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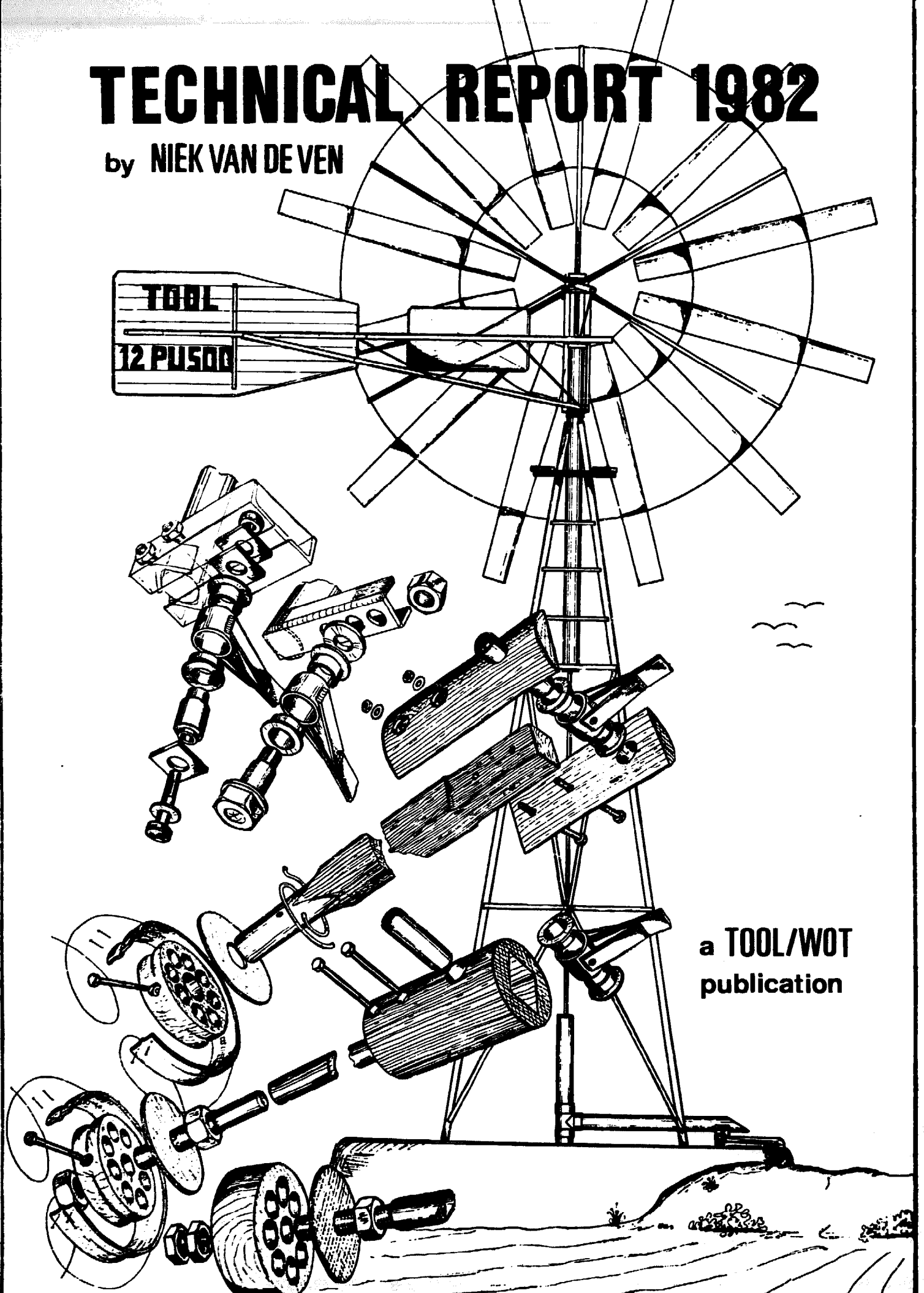
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TECHNICAL REPORT 1982

by NIEK VAN DE VEN



a TOOL/WOT
publication

TECHNICAL REPORT
by NIEK VAN DE VEN
dealing with the
TOOL WINDMILLPROJECTS
over the period
AUGUST 1977. MARCH 1981

TOOL TECHNICAL DEVELOPMENT WITH DEVELOPING COUNTRIES
MAURITSKADE 61 a, 1092 AD AMSTERDAM, THE NETHERLANDS

WOT WORKING GROUP ON DEVELOPMENT TECHNIQUES
T.H. TWENTE, VRIJHOF 152, P.O. BOX 217,
7500 AE ENSCHEDE, THE NETHERLANDS

Acknowledgement

The Netherlands assistance in the windmill projects in Ghazipur and Allahabad officially stopped at the end of March 1981. It was recognized by the project management committee that the experiences of the experts in these projects should be recorded.

Finally it was agreed that the financing of this activity took place through the Steering Committee Windenergy Developing countries (SWD). This is a government financed organisation promoting the interest for wind energy in developing countries and aims at helping governments, institutions and private parties in the Third World with their efforts to utilize wind energy.

The author is very grateful to all parties concerned that the experiences could be materialized in this publication. It is hoped that it will contribute to the extension of development in many countries

NIEK VAN DE VEN

TOOL is a Dutch foundation participating in the global process of renewable development and application of socially appropriate technologies.

The broad objective is to promote greater freedom for groups which are deprived of full opportunities for local, self-programmed and self-sustained development.

The strategy is to provide and support information resource links among the practitioners, users and generators of appropriate technology for development.

The operations of TOOL are designed to match need and resource:

- technical advice and support
- research and development
- publications
- documentation systems and services
- application projects
- education and training
- organisational linkages.

WOT is a non-profit organisation at the Twente University of Technology and gives technical advice in the field of wind energy, solar energy and water supply. The broad objective is to improve the position of the weaker sections in society and the advice should be appropriate to the local situations and circumstances. To support the technical advice the WOT has a testing field where various designs are being developed and tested. The WOT is mainly a voluntary organisation and consists mainly of students of the university. Several staffmembers take care for the administrative and technical support.

CONTENTS

page

0.	<u>Short History.</u>	
1.	<u>The design criteria and first developments.</u>	
1.1	The construction of the first prototype	1.3
1.2	The first experiments in the Netherlands	1.11
2.	<u>Technical developments of the windmills.</u>	
2.1	The first experiences with the 5 m dia windmills	2.2
2.2	The prototypes under development	2.5
2.2.1	The tower construction	2.6
2.2.2	The head construction	2.8
2.2.3	The moving parts: Crank mechanism, bearings etc.	2.14
2.2.4	The rotor	2.23
2.2.5	The piston pump	2.28
2.2.6	The pump suspension	2.39
2.3	The 4 PU 250 windmill for low water lifting	2.43
3.	<u>Test - Rig for 12 PU 500 windmill.</u>	
3.1	Demanded features of the Test - Rig	3.1
3.1.1	Drive of the Test - Rig	3.2
3.1.2	Self-moving head construction	3.4
3.1.3	Simulation of the elevation head	3.5
3.1.4	Instruments	3.7
3.1.5	Way of testing	3.9
3.2	Pumps to be tested	3.10
3.2.1	The 4" S 500	3.11
3.2.2	The 5" SS 500	3.12
3.2.3	The 6" PVC 500	3.12
3.2.4	The 6" S 500	3.13

3.3	Testresults	3.13
3.4	Volumetric efficiencies	3.16
3.5	Conclusions with regard to life-time features of the test pumps	3.16
4.	<u>Properties and characteristics of the 12 PU 500.</u>	
4.1	Input-output relations, volumetric and overall-efficiencies	4.1
4.2	The power characteristics of the windmill	4.6
4.3	Analysis of the windmill-pistonpump combination	4.9
5.	<u>Defining optimal starting windspeed, windmill- and pump-dimensions.</u>	
5.1	Deriving the optimal starting windspeed	5.2
5.2	Deriving required rotor dia	5.7
5.3	Pump dimensions	5.8
5.4	Numerical example	5.13

Short History

In 1975 the Organization of the Rural POOR (ORP) in Ghazipur (India, U.P.) wanted to support small and marginal farmers in growing an extra crop during summer season by means of irrigation. As rather high wind speeds occur during summers the idea was born to use wind energy as the power source for pumping the irrigation water from the wells.

In cooperation with the TOOL-foundation in the Netherlands some feasibility studies have been carried out and eventually a proposal for a pilot windmill project has been granted both by the Government of India and the Netherlands. The latter sponsored the pilot project which started in August of 1977.

The project was extended year by year while the 12 PU 500 Windmill design improved step by step. Expansion of the project occurred in 1979 when the newly built ORP-TOOL-Windmill workshop was inaugurated and the Windmill Research and Developments activities were taken up at the Allahabad Polytechnic Allahabad (APA). In the course of 1980 another Windmill project started in Trichy (South India) where the Workshop for Rehabilitation and Training of Handicapped (WORTH) also adopted the same windmills for irrigation as one of its products. (The latter has been financed by HIVOS.)

In January of 1981 the Allahabad Polytechnic Allahabad started the "National Windmill Demonstration Project" which was initiated and sponsored by the Department of Science and Technology (DST) of the Government of India. During the first three months thirty 12 PU 500 windmills have been successfully distributed all over India attended with training courses for mechanics and engineers, after which the TOOL-project ran to its end.

The following year three hundred 12 PU 500 windmills have been

built by the Allahabad Polytechnic by order of the Department of Science and Technology while plans exist regarding a windmill production of several thousands during the next year.

1. The design criteria and first developments.

Previous to the introduction of the new waterlifting device sufficient knowledge concerning its feasibility and acceptance should be gathered in order to obtain relevant input for a proper set up of a pilot project.

Therefore short term missions were undertaken to Ghazipur to gather information about materials, equipments and expertise. Also information on winddata of the eastern part of Uttar Pradesh gave important information in order to calculate the size of the windmill which had to be designed.

Since the windspeeds in the Ghazipur district are rather low, rough calculations pointed out that even in the windy season a windmill applied for irrigation of a command area of two and a half acres (1 ha) needs a rotor diameter of at least 7 metres. This calculation was based on the assumption that the average water requirement of the irrigated plots amounts to \pm 7 mm a day, the total pumping head increases to 14 metres (dry season) and that the windmill starts pumping with a total efficiency of 0.10 (if the windspeed exceeds 2.5 m/s.).

Other calculations also led to smaller windwheel diametres, very high starting windspeeds and extremely huge storage tanks on the one hand and a large rotor diameter, moderate tank-capacities and low starting windspeeds on the other.

An optimum must exist depending on material- and labourcosts and the loss of agricultural area in order to realize the needed storage tank. All these matters were taken into account to approach this unknown ideal of windmill size and storage capacity, but still a lot of uncertain aspects and doubts remained.

Moreover in 1977 the availability of expertise and successful designs of cheap, reliable and appropriate windmills were

rather limited in spite of the fact that many efforts had been undertaken already to develop windmills in other developing countries.

Such experiences always showed that the introduction of the windmill is easily underrated. First the technology has to be developed and implemented successfully under the local circumstances after which a process of transfer of technology should take place.

Due to the above mentioned lack of sufficient experience, it was decided to design and develop first a proto-type windmill in the Netherlands which should be completely constructed with the materials, expertise and implements which are locally available in Ghazipur. The total material-costs should amount to Dfl. 1000.-- (Rs 3000.-- up to Rs 4000.-- 1977).

Materials like gas-pipe, angle-irons, flat- and sheet-irons, ball-bearings, bolts & nuts etc. would be available in plenty there according to the information obtained.

The local blacksmiths in India are able to construct simple implements from these, like wheat-threshers and many other agricultural equipment. Moreover the electrification of several villages sparks off more or less sufficiently equipped blacksmiths and small industries. So welding and simple machining, like drilling- and lathe-work, are rather current.

In comparison with steel (1977: angle iron RS 2.20/Kg) wood is very costly and later on it proved not to be available in required size and quality. For example wood for the construction material for building a tower-structure would not be attractive as far as the lifetime is concerned. Moreover the Indian Government stimulates application of other construction-material rather than wood in order to prevent the severe erosion of the country due to deforestation.

Such considerations and restrictions led to new ideas and alternative designs of some essential parts of the windmill. In September 1977 the construction of the first proto-type windmill was carried out at the testing field of the Working

Group on Developing Techniques (WOT) which is a member of the TOOL-foundation.

1.1 The construction of the first proto-type

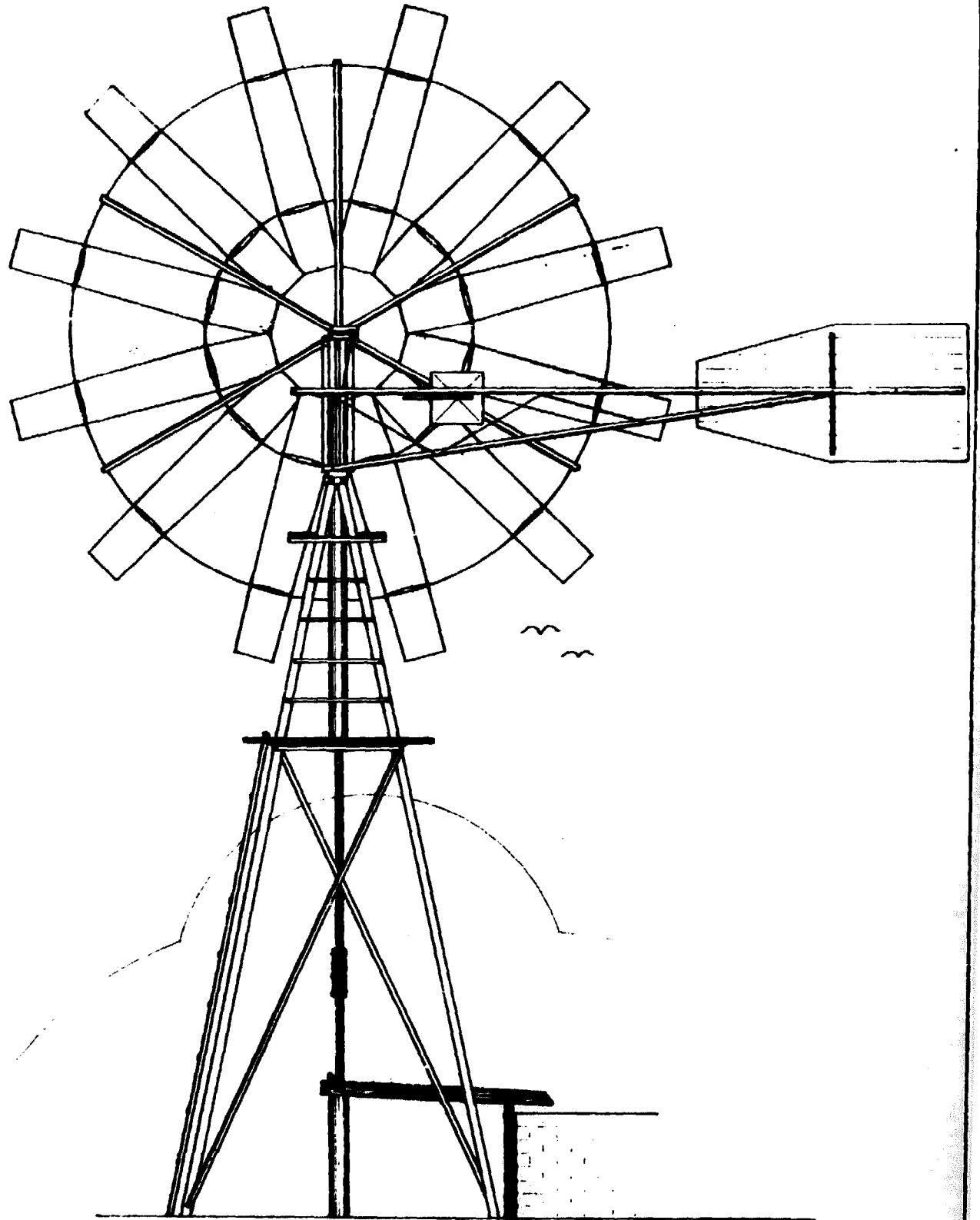
This first proto-type windmill was fitted with a 4m diameter 16 bladed rotor which was left after an education program of the WOT in which it was constructed. It seemed to be a fruitful opportunity to integrate it in the design which had to be developed at that time, but afterwards it turned out that this rotor was too weak, too complicated and too expensive. Moreover according to the estimation a 4 m. diameter-windmill is rather small to serve the purpose. So after some trouble-shooting during the months of September-November, the experience with the very first proto-type caused a complete re-designing. This resulted in a set of drawings of the tower construction, head construction, moving parts and the windwheel of a new 5 m. dia. 12-bladed proto-type. Besides also a small building manual of the new proto-type has been edited, but actually the total set was not yet completed. Still the design and the drawings of the most important and essential part of this wind-powered water-lifting device, the pump, failed. In the next chapters extra attention will be paid to the pump designs which followed.

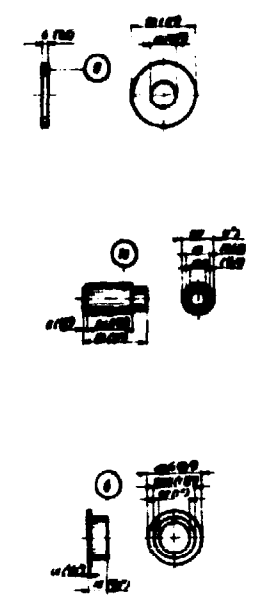
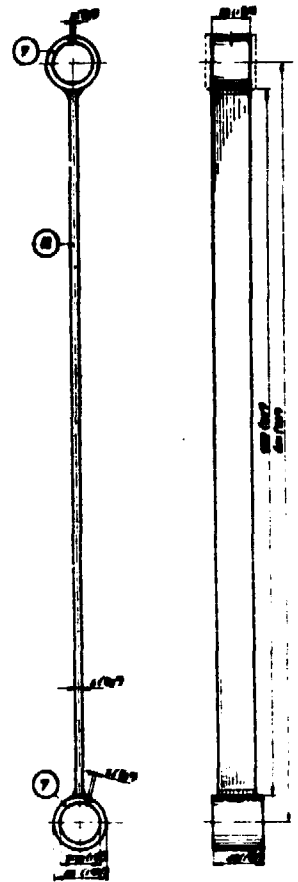
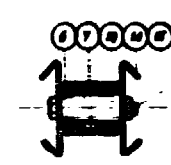
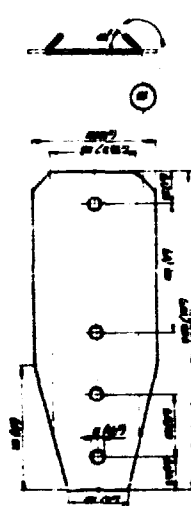
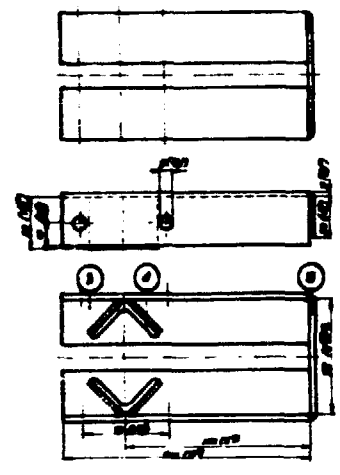
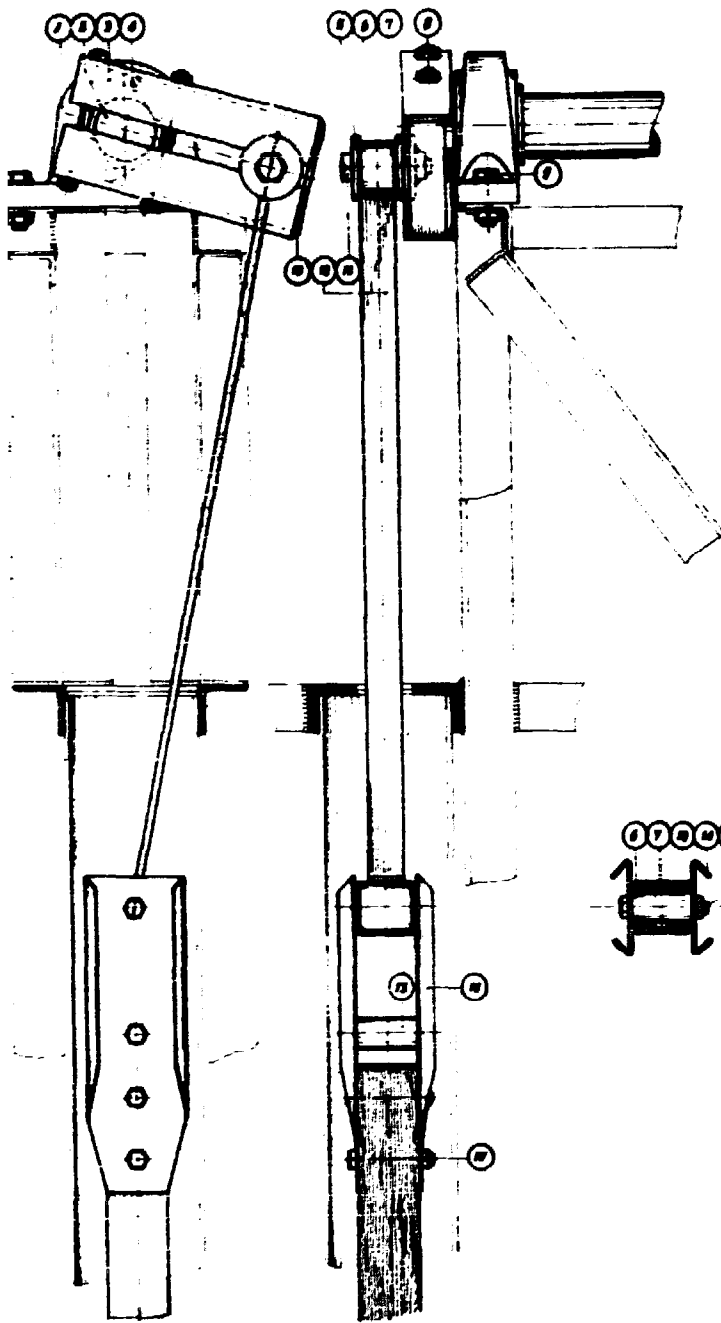
Basic designs

The expected rotor efficiency of the newly designed windmill amounts 0.38 theoretically if the windmill is loaded at a tip-speed ratio ($\lambda = \frac{\Omega R}{V}$: tip-speed divided by the wind-velocity) of two. Via a simple crank-connecting rod-crosshead mechanism the rotation of the millshaft is converted into an up- and down-movement of the pumprod which drives the single-acting reciprocating piston-pump.

The tail of the headconstruction carries a windvane which turns the headconstruction around the towerpipe in order to keep the windwheel perpendicular to the wind.

In case of severe storm a simple security-mechanism will dislock automatically the headconstruction from the tailstructure after



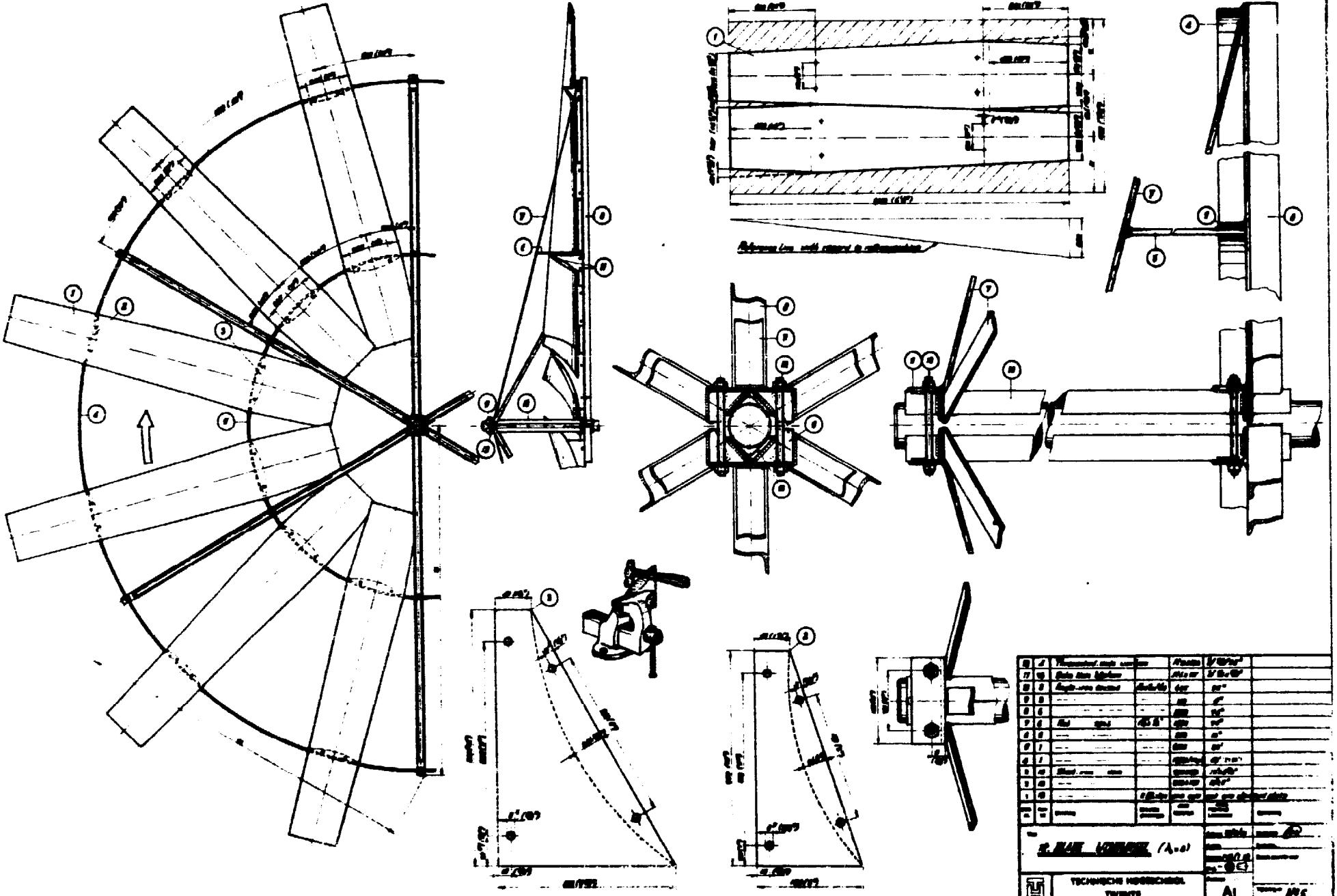


№	Наименование	Материал	Диаметр	Длина	Значение	Примечание
01	Корпус	Сталь	40x40	100		
02	Шток с шайбой	Алюм.	10x100			
03	Шайба - шток	Сталь	10x10			
04	Шайба	Сталь	10x10			
05	Самонамотка	Вол.	10x100			
06	Шайба	Сталь	10x10			
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СНПД, ИРТАНСКИЙ, Л. П. П. П. П.

ТЕХНИЧЕСКОЕ ЧЕРТЕЖИ

А1



№	Наименование детали	Материал	Условное обозначение
1	Корпус	Сталь	120х120х120
2	Плита	Алюминий	100х100х10
3	Втулка	Сталь	10х10х10
4	Шпилька	Сталь	М6х10
5	Гайка	Сталь	М6
6	Шайба	Сталь	М6
7	Пружина	Сталь	10х10х10
8	Штифт	Сталь	10х10х10
9	Штифт	Сталь	10х10х10
10	Штифт	Сталь	10х10х10
11	Штифт	Сталь	10х10х10
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18	Штифт	Сталь	10х10х10
19	Штифт	Сталь	10х10х10
20	Штифт	Сталь	10х10х10

С. МАК. КОМАНДА (А.а.)

ТЕХНИЧЕСКОЕ ЧЕРТЕЖИ
 ТИПОВЫЕ
 А1

which the head (and so the windwheel) turns 90^0 degrees out of the wind. In drawing No 1 the windmill has been drawn in that secured position.

The rotor-, head- and towerconstruction have been composed of parts of angle-iron of 1.5" (except the four towerlegs: 2") and flat-iron, 1.25" which are jointed by means of electric weldings. The application of bolt and nut connections is limited just to the mounting of sheet-iron parts and some connections like hinges, pumprod-connection etc.

The millshaft (50 mm.) rotates in dustproof self-adjusting bearings which are considerably oversized according to the S.K.F.-specifications. The crankpin- and crosspin-bearings are preferably furnished with nylon bearing-bushes, but bronze bearings can also serve the purpose if lubrication is applied from time to time. Also the crosshead which is composed of two specially shaped sheets needs the lubrication (see next chapters).

Characteristic of the headconstruction is the surrounding of the towerpipe by its framework of angle-iron which acts as a bearing. In radial sense some tolerance is permitted, and is even necessary due to the unroundness of the towerpipe.

Positive experience has been achieved already by applying this remarkable joint of the head and tower-construction in a wooden sail-wing windmill which has been designed and constructed in May 1976. Axial forces can be carried-over directly to the top-edge of the towerpipe, so the radius of coulomb's friction acts very near to the centre.

The total structure has been designed for maximum windspeeds of at least 20 m/sec and even the blade tips (free length of appr. 60 cm.) can in theory stand the forces which should act on it if the windwheel runs free of load under static conditions at a windspeed of 65 m/sec.

It is expected that the rotor is not the constraint factor of strength of the total structure. However dynamic forces (e.g. due to rotor unbalance) probably cause vibration in the natural frequency of several parts which may even lead to fatigue cracks! For example the natural frequency of the headconstruction situated around the towerpipe comes to 4.35 rad/sec (theoretically) which means that during operation of the windmill at a R.P.M.

number of approx. 45, resonance may occur. Also the slender parts like the long angle-irons of the tower- and tail-construction are free to vibrate within a scale of R.P.M.-numbers of the windmill if unbalances exist in the rotor construction. The single-acting piston pump applied in combination with the first prototype windmill consisted of a 6" p.v.c. pipe in which a wooden footvalve and piston with leather washers and sealing were acting. This kind of pump, which also was applied in combination with the former mentioned wooden sailing windmill, seemed to be very reliable as far as resistance against wearing and tearing of the sealings and washers were concerned.

1.2. The first experiments in the Netherlands.

Due to shortage of time the prototype windmill was not yet kept up to date according to the new designs, so the first experiments have been undertaken with a rotordesign which was not representative of the prototype which would be introduced in India. Moreover the elevation head in India was expected to be considerably more than the 4.0 meter head which appears in the Netherlands. In spite of that the first experience turned out already that a proper fixing of the pump in the well as well as jointing the wooden pumprods are rather difficult, especially if high R.P.M.-numbers occurred. The entire pump-construction jumped in its suspension and the pump-rod joints got loose caused by the reciprocating forces after some time during operation. The cross-head, constructed of two shaped sheets, started wearing out and making noise. Neither did the connection of the crank to the mill shaft turn out to be reliable. Although the security mechanism functioned rather well, its critical adjustment did not remain and demanded re-tightening of the adjusting bolt from time to time.

Especially its required and accurate hinges cause that this sensitive mechanism may never be successful, so other possibilities had to be considered and developed in order to obtain a simple and reliable security device.

A rather remarkable aspect has been discovered in those days. Depending on the R.P.M. number the amount of water, delivered

per stroke of the piston pump exceeded the stroke-volume in a percentage of more than 30 %. Later on this effect was recognised as an inertia-effect: the kinetic energy of the accelerated water column is converted into an extra delivery. Even after introduction of a small but permitted leakage in the piston sealing, which is done in order to decrease the starting torque of the piston pump, this inertia effect still persisted. Also some experiments with sealingless pistons has been carried out but unfortunately the required time for a proper investigation failed and the TOOL- windmill experts travelled to India at the end of November 1977.

2.1. The first experiences with the 5 m. dia. windmills.

As mentioned above the experiences with the first prototype windmill in the Netherlands were rather poor and still a new and unknown security-mechanism and a complete new and untested rotor was to be applied. In spite of that the realization of the first windmill at the Technical School in Ghazipur progressed smoothly. Also a quick prefabrication of the next two prototypes in the R.T.I. workshop, later on, has been achieved by using welding- drilling- and shaping-moulds. Small changes in the original designs were caused by slight differences in quality and size of the materials which are available locally.

Transport of the entire windmills to the site proved to be rather uncomplicated. A truck or tractor with lorry can easily contain all the separate parts (tower, head, windwheel) of a complete windmill. Local people are always prepared to carry the unloaded parts, lying on the roadside, to the site where the windmill is going to be erected.

In general the windmill is built above an existing well, from which water was drawn previously for irrigation purposes by using bullocks as an energy-source. Since the maximum pumping capacity of the windmill amounts to appr. $30 \text{ m}^3/\text{h}$ the water-supply to these wells is often insufficient.

In order to increase this capacity a tubewell has to be applied at the bottom of the well. The length of these tubewells varies between 12 to 15 meters depending on the depth of the aquifers.

The erection of the tower is achieved simply by pulling and pushing it upwards by means of offered manpower of the local people. After the tower has been positioned (exactly in the centre above the tubewell) the towerlegs are poured in with concrete in the 40 cm deep holes which have been made in advance.

After a five-days period the concrete is sufficiently hardened out to stand the extra load acting on it during lifting and positioning of the headconstruction and windwheel. Next page

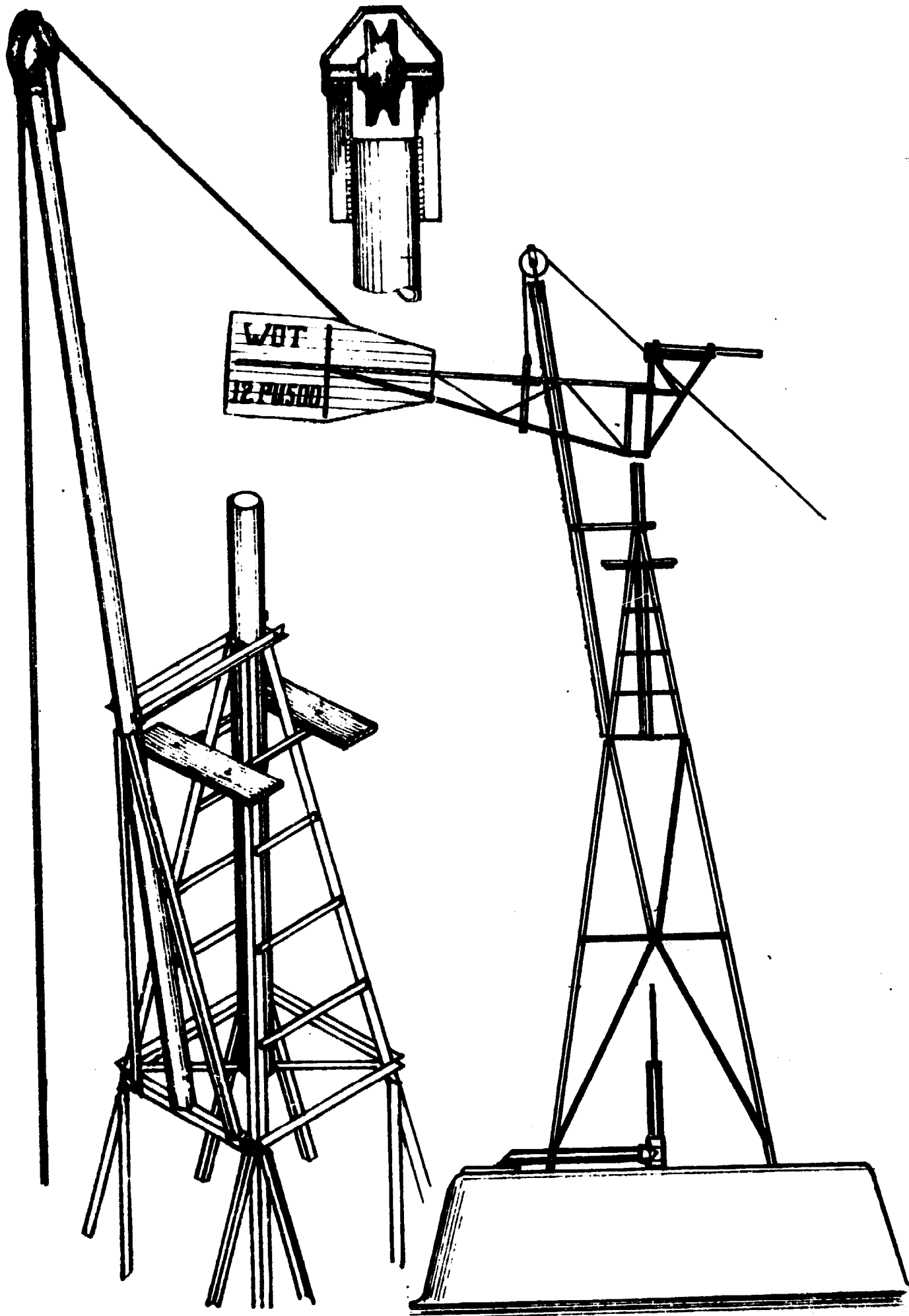
2. Technical developments of the windmills

In the beginning of December 1977 the windmill-project started in Ghazipur. Although a workshop was not at the disposal of the counterpart organization: The Organization of the Rural Poor (O.R.P.), the facilities seemed to be sufficient in Ghazipur-village.

