

# Twin City Fan & Blower

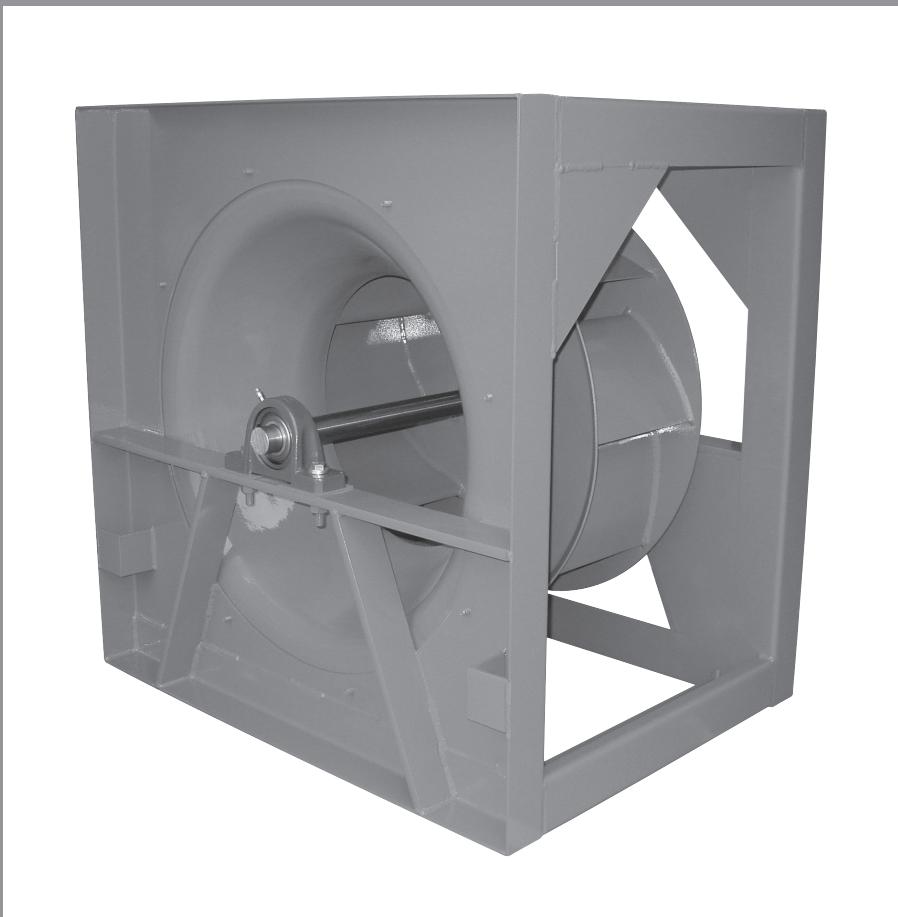
BULLETIN 470

January 2007

## *E-SERIES PLENUM FANS*

**TYPE EPF, EPFN (High Efficiency)**

**TYPE EPQ, EPQN (Better Sound Quality)**



# E-Series Plenum Fans

Twin City Fan & Blower, the world's largest supplier of plenum fans, now offers the completely redesigned E-Series, the first plenum fan to be AMCA licensed for sound and air in both an Arrangement 1 and 3 configuration.

The E-Series offers the flexibility of two plenum fan designs, with each model offering its own unique performance characteristics. While every E-Series fan is highly efficient and quiet, you can choose an E-Series design option that optimizes the performance requirements most important to your application.

## 9-Bladed Wheel Models

### EPF (Arr. 3)

The model EPF features a highly efficient and cost effective, nine-bladed airfoil wheel design. The high efficiency of the EPF will often allow the use of smaller fans without increasing power requirements. The EPF is an Arrangement 3 design.



### EPFN (Arr. 1 and 4)

The model EPFN features the same highly efficient, nine-bladed airfoil wheel design as the EPF, but is available in Arrangement 1 or 4 designs without inlet obstructions.

## 12-Bladed Wheel Models

### EPQ (Arr. 3)

The Better Sound Quality model EPQ features a twelve-bladed airfoil wheel design that flattens the sound spectrum and reduces the dominance of pure tones. The EPQ is an Arrangement 3 design.



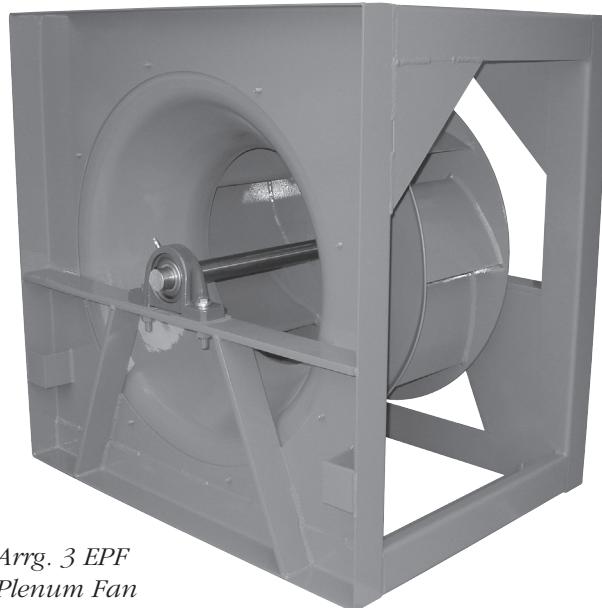
### EPQN (Arr. 1 and 4)

The model EPQN features the same Better Sound Quality, twelve-bladed airfoil wheel design as the EPQ, but is available in Arrangement 1 or 4 without inlet obstructions.



Twin City Fan & Blower certifies that the Type EPF, EPFN, EPQ & EPQN Plenum Fans shown herein are licensed to bear the AMCA Seal. The ratings shown are based on tests and procedures performed in accordance with AMCA Publication 211 and AMCA Publication 311 and comply with the requirements of the AMCA Certified Ratings Program.

Refer to Bulletin 475 for sound power levels.



Arrg. 3 EPF  
Plenum Fan

## Ultra Low Vibration Options

The standard E-Series plenum fans already offers a low vibration design, but when faced with stringent vibration requirements, Twin City Fan & Blower offers patent pending Ultra Low Vibration (ULV) designs with a full spectrum dynamic balance.

Along with the ULV balance guarantee, a full vibration report is provided that includes a summary of banded spectrum limits, spectrum plots on 3 axes, a waterfall (cascade) plot, a time waveform plot, and a transient capture (coast down) plot.

## Compact Designs

### with Performance Assurance

Space is often a key consideration in the selection of plenum fans, making the compact Arrangement 3 configuration very popular.

