great an impact as those from the prior conferences.

The page size of the proceedings has been reduced, partly to be compatible with the standard size of the IIR booklets, but primarily because we believe it will be handier for readers to use. Reduction in size has required that we use three volumes. Your comments regarding them will be appreciated. Appendix A contains papers from the seventh conference which were presented in 1984 but which had not arrived in time to be printed in the 1984 Proceedings. Appendix B contains papers which are to be presented at the 1986

conference, but for which the manuscripts arrived too late to be included in their proper place. Astracts appear for some papers which were presented orally but for which manuscripts did not come in time for inclusion.

Again we are fortunate to have so many cooperating organizations join us in presenting the 1986 compressor conference. Our cooperating organizations provide a real service to the conference and especially to their membership by their help with publicity, and by encouraging their members to participate at all levels — on conference committees, as authors, participants and often as session chairpersons. My thanks to them, and to the following for their considerable help and encouragement:

- + The IIR for making it possible to hold these two conferences jointly.
- + The compressor conference advisory committee.
- + Representatives of cooperating organizations.
- + Session chairmen and authors.
- + The Purdue Division of Conferences and Continuing Education, and especially Barbara Meyer, the conference coordinator.
- + Professor Rahmat Shoureshi for the Short Course preceding the conference titled "Software/Hardware and Applications of Microprocessors".
- + The papers committee, consisting of Carl Speich and Professors James Hamilton, Raymond Cohen and Werner Soedel.
- + Connie Marsh, the Herrick Laboratories conference secretary, who attended to the myriad of details so necessary for a successful conference.
- + Herrick Laboratories staff and students.

The ninth compressor conference at Purdue is planned for the week of 17-22 July 1988. Please check the dates with the Herrick Laboratories as the time for it becomes closer.

James Hamilton and Raymond Cohen, Conference Co-Chairmen 5 July 1986

PUBLICATION IN ARCHIVAL JOURNALS OF COMPRESSOR CONFERENCE PAPERS

Many excellent papers are presented at the International Compressor Engineering Conferences at Purdue University. However, not all such papers are archival in nature and could not be accepted for publication in archival journals. An archival paper should contain original, quantitative, detailed scientific and technical material which is placed in proper perspective relative to prior work and is supported by references to the appropriate literature.

Because of space limitations, compressor conference papers may not be able to satisfy all of these criteria. Also some compressor conference papers may describe present practice or be of a design nature which, though important to attendees, has relatively short temporal interest.

Because of these reasons, and especially because of the small number of copies of the Proceedings printed, the Organizing and Advisory Committees recommend to all authors who have papers which qualify to submit them to archival journals for later publication. We request that authors who choose to do so acknowledge that their paper was presented at the 1986 compressor conference, and notify the Organizing Committee of their intention to do so.

PAPERS TO BE PRESENTED AT THE

August 5-8, 1986

PLENARY I:

F. Steimle, Universitat Essen, Essen, West Germany, "Trends in Air Conditioning in Europe Compared with United States"

SESSION: "EXPANSION DEVICES" (COMMISSION B1)

- L.J.M. Kuijpers and M.J.P. Janssen, "Continuous Control of Refrigerating Appliances; Limits Due to Capillary Tube Behavior"
- X. Qian, "The Superheat Degree Calculation of R-12 Expansion Valve at Off-Standard Condition"
- S. Touber and J.S. van der Meer, "Influence of the Expansion Valve on the Evaporator Performance"
- Li Li, Changlin Zhang and Yongzhang Yu, "The Performance and Mathematical Model of an Expand Valve"
- M.B. Pate and D.R. Tree, "Two-Phase Flow in a Non-adiabatic Capillary Tube"

PLENARY II:

J. Bougard, Faculte Polytechnique de Mons, Mons, Belgium, "Thermodynamical and Technical Problems in Solar Adsorption"

SESSION: "NON-AZEOTROPIC MIXTURES" (COMMISSION B1, B2, E2)

- J.C. Blaise and T. Dutto, "Some Practical Results Obtained with Non-Aezotropic Mixtures of Refrigerants in High Temperature Heat Pumps"
- M. Kuver and H. Kruse, "The Use of Non-Azeotropic Refrigerant Mixtures in Two Temperature Refrigerators"
- R. Gronseth and T. Kuehn, "The Use of Non-Azeotropic Refrigerant Mixtures in Vapor Compression Cycles"
- H. Nomura, "Application of Nonazeotropic Refrigerant Mixtures in Multi-Zone Heat Pump Room Air Conditioner with Hot Water System"