Several blacksmiths and institutes proved to be interested in the windmill-technology (there was no windmill-history in the rather remote Ghazipur-area) and it was decided to construct the first windmill in cooperation with the teachers and students of the local Technical School.

On Friday the 20th of December, the first windmill (KK I) was erected near the Kusumih Kalan village beside the national-highway Ghazipur-Benares and it was baptised by local villagers and authorities. During the month of January two other windmills have been prefabricated in the workshop of the Rural Trainings Institute (R.T.I.) where agricultural implements like plows and threshers are manufactured by trainees and staff members.

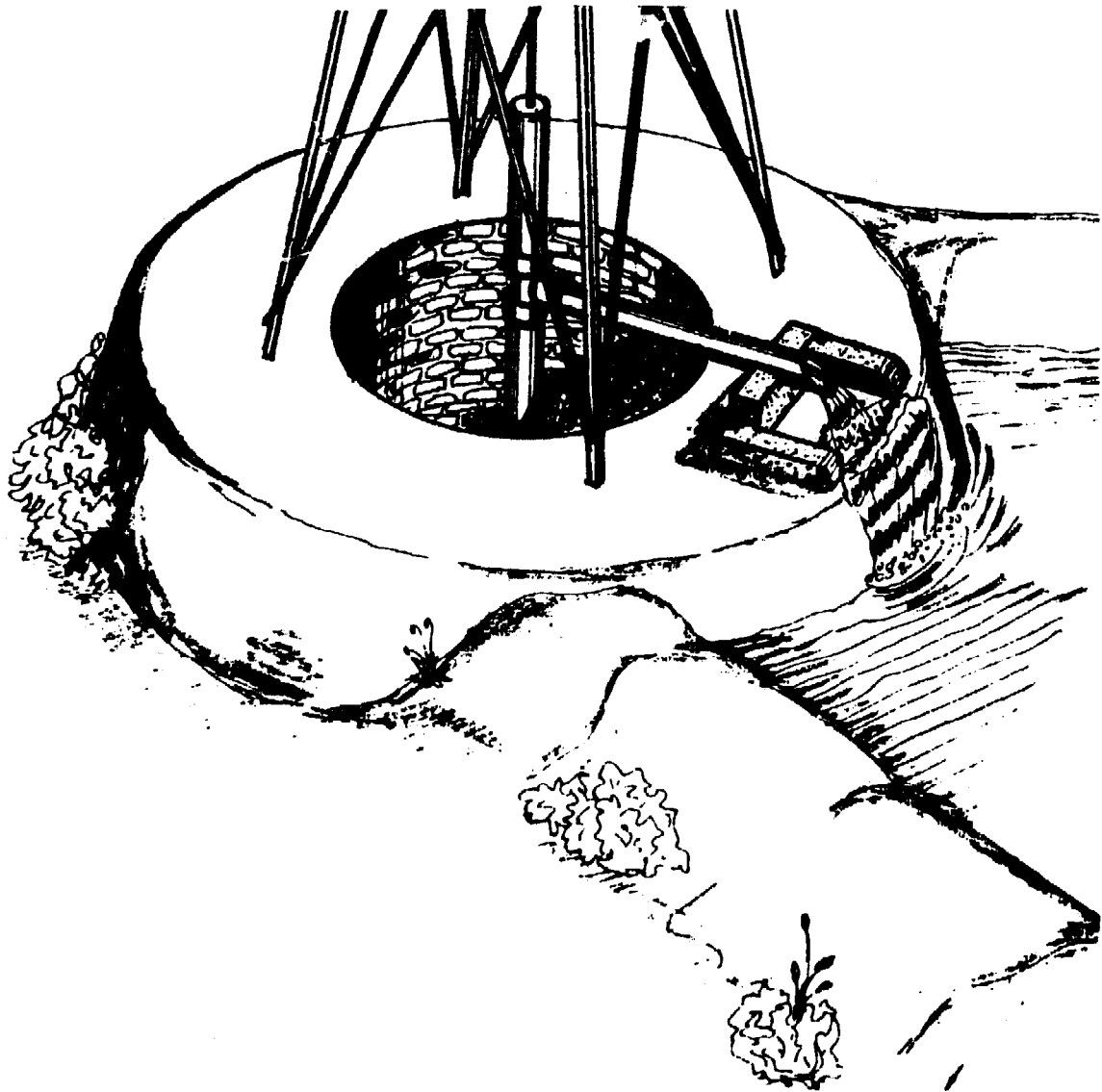
In the course of 1979 a newly built workshop, situated at the ORP-campus, came at the disposal of the windmill project. A complete set up of windmill production, maintenance and training facilities has taken place in this workshop. At the same time all research- and development activities were taken up at the Allahabad Polytechnic Allahabad (APA) where already a modest windmill production was sparking off as well. During the period of November 1979 up to March 1981 an intensive program of pumpdesign, pumptesting, redesigning of windmillparts and training was carried out over there.



shows how these can be carried out quickly and safely by means of a simple lifting device.

The needed storage tank is constructed from mud-made walls of about 1 metre high, which are partly bricklined and plastered in places where erosion or seepage is expected. The content of a storage-tank amounts 50 up to 150 m³, depending on the expected need and the available area which can suitably be occupied by the tank. An overflow pipe is masoned into the wall in order to prevent that overflowing water will damage the mudwalls (if the tank is full).

Since the local people often utilize the fresh water (delivered by the windmill) for domestic purposes, like drinking, bathing and doing the wash, the mudwalls in the environment of the delivery pipe definitely will be damaged. Therefore a simple washing accommodation is provided by means of some masonry.



The water can be released from the tank by the farmer(s), using a 2.5" hose, which acts as a siphon. Since this device is easy to handle the water can be tapped at any place from the tank and can be led to the plot(s), via one of the several irrigation canals. The farmers have to be well-informed in handling the windmills. During storms the windmills stop automatically, so afterwards the farmers have to climb on their windmills in order to reset the windmill into the wind. At the same time it is an opportunity to inspect and lubricate the moving parts.

However, soon after the introduction of the first windmills several breakdowns and long windless periods proved to be a draw back for this particular technology. In spite of this the farmers involved remained rather enthusiastic and local agencies and Institutions developed interest as well.

2.2 The prototypes under development.

During field-tests some parts of the windmill components needed redesigning in order to achieve a higher reliability on the one hand and a costprice reduction on the other.

Although this seems to be more or less contradictory it is proved that both demands mentioned can partly be conceded by surging for the most simple solutions and alternatives which can be realized with the local means and materials. Therefore it is a must to know the local market and the means of production to which the designs have to be adapted.

In practise still unknown factors like the extent of wear, corrosion, vibration etcetera will remain and just a thorough fieldtesting will provide the answers in the long run and broaden the experience. This disadvantage of such research is that failures can cause the distrust of the local people in the windmill technology. To avoid this it was decided to carry out the research and development as much as possible under "laboratory" conditions. For this

reason a testing machine has been designed and built (see chapter 3) in order to speeden up the developement of the windmill.

These experiments as well as the field experiences led to the stepwise evolution of several windmill components which is described in the following paragraphs.

2.2.1. The towerconstruction.

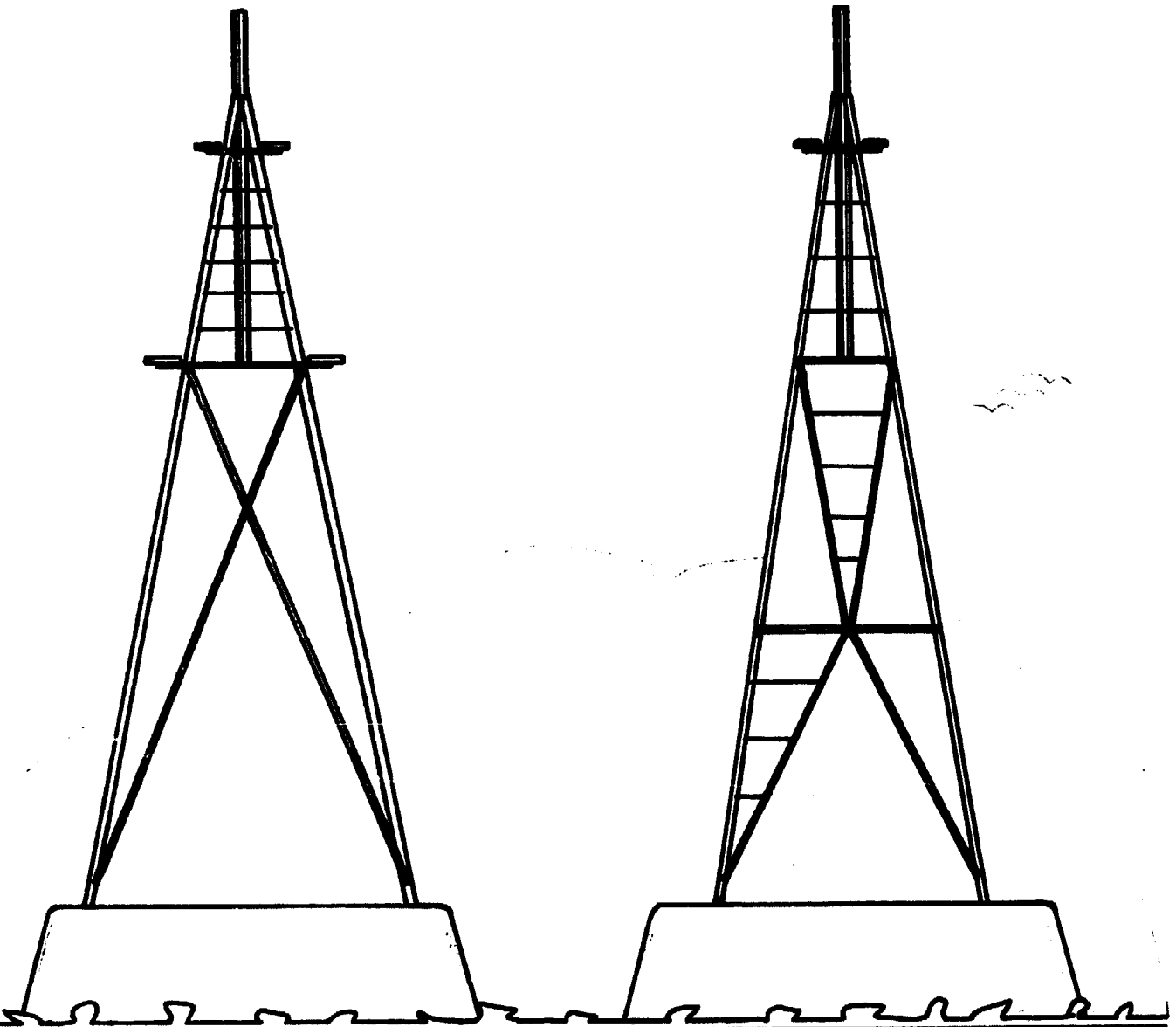
The fabrication of the tower is very simple. The two pre-fabricated halves are composed: the towerpipe is pushed in, positioned and welded. In three hours the tower is completed with the help of three persons.(including the cutting and straightening of the materials).

The first and second platform are rather safe and comfortable to stand on but actually the first platform is superfluous: lubrication and repairs will always be carried out standing on the top platform.

Climbing on the tower is not done by means of a ladder: by coincidence the diagonals of the lower tower section just provide an adult the needed facilities to reach the first platform. For esthetic reasons the base-measurement of the tower has been reduced from 2.50 to 2.00 meters and still its foundation can surround the opening of the well which is seldom more than 1.8 meters in diameter.

Previously the total material costs of the tower amounted to \pm 1/3 of the total material costs of the windmill, so a reduction in tower weight has been undertaken. Applying 1.5" instead of 2" angle-iron for the four towerlegs decreases the weight considerably but the legs became too slender which means that extra compartments in the structure must be applied in order to achieve sufficient strenght in the entire construction. Also some minor modifications, like guiding the towerpipe by flats instead of angles and cancelling the first platform decreased the weight and costs. It was also proposed to reduce the length of the towerpipe, but extra angles and flats will be necessary to fix it properly and to provide sufficient rigidity to the tower-top structure.

However the original simplicity of the construction will turn over in an extra complicated one appearing during fabrication and defenitely resulting in loss of time due to mistakes. Due to these above mentioned modifications the towerweight has been reduced from appr. 225 to 125 kg. Also another advantage is that the tower is easier to handle during transport and installation while the strength is almost the same. Climbing the tower is facilitated by applying some welded flats in the lattice.



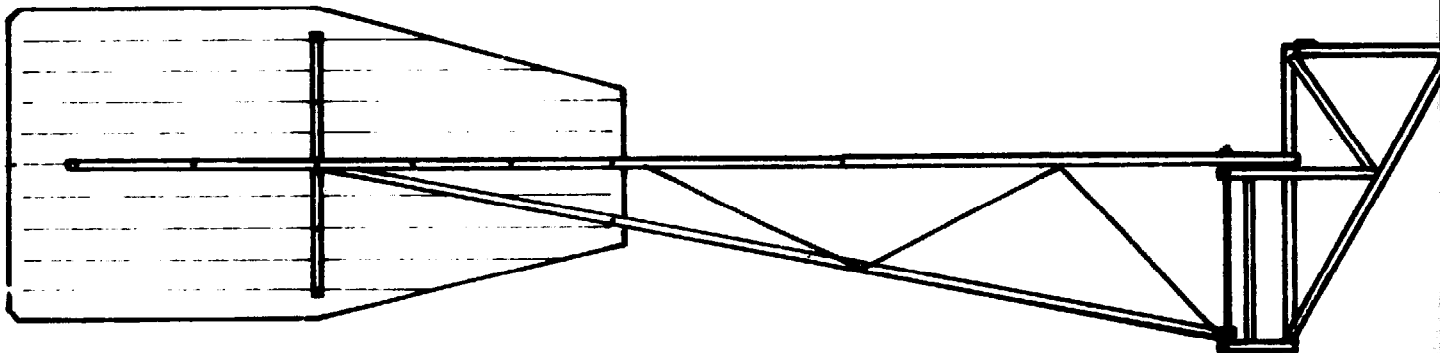
OLD TOWERDESIGN

NEW TOWERDESIGN

2.2.2. The headconstruction.

Some minor parts in the framework of the headconstruction have been changed. The most important and valuable change was reduction of the total length of the tail. This has been done in order to obtain a better balanced structure; the length amounts to $0.8 D$ and a better steering resulted. Since the bearinghouses, which are available in India, are rather wide some extra space had to be created for the support of the rear-bearing. The flange of this support (angle-iron $2" \times 2"$) is pointing to the front of the headconstruction in order to achieve that.

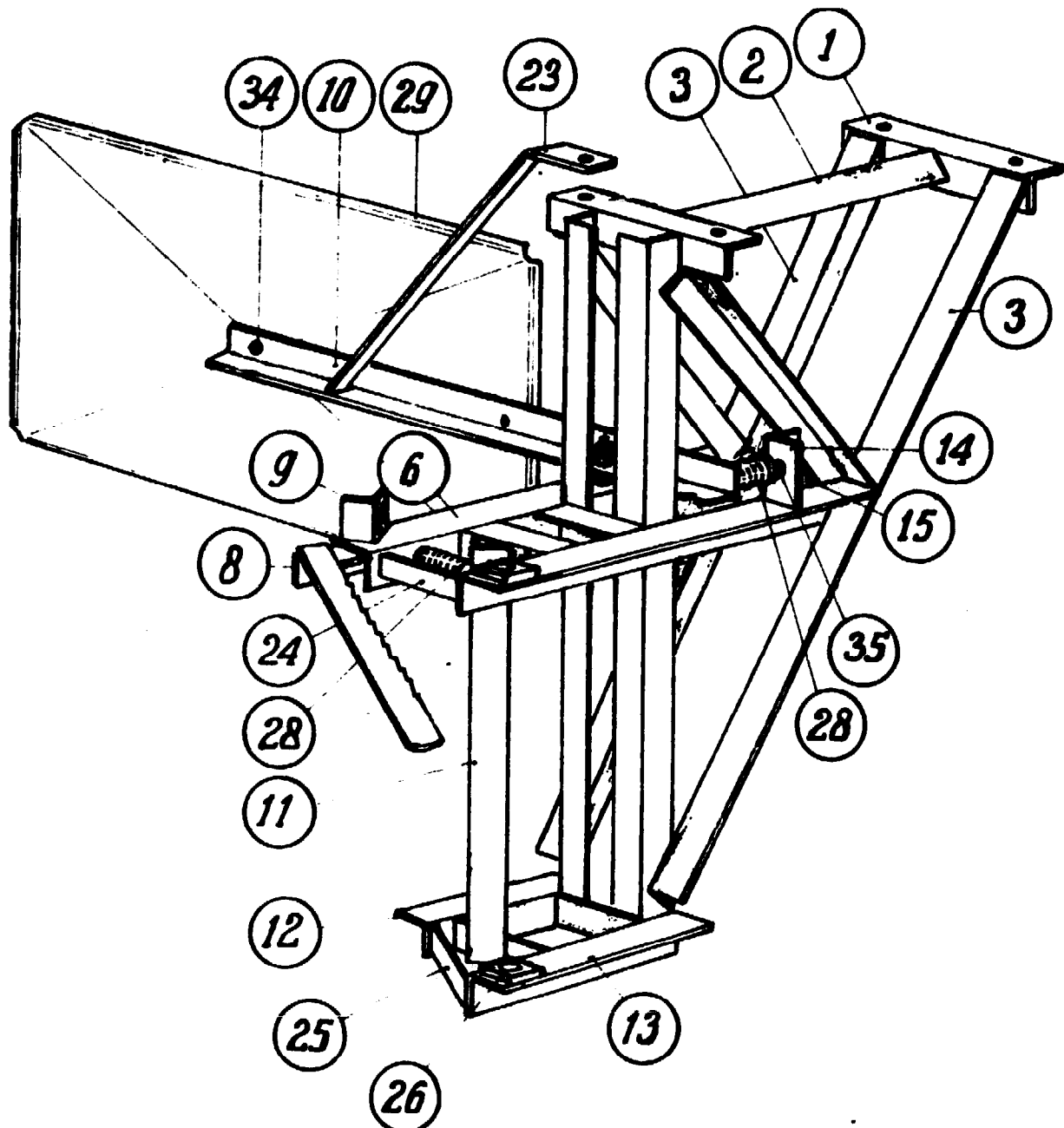
Worthmentioning is that using a simple fixture for welding the head saves time and moreover accurate work results.



The security mechanism

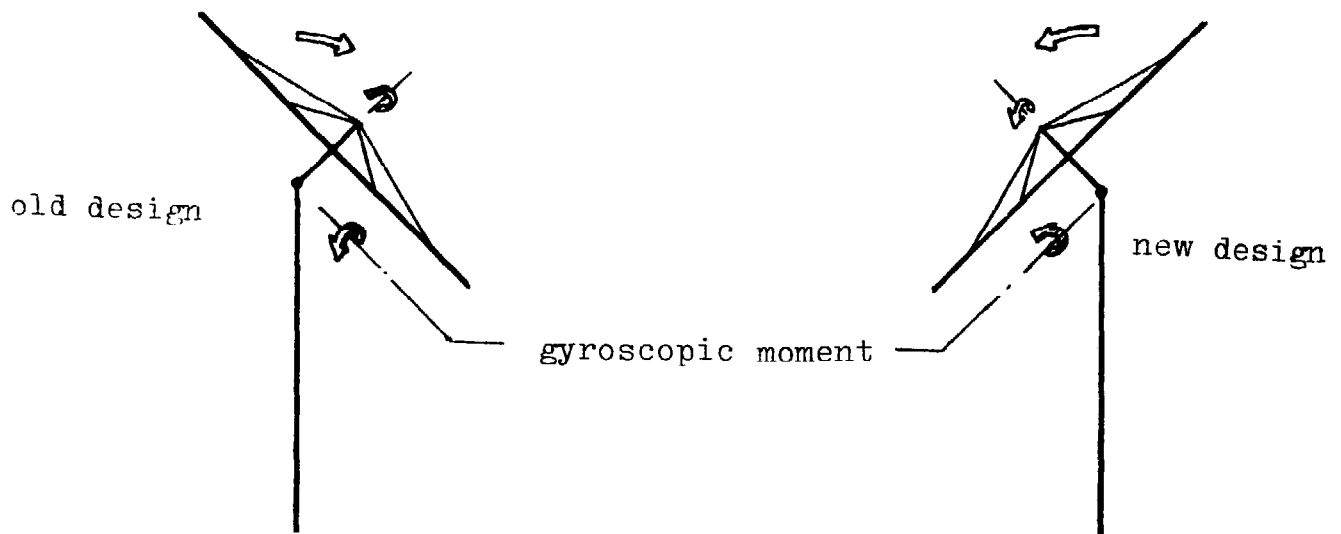
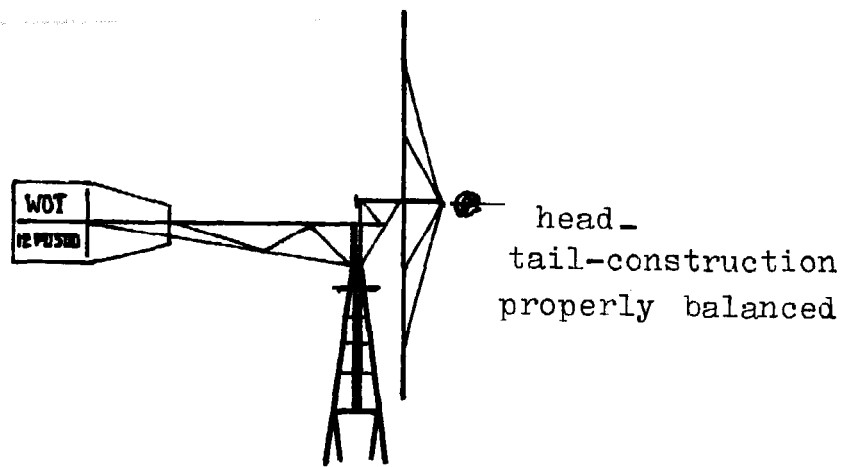
In the very first designs the required accurate hinges of the security-mechanism caused lots of problems concerning its adjustment which did not remain constant. Initially a new design has been introduced in all the Indian prototypes which proved to be very simple and reliable. A helpvane, situated behind the rotor and besides the headconstruction, is pushed backwards by the wind if the adjusted preload of a spring is exceeded. Due to that the achieved displacement unlocks the headconstruction from the tailstructure by opening a simple lockmechanism. The moment, caused by the windpressure acting on the helpvane, initiates a small rotation of the head (and so the windwheel) with regard to the tail and winddirection.

The windpressure acting on the windwheel provides a further rotation of the headconstruction until the windwheel is turned 90 degrees out of the wind and a lock-system finally fixates the head to the tail.



This lock has to be applied in order to prevent that during storms, accompanied by sudden changes of wind direction, the tail and head will move separately which can result in very high impacts in case of concussion of both parts. During this securing motion a toothed handle prevents such separate movements and it will not allow the headconstruction to turn back with regard to the tailconstruction.

Since there is almost no damping in the entire security system the kinetic energy, stored by the wind into the rotating

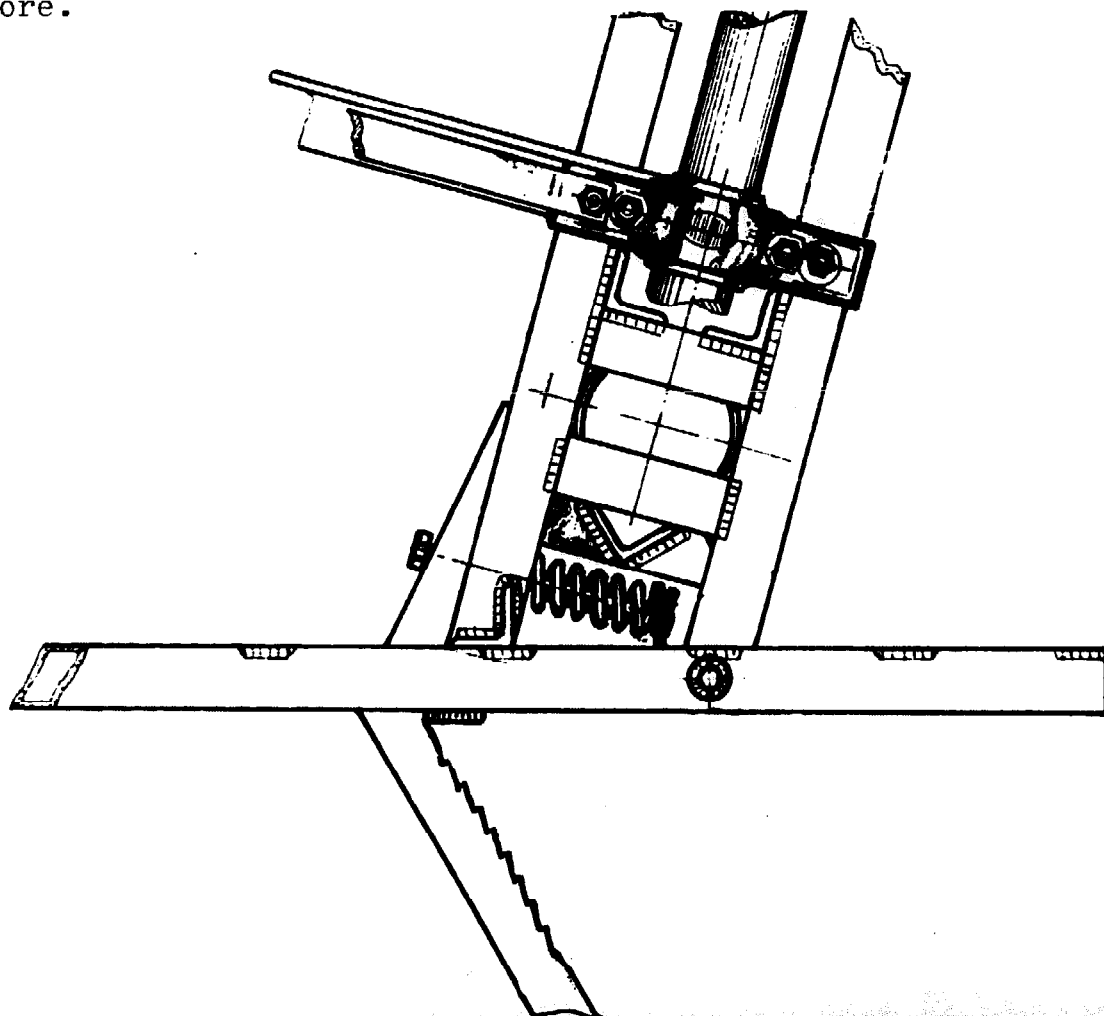


headconstruction, has to be dissipated. The impact taken by the final lock, proved to be considerable at the end of such movement of securing. Although there is the Coulomb's friction, its dissipation capacity is too less and moreover its friction is eliminated more or less by the gyrosopic moment which appears during this security movement. So even this damping can be neglected. In order to use this gyrosopic effect an extra generated Coulomb's friction could be added in positive sense by changing e.g. the direction of rotation of the windwheel. Since the windwheel runs clockwise in connection with the bolted crank pin, it is preferable to maintain this, but inverting the direction of turning of the headconstruction with regard to the tail will also lead to the same achievement.

Nowadays the headconstruction turns anti-clockwise out of the wind (topview!), in order to obtain the extra needed friction for damping caused by the gyrosopic moment. The impact is reduced considerably and hardly audible.

Although the windwheel is kept out of the wind by the steering-function of the tail, it will still be hit by the gusts during storms. This is caused by the inertia of the total secured structure: during stormy weathers it was observed that the rotor changes its direction of rotation continuously : clockwise-anticlockwise, etc, which means that it is also attacked by these gusts from the back. This resulted several times in a forward bending of the blade-tips because its rigidity is low in forward direction.

In order to prevent such damage it was proposed to increase the rigidity by hammering a profile in the blades in the environment of the outside-ring blade-support. However, in this way the airfoil will be spoiled and so the efficiency will decrease. Another possibility is keeping the windwheel slightly into the wind in such a way that it will just not be attacked from the back. This is achieved if the windwheel is turned out of the wind less than 90 degrees: the rotor maintains clockwise running too. Nowadays the final lock of the security mechanism is situated in such way that the windwheel turns appr. 75 degrees out of the wind and forward bendings of the blade tips do not occur any more.



Though this automatic security device never failed the required reset procedure proved not to be practical in places where wind speeds fluctuate too much. Therefore efforts have been undertaken to develop systems in order to tackle this reset problem.

For instance a rope connected with the reset lever and led via the tail end to ground level facilitates a reset possibility which excludes the need of climbing the tower. However this system still demands the presence of an operator so it is not a great improvement.

As a matter of fact several fully automatic security devices are common in commercial windmills which principle is based on the momentum equilibrium of head and inclined hinged tail. However such mechanism demands a frictionless rotation of the head over the tower top which does not apply for the simple windmill design described here.

Therefore it was tried to derive a fully automatic security device from the existing mechanism which finally led to the following designs:

- a. ratchet system
- b. stepless system

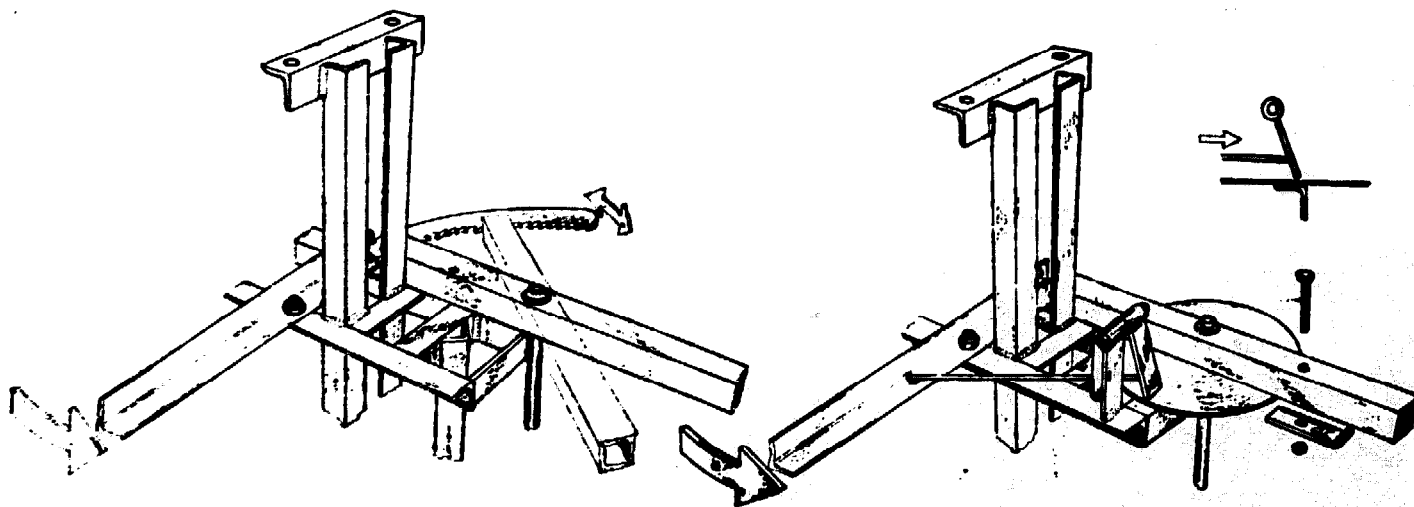
Both new systems have in common that the helpvane releases the fixation between head and tail in order to allow the head to turn backwards out of the wind. This process continues till the helpvane does not detect any exceeding wind pressure anymore with the result that fixation between head and tail is restored in that particular position. This fixation is achieved by means of a ratchet- and a stepless friction mechanism respectively in these systems.

Minor changes in wind direction cause minor oscillations of the tailvane which are most essential in order to return the head and rotor more or less facing the wind again if the storm decreases. This return motion is possible due to the "one way" character of the ratchet and stepless friction me-

chanism as long as the helpvane does not detect any overpressure in its newly found position.

So both the systems allow the head and rotor to turn out of the wind to a certain extent depending on the actual windforces. The oscillating tail vane will see for the automatic reset. However for the simple ratchet system a minimum oscillation of the tail vane is required during the automatic reset procedure in order to reach for the next tooth of the ratchet. In case of rapidly fluctuating wind directions impacts on the teeth will occur which may lead to wear of the ratchet and its counterpart in the long run. Also an impact occurs at the end of the securing motion if suddenly the helpvane puts the ratchet in action again. Observations made during field tests just partly confirmed these disadvantages and presently the ratchet devices are still observed.

The "stepless" system, as the word suggests, responds to very minor oscillations in a less hesitating manner than the "ratchet" does. The pivoted catch induces sufficient high friction between the disk (jointed to tailbeam) and contact surface (jointed to head) resulting in a tight grip. In this system also the sudden impact exists at the end of the security motion. This disadvantage has been eliminated by allowing slip in between the disk and tail beam in order to dissipate severe shocks.