The Arrangement 3 configuration is constructed with a bearing and bearing bar in the inlet, which will affect fan performance. These performance affects should be taken into account to ensure that your system functions as designed.

As the leading supplier of plenum fans, Twin City Fan & Blower understands the importance of having confidence in performance ratings. Twin City Fan provides our customers that confidence as the only plenum fan manufacturer to offer AMCA licensed sound and air performance on both the Arrangement 1 and 3 fan designs.

# Application Information

Plenum fans are unhoused fans designed to operate inside of field-fabricated or factory-built air handling units.

The fan wheel pressurizes the entire surrounding air plenum in which the fan is installed, allowing air ducts from any direction to be directly connected to the air handling unit enclosure. This design generally saves space by eliminating the fan housing, transitions, and diffusers within the air handling unit.

Plenum fans have found a ready acceptance in the air conditioning industry. In addition, the construction versatility, adaptability in the direction of the discharges, suitability for internal isolation and application of sound panels, and generally lower cost makes it a very popular fan arrangement.

## Benefits of a Plenum Fan

Saves Space – There are no housings, transitions, or diffusers within the air handling unit.

Efficiency – Plenum fans can be as efficient or more efficient than scroll type fans at specific operating points towards the bottom of the fan curve.

Lower cost – Plenum fans are less expensive than scroll type fans.

## EPQ / EPQN Advantage

The EPQ/EPQN plenum fans offers unique performance features that are beneficial for many sound sensitive and higher pressure applications.

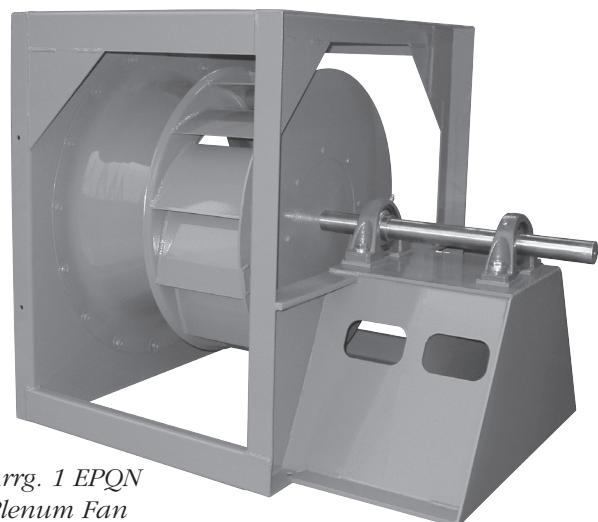
The EPQ/EPQN features a twelve-bladed airfoil wheel versus the nine-bladed wheel of our type EPF/EPFN plenum fans or eight- to ten-bladed wheels with most other competition. The "Q" in the EPQ/EPQN designation stands for Better Noise Quality. Noise quality is a subjective description for noise that is less objectionable.

Looking at the sound comparison, you will notice that the type EPQ/EPQN offers noise (SPL) that is more equally distributed across all frequencies. This can be more pleasant to hear than the sound characteristics of a nine-bladed design. Fans are often dominated in noise by the noise occurring at the blade pass frequency. (Blade pass frequency = RPM x Number of blades/60.) Noise quality is improved by reducing the difference in amplitude between the blade pass amplitudes and the neighboring frequency amplitudes. The increased higher frequency sound power levels on the twelve-bladed wheels mask the blade pass frequency offering a better sounding fan. Although the overall A-weighted sound power levels of the nine-bladed EPF/EPFN fans are slightly lower, the sound "quality" of the twelve-bladed EPQ/EPQN fans may be desirable for the application.

A higher blade pass frequency allows for easier attenuation of the noise, especially when installed inside an air handler cabinet. In many applications, the use of the EPQ/EPQN design

will move the blade pass frequency from the second octave band to the third octave band. Acoustic silencers will normally perform about 10 dB better in the third band.

In addition to sound considerations, there are also additional benefits to using the EPQ/EPQN at higher pressures. Selections over 8" wg static pressure are often near the peak pressure of the fan. The additional blades give a higher peak pressure and also add stability to the fan. Twelve smaller passages through the fan wheel are more resistant to flow disturbances on the inlet than nine larger passages. The EPQ/EPQN is thus more resistant to system effects when operating at high pressures and the higher inlet velocities that accompany these selections.



Arrg. 1 EPQN  
Plenum Fan

TYPE	CFM	SP	RPM	BHP	FREQUENCY, HZ								LwA
					63	125	250	500	1000	2000	4000	8000	
EPQN - 12 Blades	20,000	3	977	13.42	86	89	(90)	83	81	77	69	64	87
EPFN - 9 Blades	20,000	3	967	12.92	89	(94)	87	79	80	74	67	63	85

**NOTE:** Circled figures indicate blade pass frequency.

# Construction Features

## Wheels

High efficiency, non-overloading airfoil wheels are provided on all sizes and arrangements.

**Arr. 1 and 3** – Aluminum wheels using extruded aluminum blades are standard to size 245 on arrangement 1 and 3 fans, and available as an option on larger sizes. Steel wheels are standard on sizes 270 and larger.

**Arr. 4** – Aluminum wheels using extruded aluminum blades are standard to size 600 on direct drive arrangement 4 fans, a popular choice for applications requiring precision balance and improved reliability.

## Inlet Cones

Heavy-gauge, spun steel inlet cones are closely matched to the wheel intake rim to ensure efficient and quiet operation.

## Structural Frame

Frames are constructed of heavy-gauge steel, continuously welded at all connections for maximum strength and rigidity. The “cross frame” bearing support is designed for maximum stability and load distribution.

## Shafts

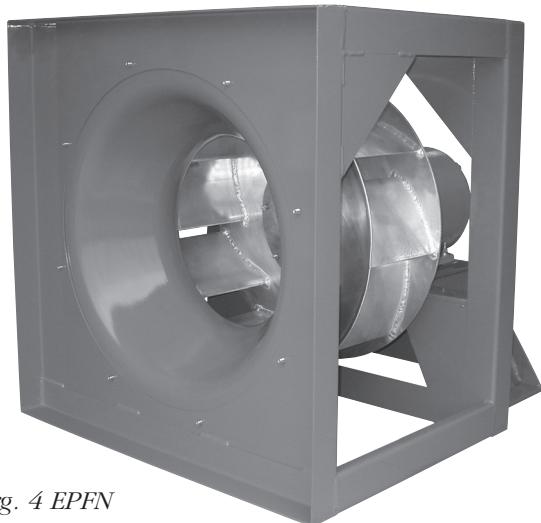
Shafts are AISI Grade 1040 or 1045 hot-rolled steel accurately turned, ground, polished, and ring-gauged for verification. Shafts are generously sized for a first critical speed of at least 1.43 times the maximum speed for the class.