- K. Maczek and J. Schnotale, "Investigations into the Use of Refrigerant Mixtures in Air Conditioner Operating on a Steel Industry Crane Cabin"
- U.W. Schulz, "Thermodynamic Properties of Multicomponent Refrigeration"

SESSION: "HEAT PUMP MODELING AND VERIFICATION" (COMMISSION B2 AND E2)

- M. Sukiennik, "Experimentally Derived, Energetistic Efficiency of a Small Heat Pump in an Economic and Technical Aspect"
- T. Beckey, "Modeling and Verification of a Vapor Compression Heat Pump"
- M. Otsubo, K. Okuma, K. Yamazaki, and H. Yuyama, "Analysis of a Heat Pump System Driven by Gas Engine for Domestic Use"
- J. Reichelt, "Experimental Experiences with Evaporator Defrosting of Heat Pumps to DIN 8900"
- H. Rajendran and Michael Pate, "A Computer Model of the Start-up Transients in a Vapor Compression Refrigeration System"
- D.R. Tree and B.W. Weiss, "Two Time Constant Modeling Approach for Residential Heat Pumps"

PLENARY III:

SESSION: "AIR CONDITIONERS" (COMMISSIONS B1 AND E1)

- K. Katsuta and I. Ishihara, "Studies on Pressure Drops in Air Flowing Through Inside Tubes with Frosting"
- K. Torikoshi, S. Uemura, R. Yajima, and M. Fujiwara, "Prediction Using Equivalent Ratio in Estimating of the Performance of Heat Pump Air Conditioner"
- M. Delandre, "Air Conditioning with Double Air Flow"
- S.N.Y. Gerges and E.B. Teodoro, "Noise Reduction from Air Condition Units"
- G. Scalabrin, "A Liquid Sorption/Desorption Air Conditioning System Powered by Recovered Heat"

PLENARY IV:

S. Nowotny, "A New Designed System of Computer Programs to Generate, Evaluate, Check-up, Manufacture and Measure Automatically Pairs of Screw Rotors of Refrigerating Compressors"

SESSION: "SPECIAL HEAT PUMPS" (COMMISSION B1, B2, AND E2)

- T.H. Kuehn, "Optimization of Heat Exchanger Design and Fan Selection for Single Stage Refrigeration/Heat Pump Systems"
- J. Rasson, K.Dao and Michael Wahlig, "The Double-Effect Regenerative Absorption Heat Pump: Cycle Description and Experimental Test Results"
- K. Murozono, H. Wakabayashi and M. Hori, "New Defrosting System for Residential Heat Pumps"
- I. Cerepnalkovski, M. Sarevski and Risto Ciconkov, "Performances of a Turbocompressor Heat Pump as Common Characteristics of the Elements of the Energy System"
- M. Sarevski, "Temperature Boundary Effect of the Large Heat Pump Cycle on the Characteristics of the Turbocompressor"

PLENARY V:

J. Wurm, "Review of Open Cycle Desiccant Air Conditioning Concepts and Systems"

SESSION: "HEAT EXCHANGERS & HIGH TEMPERATURE HEAT PUMPS" (COMMISSIONS B1 & B2)

- J.C. Blaise and T. Dutto, "R142b, A New Refrigerant. for High Temperature Heat Pumps"
- Y. Kubo and S. Sakuma, "High Temperature Heat Pump Research and Development"
- A.L. Stolk and R.H. Wassenaar, "Heat and Mass Transfer Phenomena in an Absorber with Drop-Wise Falling Film on Horizontal Tubes"
- K.N. Agrawal, H.K. Varma, and S. Lal, "An Experimental Study of the Temperature Distribution in a Horizontal Refrigerant 12 Evaporator Fitted with Twisted Tapes"