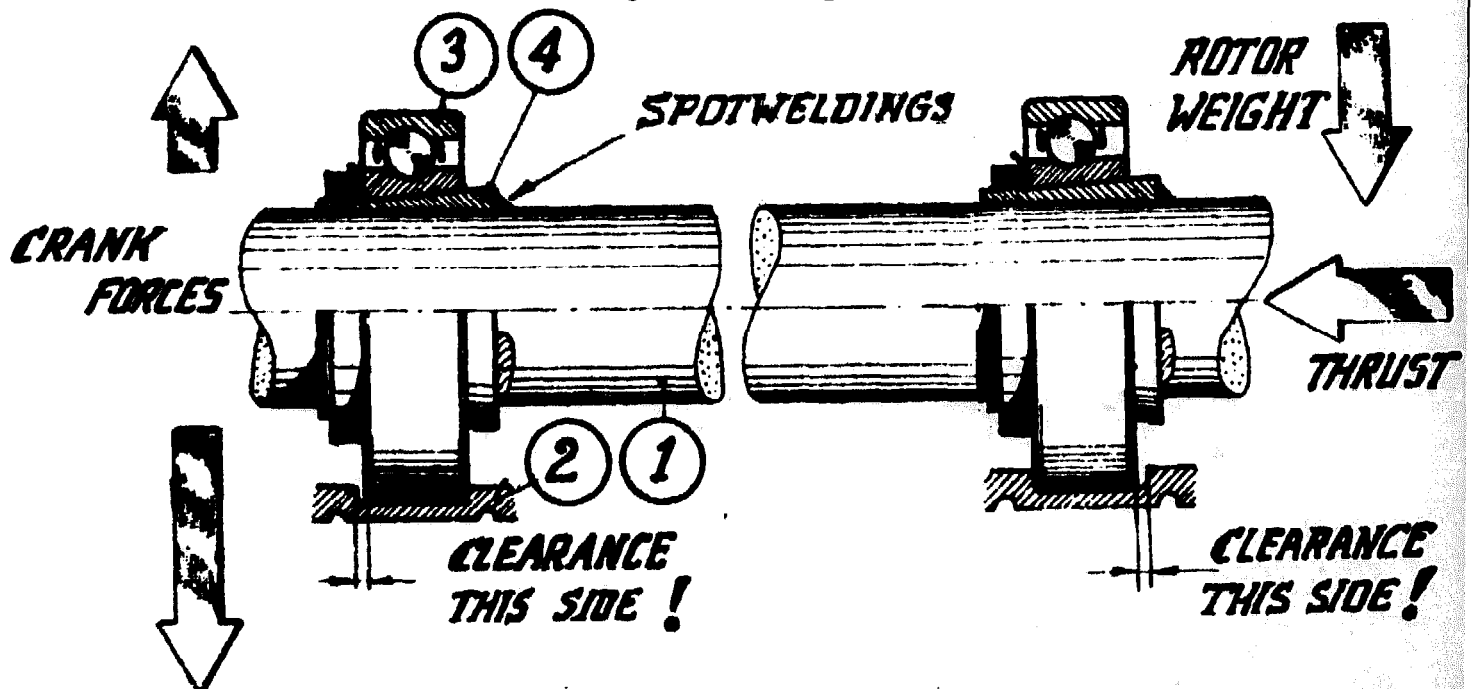
2.2.3 The moving parts: Crank-mechanism, bearings, etc.

Although the principle of converting the millshaft rotation into the up-and down-movement of the pumprod was still maintained, the bearings as well as the simple crank-mechanism have been changed a lot. Many thousands of revolutions of the windmill were necessary to indicate and to eliminate the weak components which finally resulted in a complete redesigning of these essential parts which are still simple in manufacturing and assembling.

The mainshaft bearings

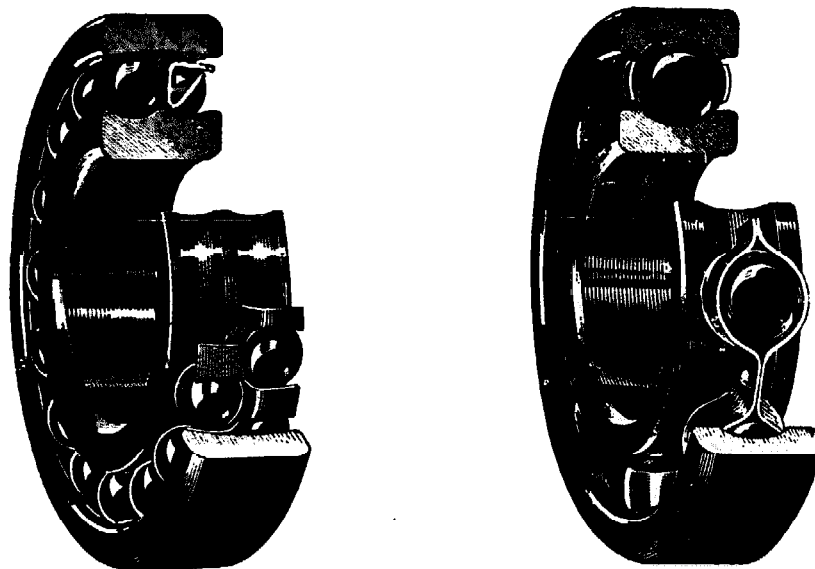
Two kinds of loads actuate on the two main-bearings. The front bearing carries a radial load of appr. 1000 N (rotor-weight) and a thrust-load upto 7000 N, while the rear-bearing takes the alternating forces carried out on the crank-mechanism. If these bearings are nicely adjusted the above mentioned assumption will be actual but unfortunately there are constraints in practice.

Due to considerable unroundness of the shaft and poor quality of the bearing-bushes (sleeve-type) a proper fixing of the bearings to the shaft often led to complications. After some time the bearing-bushes got loose and the shaft started rolling and sliding in them. This rolling effect will increase while the shaft slides backwards by the windpressure acting on the rotor



and the sharp edges of the angle iron hub start scraping at the front of the bearinghouse. Of course, few thousands of revolutions are sufficient to destroy the bearing-house completely and the ball-bearing (due to the scraping-dust). This problem is solved by locking the bearing-bush to the shaft by a short spotweld so that the shaft cannot roll and slide. Proper position of the bearings to the shaft with regard to the axial clearance of the bearings between the inside edges of the bearing-housings will assure which bearing is going to carry which load.

Besides, there were the problems with the bearings themselves. Since the bearinghousings are bolted to a welded framework self-aligning bearings (double-roller type) have to be applied.



double-roller selfadjusting

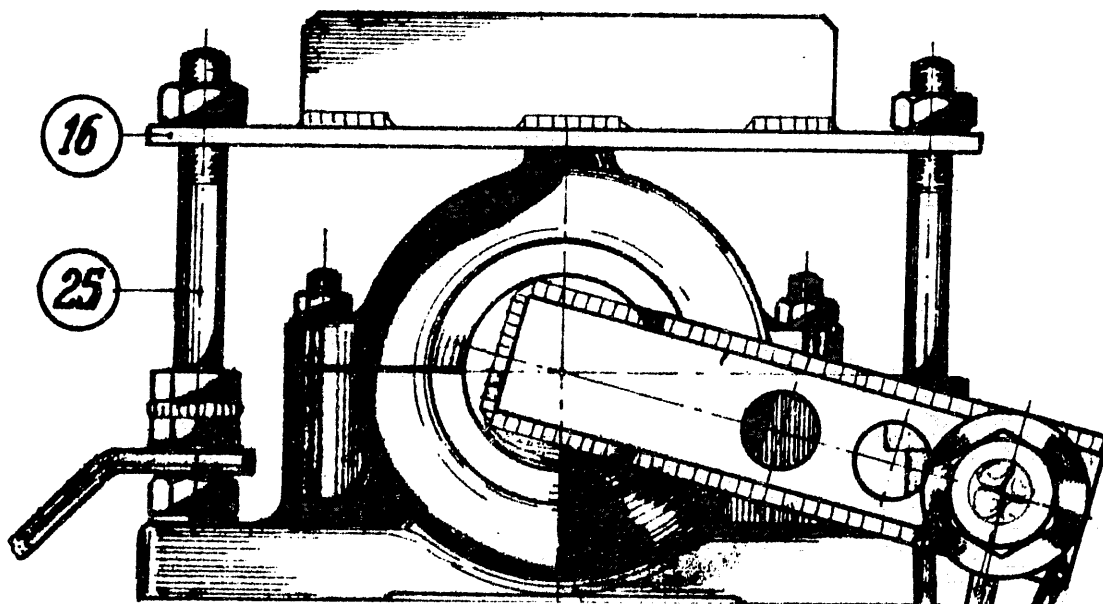
single-roller

Although these bearings are rather oversized, according to the S.K.F.-specifications, the lifetime proved to be too short (appr. $1 \div 5$ millions of revolutions). This means that these specifications are not representative of the bearings available in the local markets. Many bearings of several trademarks are offered but specifications are unknown and the quality is not guaranteed. Often these bearings are "repaired" old ones: the rollersurfaces have been lightly ground and oversize balls are applied. The result is surprising; only insiders can detect the minor differences from the new ones. Since these bearings are not able to stand the loads and S.K.F. is not easily

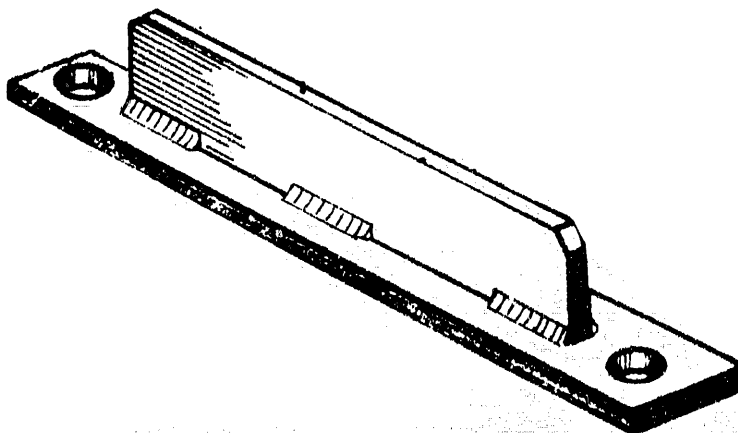
available one has to go for the best qualified trade mark like N.B.C. The latter really offers good quality bearings and sleeved bushes. Unfortunately the costs are considerable.

The same counts for the "one piece" bearing blocks (imported) which are of excellent quality but also quite costly.

Another possibility is to apply single roller bearings which can be loaded more than the double roller type due to the bigger contact surface. But a proper alignment of the housings is absolutely necessary and moreover the rotorshaft should be exactly straight

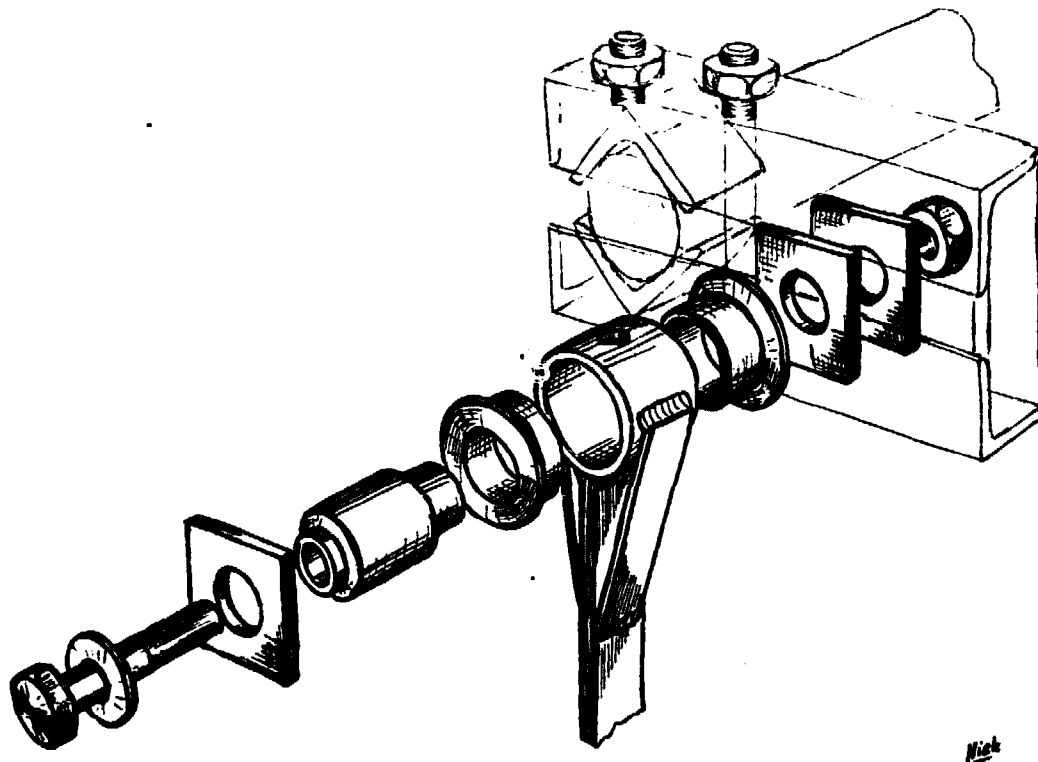


Since the rear bearing is loaded by alternating forces a crack of the weak bearing-housing-top might occur. This leads to a disastrous damage of the rotor, because it will tumble forward and hit the tower. To avoid this a simple supporting bracket is applied which supports the housing-tops in carrying upward forces.



The crank

In the previous designs an "open" crank has been preferred to a "closed" one. The advantage of the application of an open crank is that the radius of the crankpin can be adjusted easily. Moreover the assembly of the connectingrod is very simple because there is no need of a partable construction of its bearing-housing and bearing.

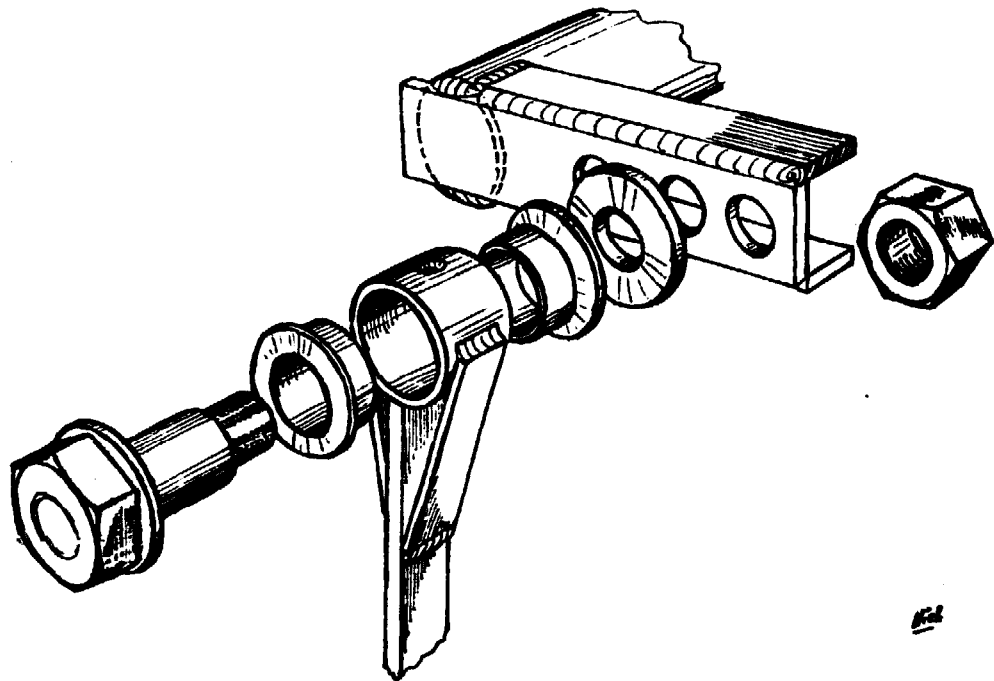


An adjustable crankradius always creates the opportunity to "match" the windmill to the pump, depending on the actual windspeed and the elevationhead. Therefore the first windmills have been provided with a slotted crank in which the crankpin can be positioned at any radius between 50 and 125 mm (2" and 5"). This slotted crank, composed of angle iron (1.5"), was clamped, just like the hubconstruction of the windwheel at the end of the mainshaft but this unkeyed connection proved not to be reliable. Slipping led to fretting and the end of the shaft as well as the crankhub were spoiled. Several efforts have been undertaken (central bolts, keys), but a 100% reliable clamping-device has never been achieved.

Welding of the crank to the shaft-end solved the problem as long as replacing of the mainbearings of the millshaft was not required. In general welding to a shaft is not advisable, because

straightening is difficult to maintain, but also the metal-structure will be affected or even spoiled due to the enormous heat. Since this welding takes place at the end of the shaft which un-straightning of it will occur in the rear section of the shaft which can be eliminated in the crank itself. Also the affected metal-structure is situated behind the rear bearing, so if a fatigue-crack will appear in this place the rotor remains and a further damage is avoided.

Although the slotted crank served its purpose very well, it needs a very tight fixing of the central crankpin-bolt in order to prevent that it gets loose and starts sliding in the slot. This was a result of experiments with 8" dia pumps (normal pump-dia 6"). Moreover in practice only two of the infinite adjusting facilities were used: maximum and minimum position! This led to the idea to introduce a new crank with three or even two crank radia only.



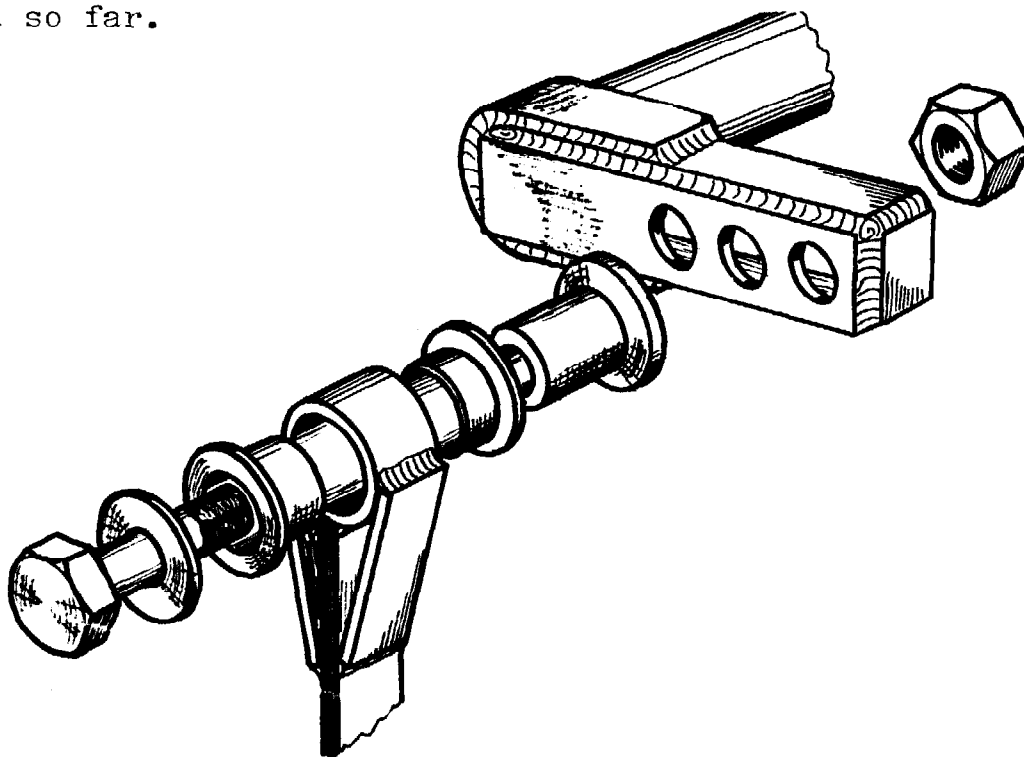
The crank is composed of several pieces of flat iron which are welded to the shaft end. Later on it proved to be necessary to create reinforcement by applying an extra flat situated near the shaft in order to obtain sufficient strength. The U-shaped crank provides a sliding fixation of

the crank pin nut which facilitates assembling. For aesthetic and safety reasons the sharply edged tip of the crank is closed by welding a small piece of flat to it.

A crank made of a solid steel block, directly screwed to the shaft, showed also satisfactory results especially regarding the revision to the rear bearing. However, generally, the less sophisticated construction of the composed crank, as described so far, is preferred.

The bearing surface of the bolt-type crank pin loading the crank plane proved to be too small for yield of the material occurred resulting in a loosening crank pin- One can imagine that this leads to disastrous damage of all the components concerned (including the connecting rod and its bearings).

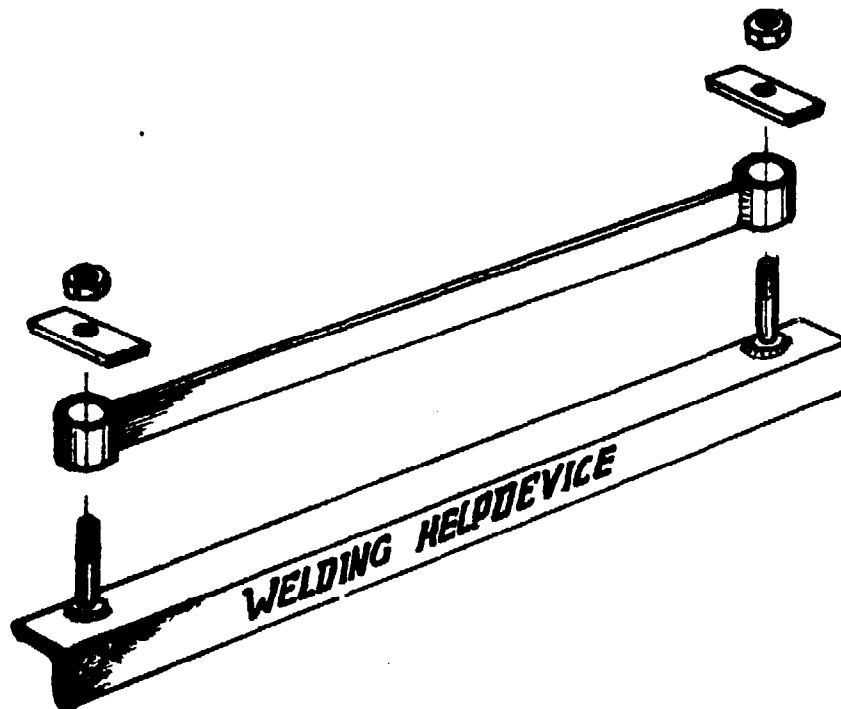
Improvement has been achieved by applying a collar bush combined with a central crank bolt which latter ensured a sufficient strong connection of the bush to the crank plane. No indication of yield or loose crank pins have been discovered so far.



The connecting rod

To the upper- and lower-end of the connecting rod (flat iron) cylindrical steel-bushes are welded which enclose the flanged nylon bearing-bushes. In the beginning these steel-bushes have

been made of 1.5" gas pipe sockets after the screwthreads have been removed by turning. The remaining thickness in combination with the poor metal properties lead to unroundness and even cracks of these bearing houses, in spite of the fact that reinforcement-flats have been applied. Therefore it was decided to apply stronger bushes machined of scrap which remains from the millshaft if it is sawed on the right length. Nowadays the thickness of the bushes amounts to ± 6 mm. During composing and welding the connecting rod, a simple device is applied in order to obtain a correct parallelism of both bushes. The unroundness of the bushes,



caused by the welding-procedure, does not affect a smooth function of the nylon bearings which fit nicely over the crankpin with $0.2 \div 0.3$ mm. clearance in radial sense. An axial clearance of appr. $1 \div 2$ mm. is usual. Up till now no nylon-bearingbushes wore out, and were replaced accordingly.

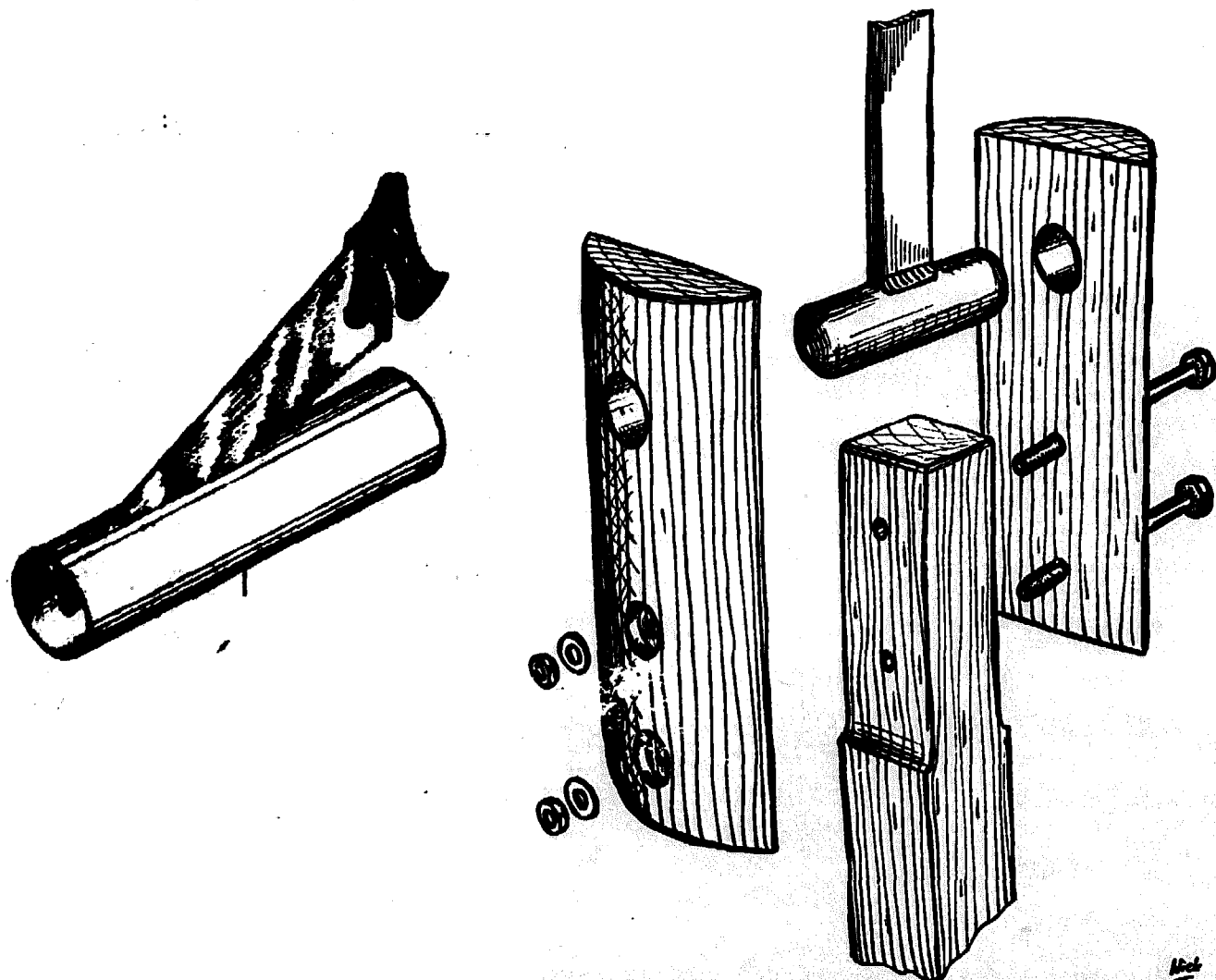
The crosshead

The crosshead is situated and guided in the towerpipe. As mentioned before a rather high rate of wear of the very first crosshead has been noted, so another one had to be designed. Since the towerpipe (gas pipe) always has a seam inside a proper guidance of the crosshead is impossible unless the entire seam is removed. This can only be done by grinding, but the

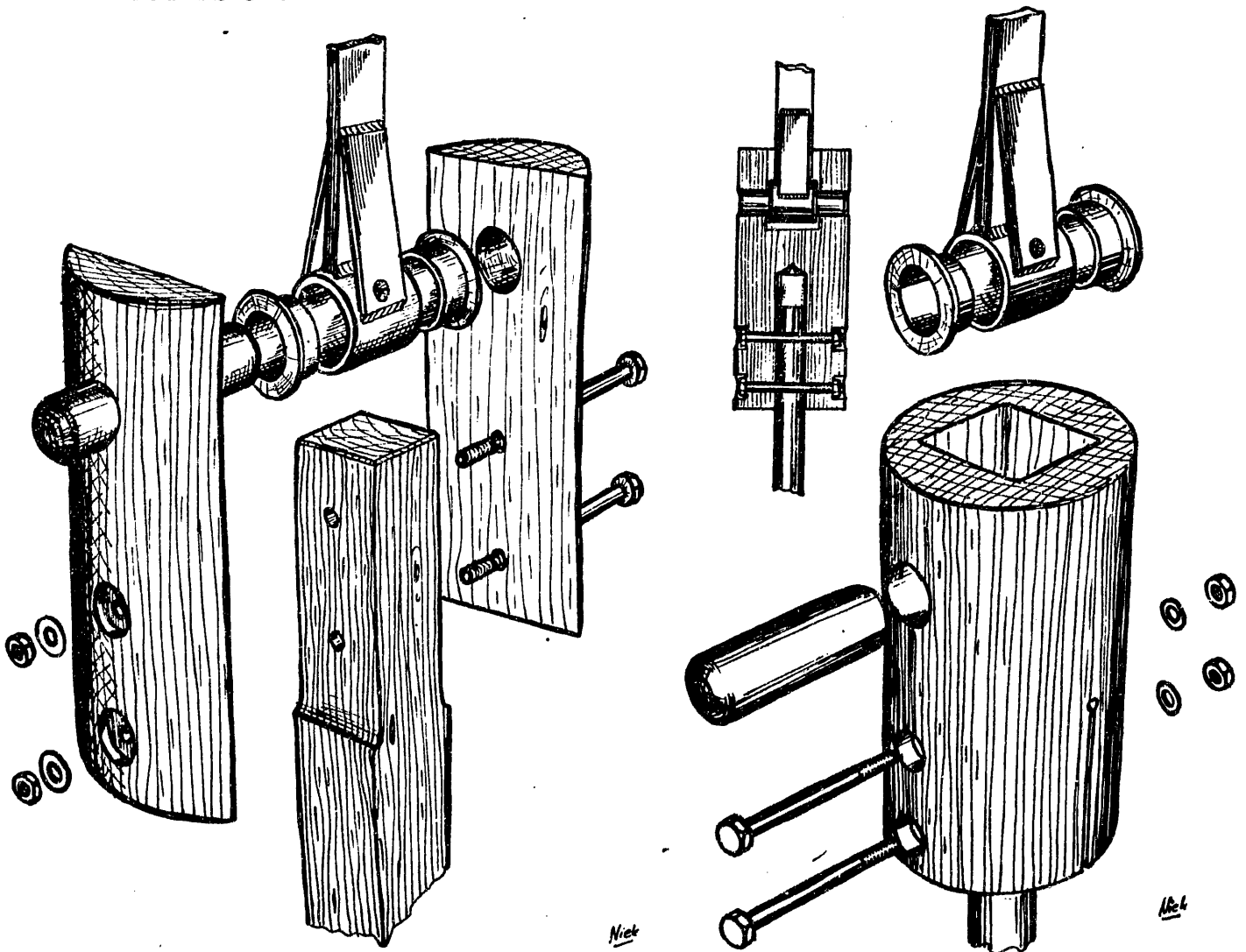
required grinding equipment is rather advanced, not always available and moreover the resulting surface remains rough.

Efforts undertaken in obtaining an inside surface of an acceptable roughness were not successful during constructing the first prototype (KK I) in India.

The idea was born to install a P.V.C. insert inside the towerpipe. This insert is made of a 4" P.V.C.-pipe of sufficient length from which a strip is cut in such a way that the circumference measure is a little less than the inside-one of the towerpipe. The opening just provides enough space for the seam which is completely counter-sunk then. At the bottom a small bolt, screwed through the towerpipe, locks the insert in axial sense. Since P.V.C. is rather soft the crosshead must have a sufficient wide contact surface in order to prevent high specific loads. Also sharp and hard edges must be avoided (scraping!). It was decided to compose the crosshead of hardwood because this material was expected to be a better counterpart for the P.V.C.lining than e.g. steel.



Previously the first pumprods also consisted of wood (ϕ 1.5"; see next chapter) and the first crosshead had been composed of two parts of sesam-wood which clamped the pumprod by tightening two $3/8$ " countersunk bolts. The first experiments seemed to be satisfactory but after some time the upper-portion of the two halves started wearing due to the gap of bearing-surface between both parts and the crosshead became more or less conical. Later on the steel pumprod has been introduced, which caused a complete redesigning of this crosshead. After some trouble-shooting the crosshead evolved in a simple cylindrical wooden part in which the steel pumprod is hammered and clamped by two $3/8$ " bolts at the bottom side. In the top a square hole is made by chiseling in which the lower-section of the connecting-rod is enclosed.

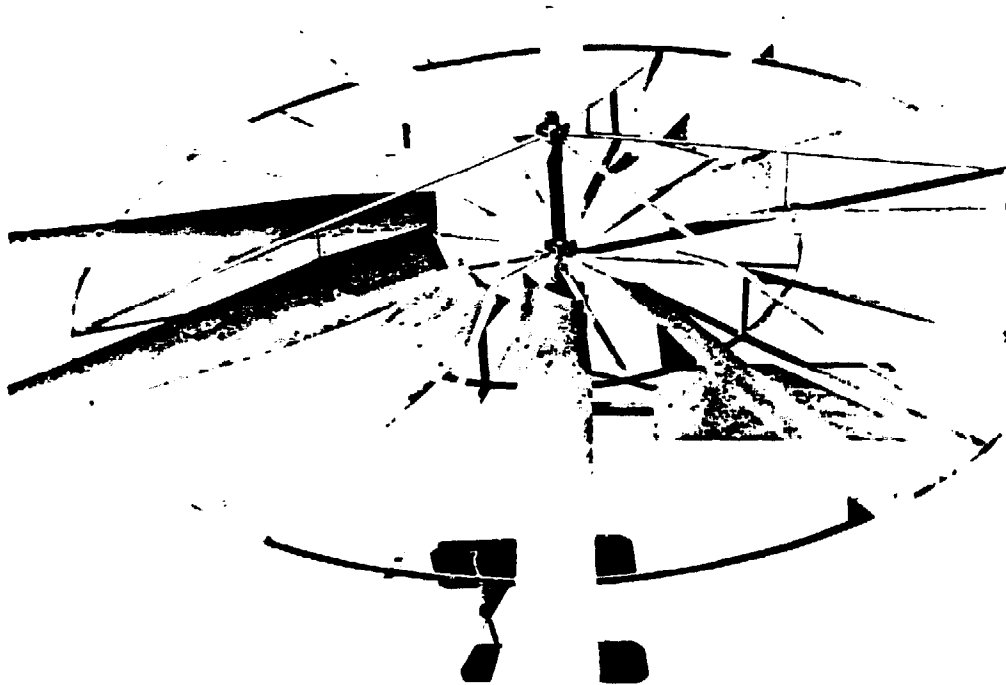


The measurement above the crosspin of the wooden crosshead amounts to appr. 2" in order to obtain sufficient strength.

Lubrication is applied by grease from time to time, but also soaking in expired motoroil before assembling assures a smooth motion, and oil in the square hole provides a continuous lubrication

2.2.4. The rotor

The twelve-bladed rotor is composed by the rotorframe, bladesupports and blades which are completely prefabricated in the workshop. During installation of the windmill the rotorframe is lifted and installed first and the blades are fixed afterwards.