## Fan Bearings

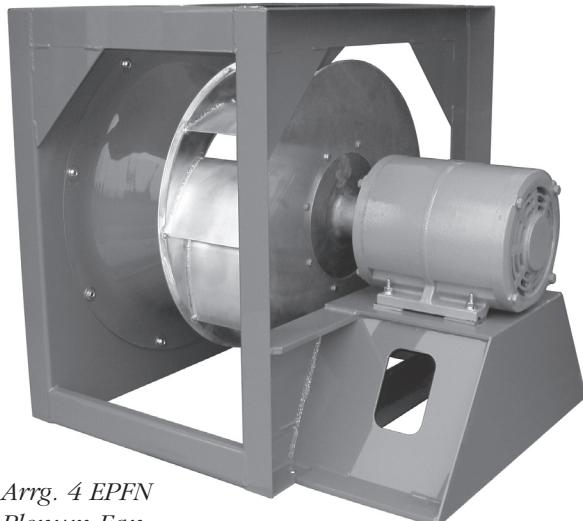
Either ball (adapter mount) or spherical roller, heavy-duty, self-aligning, pillow block type bearings are provided. Bearing selection is based on minimum L-10 life of 80,000 hours. Considering the long life offered with our standard bearing selections, we do not recommend upgrades to split-roller bearings due to their large size, especially on Arrangement 3 fans.

## Inlet Collar

Horizontal configurations are designed to be flex-connected to the perimeter of the square panel without the addition of an inlet collar.



*Arrg. 4 EPFN  
Plenum Fan*



*Arrg. 4 EPFN  
Plenum Fan*

# Flow Measurement System

## Piezometer Ring (Airflow Measuring System)

A piezometer ring is available on plenum fans, as well as other Twin City Fan housed fans, as part of an airflow measuring system, based on the principle of a flow nozzle. The inlet cone of the fan is used as the flow nozzle. The flow can be calculated by measuring the pressure drop through the inlet cone. No tubes or sensors are inserted in the high velocity airstream which could obstruct airflow.

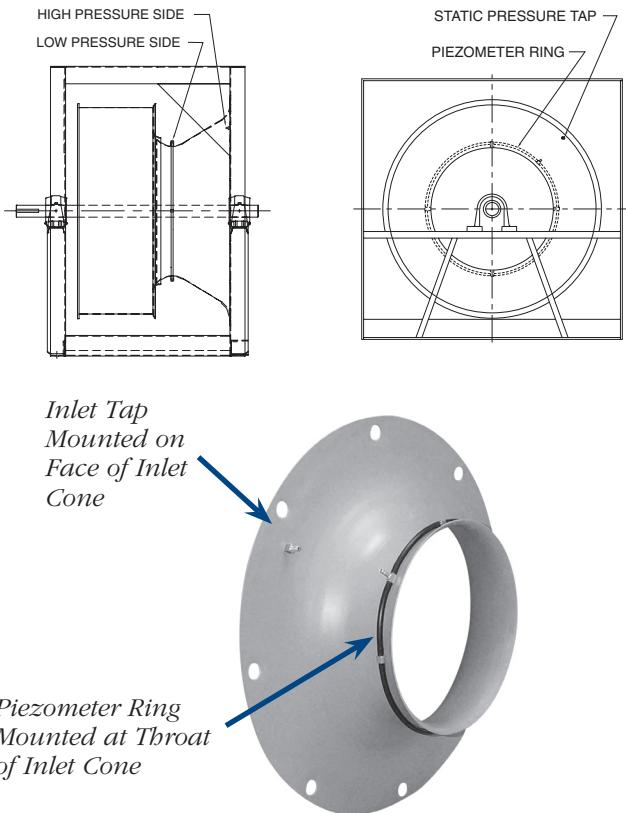
The system consists of a piezometer ring mounted at the throat and a static pressure tap mounted on the face of the inlet cone. A differential pressure transducer and digital display can also be provided.

The pressure drop is measured from the tap located on the face of the inlet cone to the piezometer ring in the throat. The inlet tap is connected to the high-pressure side of the transducer and the piezometer ring is connected to the low-pressure side. See diagram on right.

Based on Twin City Fan laboratory tests, the system was determined to be accurate within +/-5%.

Refer to Twin City Fan Engineering Supplement ES-105.

**NOTE:** Twin City Fan does not recommend placement of flow measuring probes inside the fan inlet cone in the path of airflow. These devices create disturbances and unpredictable performance losses. Twin City Fan will not be responsible for loss of performance due to such devices.



# Accessories

## Variable Inlet Vanes

Variable inlet vanes provide economical, stable, and efficient air volume control for manual or motorized operation. Blades are supported with fatigue-resistant steel shafts and two needle roller bearings riding on zone-hardened surfaces to minimize wear. Bearings are lubricated for life with high grade moisture resistant grease and protected with lip seals. The vane bearing housings are welded in position and stiffened with a welded support ring. The welded structure eliminates flutter and vibration while utilizing a cantilevered design to minimize insertion loss.

**NOTE:** Inlet vanes are not recommended on fans smaller than size 182 due to noise and performance loss.

## Inlet Screen

Heavy-gauge barbecue grille style inlet screen that nests in the inlet funnel for personnel protection on non-ducted inlets.

## Inlet Collar

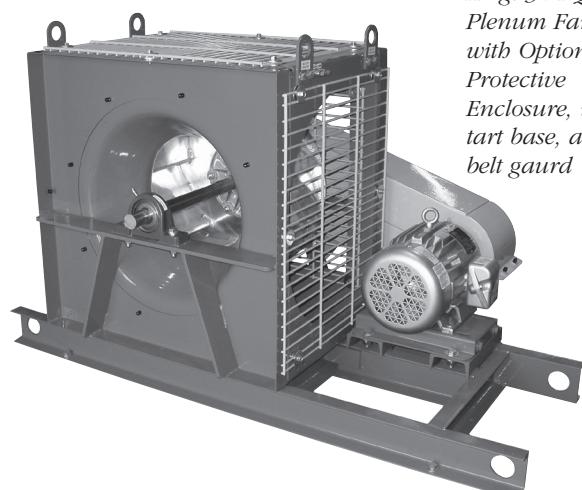
The standard, square-panel design provides the means for flex connecting on all arrangements without an inlet collar.

## Belt Guard

Provides protection to personnel from the moving drive parts. Both standard and OSHA totally enclosed types are available.