xxvii

TABLE OF CONTENTS

Foreword v
Author Index xvii
Key Word Index xxi
IIR Papers xxv
VOLUME I
SESSION: "VALVES - FLOW I"
Chairman: Ed Eisele, Whirlpool Corporation, Benton Harbor, Michigan
J. Piechna and G.E.A. Meier, "Numerical Investigation of Steady and Unsteady Flow in Valve Gap"
X. Qian, "An Investigation on the Calculating for Optimal Lift of the Ring Valve"
L. Boswirth, "Valve Flow Experiments with Enlarged Models"
SESSION: "SCREW COMPRESSORS I"
Chairman: Hu Richardson, Tecumseh Products, Tecumseh, Michigan
G. G. Haselden and M. D. Yell, "The Challenge of Using the Single-Screw Compressor with Steam"
P. J. Singh and J. L. Bowman, "Effect of Design Parameters on Oil-Flooded Screw Compressor Performance"71
L. Sjoholm, "Different Operational Modes for Refrigeration Twin-Screw Compressors"
 H. Mori, K. Kasuya, Y. Takahashi, A. Susuki and M. Aoki, "Single Stage, Oil-Free Screw Compressor with a Compression Ratio Eight"

T. Hirai, S. Noda, Y. Sagara and K. Tsuzi, "Performance Analysis of OIF Single Screw Compressor"	119
SESSION: "THERMODYNAMICS AND HEAT TRANSFER"	
Chairman: David McCulloch, Joy Manufacturing, Michigan City, Indiana	
P. J. Singh and J. L. Bowman, "Heat Transfer in Oil-Flooded Screw Compressors"	135
Y. Kang "The Intercooler with Spraying Water for Air Compressors"	153
G. W. Recktenwald, J. W. Ramsey and S. V. Patankar, "Predictions of Heat Transfer in Compressor Cylinders"	159
Y. Gu and Y. Wu "Experimental Investigation on Heat Transfer in the Manifolds of Refrigerating Compressors"	175
Y. Kang, "The Temperature Measurement for Rotary Compressor with Oil Injection"	187
SESSION: "COMPRESSOR RATING"	
Chairman: Robert McLaren, Prestcold Limited, Thea England	le,
S. Lawson and H. Millet, "Rating Technique for Reciprocating Refrigeration Compressors"	195
H.G. Najork and H.J. Kleinert, "Energetic and Volumetric Characteristics for the Uniform Valuation of Gas and Refrigeration Compressors"	210
K. Sakitani, J. Koiwa and T. Maekawa, "Performance Evaluation of Hermetic Refrigeration Compressor Using Torque	000
Measurement Method"	228
	414

SESSION: "NEW DESIGNS" Chairman: Richard Sweetser, Single Screw Compressor, Norwalk, Connecticut F. Wrede and H. Kruse, "Recent Status of Trochoidal Type Compressors for Heat Pumps in Germany" L. Wydra, "Development of Outer-Envelope Trochoidal Compressors" K. Sakaino, K. Kawasaki, Y. Shirafuji and O. Ohinata, "The Study of Dual Cylinder Rotary Compressor". SESSION: "SCREW COMPRESSORS II" Chairman: Geoffrey Haselden, University of Leeds, Leeds, United Kingdom X. Zenan and X. Dagang "Study in Actual Profile Surface and Engaging Clearance of Screw Compressor Rotors". . . . G. Jin and Y. Tang "A Study of the Single Screw Compressor Profile". Z. Xiong "Use the Method of Magnetic Score to Measure the Dynamic Parameters of the W. Post and M. Swaans, "Computer Simulation of the Hydrodynamic Lubrication in a

254

292

305

312

321

334

Oil-Flooded Refrigeration Twin-Screw 349 SESSION: "VALVES - VIBRATION AND STRESS" Chairman: Fran M. Simpson, Copeland Corporation. Sidney, Ohio R. E. Drews, "The Development of a Longer Life and Superior Performance Compressor 362