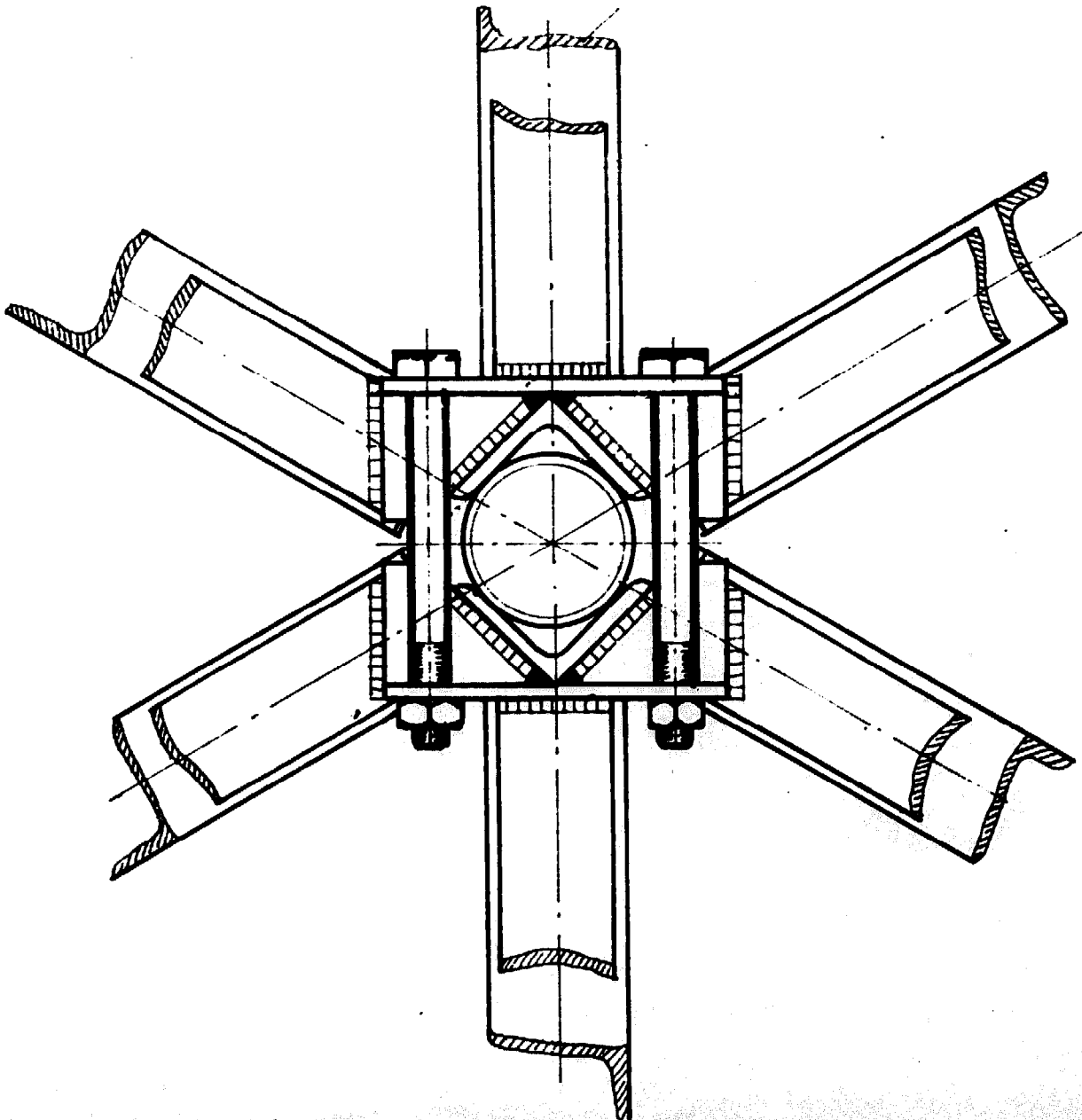
The rotorframe.

Using the shaft, bearings and headconstruction as basement during composing and welding of the rotorframe the latter is composed very accurately. However the disadvantage was felt during transportation: the diameter of the rotorframe amounts to : 3.8 m, so its transport can be complicated. Nowadays the rotorframe is composed of two halves: which can be obtained easily due to the fact that the hub is partable.

In the beginning there were some doubts concerning the strength of the inside ring which is supposed to carry the centrifugal forces acting on the blades. Although no deformation has been indicated the rotorframe of the next four prototypes have been reinforced by extra flats which provide extra support to the inner-ring. Later on this precaution proved to be superfluous because an overhaul of the KKI-windmill pointed out that the inner-ring still was perfectly circular. Since the rotorframe proved its reliability in combination with the broad blades of the old design no doubts remain concerning its strength in combination with the smaller blades. Nowadays the rotors are constructed without these extra reinforcement flats.

The hub.

During the introduction of the bigger pumps (6" and 8" dia)

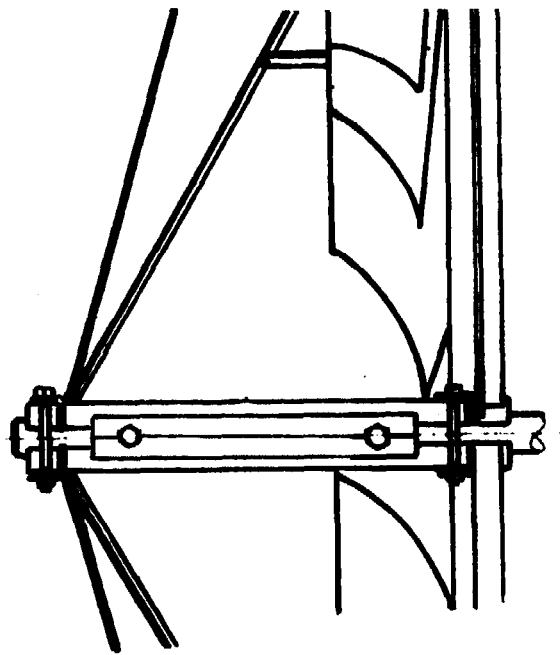


and allowing the windmill to run in windspeeds higher than 12 m/s the hub of the rotor started slipping and screwed backwards over the shaft.

Obviously the clamping of the hub was not sufficient in order to prevent the rotor from slipping which results in wrong position with regard to the shaft (Rotorframe is fabricated on its shaft to eliminate unstraightness) Defenitely a "shaking" windwheel will result, which leads to vibrations and wearing and tearing will result of several parts like the security-lock, head/tail-hinge and head/towerpipe-joint, so avoiding this is a must.

Practice proved that just a bolt through the shaft acting as a key is not sufficient: if slipping occurs the two hub-halves (angle-iron) will be bent open and the entire hub- and rotor-construction is spoiled.

Finally an acceptable solution for this problem was found by applying two extra clamping angle-irons clamped firmly by two 1/2" bolts.

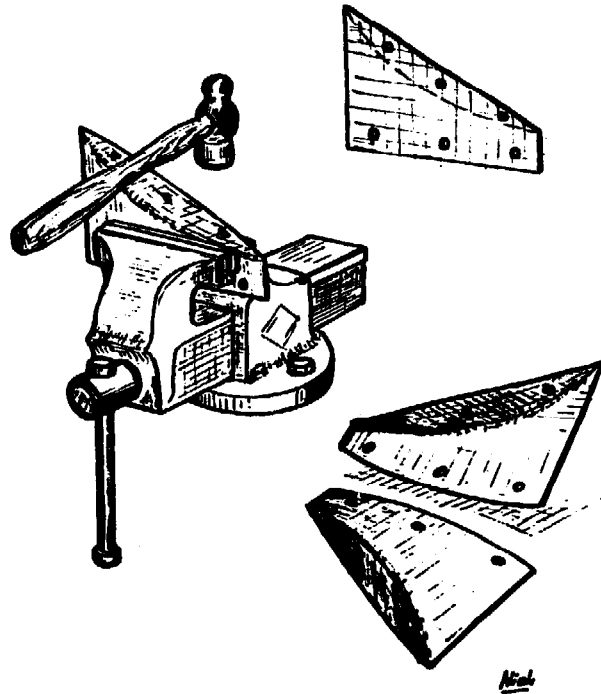


Blade-supports.

The blade-supports are manufactured from sheet-iron and if one is able to prefabricate two sets of twelve equal blade-supports an accurate running windwheel will result. This is achieved by making the supports in sets of twelve, while the

2.20
first of each set is used temporarily as a simple shape during cutting and drilling of the other eleven supports. After marking and hammering nice blade supports result in satisfactory shape and sufficient strength. However, in the first prototype windmills the inside blade supports proved to be not fatigue-resistant as cracks developed at the bolt-hole edges, near the inside ring. This problem was solved by applying 2mm sheet iron for the fabrication of the inside blade supports. The outside blade supports served their purpose best and are still made of 1mm sheet.

Some efforts have been undertaken to compose the blade supports of pre-drilled and curved flats which are welded to the rings. Unfortunately this experiment turned into a failure. Obviously due to the rigidity of these supports the forces setting of the blades in them was often accompanied by initial stresses resulting in increase of fatigue sensitivity of the blades

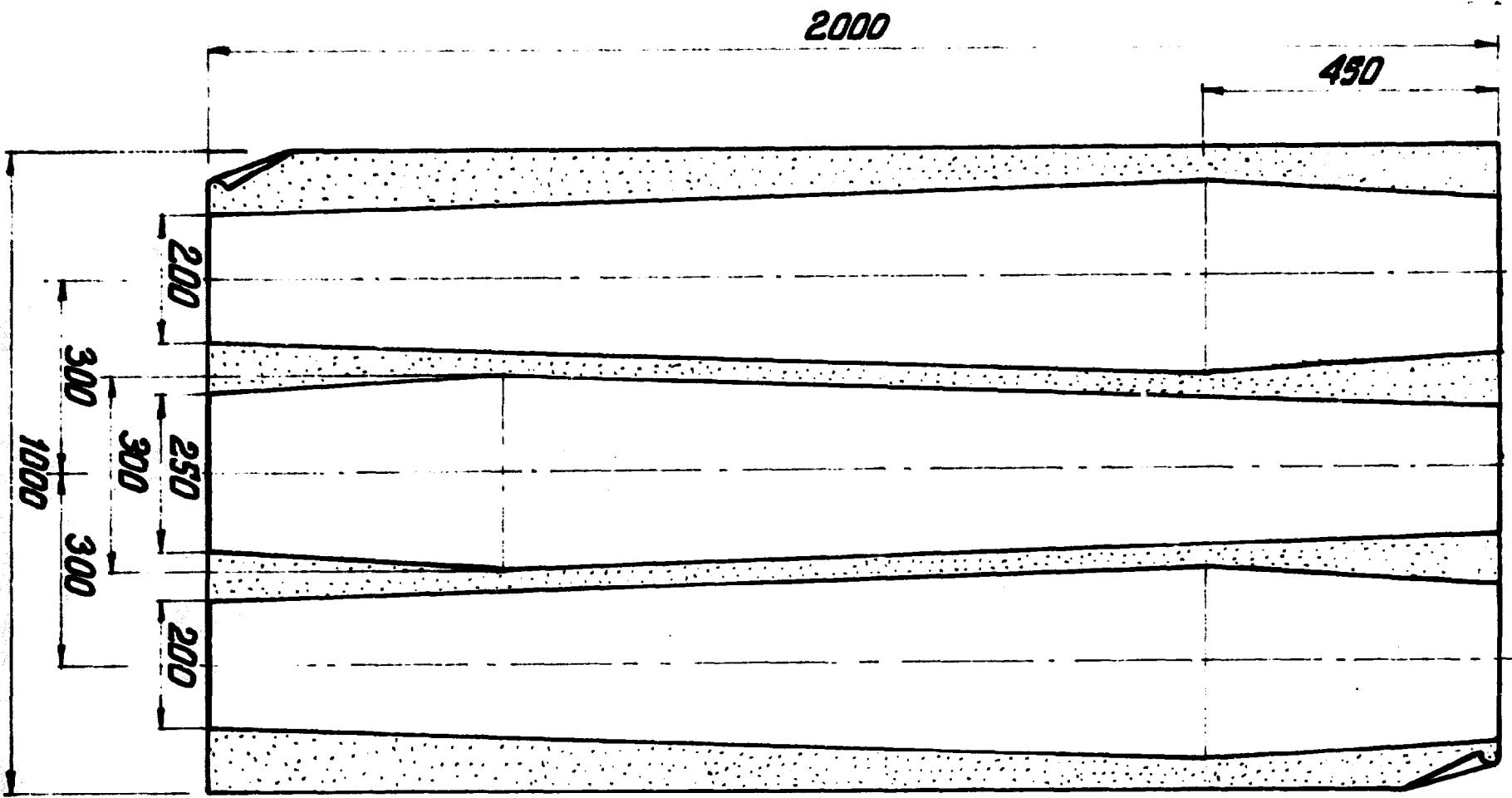


in places near the bolt holes. Such complications do not occur if the sheet iron blade supports are applied for these show "elastic" properties which are stress-relieving.

The blades.

The first three prototypes (KKI, KKII and RTI) have been equipped with sheet-iron blades which were curved 10%.

Due to a mistake in the assumption the blade-shape was calculated for 7% airfoils which resulted in broader blades than was actually needed. The production of the blades from 1 metre wide standard-sheets proves to be rather



uneconomical (two blades per sheet). It was decided to narrow the blades by applying the properties of the 10% airfoils which resulted in a new blade-shape: three blades can be cut from one standardsheet.

Unfortunately the starting-torque coefficient of the rotor decreased from 0.19 to 0.14 but the advantage of costprice-reduction made this quite acceptable.

It was also proposed to cut the blade tips in a circular shape which might increase the efficiency by appr. 2.5 %. Although wind tunnel tests on this topic did not show any significant improvement. Some of the 12 PU 500 - windmills have been fitted with blades of circularly shaped blade tips and are accepted (more or less) for aesthetic reasons.

2.2.5. The pistonpump.

From the beginning the major part of the time and energy spent in developing the windmill-installation has been required for the evolution of the pumpsection.

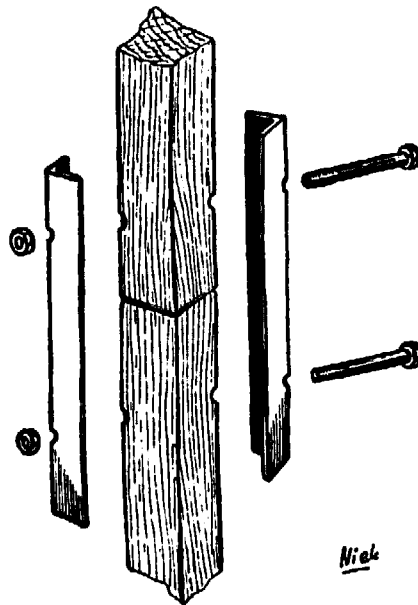
Many problems had to be solved concerning the fixation of the pumps and delivery-pipes into the wells and also the design of the pistonpump changed from time to time.

Since the windmill drives the pistonpump with R.P.M-numbers of 15 up to 120 the application of air-chambers proved to be necessary in order to decrease the acceleration-forces acting in the pumprod, pump suspension and transmission. These forces were always underrated and several times cracks of the pumprod-connections and loose pump suspensions resulted. In some cases even the entire tubewell was pulled out and led to damage of the pump and pumprod as well.

The pump rod and pump rod connections

As mentioned before the first windmills have been fitted with wooden pump rods which proved not to be successful.

The wooden rods, if available, do not exceed the length of appr. 2 m and they are always unstraigth. Since the length of a total pumprod is at least 10 meters many connections have to be applied.

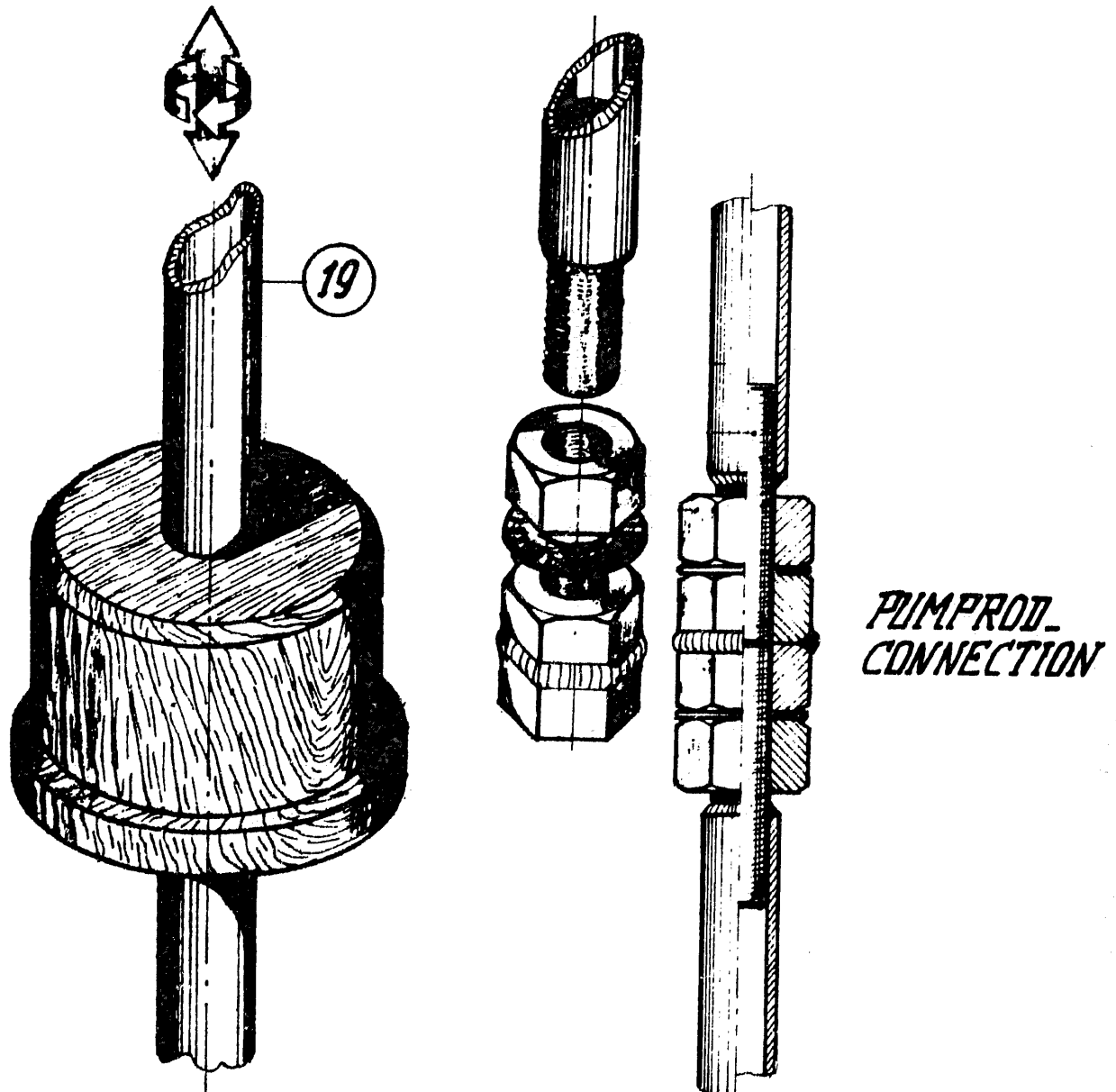


These connections are realized by using simple clamping devices of angle iron. These seemed to be very strong but sooner or later, due to the reverse of pumprod forces, these connection got loose. Actually these failures resulted in applying steel-pipe as a pumprod. In order to minimise the total weight the first steel-pumprod has been composed of 1" pipe with 1 mm. thickness only, but still the problem of simple joints persisted.

A simple rod connection, made by two belts through it, did not serve the purpose. Such joints also got loose, worn out and finally cracked. Flanges made of flats which have been welded to the pump rod ends offered a strong and reliable joint after bolting them.

The disadvantages of such connections were that the pump rod sections were difficult to align and moreover the assembling of the pump-rod guides became complicated. The latter had to be partable. Moreover the thin walled pump rods needed many guides in order to prevent collapse during downward motions. Therefore normal 3/4" gaspipe has been applied for all the pumprods and the introduction of a new and simple joint solved all the pump-rod troubles.

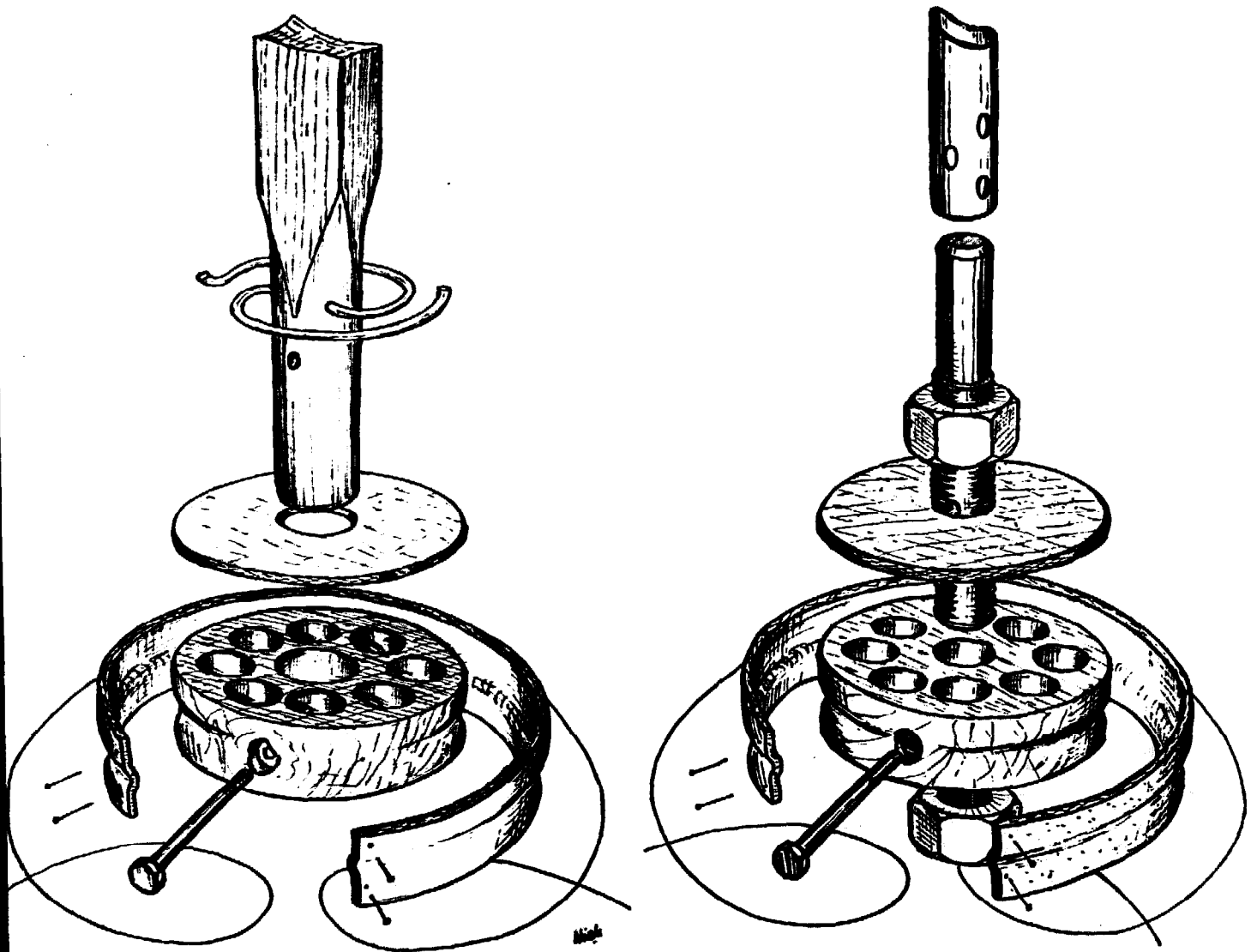
3/4" screw-threaded rods are hammered into the 3/4" pump rod and welded to it. Two or three nuts provide a simple threaded-bush in which the threaded ends of the pump rods, with a spring-washer in between, are locked by an extra nut. These pump rods and its joints serve the purpose very satisfactorily and no complications, concerning alignment, cracks or looseness, appeared anymore.



The first prototype-pistonpump

The first prototype existed of a set of P.V.C. pipes of 5" dia in which the wooden footvalve and wooden piston with leather sealing were situated near the watertable.

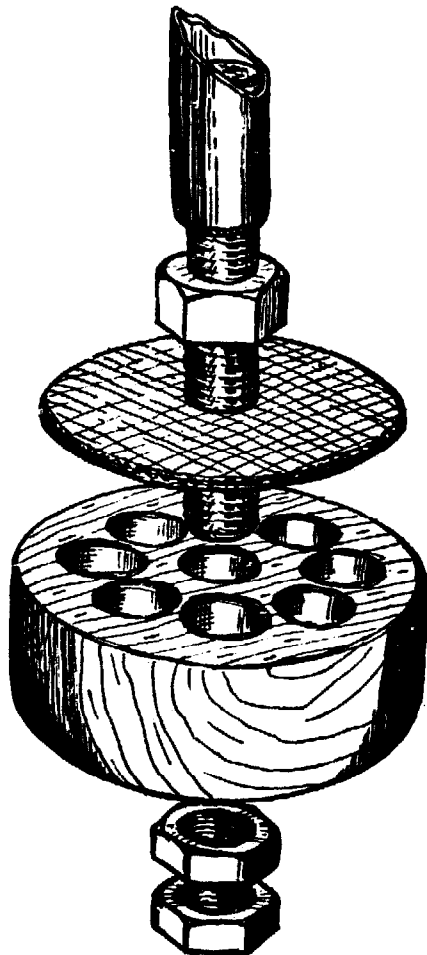
Besides the developing of the pumprod and its connections the piston became the bottle-neck when the stronger pumprods were introduced. Since the piston is made out of wood its strength was improved by increasing the thickness from 1.5" up to 3". The leather piston sealing proved to be very suitable as far as wearing and tightening were concerned, but due to the high friction coefficient of the leather/P.V.C.-combination



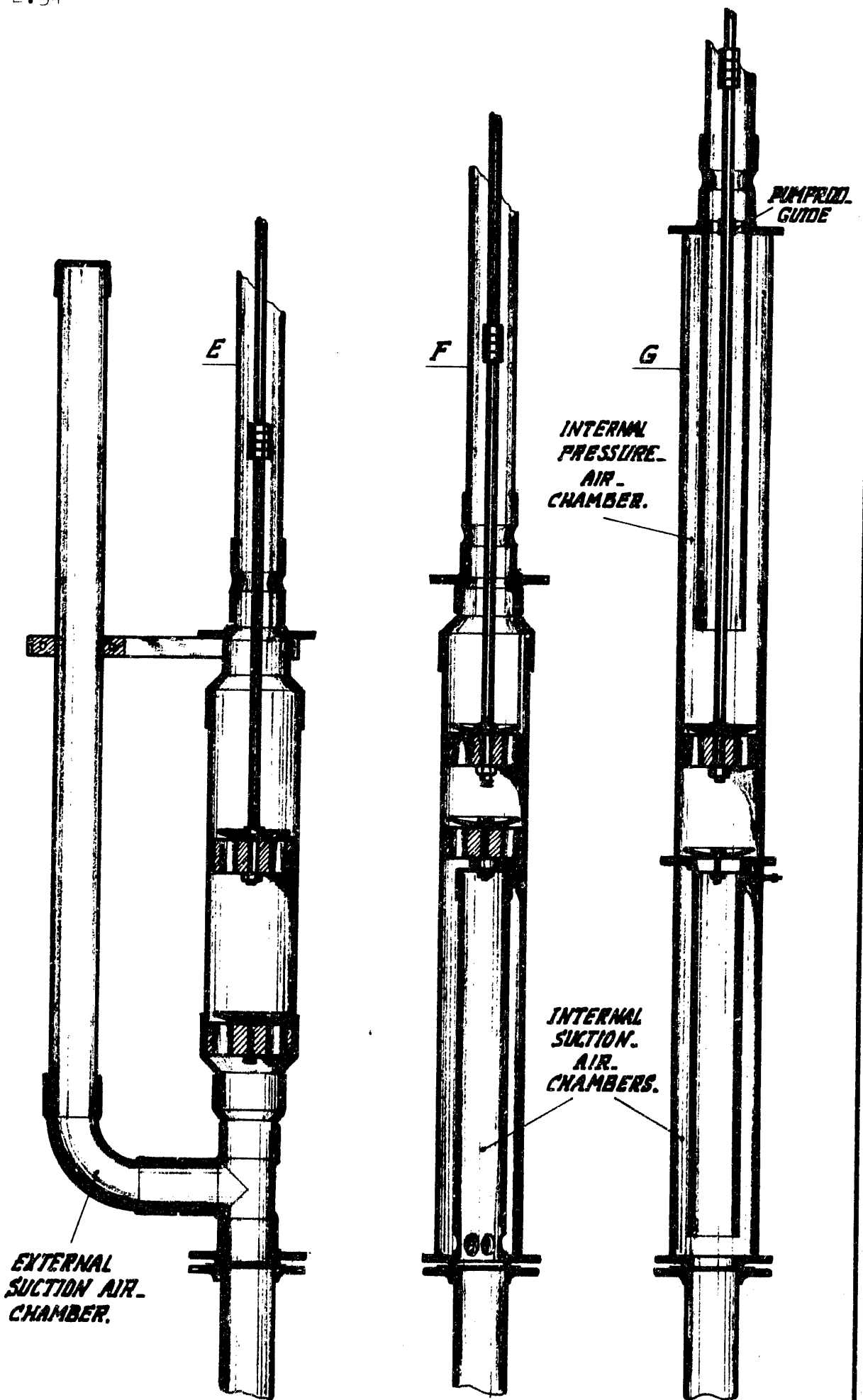
and the high static pressure the leather sealing set up and caused a sticking slide of the piston in the cylinder resulting in a very high starting torque. First a rather high wind gust (upto 6 or 7 m/sec) was required to start the windmill while the minimum running speed amounted to 3 m/sec. The idea was born to apply a small but permitted leakage in the piston in

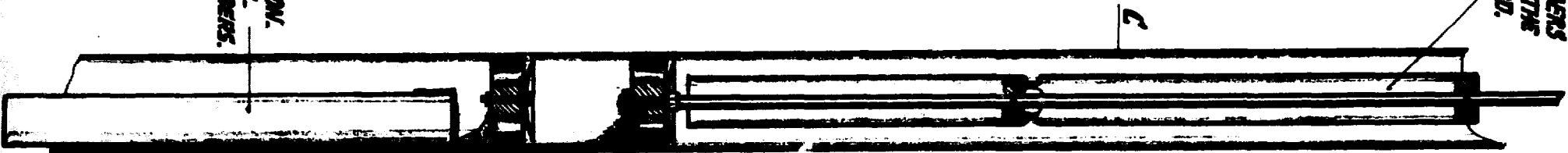
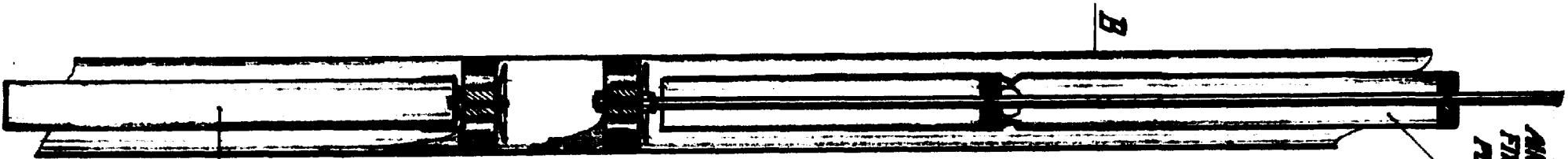
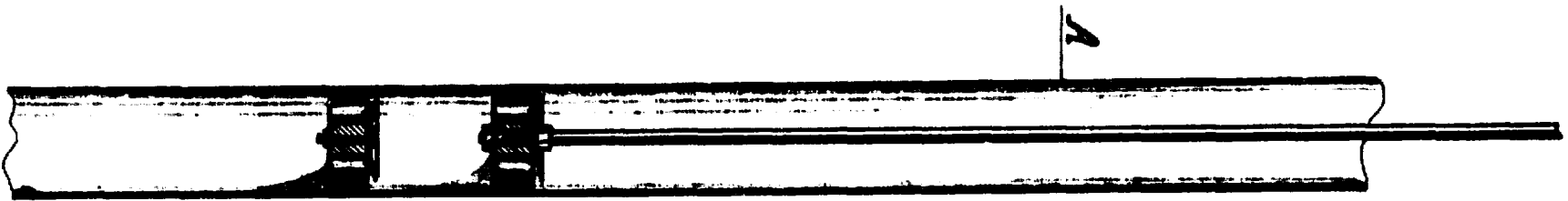
such a way that the windmill can slowly move the piston in the top-position and is able to start running unloaded during the first half revolution. Probably the stored kinetic energy in the rotor might maintain the rotation so the starting-windspeed can be reduced..

During these experiments the inducted friction due to the set up of the leather sealing still persisted and just a small improvement has been noted.



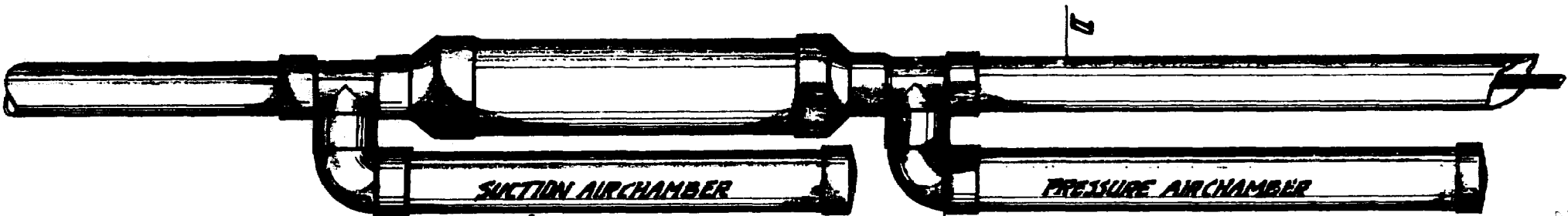
A new experiment with a sealingless piston showed a considerable improvement due to the absence of the Coulomb's friction acting on the P.V.C.-leather-surface. In spite of the fact that the volumetric efficiency is badly affected at very low R.P.M.-numbers this efficiency seemed not to be influenced if higher R.P.M.-numbers are actual. Although the expected lifetime was quite uncertain concerning the increasing of leakage (decreasing of volumetric efficiency) sooner or later this sealing-less piston has been fitted in the existing prototypes. The experience with the sealingless pistons in practice is rather positive: depending on the sliding-fit at the beginning, the purity of the lifted water and the actu-

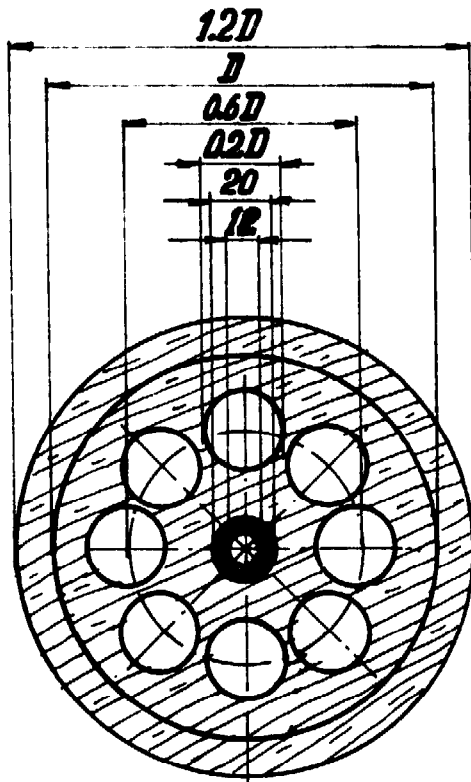
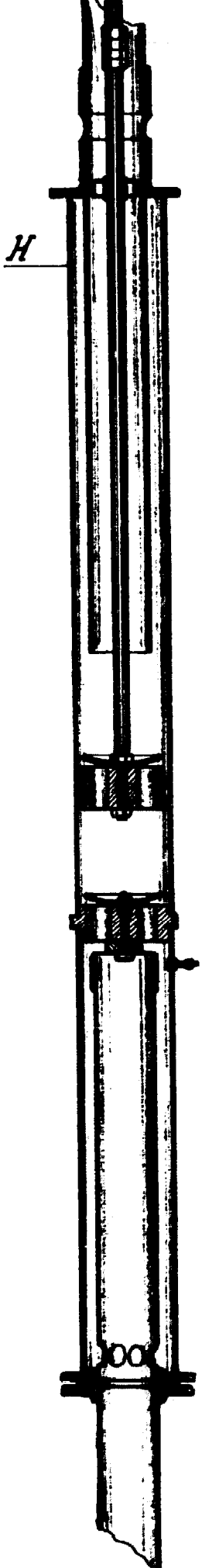




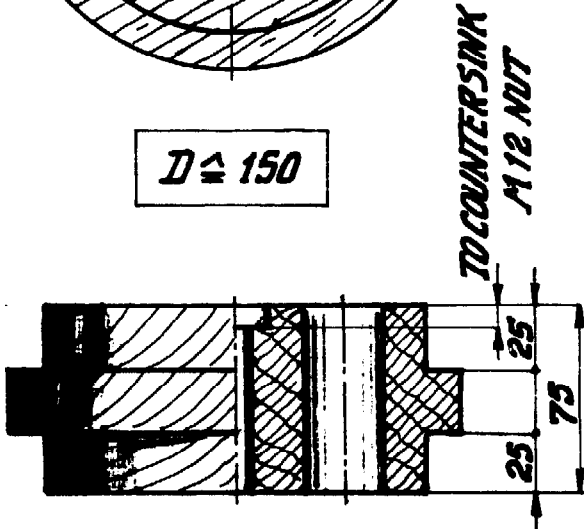
AIR CHAMBERS
FIXED TO THE
PUMP ROD.