## Protective Enclosure

Grill style protective enclosure completely encloses all sides and the back of the fan wheel. Side panels are individually removable to provide access to the wheel.



**NOTE:** On belt driven units, a belt guard should be used for full protection.

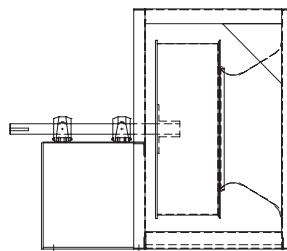
# Arrangements

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## Arrangement 1

Arrangement 1 features an overhung wheel design suitable for V-belt drive and requires mounting of motor independent of the fan.

- Models EPFN and EPQN.
- Class I and II available in sizes 122 to 730. See dimensional drawing on page 28.
- Class III available in sizes 182 to 730. Contact factory for dimensional drawing.

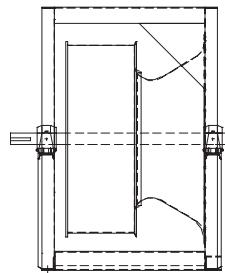


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## Arrangement 3 (Horizontal)

This is the most common plenum fan arrangement for use in OEM and site-built air handlers. Arrangement 3 is suitable for V-belt drive and requires mounting of the motor independently of the fan. Twin City Fan & Blower offers common unitary bases and isolation bases for the fan and motor as accessories.

- Models EPF and EPQ.
- Class I and II available in sizes 122 to 730. See dimensional drawing on page 29.
- Class III available in sizes 182 to 730. See dimensional drawings on page 30.



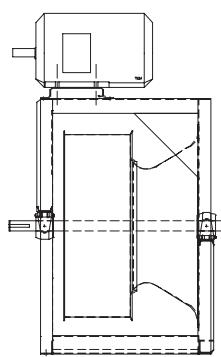
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## Arrangements 3HS and 3HA (Horizontal with Top Mounted Motor)

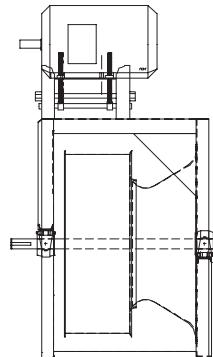
Arrangements 3HS and 3HA provide a means for mounting the motor on top of the unit. This design is often desirable when floor space is limited.

Available with two different motor mounting options: slide base type (Arrangement 3HS) and adjustable motor base (Arrangement 3HA). Due to limited belt center range, NEMA "slide base" option is available on sizes 182 and larger only. A heavy duty Twin City Fan & Blower designed "adjustable motor base" is available for all fan sizes.

- Models EPF and EPQ.
- Arrangement 3HS is available in Class I and II with motor slide base for sizes 182 to 542. See dimensional drawing on page 32.
- Arrangement 3HA with pivot motor base is available in Class I and II for sizes 122 to 542. See dimensional drawing on page 32.



Arrg. 3HS



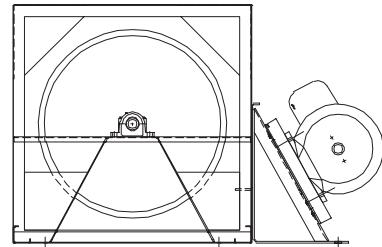
Arrg. 3HA

# Arrangements

## Arrangement 3SM (Horizontal With Side Mounted Motor)

Arrangement 3SM is designed to provide an economical and space-saving means to supply plenum fans with motors mounted to the side of the fan frame. A motor slide base allows for quick and easy belt adjustments.

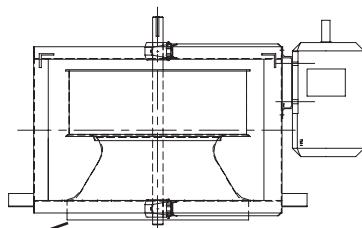
- Models EPF and EPQ.
- Class I and II available in sizes 165 to 600. Motor limited to maximum frame size shown on drawing.
- See dimensional drawing on page 31.



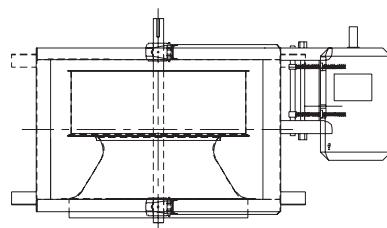
## Arrangements 3VS and 3VA (Vertical with Side Mounted Motor)

Vertical Arrangement 3 is available with two different motor mounting options: slide base type (Arrangement 3VS) and adjustable motor base (Arrangement 3VA). Due to limited belt center range, NEMA "slide base" option is available on sizes 182 and larger only. A heavy duty Twin City Fan & Blower designed "adjustable motor base" is available for all fan sizes.

- Models EPF and EPQ.
- Arrangement 3VS is available in Class I and II with motor slide base for sizes 182 to 542. See dimensional drawing on page 33.
- Arrangement 3VA with pivot motor base is available in Class I and II for sizes 122 to 542. See dimensional drawing on page 33.
- Unless specified otherwise, units will be built for vertical up airflow.



Inlet collar is now optional on 3VS, 3VA



Arrg. 3VA

Shown with optional Inlet collar.

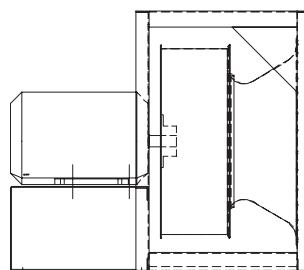
## Arrangement 4 (Horizontal)

Direct drive Arrangement 4 mounts the fan wheel directly onto the motor shaft. This arrangement provides a compact fan/motor unit which eliminates belt residue and requires less maintenance than other arrangements.

For these reasons, Arrangement 4 plenum fans are widely used in cleanroom, pharmaceutical, and other critical applications.

Fans can be selected with varying wheel widths to provide desired performance at direct drive motor speeds. Performance changes in the field are usually achieved by means of variable inlet vanes or VFD.

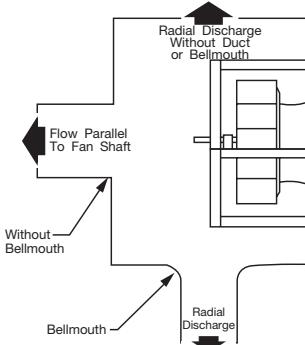
- Models EPFN and EPQN.
- Aluminum wheels using extruded aluminum blades are standard.
- Class I and II available in sizes 122 to 600.
- Class III available in sizes 182 to 600.
- See dimensional drawing on page 34.



