

between the vacuum pump and the system; where intended for continuous operation they do not require a receiver. Such pumps employ a vacuum producing impeller which removes air from the receiver or heating system under a partial vacuum and delivers it through an air separator against atmospheric pressure. The condensate is removed from the receiver under a partial vacuum by a separate impeller and is delivered to the boiler or feed water heater. For evacuating and discharge, a water displacement vacuum producer with two pump impellers is used.

Receiver Capacities for Vacuum Pumps

Where receivers are used in connection with vacuum pumps there is a definite relation between the capacity of the receiver and the capacity of the pump. The receiver should have a capacity of not less than $1\frac{1}{2}$ times the volumetric quantity of condensation per minute and should not have such a capacity that the pump will empty the receiver in less than half a minute. Receivers of larger capacities will result in less frequent periods of operation.

Piston Displacement Vacuum Pumps

Piston displacement return-line vacuum heating pumps may be either power or steam driven. They should be provided with mechanical lubricators and their piston speed in feet per minute should not exceed 20 times the square root of the number of inches in their stroke. While the volumetric displacement for such pumps was formerly figured at 8 to 10 times the volumetric flow of condensation to be handled, the more efficient thermostatic traps used today in connection with vacuum heating systems make it possible to change this proportion so that the volumetric displacement of these pumps may not be less than 6 times the volume of condensation.

Vacuum Pump Controls

In the ordinary vacuum system the vacuum pump is controlled by a vacuum regulator which cuts in when the vacuum drops to the lowest point desired and which cuts out when the vacuum has been increased to the highest point. This is done largely to eliminate the constant starting and stopping of the vacuum pump which would occur if the vacuum were maintained constant. In addition to this control, a float control is included which will automatically start the pump whenever sufficient condensation accumulates in the receiver, regardless of the vacuum in the system. This arrangement makes the vacuum pump primarily a condensation pump and secondarily an air pump.

On the sub-atmospheric systems the high vacuum pump is controlled by a differential regulator which keeps the vacuum in the return line always a few inches higher than that in the steam line and in the radiators.

TRAPS

Traps are used for draining the condensate from radiators, steam piping systems, kitchen equipment, laundry equipment, hospital equipment, drying equipment and many other kinds of apparatus. The usual

functions of a trap are to allow the passage of condensate and to prevent the passage of steam. In addition to these functions, traps are frequently required to allow the passage of air as well as condensate. Traps are also required to allow the passage of air and to prevent the passage of either water or steam, or both.

In addition, traps are used for returning condensate either by gravity, by steam pressure, or by both, to a boiler or other point of disposal, and for lifting condensate from a lower to a higher elevation, or for handling condensate from a lower to a higher pressure.

The fundamental principle upon which the operation of practically all traps depends is that the pressure within the trap at the time of discharge shall be equal to, or slightly in excess of, the pressure against which the trap must discharge, including the friction head, velocity head and static head on the discharge side of the trap. If the static head is in favor of the trap discharge it is a minus quantity and may be deducted from the other factors of the discharge head.

Traps may be classified according to the principle of operation as (1) float, (2) bucket, (3) thermostatic, or (4) tilting traps.

Float Traps. A discharge valve is operated by the rise and fall of a float due to the change of water level in the trap. When the trap is empty the float is in its lowest position, and the discharge valve is closed. A gage glass indicates the height of water in the chamber.

Unless float traps are well made and proportioned there is danger of considerable steam leakage through the discharge valve due to unequal expansion of the valve and seat and the sticking of moving parts. The discharge from a float trap is usually continuous since the height of the float, and consequently the area of the outlet, is proportional to the amount of water present.

Bucket Traps. Bucket traps are of two types, the upright and inverted, and although they are both of the open float construction, their operating principle is entirely different. In the *upright bucket trap*, the water of condensation enters the trap and fills the space between the bucket and the walls of the trap. This causes the bucket to float and forces the valve against its seat, the valve and its stem usually being fastened to the bucket. When the water rises above the edges of the bucket it flows into it and causes it to sink, thereby withdrawing the valve from its seat. This permits the steam pressure acting on the surface of the water in the bucket to force the water to a discharge opening. When the bucket is emptied it rises and closes the valve and another cycle begins. The discharge from this type of trap is intermittent.

In the *inverted bucket trap*, steam floats the inverted submerged bucket and closes the valve. Water entering the trap fills the bucket which sinks and through compound leverage opens the valve, and the trap discharges. It is impossible to install a water gage glass on an inverted bucket trap, but if visual inspection is necessary, a gage glass can be placed on the line leading to the trap. No air relief cocks can be used but this is unnecessary, as the elimination of air is automatically taken care of by air passing through the vent in the top of the inverted bucket regardless of temperature.

Thermostatic Traps. Thermostatic traps are of two types, those in which the discharge valve is operated by the relative expansion of metals, and those in which the action of a volatile liquid is utilized for this purpose. Thermostatic traps of large capacity for draining blast coils or very large radiators are called *blast traps*.

Tilting Traps. With this type of trap, water enters a bowl and rises until its weight overbalances that of a counter-weight, and the bowl sinks to the bottom. As the bowl sinks, a valve is opened thus admitting live steam pressure on the surface of the water and the trap then discharges. After the water is discharged, the counter-weight sinks and raises the bowl, which in turn closes the valve and the cycle begins again. Tilting traps are necessarily intermittent in operation. They are not ordinarily equipped with glass water gages, as the action of the trap shows when it is filling or emptying. The air relief of tilting traps is taken care of by the valves of the trap.