SECTION
AIR
CHAMBERS.





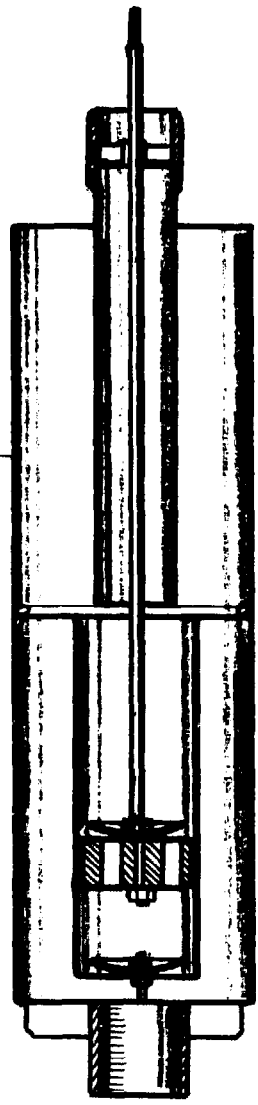
$D \approx 150$



**MEASUREMENTS IN
WET CONDITION!**



1



7

al accuracy of the pump-rod guidance (!) the lifetime varies considerably.

A worn-out piston/cylinder-combination still operates, but the efficiency becomes unacceptably low. Therefore maintenance and repair must be carried out, and if possible in a quick and uncomplicated way.

Since the leather valves need inspection and repair too the above mentioned demands had to be taken into account with regard to the pump designs. Finally the required air chambers and the materials available determined this pump design. Right from the beginning the development of the piston pump reached many stages resulting in type (A up to J) and still the way of developing by trial- and error detected the weaker sections in these designs. Time, wind, patience, optimism and invention in particular proved to be the most required tools in order to develop the piston-pump step by step. Briefly types A up to J will be described.

- A Basic type; very simple and reliable (handpumps) as far as no high frequencies actuate!
- B and C The need of air chambers were felt. Forces acting on the internal chambers were underrated. Complete chamber sections got loose and caused damage to foot-valve and piston. Especially the airtightness of the pressure chambers was difficult to achieve.
- D When the P.V.C.-sockets, elbows and T-connections were available, external air chambers have been composed and applied. But action-reaction effects in the external pipes caused vibrations while the presence of air in the pressure section remained doubtful after some time of operation. (Air solves into the water under high pressure conditions.)
- E Suitable for moderate elevation head (no pressure chamber). In this stage 7/8" pump rod and 7/8" connection have been introduced.

- F Cheaper and simpler construction; by applying an internal suction-air chamber several reducing sockets, T-connection and elbow were superfluous. Total section is clamped between two flanges.
- G Similar type but suitable for higher elevation head. Air in pressure chamber is maintained due to small but permitted leakage in suction section (by bicycle tube-valve). Due to the location of the suction-air chamber a foot valve with central supply has been applied. The latter did not operate satisfactorily in combination with the sole-leather valve disk which deformed in such a way that leakage resulted. The pump is simple to open and to inspect.
- H The "combination pump" combines the advantages of pumptypes F and G resulting in the following properties of the pump:
- double air-chambers (reduces pump-rod forces)
 - reliable valves (self-priming)
 - proper pumprod guidance (life-time piston)
 - "automatic air injector" (pressure chamber remains full)
 - total pump sections can be replaced easily (quicker repair, maintenance)
 - pump is opened quickly (repair, maintenance is normally carried out in the workshop).
- I This pump is completely composed of steel components which are jointed by weldings. The pump is easy to open in order to carry out maintenance and repairs. The cylinder is made of gaspipe from which the inner seam is removed by means of a simple cutting device and final finishing is done by honing. Though its construction is more advanced than those of the other pumps its reliability proved to be better. (See chapter 4).

J. Same type but the footvalve is made of sheet iron. This allows a shorter cylinder which facilitates removing the seam. Moreover no doubts remain whether leakage occurs between valve-body and cylinder as sometimes seemed in the foregoing pumptype. Also this pump has been tested thoroughly as described in chapter 4.

The air-injection system in both the pumptypes I and J has been abandoned. as pumptests showed (by means of waterlevel gauge) that the air in the pressure vessel still remained. Results of thorough tests of the pumps latter mentioned are described in chapter 4.

2.2.6 Pump suspension

Practice showed that fixation of the windmill pump can be rather complicated. Especially during stormy weather considerable forces are acting on all moving parts and the pump structure in particular. One can imagine what happens if the suspension shows some play. In some cases the entire tube-well got loose and was simply pulled up till the piston started hammering on the foot valve!

Besides the need of an adequate fixation in vertical sense supports are also necessary to keep the long pipe lines centered. Previously this was achieved by means of wooden crosses which have been wedged in the well by means of keys. Though such arrangements served the purpose some danger exists as people tend to stand on the crosses during climbing into the well. A simple tripod-"umbrella", combined with the pipe-line socket, proved to be very useful. Centring is done simply by adjusting the "pods" and locking them in the brick wall by means of a few hammer blows.

Proper fixation of the entire pump sections have been achieved by applying the following constructions:

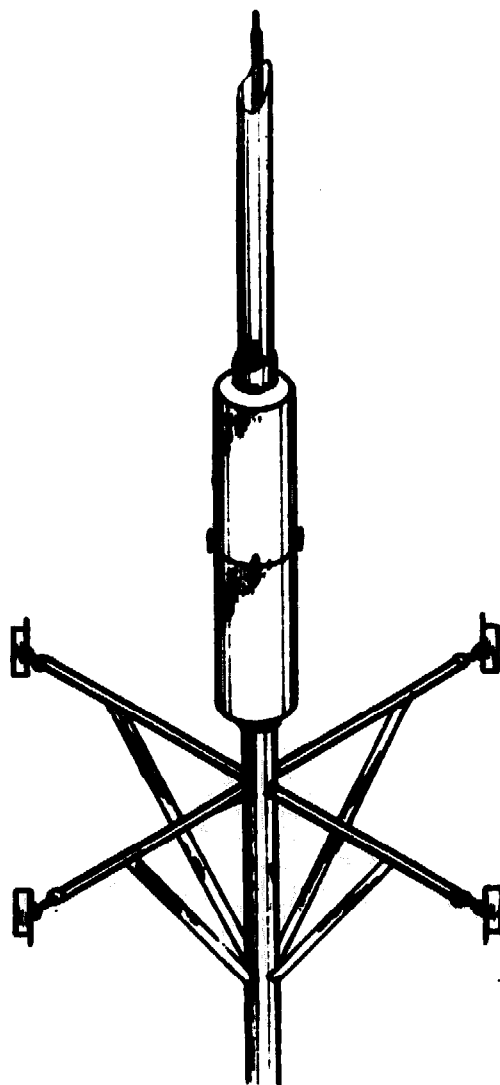
- Anchors masoned in the well
- Expanding clamping-devices
- Tower-pipe connection
- "Bridge"

Anchors masoned in the well

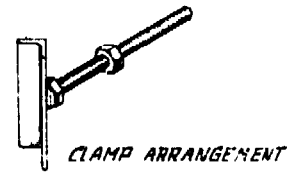
In case of an excentrically placed tower, which is often done in order to facilitate waterlifting by means of other devices, the well-structure itself provides attachments for the pump section. Anchors are masoned into the wall so that the delivery pipe-line can be fitted.

Expanding clamping device

Provided that the well casing is of proper construction the entire pump arrangement can be fixed suitably by means of an expanding clamping device. The latter is composed of 1" gas pipes which are welded at right angle either to the bottom section of the pump or to the suction pipe. Mutual braces (angle iron) ensure a rigid construction. The clamping arrangement is obtained by fitting longthreaded bolts or screw studs into the extruding pipe ends. Tightening their nuts causes the expansion and fixation of the frame.



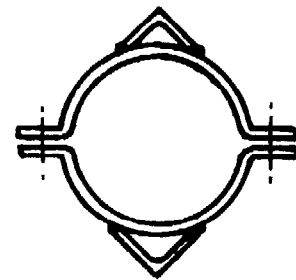
In order to prevent damage to the bricks of the well casing it is necessary to enlarge the bearing surface by means of pieces of angle iron.



Such clamping device proved its worth in combination with the "bridge" construction.

Tower pipe connection

In cases of weak or brittle well casings the pump rod forces are hardly carried by masoned anchors and other devices to such well-casings. Therefore it is preferable to carry over the forces directly via a tower-pipe extension, which is composed of two long angle irons and some clamps. As a matter of fact the entire pump section hangs from the tower pipe and all acting forces are led through this suspension instead of through tower structure, foundation, well casing and the pump suspension respectively.

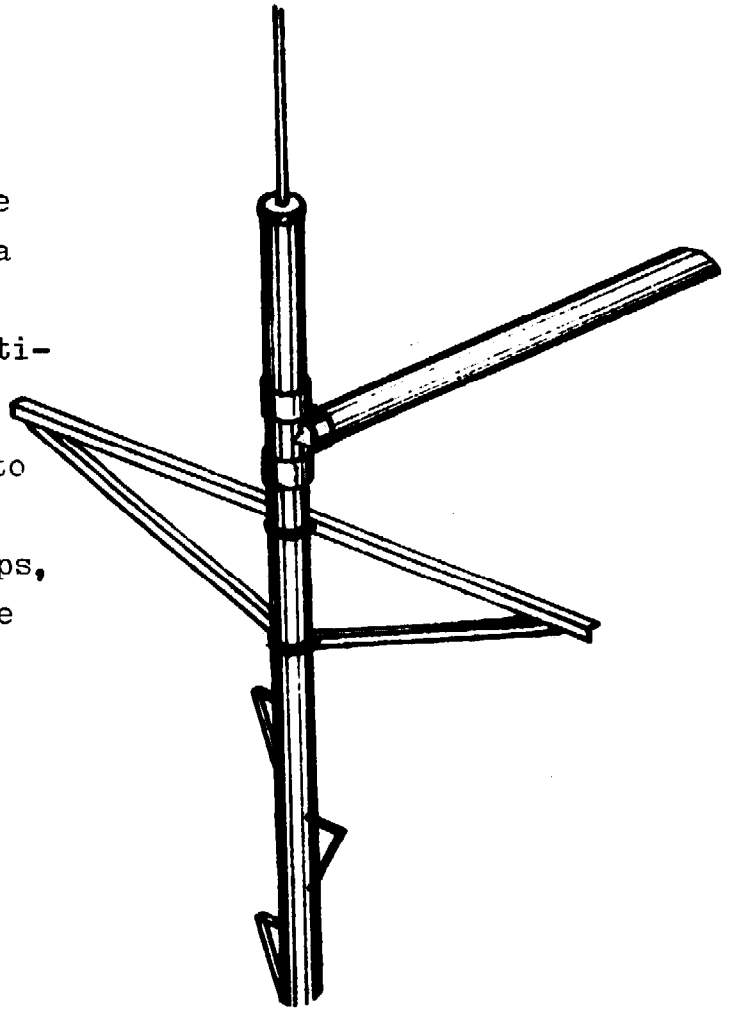


Sideward vibration hardly occur and if so, retaining of the pump section is simply achieved by means of applying the "tripod umbrella" (as mentioned earlier), masoned anchors or the "bridge".

"Bridge"-suspension

If a strong and proper well casing is available the simple bridge construction provides a rigid suspension of the pump section in horizontal and vertical sense both.

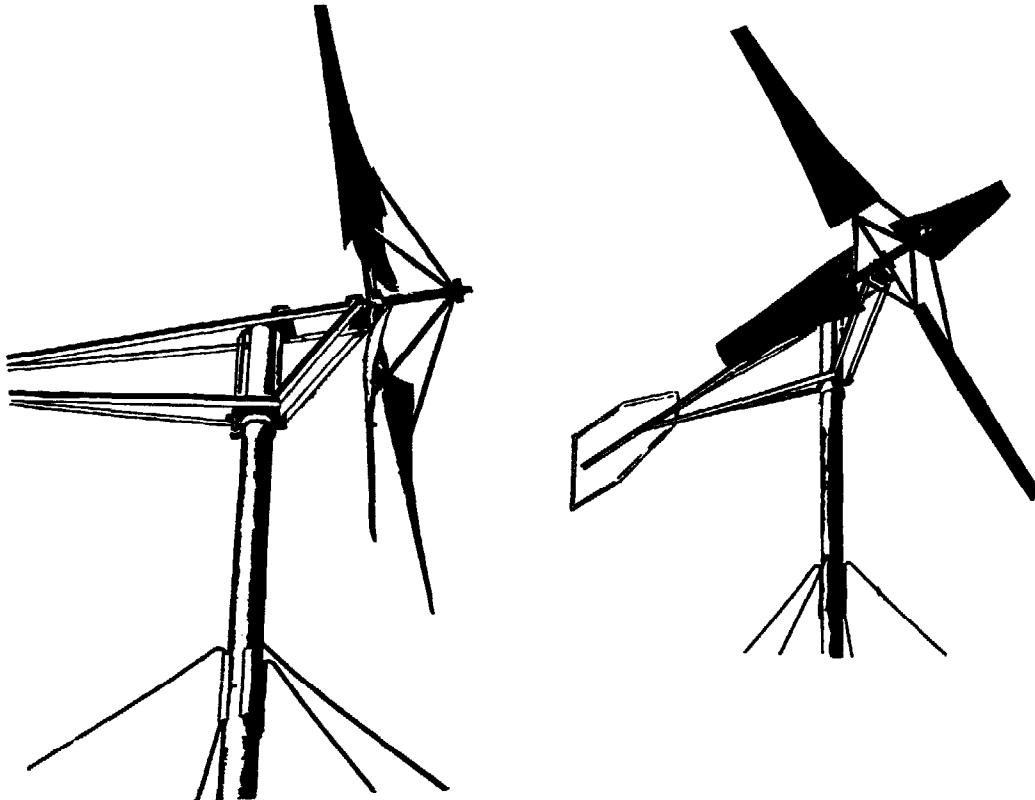
The delivery pipe is clamped to the bridge by means of two clamps. By opening these clamps, and the pumprod-connection, the entire topsection of the pump (including delivery line) can be lifted in order to facilitate repair and maintenance the moving parts of the pump.



2.3. The 4-bladed 2.50 m. dia. windmill for low-water-lifting.

In winterseason surface water, which remained from the rain-season, is used in some cases for the irrigation of the winter-crops. Several small farmers lift this surface water by manpower to their fields; the idea was born to develop a small and cheap windmill which can do this job.

Although this low-waterlifting wasnot planned in the project-schedule and its need was not actual, some time has been spent by the Dutch windmillengineers in developing this windmill. Therefore some attention is paid to this subject.



Actually it was the size of the scrap of steelsheet, which was left from the production of the big windmills which determined the dimensions of this small windmill. The first prototype has been fitted with a 4" pistonpump combined with a 3" towerpipe. The total structure stands on its pump-section and is held in position by guys. The latter are simply made of 3/8" steel rods and anchored by pegs to the ground. The conversion of the millshaft-rotation into the up-and downward -motion of the pumprod is obtained by means of a crank-pumprod-mechanism. The elasticity of the rod allows its outward bending besides the up-and down-movement so a

2.44
connecting-rod and crosshead are superfluous. Two wooden guides, situated in the tower, provide a further support to the 6 m.-long pumprod. The piston is made sealingless in order to enable the windmill to start almost unloaded. This is necessary since the starting-torque of the 4-bladed windmill is very low. The measure of leakage is determined by trial and error and a clearance of the piston in the cylinder of appr. 1/2 % of the piston-diameter proved to lead to satisfactory results. In spite of this leakage the volumetric efficiencies are reasonable and even the value of 100% is exceeded due to the inertia-effects in the watercolumn if high R.P.M.-numbers occur.

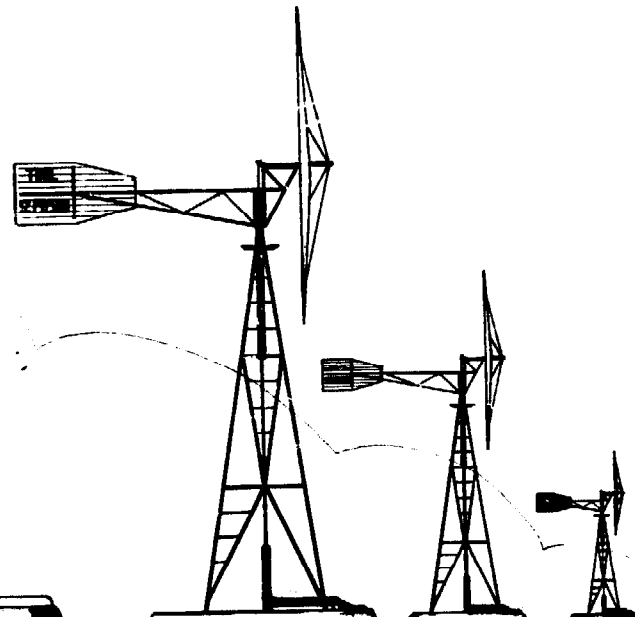
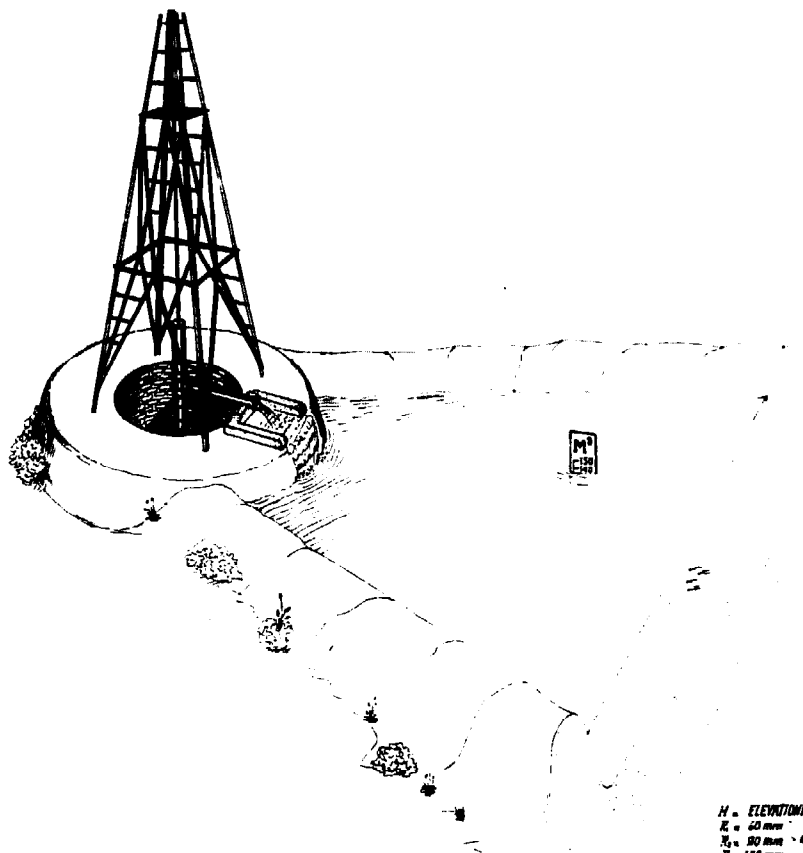
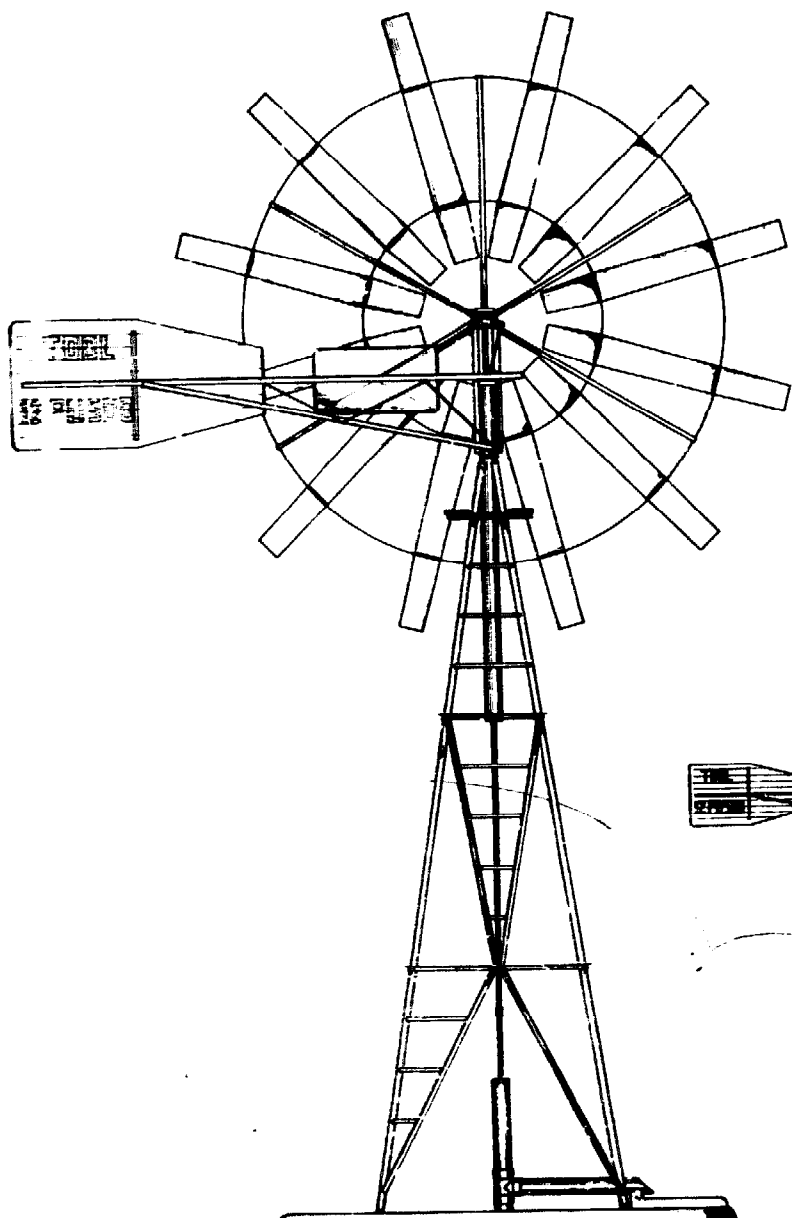
In 1978 the total material-costs of the small windmill amounted to less than Rs. 500,- while the required manpower for building it is estimated at appr. 50 manhours.

Later on 3 other small windmills have been built and installed. These were slightly different in size and design (3.2 m. dia., tip-speed ratio 5) and consequently more costly.

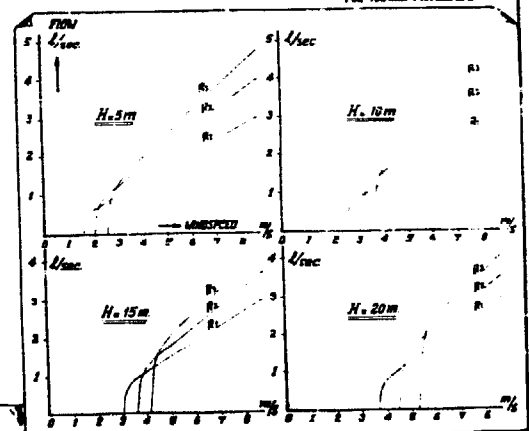
In the longer run some technical problems (e.g. fatigue-cracks in the blades) in combination with the low windspeeds made it clear that the use of these small windmills was not quite successful in the Ghazipur district, but on the other hand its simplicity and cost-price caused that it was adopted by the WOT (TOOL-member in The Netherlands). Developing and testing there, proved that this small windmill can still be attractive for low-waterlifting purposes while the basic design is maintained and applied in other WOT windmill types.

In the framework of these windmill types the small windmill is coded: 4 PU 250 (4-bladed pumping unit of 250 cm. dia.)

Applying some small modifications the windmill can be fitted with a transmission to groundlevel by means of a rotating shaft for multi-purposes (4 MP 250). Also generating electricity is possible by applying this basic design and a 4 EG 250 will result.



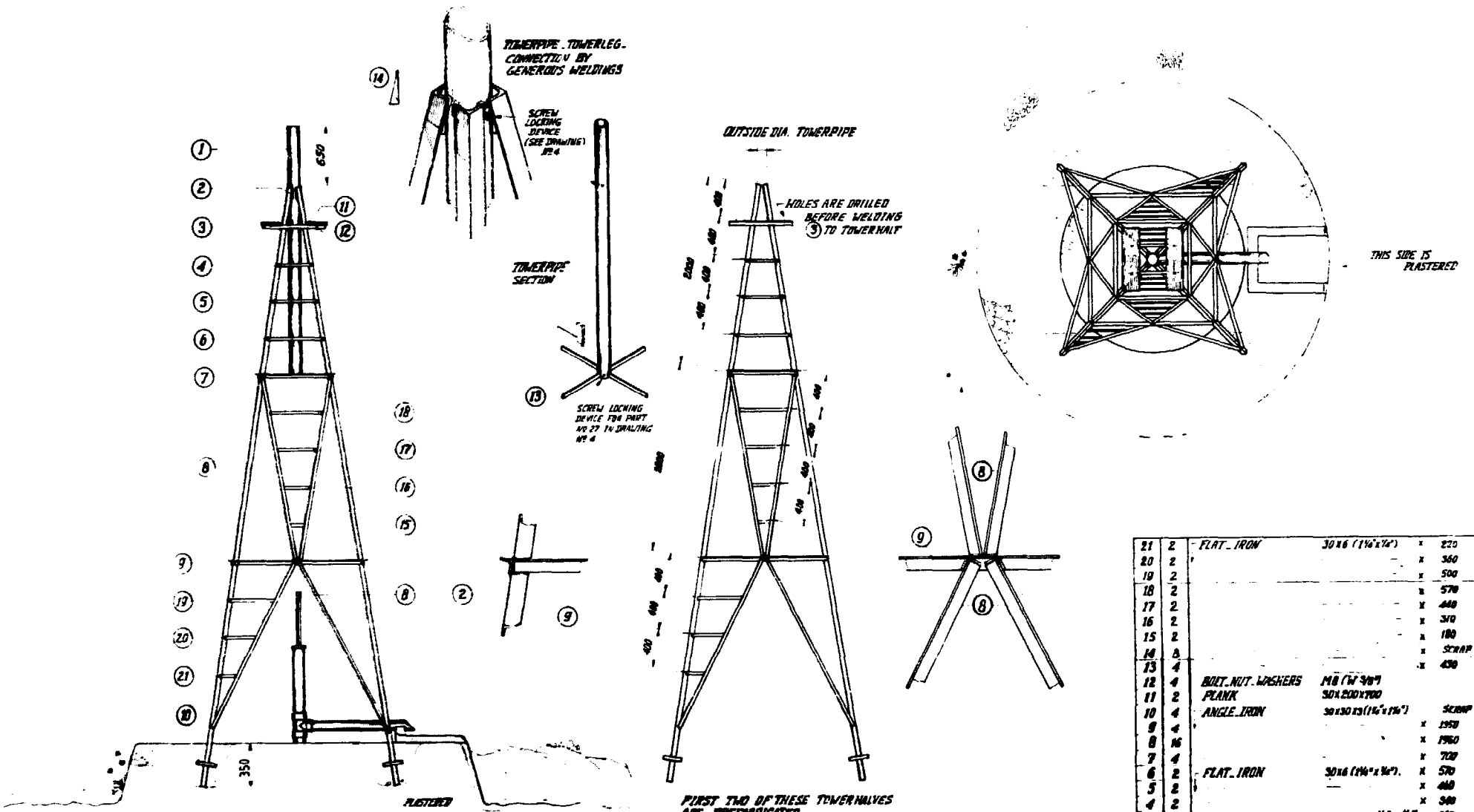
H = ELEVATION HEAD
 R = 60 mm
 R₂ = 90 mm - CROWN RADIUS
 R₃ = 125 mm
 FOR 150 mm PISTON PUMP



12 PUSO WINDMILL FOR IRRIGATION

FOR INFORMATION: Workshop on Development of Irrigation
 T.H. Tuijthuis - Vrijhof 132
 P.O. Box 237 Eindhoven
 The Netherlands

WALL THICKNESS TOWERPIPE NOT LESS THAN 3.5 MM



IF DESIRED THE LATTICE MEMBERS CAN BE POSITIONED AND WELDED INSIDE THE TOWER LEGS RESULTING IN A MORE ATTRACTIVE APPEARANCE OF THE TOWER. HOWEVER THE FLANGES AT THE ENDS OF THE ANGLE IRON MEMBERS NO 7 AND NO 9 SHOULD BE CUT AT ANGLES OF 45 DEGREES.

FIRST TWO OF THESE TOWERHALVES ARE PREFABRICATED BOTH HALVES ARE COMPOSED AND THE TOWERPIPE SECTION IS SHIPPED IN AND A COMPLETE TOWER RESULTS

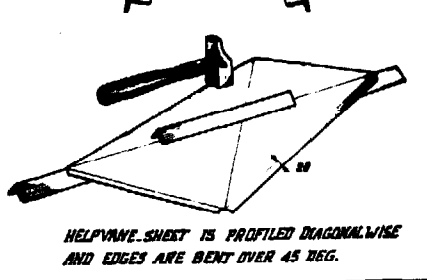
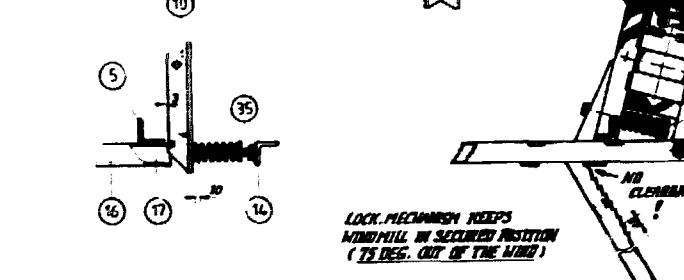
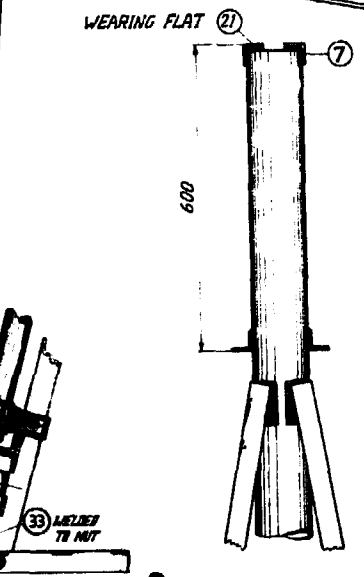
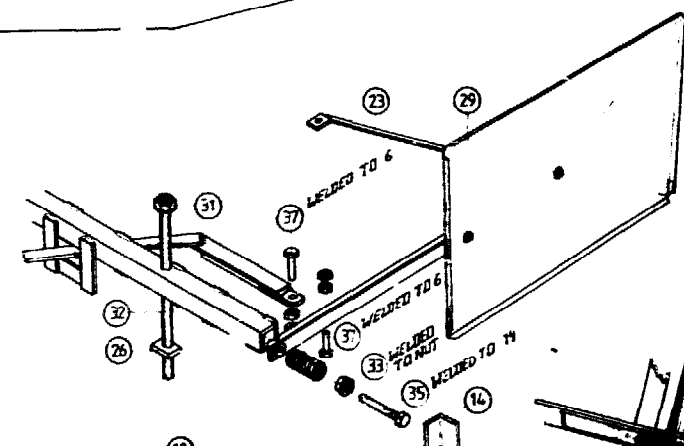
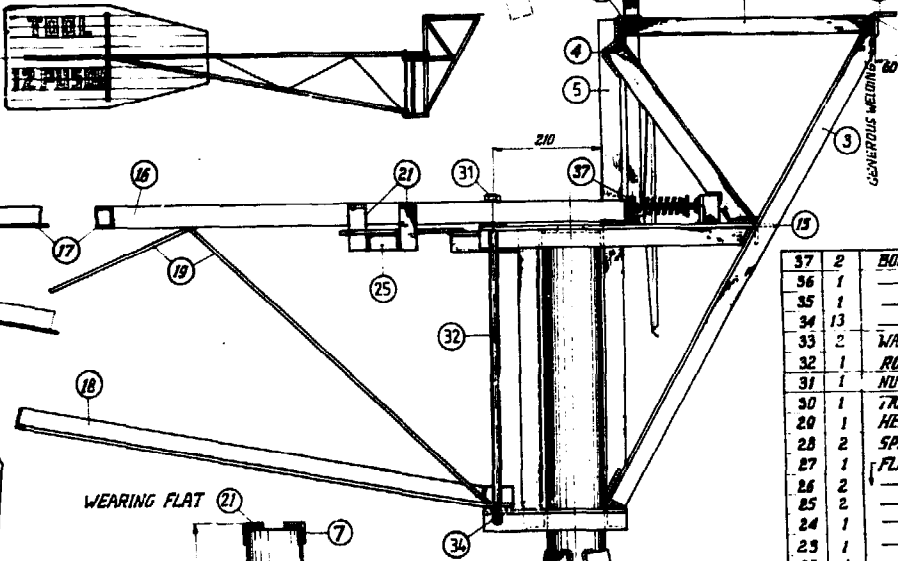
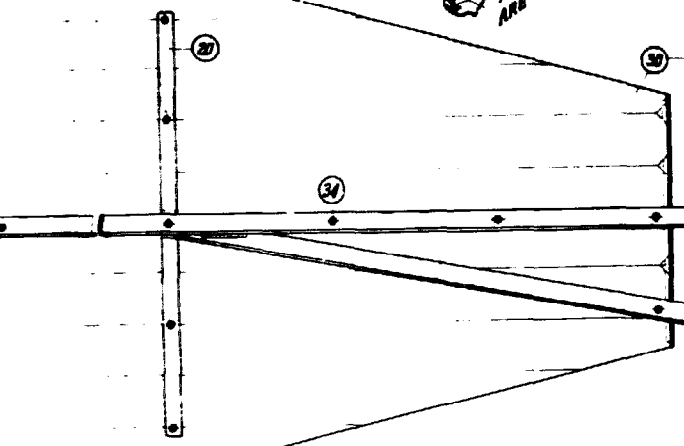
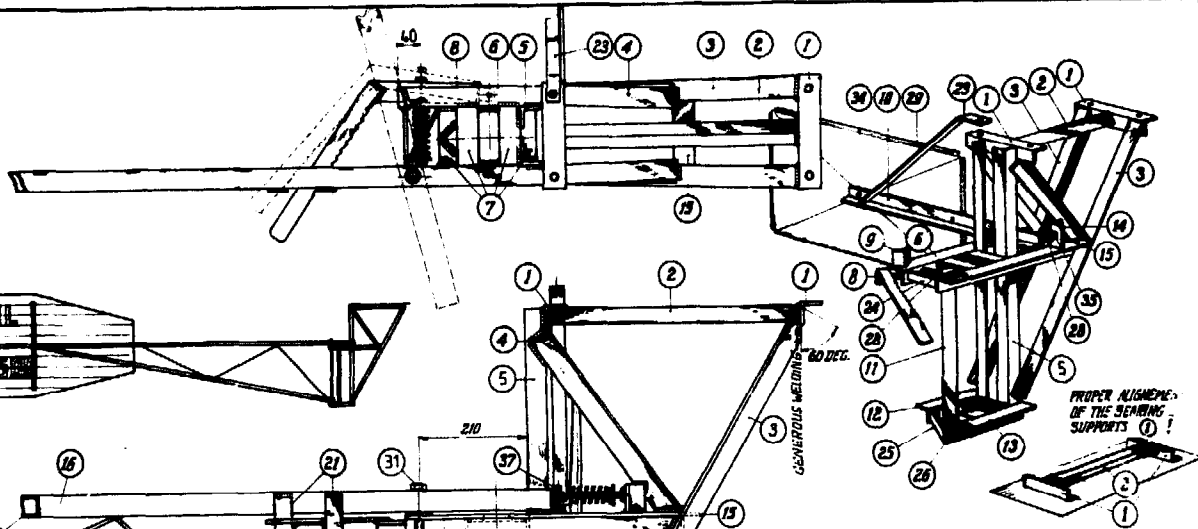
21	2	FLAT IRON	30x6 (1 1/2"x 3/4")	x	220
20	2			x	360
19	2			x	500
18	2			x	570
17	2			x	440
16	2			x	370
15	2			x	180
14	2			x	SCRAP
13	4			x	430
12	4	BOLT, NUT, WASHERS	M8 (1/4"x 3/8")		
11	2	PLANK	30x200x700		
10	4	ANGLE IRON	30x30x3 (1 1/4"x 1 1/4")		SCRAP
9	4			x	1950
8	16			x	1960
7	4			x	720
6	2	FLAT IRON	30x6 (1 1/4"x 3/4")	x	570
5	2			x	460
4	2			x	300
3	2	ANGLE IRON	30x30x3 (1 1/4"x 1 1/4")	x	660
2	4		40x40x4 (1 1/2"x 1 1/2")	x	6500
1	1	TOWERPIPE	4" GASPIPE	x	2630