# Duct Entrance Losses From Plenum Fan Cabinet

To achieve the air velocity in the discharge duct and overcome the loss associated with the air entering the ductwork, additional resistance must be added to the external static pressure (ESP) requirements of the fan. Different types of duct entrances and locations will require varying correction factors. Therefore, prior to selecting a fan, make the following correction, depending upon the type of duct and its location.

ADDITIONAL DUCT ENTRANCE LOSS TO BE ADDED TO FAN ESP	
DISCHARGE TYPE	CORRECTION FACTOR
● Radial and ducted with bellmouth	1.1 x Duct Velocity Pressure
● Radial and ducted without bellmouth	1.4 x Duct Velocity Pressure
● Radial without duct or bellmouth	1.8 x Duct Velocity Pressure
● Flow parallel to shaft and ducted with bellmouth	1.6 x Duct Velocity Pressure
● Flow parallel to shaft and ducted without bellmouth	1.9 x Duct Velocity Pressure
● Flow parallel to shaft without duct or bellmouth	2.4 x Duct Velocity Pressure



**Example:** A system requires 30,000 CFM at 5" SP at standard air density with one 4 ft diameter duct with bell-mouth placed in a radial discharge. Determine RPM and brake horsepower:

$$\text{Duct area} = (4^2 \times \pi) \div 4 = 12.57 \text{ ft}^2$$

$$\text{Duct velocity} = 30,000 \div 12.57 = 2387 \text{ FPM}$$

$$\text{Duct velocity pressure} = (2387 \div 4005)^2 = 0.355 @ \text{std. cond.}$$

$$\begin{aligned}\text{Entrance loss correction factor} &= 1.1 \times \text{duct velocity pressure} \\ &= 1.1 \times 0.355 = 0.39\end{aligned}$$

Thus, select the fan for = 5" + 0.39" = 5.39" S.P.

## Application Guidelines

### Fan Selection Recommendations

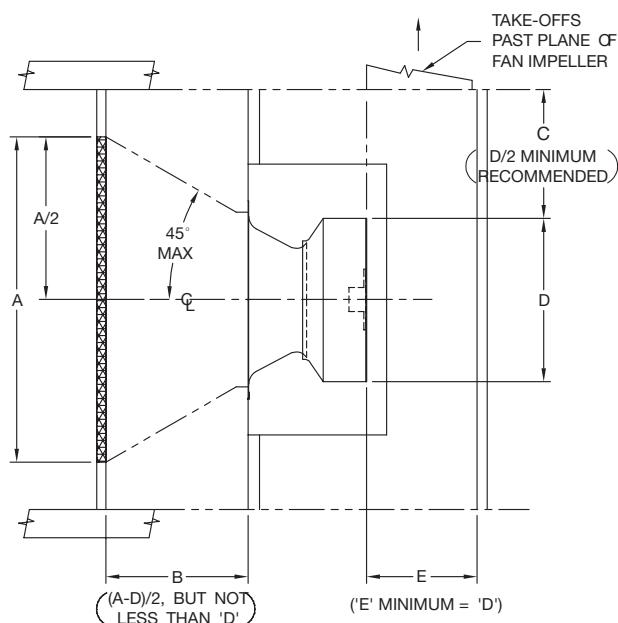
1. System effect losses (see AMCA 201) and plenum losses should be estimated and added to the required static pressure, prior to making selections. Refer to AMCA Publication 201 at [www.amca.org](http://www.amca.org) and Twin City Fan Engineering Data Letter "Fan Performance Troubleshooting Guide" (ED-100) at [www.tcf.com](http://www.tcf.com).
2. Fans should be selected so that the point of operation is approximately between 55% and 90% of the free delivery point on the fan curve.
3. Avoid selections over 4000 RPM. A narrow width, larger size impeller can be used to avoid this.
4. Arrangements 1 and 4 will offer the best efficiency and lowest noise as there are no inlet obstructions.
5. Where space is available, mount the fan and motor on a sub-base. The motor can be mounted on the fan on Arrangements 3HS, 3HA, 3SM, 3VS, and 3VA.
6. Use inertia-type isolation bases or rigid mounting for lowest fan vibration. Rigid mounting requires dynamic analysis (by others) of the support structure to avoid resonance.
7. Applications exceeding 10" SP are prone to high system effect losses. Use of housed fans (BAE-DWDI) should be considered.
8. Where static pressures over 8" wg are required, Type EPQ or EPQN are preferred because of lower operating speeds and improved stability. Select the fan so the design pressure is at least 10% below the peak pressure.
9. Where flow monitoring is required, use a piezometer ring or externally mounted flow measurement station. Fan performance may be substantially affected by flow measurement probes mounted directly in the fan inlet cone. Refer to page 5.
10. For direct drive fans without speed control (or where speed control cannot exceed 60 Hz), select fans at 3 – 5% below the nominal speed of the motor. This will normally cover the uncertainties associated with the system and air balancer's measurements. Select motors loaded no closer than 90% of the maximum loading of the motor.
11. For multiple fans in a plenum, alternate CW and CCW rotation fans to minimize losses. If fans are not counter-rotating, install walls between each fan to create cells in the outlet plenum.
12. Add losses for duct take-offs per the chart above to pressure requirements of the fan. Bellmouth entries will always reduce losses and are recommended.
13. For highest reliability, specify the required bearing life. For example, the statement "minimum L-10 bearing life = 100,000 hours" allows for the best bearing to be put on the fan without creating other problems. Some specifications state "use split roller bearings." This can cause a number of problems, such as:
  1. On smaller fans, there may not be enough radial load to prevent roller skidding. This is especially a problem for Arrangement 3 fans.
  2. Split roller bearings are not offered in sizes smaller than 1 1/16" bore. Smaller fans use shafts smaller than this.
  3. The oversized bearing in the inlet will block some air in smaller fans (above the losses that are already included in the EPF/EPQ ratings).

# Application Guidelines

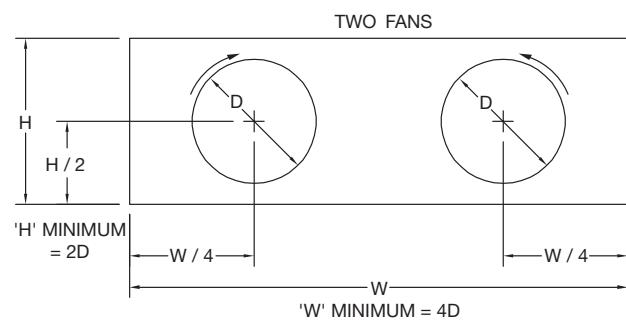
## Location and Placement of Fans in Air Handlers

- Center the fan inlets in both the horizontal and vertical planes.
- For inlet clearance, see Figure 1. The flow should converge at an angle not greater than  $45^\circ$  when approaching the opening for the fan inlet. A minimum of one fan wheel diameter clearance is recommended.
- In the fan outlet plenum, a minimum wall clearance of one-half fan wheel diameter to the periphery of the fan wheel is recommended.
- Figure 1 shows that the minimum clearance between the back of the fan wheel and the nearest component downstream (Dim. E) should be one wheel diameter. Small clearances do not allow the flow to equalize behind the fan wheel and the pressure drop of the downstream component is increased.
- When the flow enters the inlet plenum perpendicular to the fan shaft, large system effect losses can occur. See Figure 2 for a recommended flow baffle or a vortex breaker that may help preserve rated fan performance.