X. Dagan, X. Zenan, Y. Yongzhang and J. F. Hamilton, "The Computer Simulation of

K. Hartshorn, "An Experimental Test Device for Accelerated Endurance Evaluation of Compressor Valve Assemblies"	364
J. S. Kim and W. Soedel, "Impact Stress Wave Propagation in a Compressor Valve"	382
S. Ziada, S. Shine and E.T. Buehlmann, "Self-Excited Vibrations of Reciprocating Compressor Plate Valves"	398
VOLUME II	
SESSION: "COMPRESSOR DESIGN AND ROTARY COMPRESSORS I	T **
Chairman: Bob Hammond, De-Sta-Co Division, Troy, Michigan	
P. N. Pandeya, "A Simplified Procedure for Designing Hermetic Compressors"	415
S. Akella, N.J. Rao, E. Venugopal and T.J. Manohar, "An Experimental Method for Design and Performance Evaluation of a Hermetic Compressor"	428
R. Singh, J. J. Nieter and G. Prater, "Prediction of Slugging-Induced Cylinder Overpressures".	444
M. P. Waser and E. A. Tomayko, "Analysis of Rotary Compressor Lubrication Systems"	460
A. Picksak and H. Kruse, "Mathematical Simulation of Lubrication Conditions in Rotary Vane Compressors"	461
M. Sugiyama, T. Itami and M. Kube, "Estimation of Pearing Load of Rolling Piston Type Rotary Compressors Under High Speed Operation"	477
SESSION: "VARIABLE SPEED AND CAPACITY CONTROL"	
Chairman: Mike Woodford, ARI, Arlington, Virginia	
L. Sjoholm, "Variable Volume-Ratio and Capacity Control in Twin-Screw Compressors"	494

J.C. Verma, "Optimum Utilization of Capacity Control Devices in Reciprocating Compressors"	509
C. M. Bartolini and G. Vincenzi, "New Internal Capacity Control for Reciprocating Compressors"	521
J. Reichelt, "Refrigerating Compressors for Air Conditioning of Passenger Cars"	537
SESSION: "COMPRESSOR NOISE"	
Chairman: Carl Speich, Trane Company, La Crosse, Wisconsin	
S. Kawaguchi, T. Yamamoto, T. Hirahara, O. Ohinata and K. Morinushi, "Noise Reduction of Rolling Piston Type Rotary Compressor"	550
A. Fujiwara and N. Sakurai, "Experimental Analysis of Screw Compressor Noise and Vibration"	566
X. Wang, "An Approach to Reckoning of Peak Noise Frequency of Air Compressor Inlet"	583
X. Qian, "The Calculating of Air Compressor Inlet Noise SPL"	597
X. Qian, "To Reduce Impact Noise of the Valve by Using Silent Valve Plate"	607
SESSION: "VALVES - FLOW II AND COMPRESSOR MODELLING SIMULATION"	AND
Chairman: C.K. Powell, Ingersoll Rand Company, Princeton, New Jersey	
T. Yuejin and Y. Yongzhang "The Experiment and Analysis of Drag Coefficient of the Ring Type Compressor Valve"	623
R. T. S. Ferreira and J. Lainor, "Analysis of the Influence of Valve Geometric Parameters on the Effective Flow and	630

Z. Shilian, "An Analysis of Significant Differences Between Suction and Discharge Valves in Reciprocating Air Compressors"	647
N. Shige, Y. Okamoto and T. Hamada, "CAE Approach to the Development of Rotary Compressors"	656
Z. Zicheng and J.F. Hamilton, "Multi- cylinder Reciprocating Refrigerating Compressor Modeling"	669
SESSION: "LABORATORY TECHNIQUES"	
Chairman: Akemi Futakawa, Mitsubishi Electric Corporation, Amagasaki, Japan	
I. Tarutani, H. Tanaka, K. Sumiyoshi and M. Seika, "Experimental Analysis of Stress on the Valves in Refrigerant Compressor by the Nickel Electroplating Method"	684
J. Kim and W. Soedel, "On Experimental Errors in P-V Diagrams"	698
X. Sheng, "The Effect of Pressure-Inducing System of Transducers of Dynamic Pressure Measurement"	714
D. Wu, Q. Pan and X. Sheng, "The Application of a Computer in Experiment of Reciprocating Compressors"	724
D. Wang and Y. Zhang, "Stress Monitor in High-Pressure Cylinder of Reciprocating Compressor"	736
SESSION: "NON-AZEOTROPIC REFRIGERANTS"	
Chairman: Simon Touber, University of Technology, Delft, The Netherlands	
U. Quast and H. Kruse, "Experimental Performance Analysis of Reciprocating Compressor Working with Non-Acceptropic Refrigerant Mixtures".	751