NO. 12 PUSOD-TOWERCONSTRUCTION

FOR INFORMATION: Working on Developmental
T.M. Toons - Vrijhof 152
P.O. Box 217, Eindhoven
The Netherlands

HAULIERING PROFILES INTO THE
WIND SHEET INCREASES
RIGIDITY

AFTER PROFILING THE EDGES
ARE BENT OVER

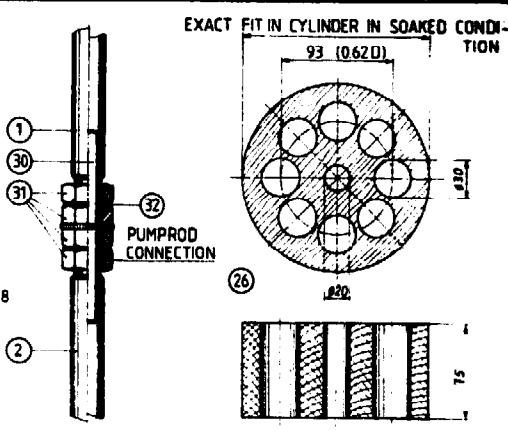
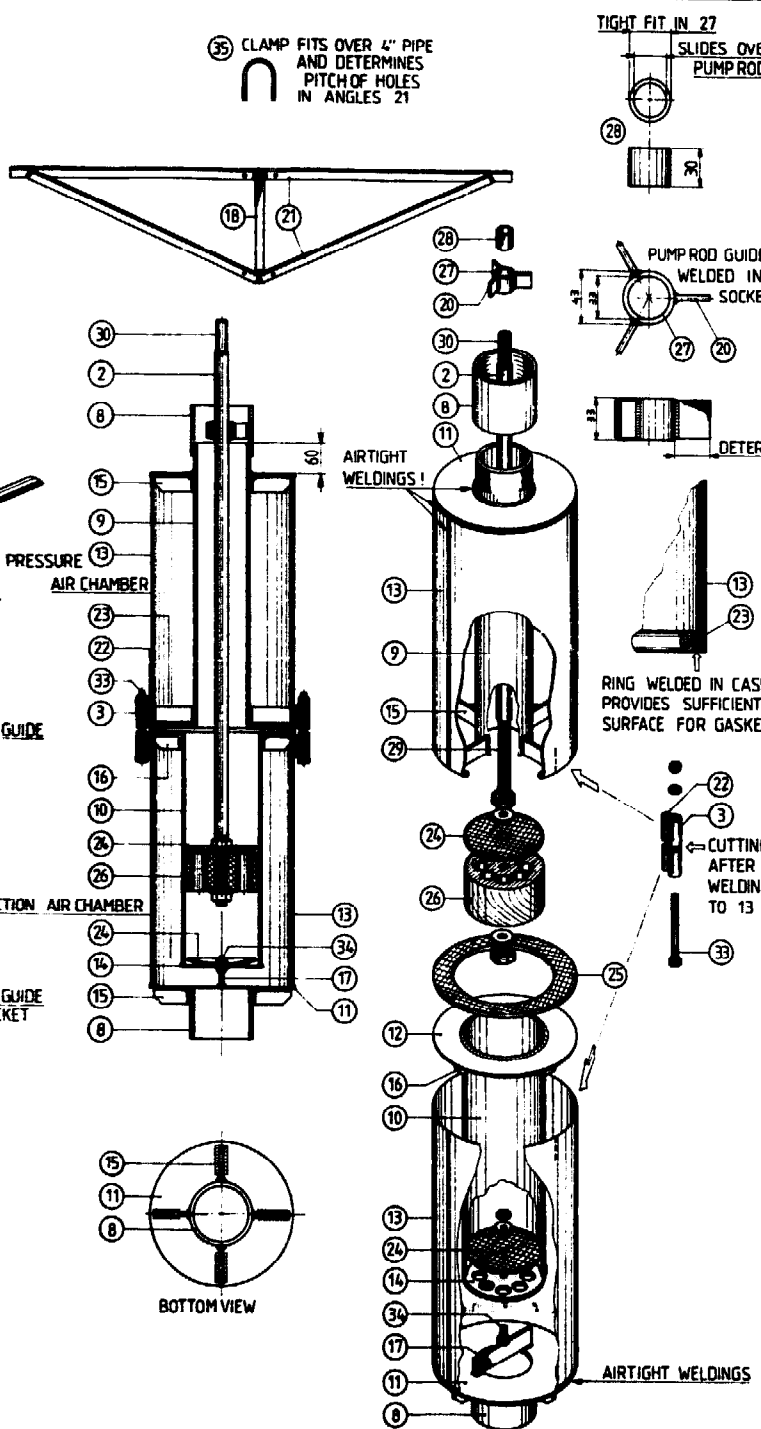
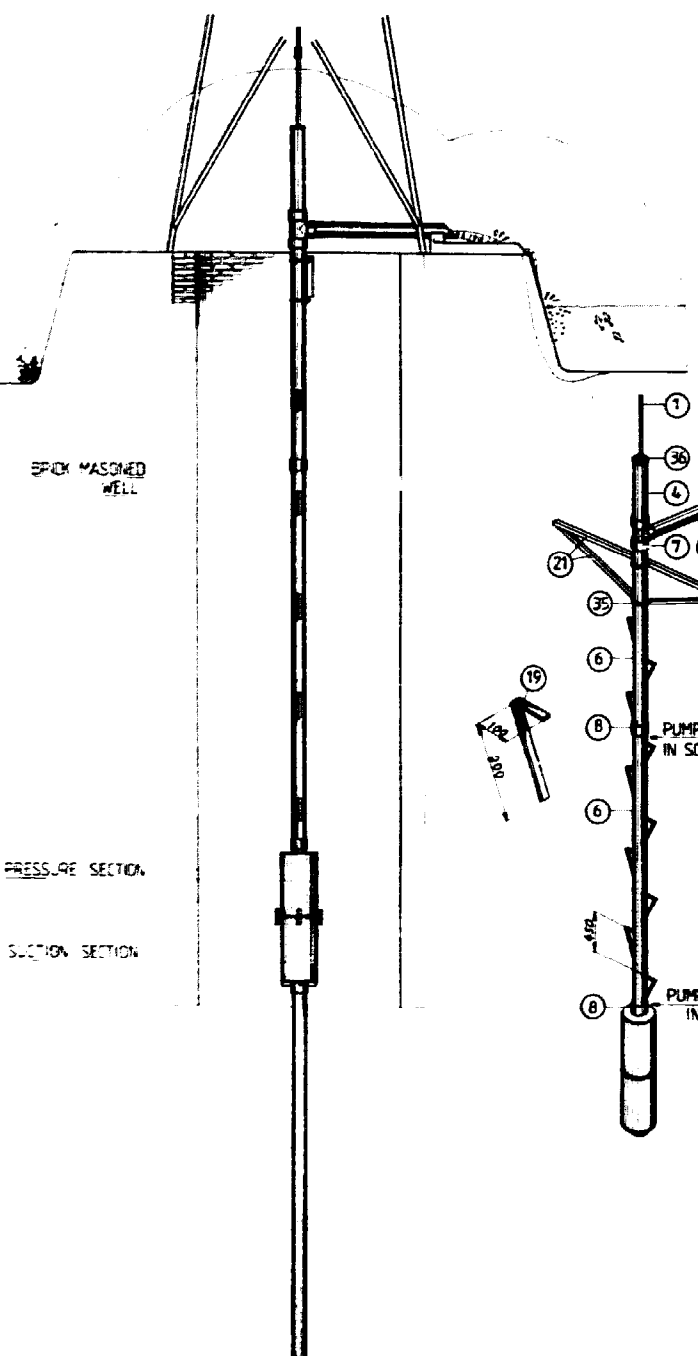


37	2	BOLT, NUT, WASHER	M12 x 40	(W 1/2" x 1 1/2")
36	1	---	M 10 x 150	(W 3/8" x 6")
35	1	---	M 12 x 100	(W 1/2" x 4")
34	13	---	M 6 x 25	(W 1/4" x 1")
33	2	WASHER	2 1/2"	(10 1/4")
32	1	ROD	Ø 18 x 650	(Ø 3/4" x 26")
31	1	NUT	M20	(W 3/4")
30	1	TRAPEZOIDAL SHEET	2000 x 1800	
29	1	HELPLINE	1800 x 500	
28	2	SPRING	APPR. Ø 30 x 100 x 64	
27	1	FLAT IRON	30 x 6 (1 1/4" x 1/4")	LENGTH 100
26	2			50
25	2			130
24	1			115
23	1			900
22	1			360
21	4			90
20	1			830
19	3			750
18	1	ANGLE IRON	40 x 40 x 4 (1 1/2" x 1 1/2")	LENGTH 3000
17	1			4000
16	1			1500
15	1			120
14	1			60
13	1			200
12	1			200
11	1			500
10	1			1000
9	1			45
8	1			180
7	4			TOWER PIPE DIA.
6	2			54"
5	2			1800
4	2			480
3	2			10.00
2	1			500
1	2			240

NO. 12
MATERIAL NAME REMARKS MEASUREMENTS

3 OF 7
HEADCONSTRUCTION - 12 PUS00 - WINDMILL

FOR INFORMATION:
Workgroup on Developmentstechniek
T.H. Twan - Vrijhof 152
P.O. Box 217 Enschede
The Netherlands



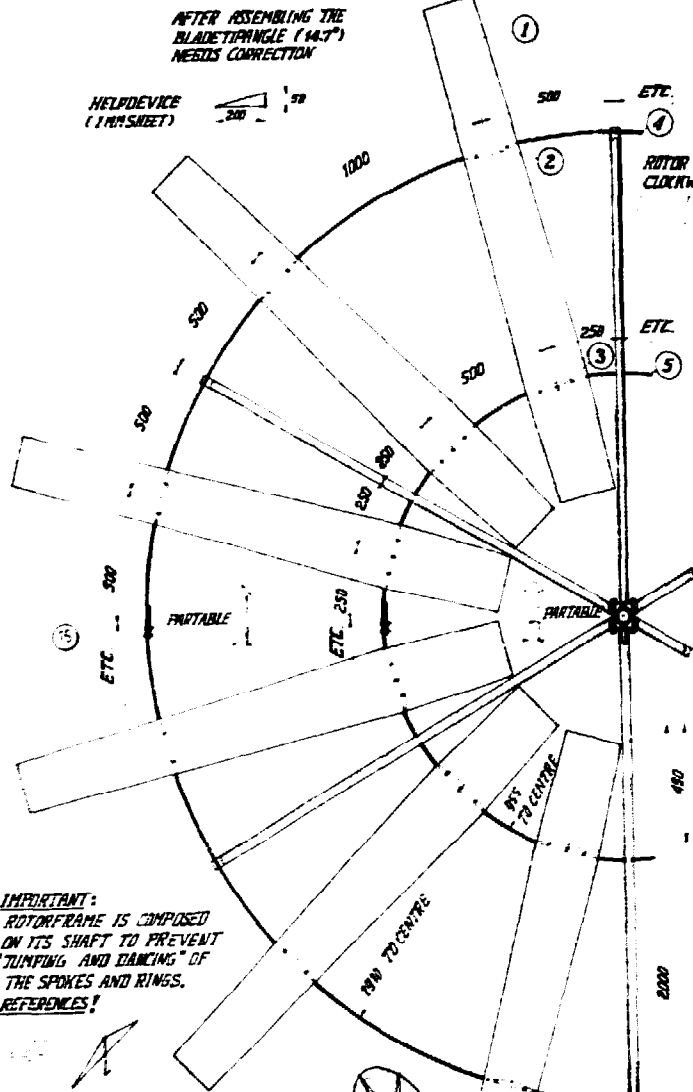
* AMOUNT OR SIZE DEPEND ON CIRCUMSTANCES

36	1	WOODEN PUMP ROD GUIDE	27 IN DRAWING NO.
35	2	CLAMP	ROD $\phi 12 (1/2") \times 370$
34	1	BOLT - NUT - WASHER	M12 $\times 20 (W 1/2 \times 1/2)$
33	4	BOLT NUT WASHER	M12 $\times 125 (W 1/2 \times 5")$
32	=	SPRING WASHERS	M24 (W 1/2")
31	=	NUTS	M24 (W 1/2")
30	=	THREAD STUD	M24 $\times 100 (W 1/2 \times 4")$
29	1	THREAD STUD	M24 $\times 150 (W 1/2 \times 5")$
28	=	GUN METAL BUSH	$\phi 33 \times 30$
27	=	STEEL BUSH	$\phi 43 \times 33$
26	1	PISTON	TEAK WOOD
25	1	GASKET	SOLE LEATHER $\phi 290 \times 6$
24	2	VALVE	$\phi 150 \times 6$
23	1	RING	ROD $\phi 8 (3/8") \times 870$
22	8	FILLING PIECE	$\times 40$
21	2	ANGLE IRON	40 $\times 40 \times 6 (1 1/2 \times 1 1/2) \times$
20	3	FLAT IRON	30 $\times 6 (1 1/8 \times 1/8) \times$
19	=		$\times 300$
18	1		$\times 450$
17	1		$\times 180$
16	4		$\times 60$
15	12		$\times 85$
14	1	FOOT VALVE	2 mm SHEET $\times 170$
13	2	CASING	500 $\times 900$
12	1	CASING FLANGE	$\times 290$
11	2	CASING FLANGE	$\times 290$
10	1	CYLINDER SEAMLESS	6" GASPIPE $\times 460$
9	1	DELIVERY PIPE	4" $\times 560$
8	=	SOCKET FOR	
7	1	T - SOCKET	4" \times
6	=	DELIVERY PIPE (EXTENSION)	4" \times
5	1	EXHAUST PIPE	4" \times
4	1	TOPPIPE	4" $\times 750$
3	4	PIPE	1/2" $\times 100$
2	1	PUMP ROD	3/4" $\times 950$
1	=	PUMP ROD EXTENSION	3/4" \times

NO	NUMBER	MATERIAL / NAME / REMARKS	MEASUREMENTS
6	OF	PISTON PUMP FOR 12 PUSOD WINZ III	
7			

FOR INFORMATION: Working on Development techniques
T.H. Tamsa - Vijet 122
P.O. Box 217, Enschede
The Netherlands

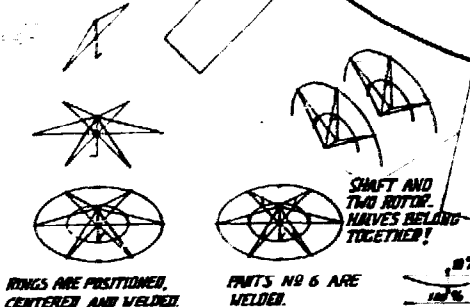
© 1980 WILLEMSTAD
FOOD FOUNDATION
AMSTERDAM
THE NETHERLANDS



AFTER ASSEMBLING THE BLADE TIP ANGLE (14.7°) NEEDS CORRECTION

HELP DEVICE (1 MM SHEET)

IMPORTANT:
ROTOR FRAME IS COMPOSED ON ITS SHAFT TO PREVENT "JUMPING AND DANCING" OF THE SPOKES AND RINGS. REFERENCES!

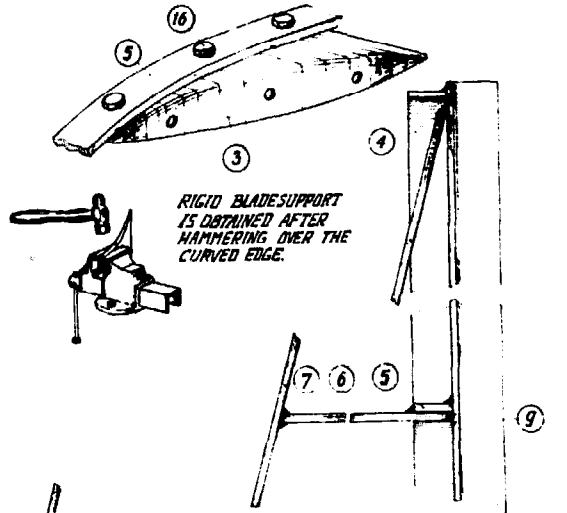
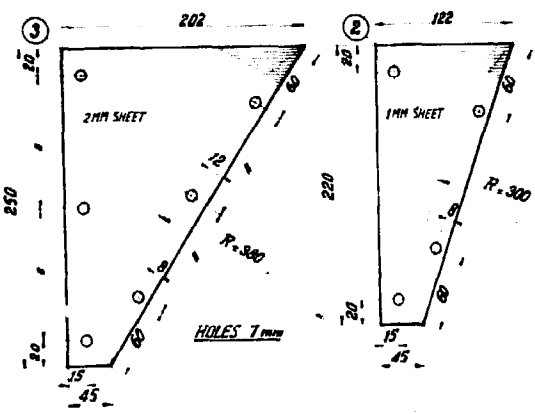
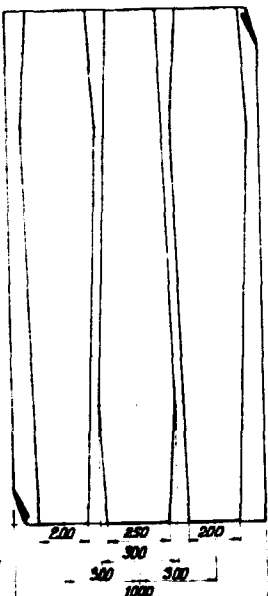


SHAFT AND TWO ROTOR BLADES BELONG TOGETHER!

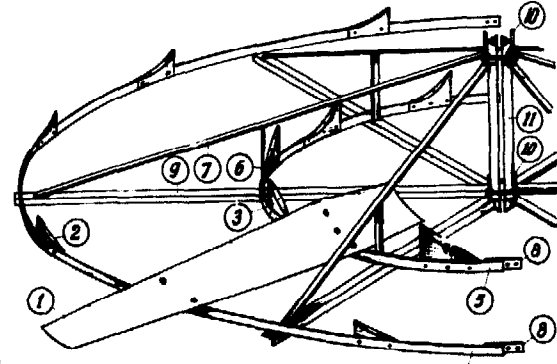
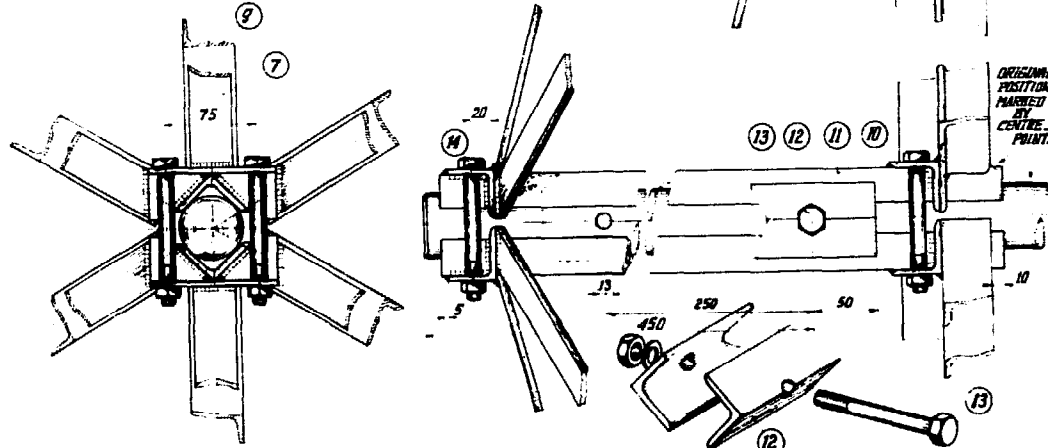
RINGS ARE POSITIONED, CENTERED AND WELDED

PARTS NO 6 ARE WELDED.

SHEET IS ROLLED IN A BENDING - RADIUS OF APPR. 900 mm AFTER CUTTING THE RADIUS IS CORRECTED SO THAT 10% CURVED AIRFOIL WILL RESULT.



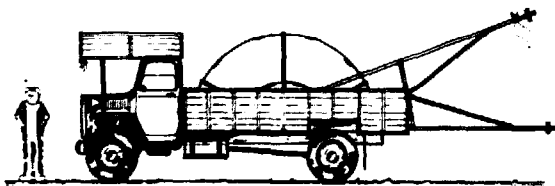
RIGID BLADE SUPPORT IS OBTAINED AFTER HAMMERING OVER THE CURVED EDGE.



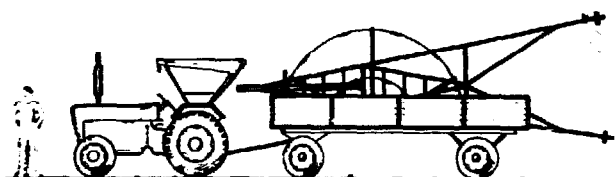
ONE OF THE BLADES IS MOUNTED ON A WELL POSITIONED SET OF SUPPORTS (AVERAGE MEASUREMENTS!) AND IS USED AS A DRILLING MOLD FOR THE OTHER 11 BLADES.

NO	AMPL	BER	MATERIAL/NOME/REMARKS/MEASUREMENTS
16	120		BOLT. NUT. WASHER 1/16 x 20 (1 1/16" x 3/4")
15	8		A10 x 25 (1/4" x 1")
14	4		M 12 x 100 (1 1/2" x 4")
13	2		M 12 x 125 (1 1/2" x 5")
12	2		ANGLE IRON 50 x 50 x 5 (2" x 2") x 350
11	2		40 x 40 x 4 (1 1/2" x 1 1/2") x 625
10	4		x 100
9	6		x 1500
8	4		FLAT IRON 30 x 6 (1 1/4" x 1/4") x 200
7	6		x 1900
6	6		x 250
5	2		x 5000
4	2		x 6000
3	12		BLADE SUPPORT 2mm SHEET
2	12		1mm
1	12		BLADE 4 STANDARD SHEETS 800 x 2000

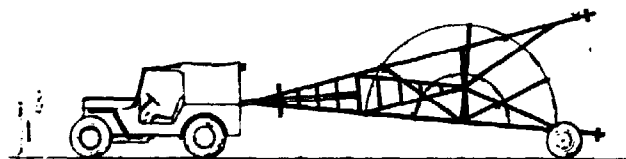
FOR INFORMATION: **ROTOR FOR - 12 PUS00 - WINDMILL (A-2)**
 Workshop on Dinovestmechanica
 T.H. Tuosto - Wipol 132
 P.O. Box 217, Eindhoven
 The Netherlands



TRANSPORT BY TRUCK

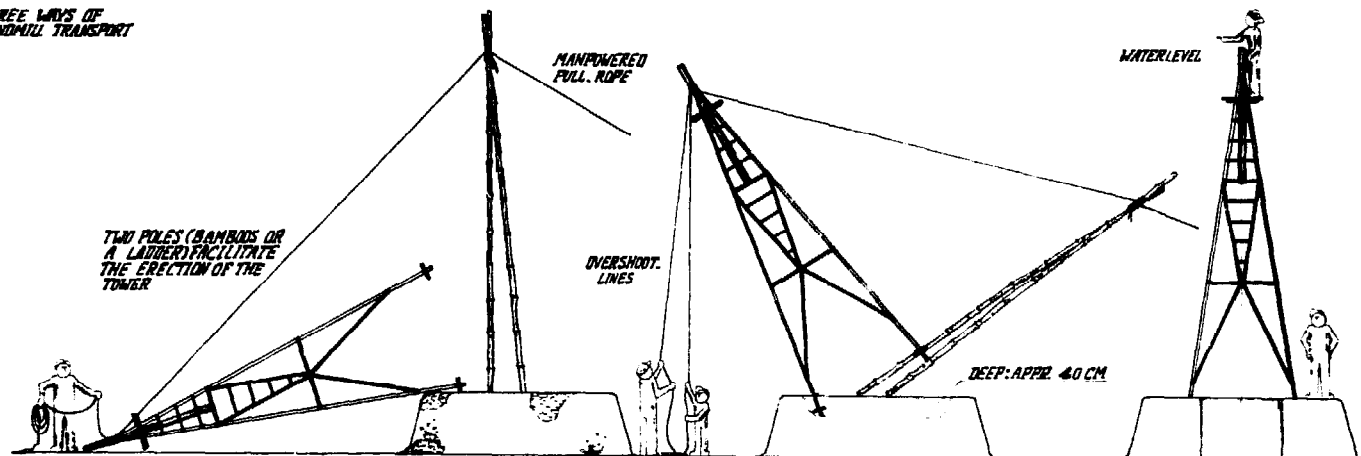


TRANSPORT BY TRACTOR AND DOLLY



TRANSPORT BY JEEP AND ROLLING HELP DEVICE

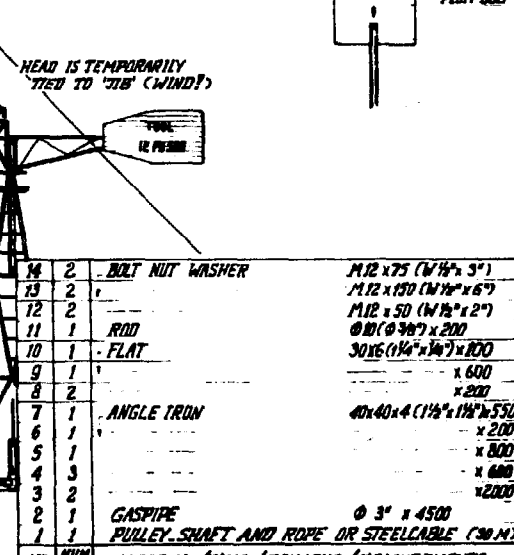
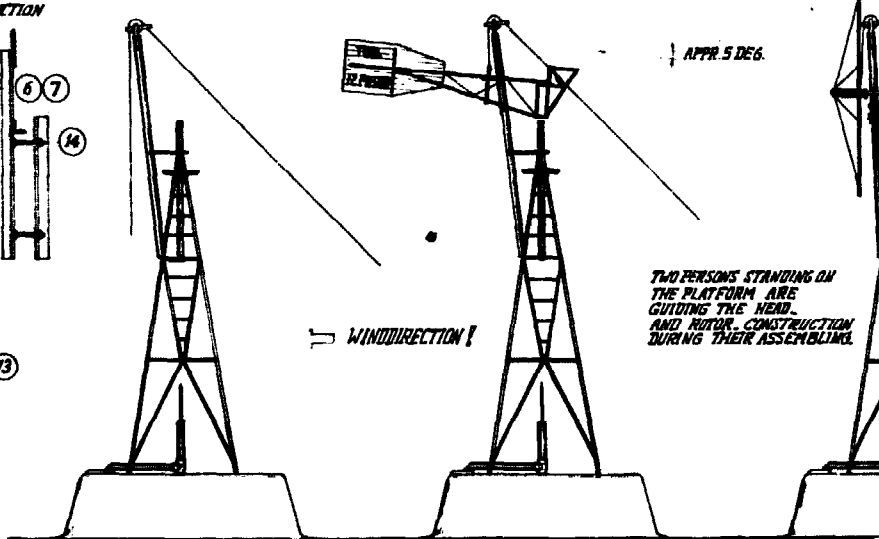
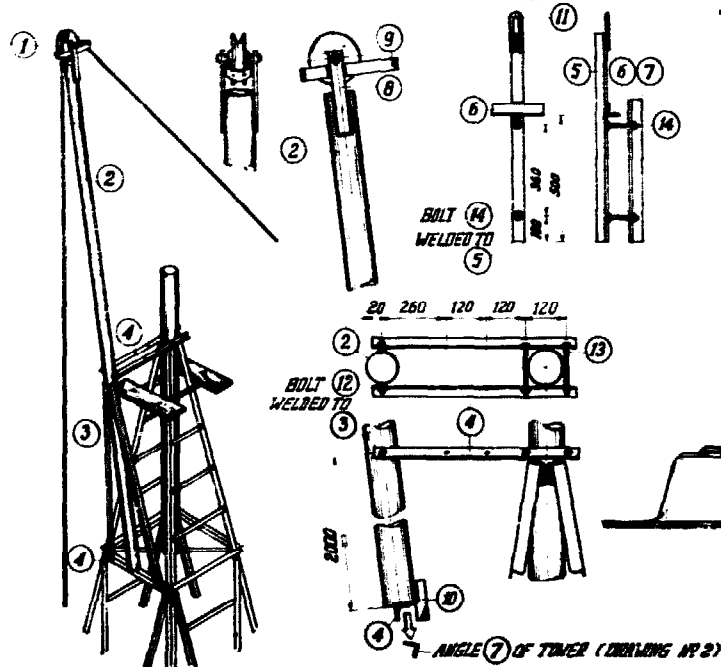
THREE WAYS OF WINDMILL TRANSPORT



IMPORTANT: AFTER PLACING THE TOWER THE TOWERLEGS ARE POURED IN WITH CONCRETE AND AFTER APPR. 5 DAYS THE HEAD AND ROTOR CONSTRUCTION CAN BE INSTALLED SAFE AND QUICK BY MEANS OF LIFTING DEVICES. DURING THE DRYING PERIOD OF THE CONCRETE FOUNDATION THE PISTON PUMP IS FIXED INTO THE WELL ACCORDING TO THE SPECIFICATIONS!

'718' LIFTING HELP DEVICE

LIFTING HOOK FOR HEAD CONSTRUCTION



Nº	NUM BER	MATERIAL / NAME / REMARKS / MEASUREMENTS
14	2	BOLT NUT WASHER M12 x 75 (M 1/2" x 3")
13	2	M12 x 150 (M 1/2" x 6")
12	2	M12 x 50 (M 1/2" x 2")
11	1	ROD Ø 80 (Ø 3 1/8") x 200
10	1	FLAT 30x16 (1 1/4" x 5/8") x 800
9	1	x 600
8	2	x 200
7	1	ANGLE IRON 40x40x4 (1 1/2" x 1 1/2" x 5/16")
6	1	x 200
5	1	x 800
4	3	x 600
3	2	x 2000
2	1	GAS PIPE Ø 3" x 4500
1	1	PULLEY SHAFT AND ROPE OR STEELCABLE (30.14)

SINCE THE CENTRE OF GRAVITY OF THE HEAD CONSTRUCTION IS SITUATED ABOVE THE UPPER TAIL ANGLE A SPECIAL LIFTING HOOK IS APPLIED. A SMOOTH SLIDING OVER THE TOWER PIPE IS ACHIEVED IF THE FRONT IS OUT OF BALANCE APPR. 5 DEGR.

ROTOR IS LIFTED WITH THE SHAFT COMPLETE WITH BEARINGS FIXED IN THE ROTOR HUB IN ITS ORIGINAL POSITION (CENTRE POINTS!) AND FIXED ON THE HEAD CONSTRUCTION. NOW THE '718' CAN BE REMOVED AND THE BLADES, SAFETY DEVICE AND MOVING PARTS ARE ASSEMBLED.

FOR INFORMATION: Workshop on Developmentstechniek T.H. Tuinman - Wijk bij Duurstede P.O. Box 217 Eindhoven The Netherlands

INSTALLING THE WINDMILL -- 12 PU 500 --

3. Test-Rig for 12 PU 500 Windmill

In the past the development of windmills took place on the site itself where they have been installed which created a lot of inconvenience with regard to breakdowns and repairs. It will be evident that such a procedure of technical development takes a lot of time and moreover the image and popularity of the technology might be degenerated due to failures. Therefore it is advisable to simulate the practical conditions in such way that the development-process is done in a shorter time and under heavy conditions without being dependent on the fluctuating and unreliable wind. So the idea was born to get a Test-Rig developed in which the essential parts of the windmill can be tested thoroughly. This activity was carried out in the Research and Development section at the Polytechnic in Allahabad.

3.1 Demanded features of the Test-Rig

Since the 12 PU 500 Windmill (12 blades Pumping Unit of 500 cm Rotordia) proved to be the most applied windmill so far the urgency of developing its essential components is favourable. On the other hand results extracted from these tests can be extrapolated usefully for other windmill types like 12 PU 250, 12 PU 350 and 12 PU 700 Windmills which are under development too. Therefore it has been decided to get the Test-Rig developed for testing the parts of the 12 PU 500 Windmill. Considering the structure of the essential moving parts and Pump of this particular windmill, testing of the following parts should be carried out with regard to wear and tear:

- Main shaft bearings
- Crank Pin
- Cross Pin
- Cross head / P.V.C. - insert tower pipe
- Wooden pump-rod guide situated in the lower end of the towerpipe.
- Pump-rod guide (Bronze and Nylon).
- Leather sealing / pump rod
- Piston / Cylinder

- Leather valves (Piston-Foot-Valve).
- Joint between tower pipe and rotating head construction.