*Figure 1. Recommended Location of Fan in Plenum*



*Figure 3. Location of Counter-Rotating Fans*



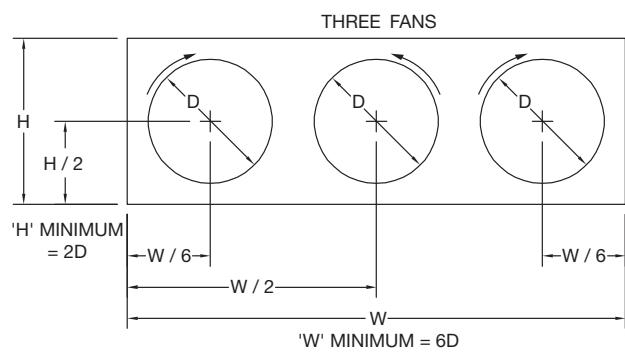
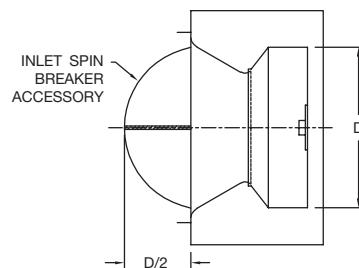
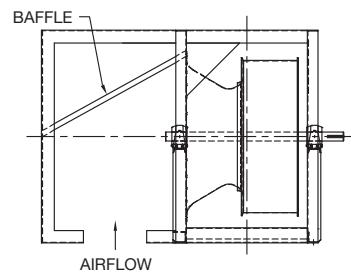
**NOTE:** 'D' = Wheel diameter

- When two or more fans are installed in a plenum, divide the plenum into imaginary cells of equal area. Center the fan inlets on each cell. See Figure 3.

## Installation Recommendations

- Install the fan so the flexible connector on the inlet remains uncollapsed during operation.
- Install thrust restraints (snubbers) to maintain the axial position of the fan when it is generating pressure.
- Peripheral equipment, such as electrical components, inverters, control panels, etc., should be positioned away from the high velocity air entering or leaving the fan.
- Adjust springs on the isolation base so that spring deflection is approximately equal for all isolators.
- Follow safety, installation, start-up, and maintenance instructions supplied with each fan.

*Figure 2. Flow Baffle and Vortex Spin Breaker Location*

































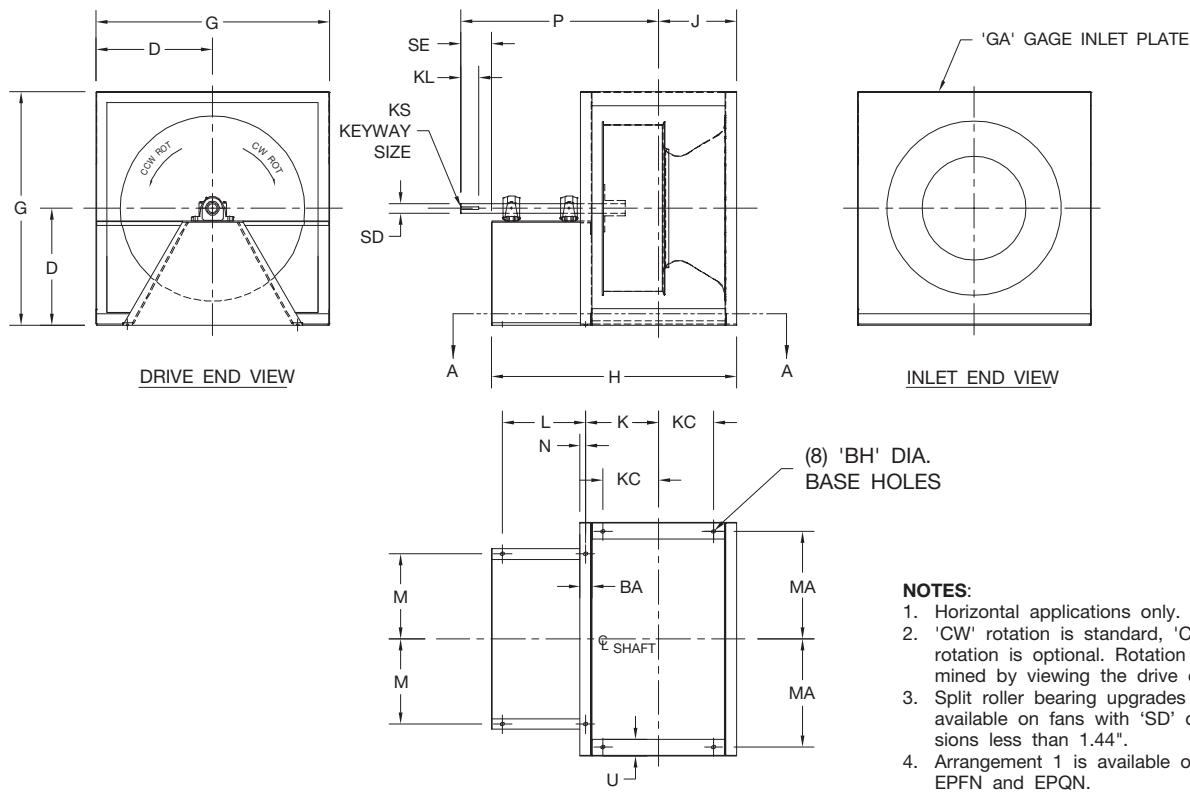








# Dimensional Data – Horizontal, Arr. 1 - Class I and II



## NOTES:

1. Horizontal applications only.
2. 'CW' rotation is standard, 'CCW' rotation is optional. Rotation is determined by viewing the drive end.
3. Split roller bearing upgrades are not available on fans with 'SD' dimensions less than 1.44".
4. Arrangement 1 is available on models EPFN and EPQN.

SIZE	BA	BH	D	G	GA	H	J	K	KC	KL	KS		L	M	MA	N	P	SD		SE	U
											CL I	CL II						CL I	CL II		
122	1.50	0.31	10.00	20.00	12	22.88	6.88	6.25	4.00	3.25	.25 x .13	.25 x .13	7.88	6.75	9.13	0.63	20.38	1.00	1.19	4.38	1.50
150	1.50	0.44	11.00	22.00	12	26.88	7.88	7.25	5.00	3.25	.25 x .13	.25 x .13	9.88	8.25	10.13	0.63	23.38	1.00	1.19	4.38	1.50
165	1.50	0.44	12.00	24.00	12	28.13	8.50	7.88	5.50	3.25	.25 x .13	.25 x .13	9.88	8.75	11.13	0.63	24.00	1.00	1.19	4.38	1.50
182	1.75	0.44	13.00	26.00	12	30.88	9.50	8.75	5.25	3.88	.25 x .13	.25 x .13	10.75	9.63	11.50	0.75	26.38	1.19	1.44	5.00	4.00
200	2.25	0.56	14.50	29.00	12	33.75	10.69	9.69	7.50	3.63	.38 x .19	.38 x .19	11.50	10.63	13.00	1.00	28.06	1.44	1.44	5.00	4.00
222	2.25	0.56	16.00	32.00	10	37.88	11.50	10.50	8.00	4.25	.38 x .19	.38 x .19	14.00	11.75	14.50	1.00	32.00	1.44	1.69	5.63	4.00
245	2.50	0.56	17.00	34.00	10	41.38	12.63	11.50	7.50	4.25	.38 x .19	.38 x .19	15.38	12.88	14.50	1.13	34.38	1.44	1.69	5.63	4.00
270	2.50	0.56	19.00	38.00	10	45.38	13.63	12.50	8.00	5.63	.38 x .19	.50 x .25	17.38	14.13	16.50	1.13	38.75	1.69	1.94	7.00	4.00
300	3.00	0.56	21.00	42.00	10	50.13	15.25	13.88	9.00	5.50	.50 x .25	.50 x .25	19.13	15.88	17.50	1.38	41.88	1.94	1.94	7.00	4.75
330	3.50	0.56	23.00	46.00	10	54.88	16.88	15.25	10.75	6.75	.50 x .25	.50 x .25	20.88	17.38	19.50	1.63	46.25	1.94	2.19	8.25	4.75
365	3.50	0.56	25.50	51.00	7	59.31	18.31	16.69	12.00	6.75	.50 x .25	.63 x .31	22.44	18.88	22.00	1.63	49.25	1.94	2.44	8.25	4.75
402	3.50	0.81	28.00	56.00	7	64.19	19.75	18.13	13.50	6.75	.50 x .25	.63 x .31	24.44	20.88	24.50	1.63	52.69	2.19	2.44	8.25	4.75
445	4.00	0.81	31.00	62.00	7	70.81	21.81	19.94	15.81	6.50	.63 x .31	.63 x .31	27.19	22.88	26.50	1.88	57.25	2.44	2.69	8.25	6.00
490	4.00	0.81	34.00	68.00	7	76.31	23.56	21.69	17.56	6.50	.63 x .31	.75 x .38	29.19	25.38	29.50	1.88	61.00	2.69	2.94	8.25	6.00
542	4.00	0.81	38.00	76.00	7	81.31	25.56	23.69	19.56	6.38	.75 x .38	.88 x .44	30.19	27.63	33.50	1.88	64.00	2.94	3.44	8.25	6.00
600	5.00	0.81	38.00	76.00	.25	89.88	28.81	26.44	21.81	6.63	.75 x .38	.88 x .44	32.75	30.63	33.50	2.38	69.56	2.94	3.44	8.50	6.00
660	5.00	0.81	40.75	81.50	.25	97.50	31.13	28.75	24.13	6.63	.88 x .44	1.00 x .50	35.75	33.13	36.25	2.38	75.00	3.44	3.94	8.63	6.00
730	5.00	0.81	46.00	92.00	.25	105.75	33.75	31.38	26.75	6.63	.88 x .44	1.00 x .50	38.75	37.13	41.50	2.38	80.63	3.44	3.94	8.63	6.00

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DIMENSIONS ARE SUBJECT TO CHANGE. CERTIFIED DRAWINGS AVAILABLE UPON REQUEST.











# Typical Specifications

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Fans shall be Type EPF, EPFN, EPQ or EPQN centrifugal plenum (plug) type, as manufactured by Twin City Fan & Blower, Minneapolis, Minnesota.

Fans shall have a sharply rising pressure characteristic extending through the operating range and continuing to rise beyond the peak efficiency to ensure quiet and stable operation. Fans shall have a non-overloading design with self-limiting horsepower characteristics and shall reach a peak in the normal selection area. All fans shall be capable of operating over the minimum pressure class limits as specified in AMCA's Standard 2408-69.

**PERFORMANCE** — Fans shall be tested in accordance with AMCA 210 and AMCA 300 test standards for air moving devices and shall be guaranteed by the manufacturer to deliver rated published performance levels. Fans shall be licensed to bear the AMCA certified ratings seal for fan inlet sound, fan outlet sound, and air performance.

Arrangement 3 fans shall be tested and rated with shaft, bearings, and bearing bar in the inlet and shall be licensed to bear the AMCA certified ratings seal for both sound and air.

**CONSTRUCTION** — Fans shall be designed without a scroll type housing and shall incorporate a non-overloading type backward inclined airfoil blade wheel, heavy-gauge reinforced steel inlet plate, structural steel frame, and shaft and bearings.

**FRAME AND INLET PANEL** — Inlet panels shall be of heavy-gauge reinforced steel construction. The inlet panel incorporates a removable spun inlet cone designed for smooth airflow into the accompanying inlet retaining ring of the fan wheel. A square, formed lip suitable for attachment of a boot connector shall surround the unit.

**WHEEL** — Wheels shall have a spun non-tapered style blade retaining ring on the inlet side to allow higher efficiencies over the performance range of the fan. Sizes 245 and smaller shall have airfoil-shaped extruded aluminum blades. Sizes 270 and larger shall have die-formed airfoil steel blades with the option of extruded aluminum blades. All wheels on direct drive arrangement 4 fans shall have airfoil-shaped extruded aluminum blades. Wheels shall be of welded construction. EPF and EPFN wheels shall have nine blades for high efficiencies. EPQ and EPQN wheels shall have twelve blades for better sound quality. All wheels shall be statically and dynamically balanced on precision electronic balancers to a Balance Quality Grade G6.3 per ANSI/AMCA 204 or better.