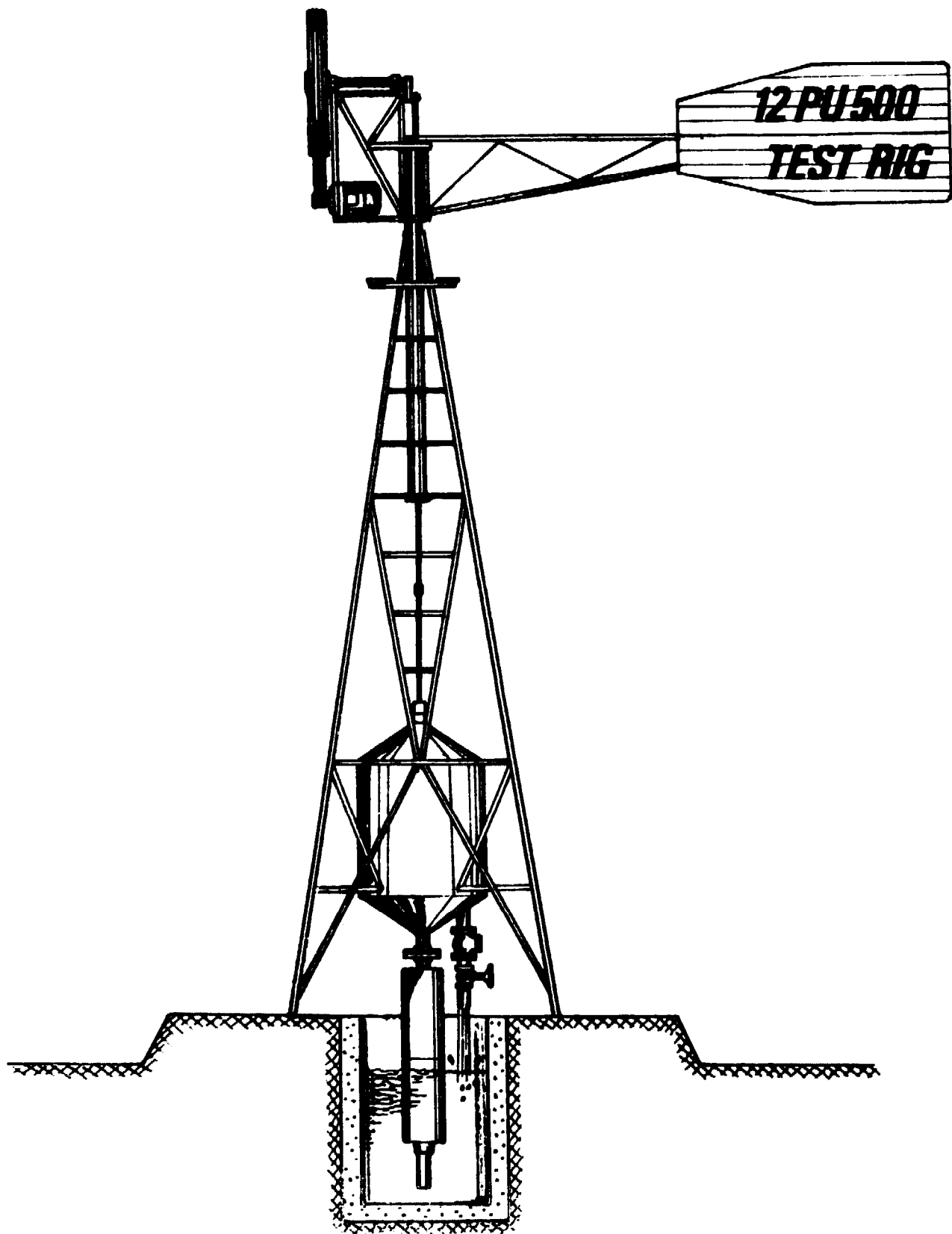
Actually there is no need of testing the rotor with regard to wear and tear, though fatigue cracks might occur. Field experiences showed that fatigue cracks had been developed right in the inner ring bladesupports which were made according to the first designs. The improved bladesupport proved to be sufficiently resistant with regard to fatigue and no failures appeared anymore. In this context there is no need to have the rotor tested.

Actually a normal 12 PU 500 Windmill installation provides the entire structure for a Test-Rig. Instead of the rotor a flywheel, which is driven by an electric motor, should be installed in order to obtain a regular drive to the fluctuating loaded mainshaft.

3.1.1 Drive of the Test-Rig

To estimate the required R.P.M.-number for the Test-Rig we consider the 12 PU 500 Windmill under extreme conditions. In practice the maximum R.P.M.-number does not exceed the value of 120 since the windmill is locked in secured position automatically by means of its automatic security device. This R.P.M.-number represents a reasonable value for testing pumps and the moving parts of the windmill.

Applying an electric motor for the drive a reduction of 1:12 is needed in the transmission. This is simply achieved by applying a V-belt transmission (directly) from motor pulley to the circumference of the flywheel. In practice the nominal diameters of pulley and flywheel turned out in 70 and 850 mm respectively while three V-belts (B-type) completed the transmission. The required power of the electric motor has been estimated at 4 K W.



3.1.2 Selfmoving head construction

In normal condition the head just rotates if the wind-direction changes which means that in the long run wear and tear might be expected in the joint of the tower-pipe and head-construction. This rotation is made by piston and cross-head as well.

However, the tests should be carried out under laboratory conditions independently from appearing winds and wind directions. This implies that the rotation of the head construction should be simulated by forcing the head to carry out this movement regularly.

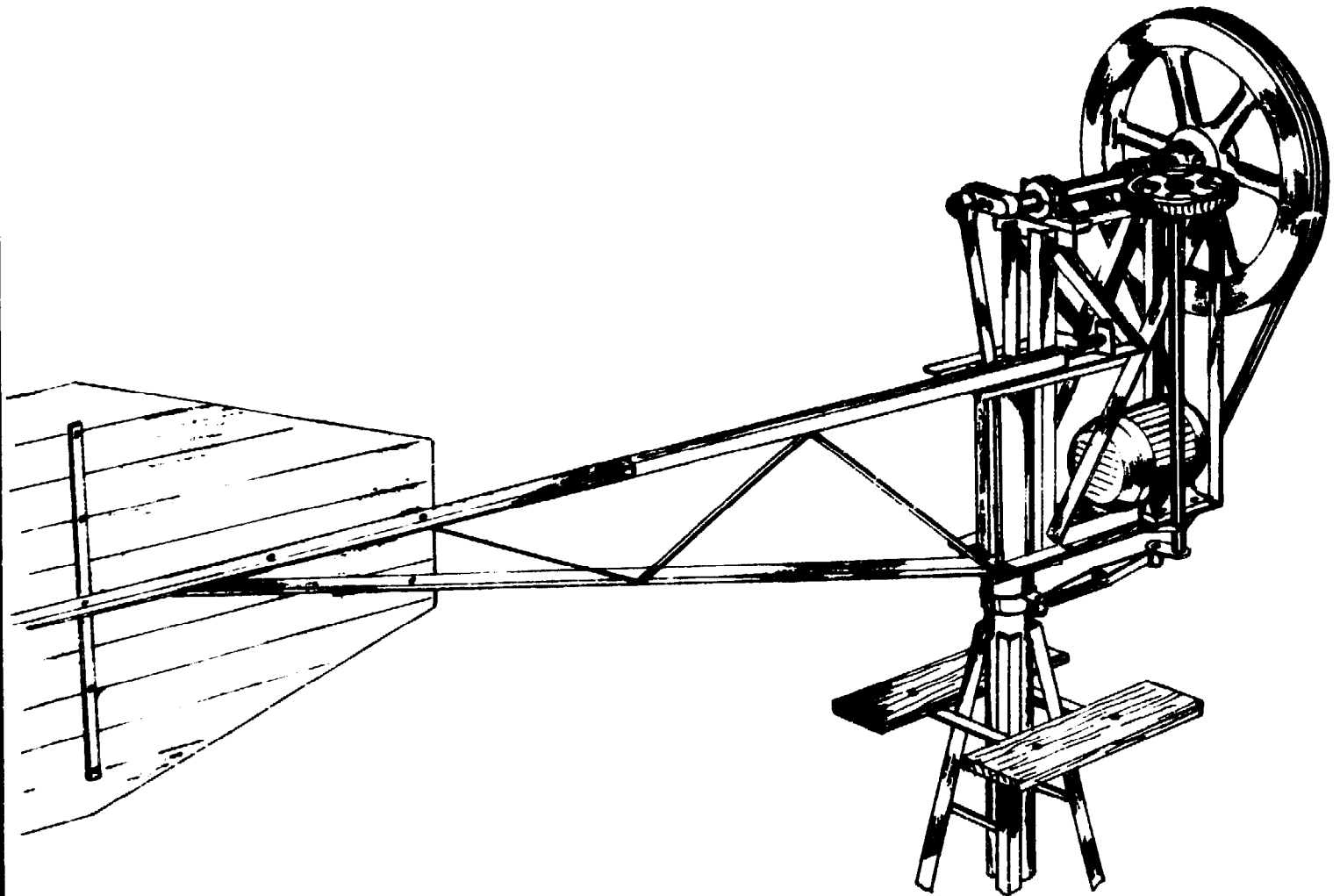
In practice it is very rare that the head rotates more than 180 degrees while in most of the cases swinging movements within a certain range of some degrees occur for a certain wind direction. Actually this is the worst condition from point of view of wear and tear since still the same part of the bearing surface (here: tower-pipe) is carrying the load.

So an attractive simulation seems to be achieved by forcing the head to swing to and fro around the tower pipe within a certain range, of degrees. This cycle should be carried out not too quickly and not too slowly but in such a way that the lubrication properties of the bearing are the same as under normal field conditions. However, it is quite difficult to quantify and to extract the required movement from the latter mentioned: wind patterns are different from place to place and from time to time.

As a compromise it has been decided to swing the head construction to and fro within the range of plus and minus 45 degrees (total swing 90 degrees). In order to obtain this movement a small crank is driven by a worm-wormwheel-transmission (1:80). The latter is fed by the main shaft (120 R.P.M.) on which the worm is fitted.

The crank is linked to a joint of the tower by means of a con-

necting rod. This mechanism forces the head construction to swing over the tower pipe. One cycle is completed in 40 seconds while this motion appears to be quite "natural".



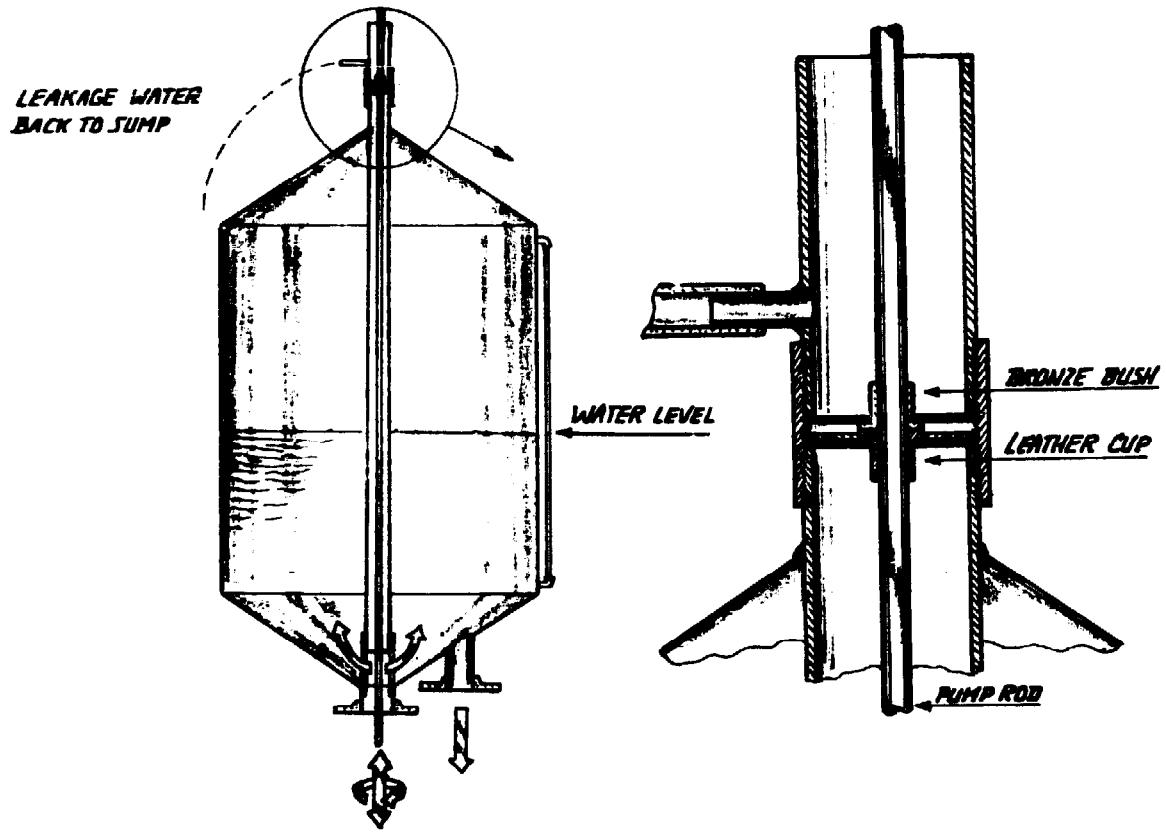
3.1.3 Simulation of the elevation head

In practice the windmills lift water over several elevation heads up to 20 metres or even more. Then the dimension of the pump applied depends on the actual head. Pump dimensions in the 12 PU 500 serie are: 3", 4", 5", 6" and 8" (piston diameters.) It is expected that, as far as pump-testing is concerned, this range of elevation heads should be applied during these tests.

In laboratory conditions it will be possible to simulate the elevation -heads by applying long pipe-lines leading to an overhead tank which should be situated on several levels.

This method is expensive and it creates quite a lot of inconvenience with regard to installation and of course it will not be practical.

Simulation can be carried out in a simpler way by pumping the water from a sump (bottom basin) and getting it delivered into an air-tight vessel where a static pressure persists. This pressure simulates the elevation head and it is built up by compressing the existing air which remained above the water table in this vessel. The latter is achieved by restricting the exhaust opening at its bottom-side by means of an adjustable valve over there. Its resistance causes the required pressure to get the actual water flow forced through it, back into the sump.



The main advantage of this system is that it is compact to be built. However its disadvantage is that the inertia-effects and pressure losses, which normally appear in long and narrow pipelines, are not simulated since they are not there. Instead the colossal vessel with compressed air is there which provides a huge air receiver which acts as an capacitor

equalizing the irregular water delivery from the single acting piston pump. Therefore it is advisable to consider this air pressure not to be the static elevation head (geodetic head) but the actual hydraulic head! The latter is known as static head plus the pressure losses.

The pressure vessel is situated in center of the Test Rig-tower in order to integrate it with the entire structure. The tower provides suitable attachments for the suspension to the several lattice joints. However a practical problem has to be solved with regard to the leading of the pump rod through the centre of the tank since its airtightness is most essential. This implies the application of a pump rod sealing which should not permit any leakage of air. The latter is achieved by applying a pipe in centre of the tank which bottom ends under water surface. On its top portions the pump rod sealing is situated. In this way air leakage is avoided in case the sealing proves not to be perfect since in that case only water-leakage will appear without any effect to the functioning of the airchamber.

3.1.4 Instruments

In order to run the Test Rig in a proper and safe way and to gather information with regard to lifetime and efficiency of the pumps to be tested, several instruments have to be applied.

These instruments are:

- Switch and relais box
- Amps meter and KWH-meter
- Water meter
- Revolution counter
- Pressure gauge
- Water level gauge

Switch and relais box

Besides the application of a main switch box it is preferable to have a relais box installed. Purposes of this device are:

- Switching-off the remaining phases if one of the phases is lacking due to power cuts. (If this is not done in time the electric motor will burn definitely.)
- Switching-off the electric motor in case one (or more) of the phase-currents exceeds an unacceptable value. (By means of thermo-elements.)
- To enable the operator to start and stop the Test Rig by a "simple push of the button". The actual switch is made by the relais.

The relais box is attached to the head construction of the Test Rig in order to obtain a short multi wired connection to the electric motor. This also means extra safety since the Test Rig can only be started by the operator which is at the machine itself; so the machine can not be started from ground level while an operator is carrying out some job at the top of the Test Rig. In case of emergency the machine can always be stopped at ground level by using the main switch.

Amps meter / KWH-meter

It is advisable to have an Amps meter installed in order to detect any overload. Moreover the Amps-meter provides information to what extent the machine is loaded.

The same applies for the KWH-meter (3-phase) which counts the amount of energy which has been consumed to drive the test pumps under different conditions.

Till a certain extent this power consumption can be derived for the specific pump under the specific conditions.

Water-meter

This instrument measures the total amount of water which has been delivered during the pump tests. This reading is most essential in order to calculate the volumetric efficiency of the test pump. The Water-meter is situated in between the pressure tank and the adjustable valve through which the water is

flown back into the sump.

Revolution counter

The revolution counter registrates each revolution of the main shaft. Its counting is essential for calculating volumetric efficiency and judging lifetime features of the test pump and moving parts as well.

Pressure gauge

As mentioned before the pressure in the tank represents the total hydraulic head, which is indicated by the pressure gauge.

Waterlevel gauge

It is advisable to indicate the actual waterlevel in the pressure vessel. This in order to detect any leakage of air which will lead to a decrease of the capacitor effect of the air-chamber resulting in a "hammering" run of the machine. Under static conditions the waterlevel gauge also provides a (rough) indication of the actual pressure in the tank.

3.1.5 Way of testing

Running the Test-Rig is done in day-time (working hours) in order to have a close look at the experiments. Day by day the following readings are taken and noted:

- Water passed through water-meter.
- Number of revolutions indicated by counting device.

These readings provide the information for calculating the volumetric efficiency. (See next chapter.)

Pumps to be tested (4" - 5" - 6") are run at 15, 10 and 7 metres head respectively simulating the hydraulic heads.

Adjustment of this head is achieved by tuning the adjustable valve situated in the return-flow. One should be aware that this adjustment is "tricky" for the following reasons:

- Its initial adjustment is quite a time-consuming procedure which is achieved by regularly made check-ups and re-

adjustments of the valve.

- After some time the features of the test pump change resulting in higher out-put (setting of valves) or lower output (wear) with the effect that the equilibrium of the system is going to be disturbed. Hence the regular check-ups are necessary too in order to give re-adjustments if needed.

The pumps are tested for at least one million revolutions while recording wear and tear and calculating volumetric efficiencies is done at certain intervals. The out-come of these will provide the information to base conclusions on.

3.2 Pumps to be tested

Since the completion of the Test Rig (March 1980) four types of pumps have been tested each for one million revolutions.

The test pumps were:

- 4" S 500
- 5" SS 500
- 6" P.V.C. 500
- 6" S 500

Each pump has been tested turn by turn during cycles of 250,000 revolutions loaded at hydraulic heads of 15, 10 and 7 metres respectively. At the end of each experiment of 250,000 revolutions the pumps have been checked up (and revised, if necessary).

In these check-ups the qualification of wear proved to be rather complicated. This in the sense that e.g. play of piston/cylinder and pumprod/pumprod guide are difficult to measure and to define due to unroundness of the several parts. Although initial unroundness exists in the cylinder (black pipe, P.V.C. pipe) and pump rod (gas pipe) which are acceptable (from the point of view of Appropriate Technology) wear and tear seem to cause an extra unroundness to these

particular parts. No doubt that the latter develops due to improper alignment of the structure and slight bends in the pumprod sections, (which is always the case in practice). In order to judge the extent of wear of the parts in such cases the non-measurable qualifications have to be expressed in degrees.

3.2.1 The 4" S 500 (Type I, see chapter 2)

This type of pump has been designed and introduced in the beginning of 1980 as a deepwell-pump. (Applied for the first time at Gohri.)

It consists of two main sections as follows:

- Topsection: composed of 2 mm steel casing, delivery pipe, top flange and pumprod guide.
The latter contains a brass guide bush.
The space between the delivery pipe and the casing provides the air pressure chamber.

- Bottom section: Composed of 2 mm steel casing, steel cylinder, top- and bottom-flange, wooden foot valve body and leather foot valve.
The wooden sealingless piston has a proper fit in the cylinder which has been honed by means of a simple honing device.

Though the nominal cylinder diameter is given in 4" the exact diameter amounts 106.6 mm. (Actually such deviations also exist for 5" and 6" pumps.)

The eight holes in piston and footvalve body are situated at a pitch circle of 0.65 D and the diameters are 0.2 D.

This has been standardized for all the pumps.

3.2.2 The 5" SS 500

Basically this pump is of the same construction as the former though the construction of the footvalve differs and the piston has been fitted with a P.V.C. piston ring. These special arrangements provided the "special" label to this test pump hence an extra S has been taken up in its code number.

Its foot valve arrangement consists of a wooden footvalve body and a 2 mm steel disk which has been lined with leather. This disk contains a steel hub which slides over the central bolt of the valve arrangement and is pressed to the valve body by a spring.

Since the rigidity of this valve disk does not provide the "Umbrella-effect", if opened like the elastic leather valves have, extra "flow round" space had to be created. This has been achieved by constructing a wider bottom part (of 6") to the 5" cylinder. Hence the outside dia of the wooden foot valve body has been made at the nominal dia of 6" but of course the hole-arrangement (dia, and pitch) refers to the actual 5" cylinder dia.

As an experiment the piston has been fitted with a PVC-ring which should act as a sealing. This 8 mm wide ring has been cut from a 6" PVC-pipe and is situated in a groove in the wooden piston. This experiment could provide lifetime information of such a sealing.

3.2.3 The 6" P.V.C. 500 (Type H, see chapter 2)

This pump, known as the "combination pump", has been developed in Ghazipur (1979) and proved to be of a quite satisfactory design. It consists of a Top - and a bottom - section.

- Top section : Composed of a 6" PVC-pipe (1.20 m long), top flang and delivery pipe. The latter carries the pumprod guide (nylon). Here

also the space between delivery pipe and PVC cylinder creates the airchamber. The wooden sealingless piston runs in the PVC-cylinder with a proper fit.

- Bottom section: Composed of a 6" PVC-pipe (0.75 long), wooden footvalve body and leather valve, PVC (4") airchamber and bottom flange.

Both sections are jointed by means of 4 anchor rods.

3.2.4 The 6" S 500. (Type J, see chapter 2)

As a matter of fact this pump is basically the same as the other steelpumps. Only the foot valve differs: which is made of a sheet-iron disk in stead of wood. Therefore this pump is shorter in total length resulting in a more economical use of sheet materials during its fabrication.

3.3 Test results

The schemes given on the next pages show results of the check-ups made after each interval of 250,000 revolutions.

As mentioned earlier quantifying the extent of wear proves to be quite difficult with the result that judgements are given in degrees of wear.

The first 250.000 revolutions

During this test interval it is found that the brass pumprod guide showed a better performance than the nylon one. The latter already wore out in an oval shape which was already visable. The leather valves functioned without any breakdown and developed a good setting to their wooden counter-parts. In contradiction with the expectation the disk-valve of the 5" SS 500 developed a good setting too, though its "steel to steel" slide of its disk-hub over the central bolt showed some wear. The fit of the wooden pistons in the steel cylinder remained proper in the sense that some jerking fit in

some positions persisted. In the PVC-pump the fit already got so loose that some play between cylinder and piston could be seen.

The PVC piston ring, applied in the 5" SS 500, wore rather seriously. The tips of the ring became sharp like a razor blade. Moreover the wear was not uniform; the thickest portion of the ring (4.0 mm) hardly showed any wear (approx. 0.2 mm) while the thinnest portion measured 1.4 mm. It has been decided to stop the experiments with the PVC ring for the time being till the cylinder surface has been polished thoroughly by the plain piston after some newly undertaken experiments. Probably a longer life of the ring would be achieved then.

After the first 500.000 revolutions

Still the brass pump-rod guides show a good sliding fit as well as the piston / steel cylinder combinations. All these moving parts showed nicely polished surfaces.

The fit of the piston in the PVC-pump showed an increased play. Though difficult to measure, its play is estimated at 2mm while a clear edge in the PVC is detected at the end and beginning of the track of the piston. Most probably due to the initial unroundness of this PVC-cylinder the piston seemed also to be worn off which is proved by a loose fit of it in an unused part of the cylinder.

The nylon pumprod guide showed increased wear. Estimated play of pumprod 1 ± 2 mm.

The valves continued functioning well. Though once the central nut of the leather foot-valve of the PVC-pump ran loose (due to poor fixation). Obviously the hub of the steel disk-valve as well as its central bolts showed no increase in wear. Probably its combination developed a good "run-in".

After the first 750,000 revolutions

The brass pumprod guide still shows an acceptable fit while the nylon guide wore out in an oval shape causing an estimated play of 2 mm.

All valves are in good condition except the leather foot-valve of the PVC pump which developed cracks due to fatigue so it had to be replaced.

The piston / steel cylinder combinations are about to show the first wear, though not simple to quantify (say 0.5 mm play). It is assumed that wear in the steel cylinders (if any) is to be neglected: the inside surfaces just show nice polishing.

The experiment with the PVC piston ring failed again : at approx. 650,000 revolutions (so this ring just run approx. 150,000 revolutions) the ring wore off that much that it slipped in between the piston and cylinder.

This caused that the wedged piston has been pulled up to its upward position with such a force that a cleavage fracture occurred in the cross-head and the connection rod had to collapse during the downward stroke. (Fortunately the Test-Rig could be stopped immediately.)

The experiments have been continued again after removing the badly deformed ring.

After the first 1,000,000 revolutions

The brass bushes show detectable wear which is still acceptable, but the clearance between pumprod and nylon guide was increased up to 3 mm.

All the piston valves as well as the foot-valves were still in good condition. However, in the 5" SS 500 the spring, applied at the top of the disk-foot valve, broke (after approx. 860,000 revolutions) and had to be replaced.

3.10
Clearance in the piston / steel cylinder combinations was detected now and it had been estimated at approx. 1 mm. On the other hand the clearance in the 6" PVC 500 increased to more than 2 mm.

3.4 Volumetric efficiencies

All the pumps showed a decreasing volumetric efficiency with increasing number of revolutions. Obviously this is due to wear of piston and/or cylinder. Although in two cases (5" SS 500 and 6" PVC 500) considerable wear has been detected still the volumetric efficiencies exceed 75% for the 4" S 500, 80% for the 5" SS 500 and 80% for the 6" PVC 500 and 6" S 500 respectively.

In all cases the decreasing behaviour of the volumetric efficiency does not seem to be due to malfunctioning of valves, since their condition did not change during the 1-million revolution tests.

It is hard to make a comparison between the pumps based upon the registered volumetric efficiencies since relative leakage will depend upon size and pressure.

Moreover taking this in consideration, it seems that the steel cylinders show better performance than the PVC cylinder as far as volumetric efficiency is concerned. Next pages show the test results, which are calculated from the readings during 50,000 revolutions in intervals of 100,000 revolutions.

3.5 Conclusions with regard to life time- features of the test pumps

It will be clear that pump testing to one million of revolutions just provide modest information with regard to life-time features of the pumps.

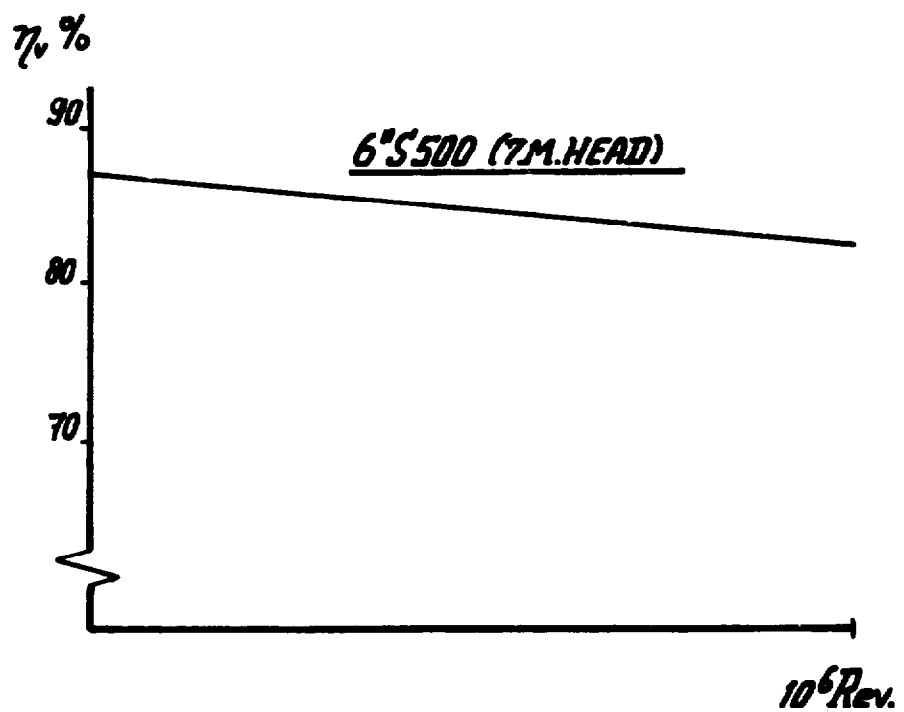
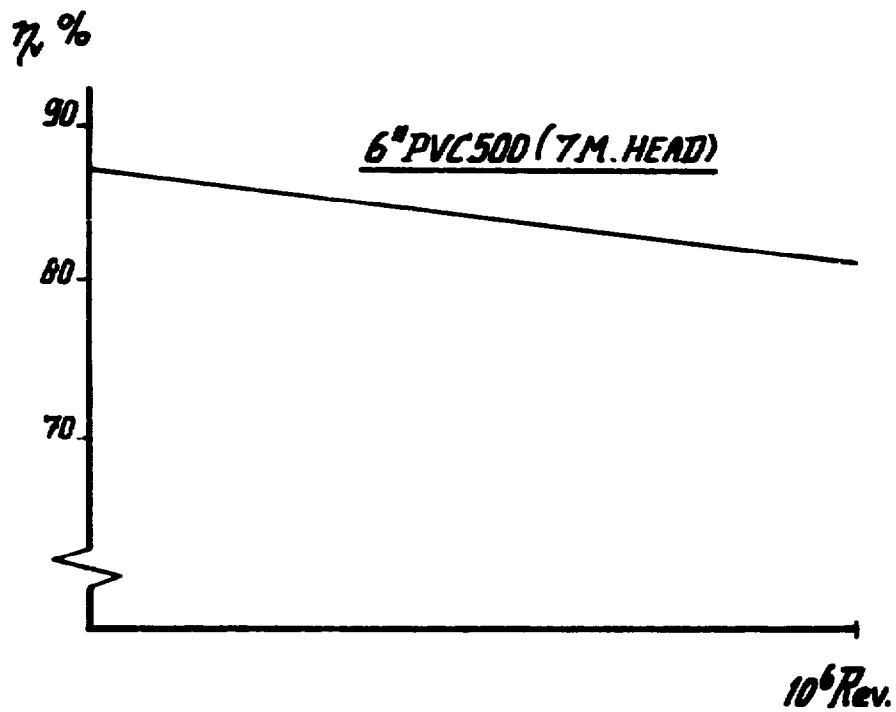
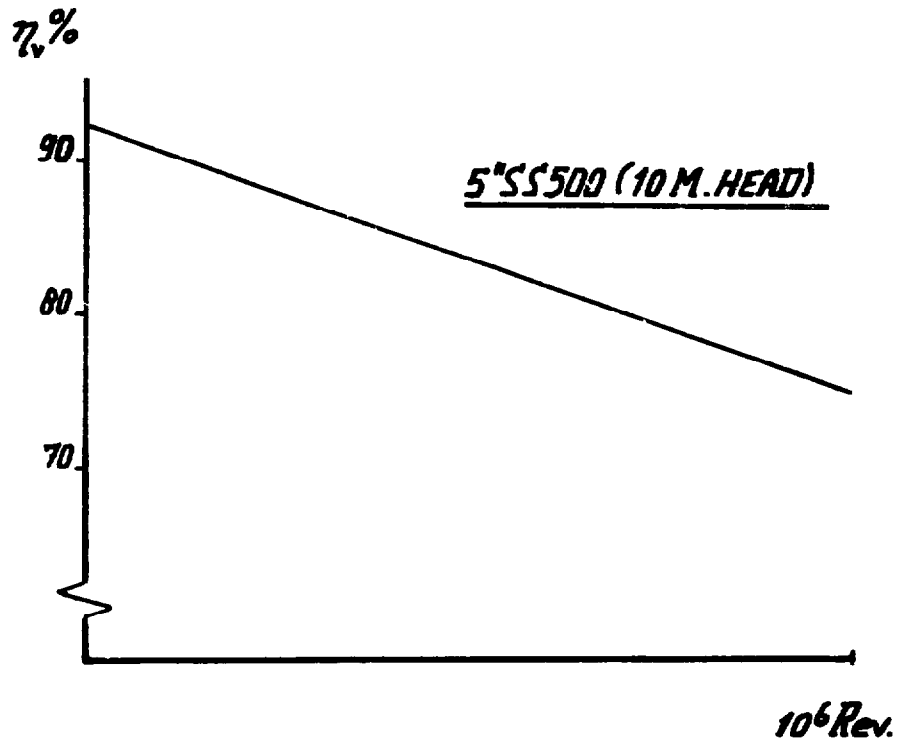
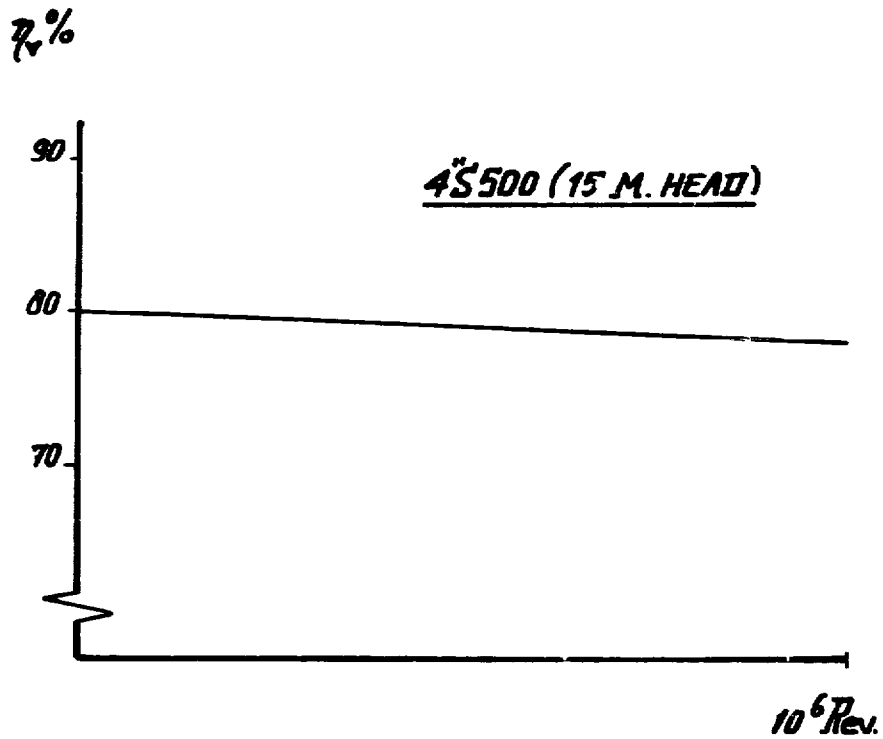
Though further testing should be applied, yet some conclusions can be drawn as far as the test results have provided obvious information.

- The combination of a wooden piston and PVC-cylinder can not compete with the wooden piston/steel cylinder combination.
- Nylon Pumprod guides show a much quicker wear than those made of brass.
- A PVC-ring hardly covers a life of 250,000 revolutions while it creates risks for the moving parts of the windmill (here: Test Rig) if it slips in between the piston and cylinder.
- The application of a spring on top of the foot-valve (here: 5" SS 500) might fail due to fatigue (crack of the spring), causing damage to piston/cylinder combination.
- Leather valves, as applied so far, proved to be quite reliable though one should apply a good quality of processed leather (sole-leather). The main disadvantage of leather is that after it has been dried its elasticity is gone and fatigue sensitivity increases.

After testing four pumps (each during one million revolutions) the Test Rig completed another one and a half millions revolutions which should provide some significant information. As a matter of fact it drove pistons up and down covering a total distance of almost 3000 kilometres. The head construction was forced to swing to and fro more than 65,000 times in order to create the possibility to study the wear between tower pipe and head.

In this stage the following conclusions are drawn with regard to life time features of the moving components of the 12 PU 500 windmill.

- No visible wear has been noticed in radial sense in the joint of tower-pipe and head. In axial sense the head just sank approx. 0.5 mm during the run-in period. Obviously after setting of the contact surfaces no additional wear appeared.



It is concluded that the joint will serve the purpose persistently.