**SHAFT** — Shafts shall be AISI 1040 or 1045 hot rolled steel, accurately turned, ground, polished, and ring gauged for verification. Shafts shall be sized for the first critical speed of at least 1.43 times the maximum speed. All shafts must be dial indicated for straightness after the keyways are cut and straightened as required.

**FAN BEARINGS** — Bearings shall be heavy duty, grease lubricated, anti-friction ball (adapter mount) or roller, self-aligning, pillow block type and selected for a minimum bearing life (AFBMA L-10) in excess of 80,000 hours at the maximum fan RPM. All bearings shall be equipped with greasable zerk fittings and, where necessary, extended lube lines for easy access for lubrication.

**DRIVE** — Motor sheaves shall be cast iron, variable pitch on applications 10 HP and smaller, and fixed pitch on 15 HP and larger. Drives and belts shall be rated for 150% of the required motor HP.

**FINISH AND COATING** — The entire fan assembly, excluding the shaft, shall be thoroughly degreased and deburred before application of a rust-preventative primer. After the fan is completely assembled, a finish coat of paint shall be applied to the entire assembly. The fan shaft shall be coated with a petroleum-based rust protectant. Aluminum components shall be unpainted.

**ACCESSORIES** — When specified, accessories shall be provided by Twin City Fan & Blower to maintain one source responsibility.

**VARIABLE INLET VANES** — When specified, the variable inlet vanes shall be internal "nested" type. Each assembly is to have eleven vanes on sizes 245 and larger, and eight vanes on sizes 182 through 222. Each vane assembly shall be complete with quadrant and handle, suitable for manual or automatic operation. Construction shall be heavy-gauge and shall be of the cantilever design. Vanes are lubricated for life with a high quality moisture-resistant lubricant.

**FACTORY RUN TEST** — All fans prior to shipment shall be completely assembled and test run as a unit at the specified operating speed or maximum RPM allowed for the particular construction type. Maximum vibration shall be within the limits of ANSI/AMCA 204 Fan Application Category BV-3. Balance readings shall be taken by electronic type equipment in the axial, vertical, and horizontal directions on each of the bearings. Records shall be maintained and a written copy shall be available upon request.

**GUARANTEE** — The manufacturer shall guarantee the workmanship and materials for its EPF, EPFN, EPQ and EPQN fans for at least one (1) year from startup or eighteen (18) months from shipment, whichever occurs first.

# Unlimited Options...

## Commercial Fans

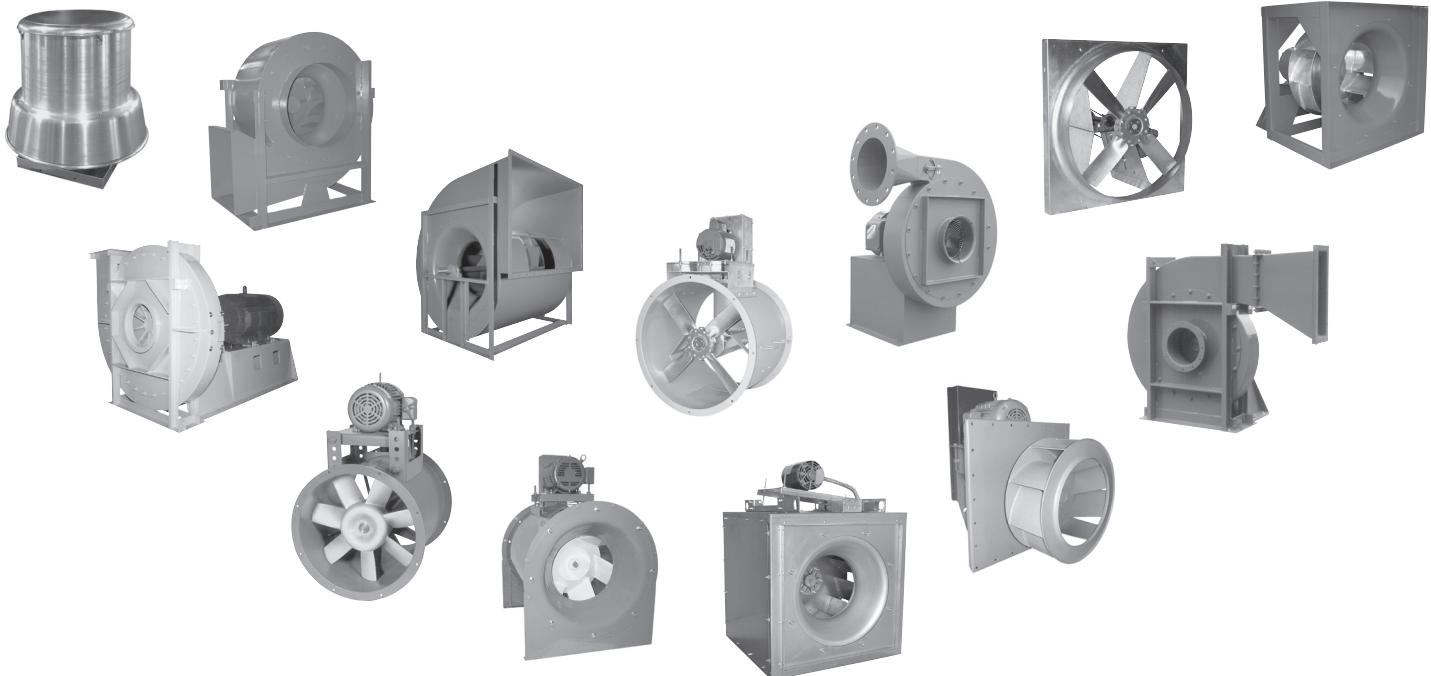
Centrifugal Fans • Utility Sets • Inline Centrifugal Fans • Plenum Fans  
Radial Bladed Fans • Centrifugal Roof & Wall Exhausters • Filtered Supply Fans  
Gravity Relief Ventilators • Ceiling & Cabinet Ventilators • Propeller Wall Fans  
Tubeaxial Fans • Vaneaxial Fans • Propeller Roof Ventilators  
Fume Hood/Smoke & Heat Exhaust Fans • Mancoolers • Fiberglass Fans

## Industrial Fans

Centrifugal Fans • Forward Curved & Air Kit Components • Inline Centrifugal Fans  
Plug Fans • Radial Bladed Fans • Radial Tip & High Efficiency Fans  
Pressure Blowers • Tubeaxial Fans • Vaneaxial Fans

## Custom Design Fans

Easy Access Fans • Insulated Fans • Inlet Boxes - Integral and Detached  
Inlet Box Dampers • Independent Bearing Pedestals • Split Housings • Bolted Housings  
Spark Resistant Construction • Ultra Fine Balancing • Modified Widths and Diameters  
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