- The bearings of the mainshaft (N.B.C.-double roller, self-aligning) did not show any defects or play, while no additional lubrication was applied.
 - Though once, the crosshead had to be replaced (cleavage due to jerking piston) its bearing properties in combination with the P.V.C.-towerpipe-lining seemed to be excellent. However, still the tests should be continued in order to find out to what extent wear will develop in the long run.
 - The nylon bearing bushes in the connecting rod did not show any wear of relevance. Neither did the cross- and crank pin.
- Though these results appear to be promising it is understood that in a suitable windy area the 12 PU 500 windmill runs in the range of 500,000 up to 1,000,000 revolutions per month. Hence the experiences, gathered so far, just represent such a windmill during the first three up to six months of its lifetime. In this regard these achievements should not be seen as a milestone, but rather a beginning.

4. Properties and characteristics of the 12 PU 500.

As mentioned in the first chapter the windspeeds in Ghazipur are rather low and actually the windmill should be sufficiently adapted to these circumstances in order to utilize the little available windpower in the most efficient way. The size of the piston pump (piston dia. and stroke) as well as the elevation head are the most important parameters in the windmill installation which define the starting windspeed (cut-in windspeed) and the design windspeed. The latter is the windspeed for which the maximum overall efficiency is obtained.

4.1. Input-Output relations, volumetric- and overall-efficiency.

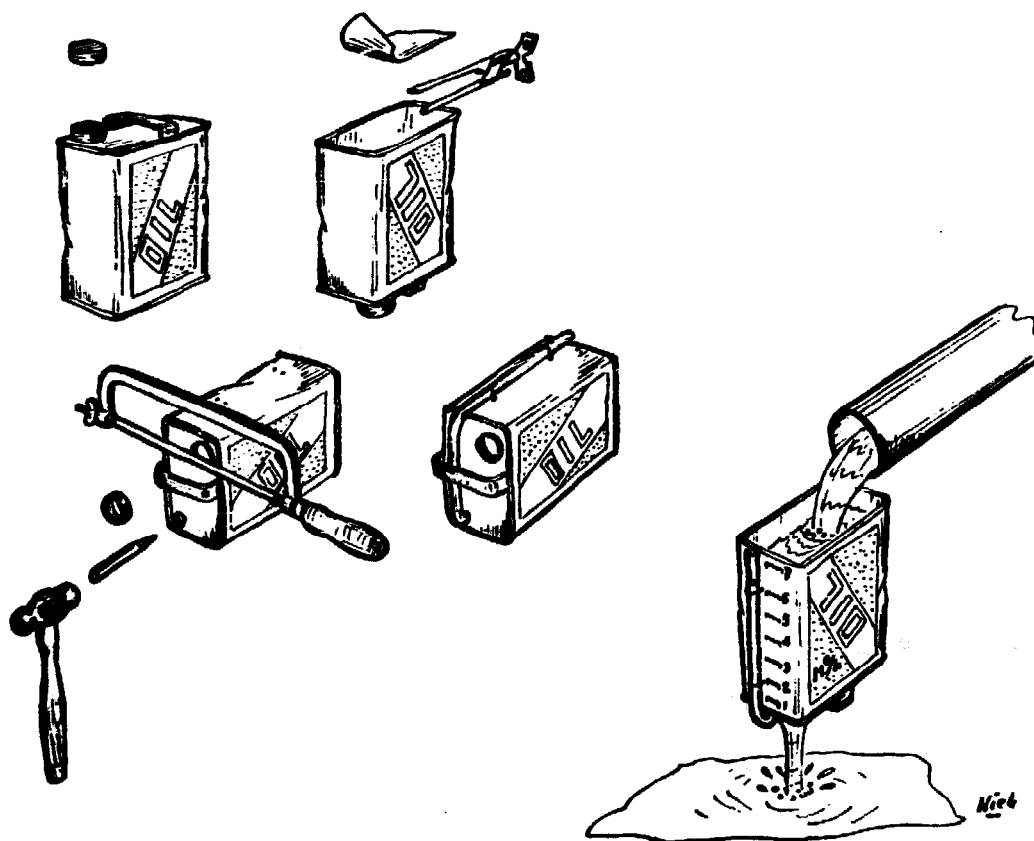
Considering the total windmill installation as a converting-system the relationship of input and output is interesting with regard to its efficiency, its capacity and the economics. The applied measurement equipment at the R.T.I.-windmill was not suitable for the definition of the input-output relationship since the windspeed is monitored interval-wise while the R.P.M.-number and output of the windmill was fluctuating continuously due to changings in the windspeed.

Accurate readings can just be taken if the circumstances are stationary which means that the windspeed as well as the R.P.M.-number are constant while the flow measurement is taken. These data will provide a relation between input and output and the required instruments are:

- anemometer
- R.P.M. counter
- flowmeter

Although these instruments were available the above mentioned measuring could not be carried out satisfactorily. In particular the flow measurements proved to be rather inaccurate due to the irregularity of the water delivery of the single-acting piston pump.

Therefore some efforts have been undertaken in developing a simple flowmeter and finally two flowmeters resulted. The first one consisted of a simple 1-gallon oilcan. The flowing water enters the open bottomside and is released through the screw-top-opening. The static waterlevel in the can will represent the actual flow which is indicated by a "gauge-glass" simply made from a plastic hose. These oilcans are standardized so a similar flowmeter can be made in any place of the world, but its use is restricted to a maximum flow of approx. $7 \text{ m}^3/\text{hr}$. Moreover an irregular flow causes considerable errors since this instrument reacts rather slow and airbulbs spoil the readings depending on the way of entrance of the water.



The second device of flowmeasuring consisted of a shallow basin in which the flow enters the back-side and leaves this basin on the other side via a V-notch. The static waterlevel in the basin also represents the actual flow according to several theoretically defined tables. Unfortunately this equipment did not serve the purpose very well. The phenomenon of slowness, due to the large volume, caused that this device acts too late in order to determine the actual output.

So both measuring devices failed because the slowness in indicating made these "instruments" unsuitable for direct flow registration.

Due to this another way of flowmeasuring has been developed: in a period of constant windspeed and constant R.P.M.-number (audible) a 20 l. drum is shifted under the output opening of the pistonpump during the downward -stroke (no output!). At the same time a stopwatch is switched on and from that moment on the number of strokes is counted (e.g. four or five). Then during the downwards-stroke again, the drum is removed quickly and its contents will amount to the delivery of four (or five) strokes. The timespan, registered by the stopwatch, the windspeed and the amount of water delivered will provide sufficient information in order to calculate respectively the input-output relation, the volumetric efficiency and the overall efficiency.

The above mentioned method proved to be the most accurate and reproductive way of measuring.

In the following table the results (screened) are printed of the first measurement which have been carried out in May 1978.

Dia. pump: 132 mm.
 Stroke: 254 mm. (10")
 Elevation head: 6.5 m.
 Pumptype: A (see pistonpumps)

V (m/sec.)	n (R.P.M.)	Φ (dm ³ /sec.)	η_v —	η_{tot} —
2.5	14	0.6	0.74	0.21
3.0	25	1.2	0.83	0.24
3.5	31	1.6	0.90	0.20
4.0	37.5	2.0	0.93	0.16
4.5	43	2.4	0.96	0.14
5.0	49	2.8	0.98	0.12
5.5	55	3.2	1.00	0.11
6.0	61	3.6	1.02	0.09
6.5	68	4.0	1.01	0.08
7.5	76	4.4	1.00	0.07

4.4
 The maximum overall-efficiency amounts to 0.24 for a wind speed of 3 m/sec. For higher values of the windspeed the overall-efficiency is decreasing upto a few per cent only.

Improvements have been obtained later when the blades of the rotor were replaced by the narrow ones and the pumps size was increased from 132 mm. to 150 mm. New measurements were carried out in May 1979. The condition of the piston was rather bad; wear of the piston caused a considerably affected output due to internal leakage, but in spite of that higher overall-efficiencies have been extracted from these measurements:

Dia. pump: 150 mm. (clearance appr. 3.5 mm.)
 Stroke: 240 mm.
 Elevation head: 6.5 m.
 Pump type: E (see piston pumps)

V (m/sec.)	n (R.P.M.)	ϕ (dm ³ /sec.)	η_v —	η_{me} —
2.5	21	1.0	0.67	0.32
3.0	26	1.3	0.71	0.24
3.5	31	1.5	0.68	0.18
4.0	36	1.7	0.67	0.13
4.5	42	2.0	0.67	0.11
5.0	47	2.5	0.75	0.10
5.5	55	3.0	0.77	0.09
6.0	63	3.5	0.78	0.08
6.5	70	4.0	0.81	0.07
7.0	78	4.5	0.82	0.07
7.5	86	5.0	0.82	0.06
8.0	96	5.5	0.81	0.05
8.5	105	6.0	0.81	0.05

Although these results are not quite representative (low volumetric efficiency) one can conclude that overall-efficiencies of acceptable value can be obtained even if the piston pump is not in proper condition. After replacing the piston new measurements have been carried out with respectively 0.5 mm. and 1.0 mm clearance between piston and cylinder. The difference in these measuring data proved to be insignificant so both data have been combined:

Dia. pump: 150 mm. (0.5 ÷ 1 mm. clearance)
 Stroke: 240 mm.
 Elevation head: 6.5 m.
 Pumptype: E (see pistonpumps)
 "Cut-in" windspeed 2.5 m/sec.

V (m/sec.)	n (R.P.M.)	ϕ (dm ³ /sec.)	η_v —	η_{tot} —
3.0	25	1.5	0.85	0.30
3.5	31	1.8	0.82	0.23
4.0	36	2.2	0.87	0.19
4.5	42	2.6	0.88	0.15
5.0	47	3.0	0.90	0.13
5.5	54	3.5	0.92	0.11
6.0	60	4.0	0.94	0.10
6.5	67	4.6	0.97	0.09
7.0	77	5.2	0.96	0.08

Decreasing the stroke from 240 to 160 mm. reduces the output and "cut-in" windspeed.

Dia. pump: 150 mm. (0.5 ÷ 1 mm. clearance)
 Stroke: 160 mm.
 Elevation head: 6.5 m.
 Pumptype: E (see pistonpumps)
 Cut-in windspeed 2.2 m/sec.

V (m/sec.)	n (R.P.M.)	ϕ (dm ³ /sec.)	η_v —	η_{tot} —
2.5	26	0.9	0.74	0.31
3.0	31	1.1	0.76	0.22
3.5	37	1.3	0.75	0.16
4.0	43	1.5	0.74	0.13
4.5	49	1.7	0.74	0.10
5.0	55	1.9	0.74	0.08
5.5	61	2.2	0.77	0.07
6.0	69	2.4	0.74	0.06
6.5	76	2.7	0.76	0.05
7.0	85	3.0	0.75	0.05

In the next paragraphs extra attention will be paid to the windmill-pump-combination.

4.2. The power characteristics of the windmill.

By means of the former described way of measuring several properties of the windmill-pump combination can be defined but still the power characteristics of the windmill as well as the pump are completely unknown. In order to investigate this also torque-measurements must be carried out. In practice many complications will be met in order to realize a reliable torque-measuring because the actual torque will fluctuate considerably due to the irregular drive of the pistonpump. Knowing the characteristics of the rotor the conversion of windpower into useful mechanical power can be calculated then for any windspeed and R.P.M.-numbers. This characteristic is known as the $c_p - \lambda$ curve; c_p is here the power coefficient (the rate of power conversion) while λ stands for the tip-speed ratio. Both dimensionless ratios are defined as follows:

$$c_p = \frac{P}{\frac{1}{2} \rho V^3 \pi R^2}$$

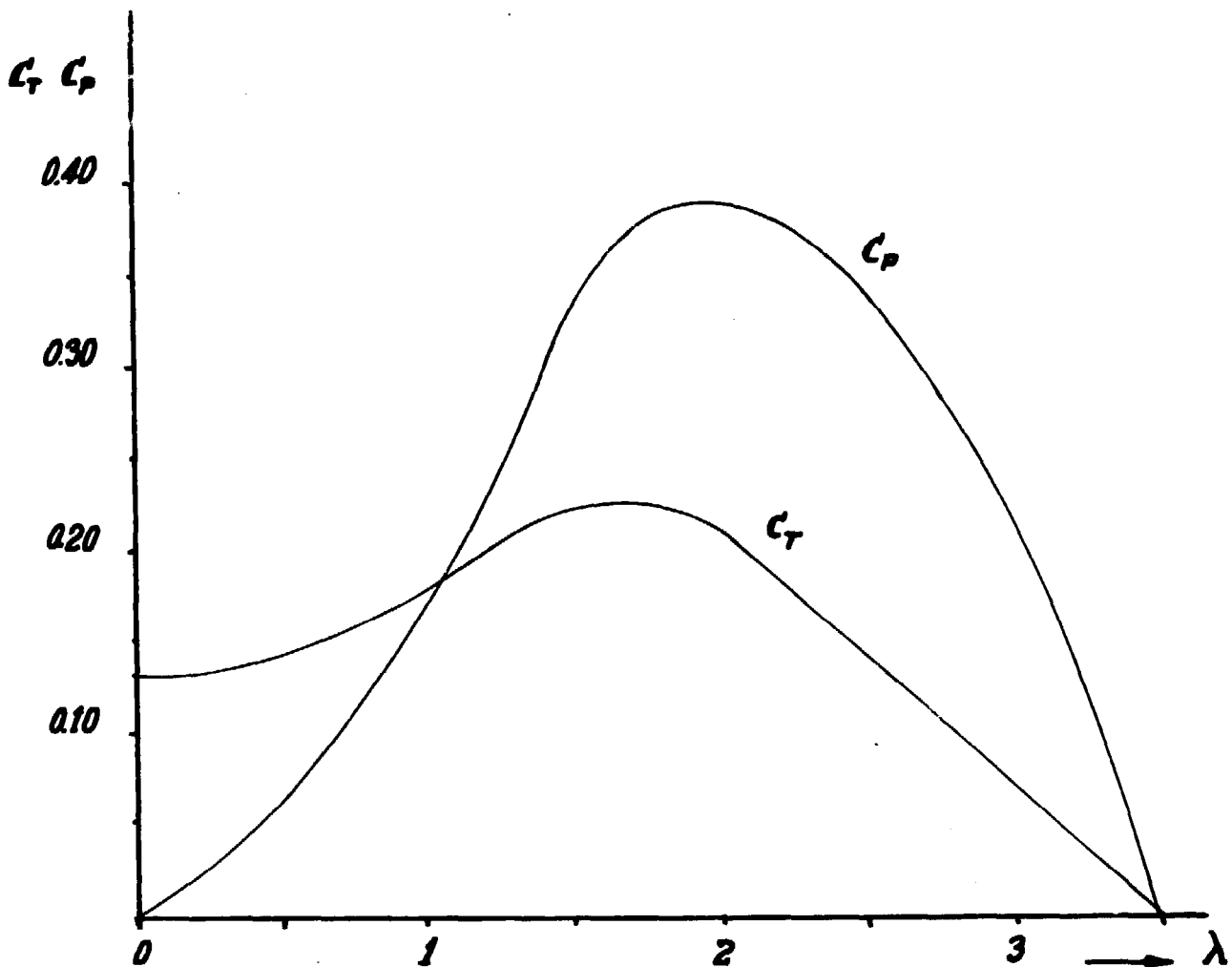
$$\lambda = \frac{\Omega R}{V}$$

Besides a dimensionless torque-coefficient is defined as follows:

$$c_T = \frac{T}{\frac{1}{2} \rho V^2 \pi R^3}$$

The symbols are representing:

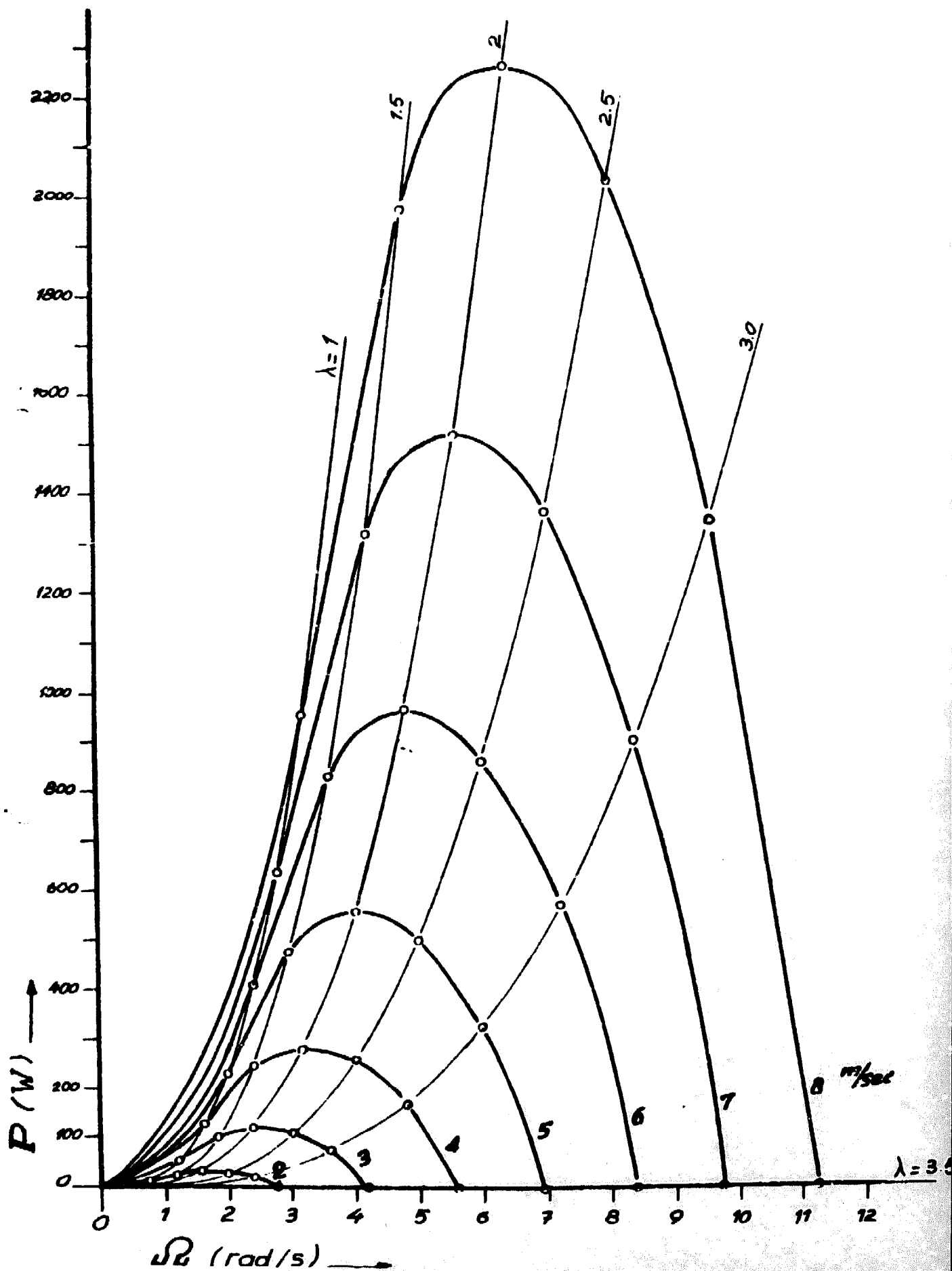
P	= useful converted power	[Watts]
T	= useful converted torque	[Nm]
ρ	= density of air	[1.2 Kg./m ³]
V	= windspeed	[m/sec.]
R	= radius of the rotor	[m]
Ω	= rotor angular velocity	[rad/sec]



Both the $C_T - \lambda$ curve and the $C_P - \lambda$ curve will represent the main properties of the rotor in a certain range of Reynolds numbers (Re). Since 10% arched steel plate airfoils are applied the curves will be valid if Reynolds-numbers appear which exceed the critical Re -number of 10^4 since the applied airfoil properties, which determined the blade design, are just valid under this condition ($Re > 10^4$). By the help of some SWD-members (SWD= Steering Committee for Windenergy in Developing Countries) the $C_T - \lambda$ and $C_P - \lambda$ curves of a scale-model (1.5 m. dia.) resulted from windtunnel-tests. In these tests the influence of the presence of several disturbing parts in the rotorframe has been investigated. Also the presence of the helpvane of the safety-device proved to affect the C_P -curve resulting in lower efficiencies.

The assumption that this $C_P - \lambda$ curve will represent the 5 m. dia. windmill provides a lot of information with regard to the actual generated power and torque. Also the power characteristic(s) of the pistonpump can be derived then. It is

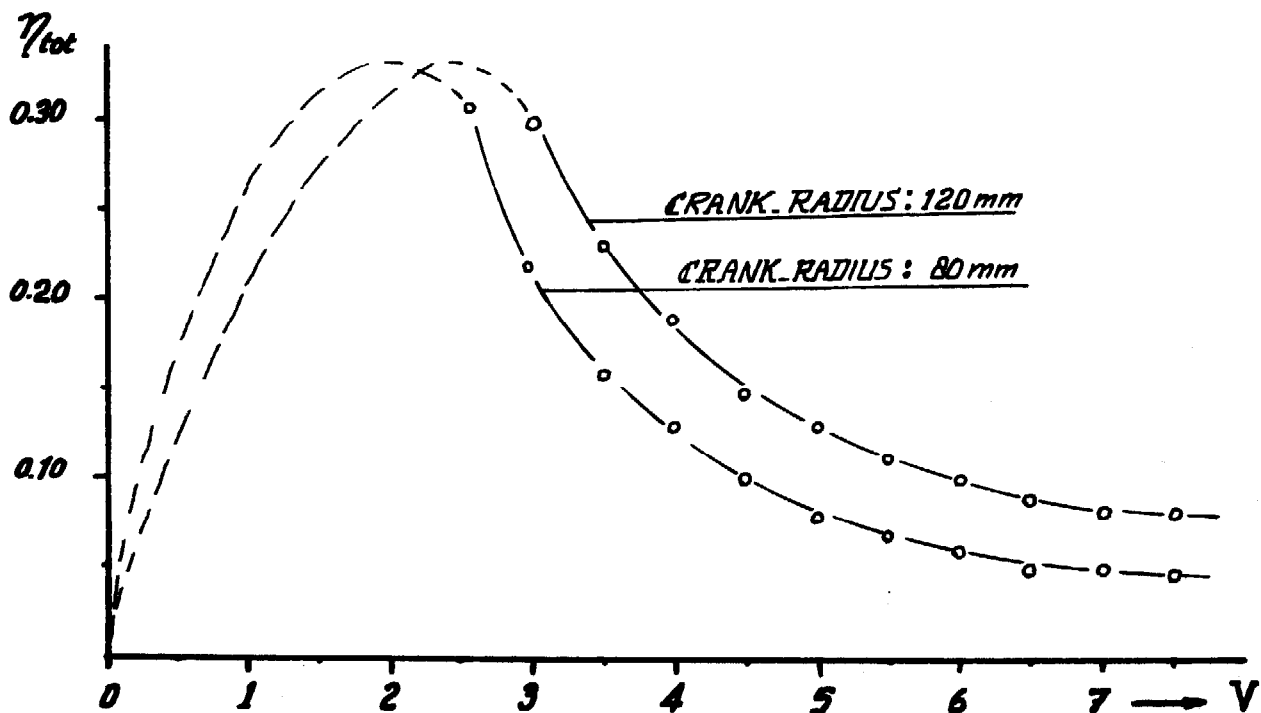
12 PU 500



evident that the mechanical losses of power must be taken into account. An acceptable value of a mechanical efficiency will be 0.90. Probably a part of mechanical loss is related to the angular velocity of the system, but is supposed to be constant in a certain range of R.P.M.-numbers. These assumptions led to the approximation of the power-curves of the 5 m. dia. windmill. The cubic influence of the windspeed is clearly visible while the most attractive load-curve should cover the cube-curve for $\lambda=2$.

4.3. Analysis of the windmill-pistonpump-combination.

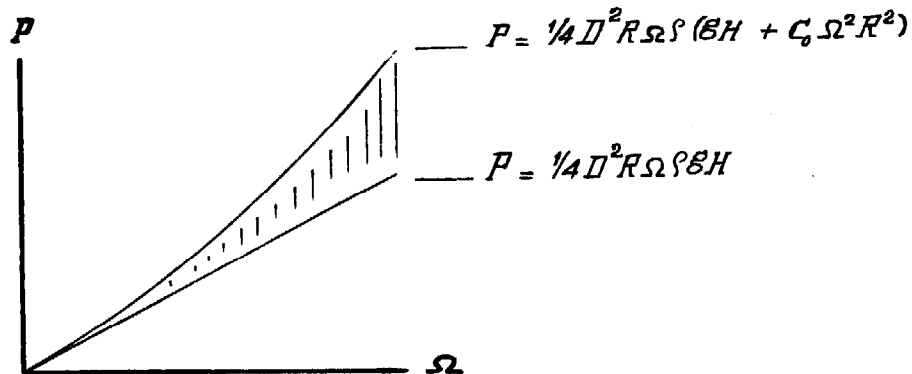
Since the R.P.M.-number in relation with the windspeed is known, the load characteristics of the pump(s) can be drawn into the former derived powercurves. Considering this it can be concluded that the transmitted power to the pump depends on the pump-performance and the crank radius. The considerable



reduction of the overall-efficiency can be explained as follows: for increasing wind velocities the combination operates at increasing values of the tip speed ratio so the rate of the windpowerconversion drops. The mechanical efficiency and the efficiency of the pistonpump affects the overall-efficiency as follows:

$$\eta_{tot} = C_p(\lambda) \cdot \eta_{mech.} \cdot \eta_{pump}$$

Since the mechanical efficiency is fixed at 0.9 and the C_p -value does not reach values below 0.15 ÷ 0.20 the low total efficiencies (e.g. 0.05 for $V = 8 \text{ m/sec.}$) must be caused by a low efficiency of the pump. This assumption can be proved simply by considering the power-curve of the pistonpump.



In case of higher angular velocities the losses in power increase considerably due to friction and all kinds of hydraulic losses.

The determined powercurves can suitably be approached by the following expression:

$$P = \frac{1}{4} D^2 R \Omega \rho (BH + C_0 \Omega^2 R^2)$$

Symbols:

P = Power	[Watt]
D = Diameter of piston	[m]
R = Crank radius	[m]
Ω = Angular velocity	[rad/sec]
ρ = Density of water	[kg/m ³]
g = Gravity-acceleration	[m/sec ²]
H = Elevation head	[m]

The symbol C_0 stands for the coefficient of loss. As far as just the hydraulic losses are concerned the hydraulic efficiency is defined by:

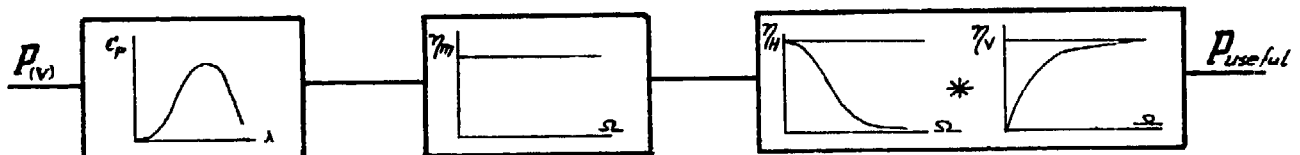
$$\eta_H = \frac{\Phi \cdot \rho BH}{\Phi \rho (BH + C_0 \Omega^2 R^2)} = \frac{1}{1 + C_0 \frac{\Omega^2 R^2}{BH}}$$

while the total efficiency of the pistonpump is found by:

$$\eta_p = \eta_H * \eta_V$$

(η_V = volumetric efficiency)

In general the total windmill-pistonpump-installation can be represented schematically in case of fixed parameters like elevation head, pistondiameter and crank radius.



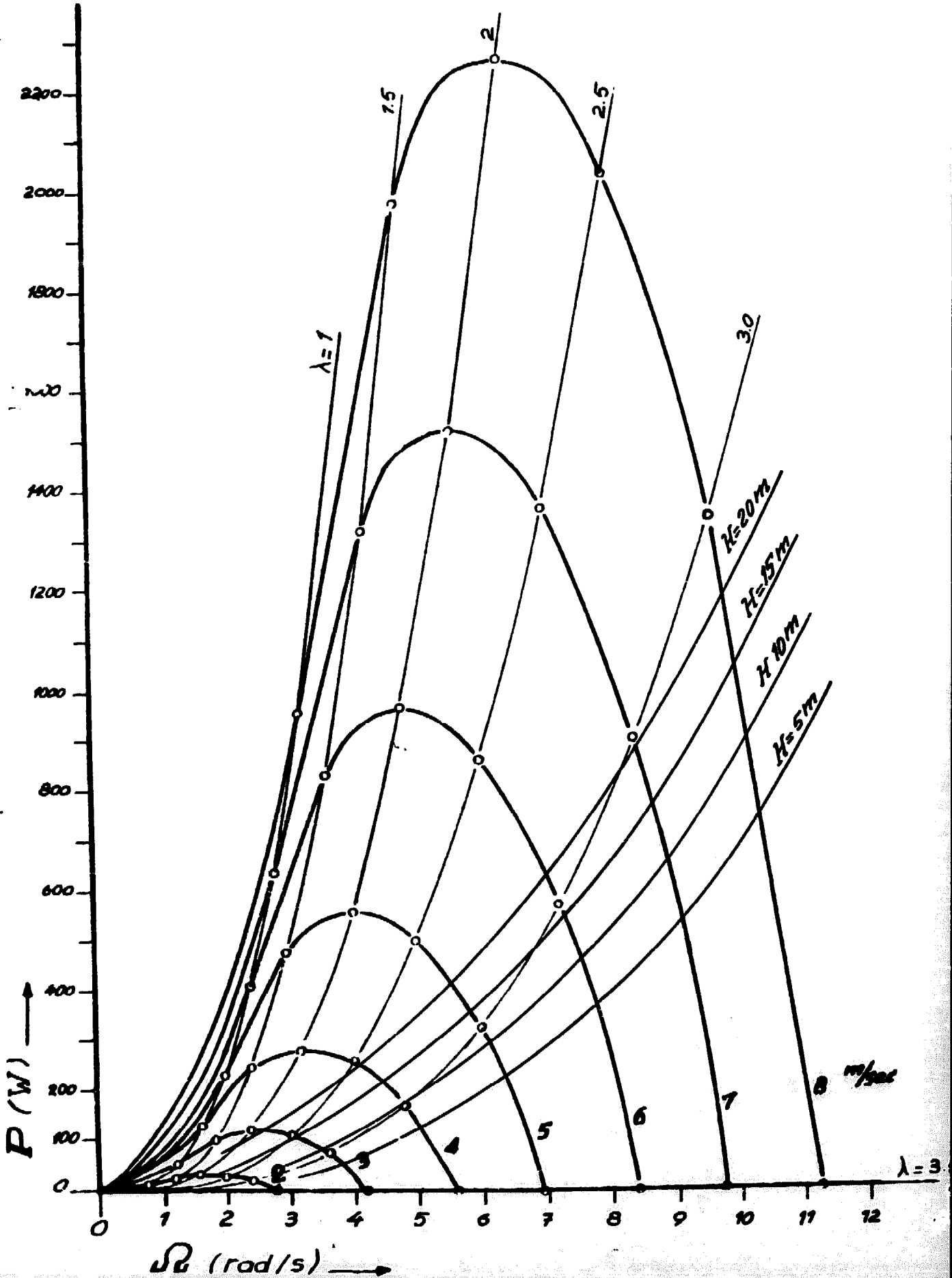
From this scheme it can be concluded that the total efficiency is badly affected by the influence of hydraulic efficiency since the measured tipspeed ratio (λ) in practice seldom exceeds the value of 3.0 while C_p maintains reasonable values.

From the two last mentioned measuring-data the value for C_0 can be derived so an approach of powercharacteristics in case of different elevationheads and crank radia will result. For $C_0 = 200$, rather "pessimistic" but acceptable powercurves can be drawn through the powercurves of the windmill in order to define the meetingpoints and the actual angular velocity of the system. Assuming the volumetric efficiency be 0.8 the input-output relation is found by the calculated output for all combinations of elevationhead and crank radia.

Although this determination is not quite valid the results will provide a rather good impression concerning the output which can be expected. One can conclude that in case of higher elevation the output is hardly affected, but the starting wind speed is higher.

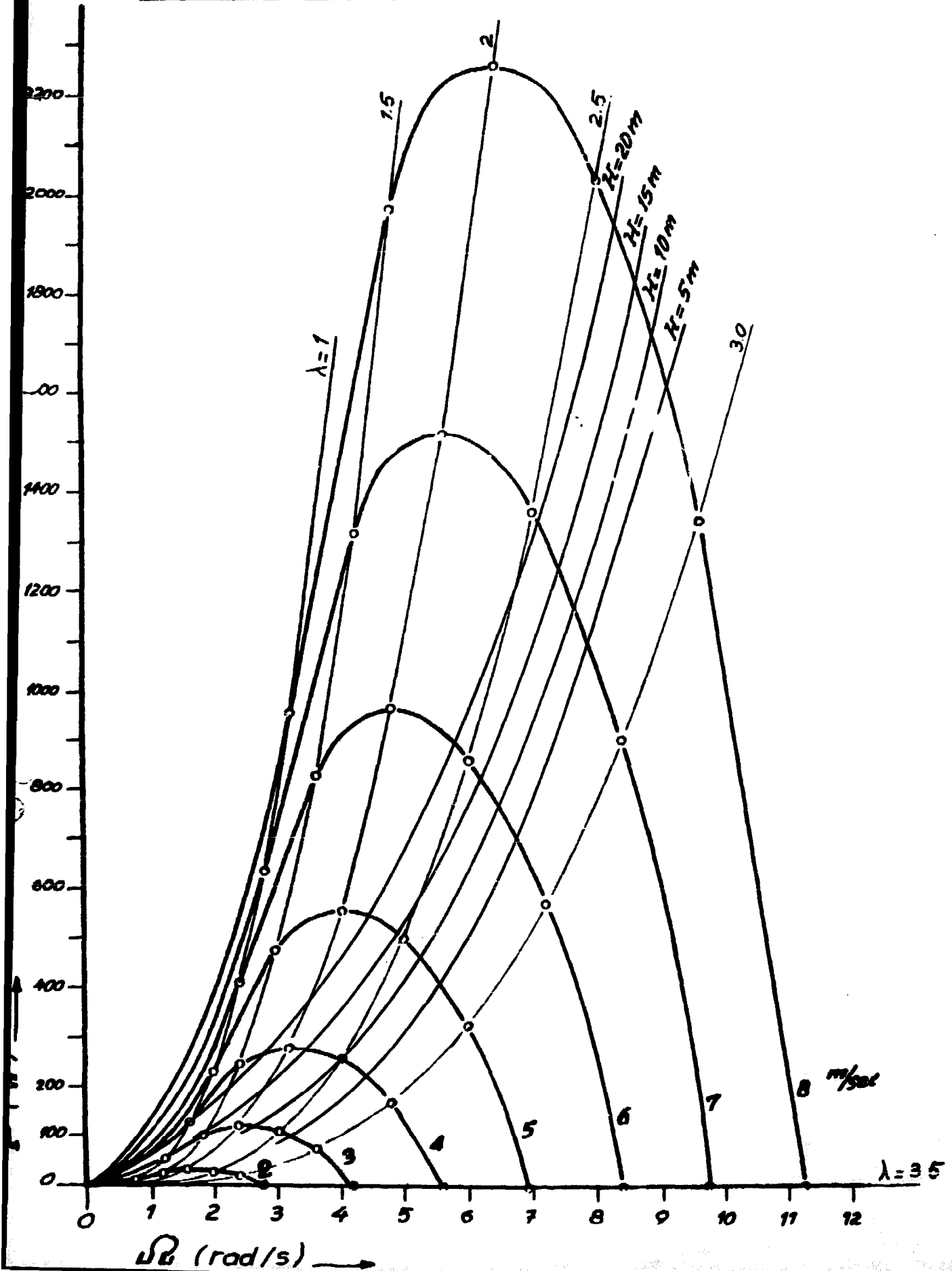
12 PU 500

CRANKRADIUS 60 mm.



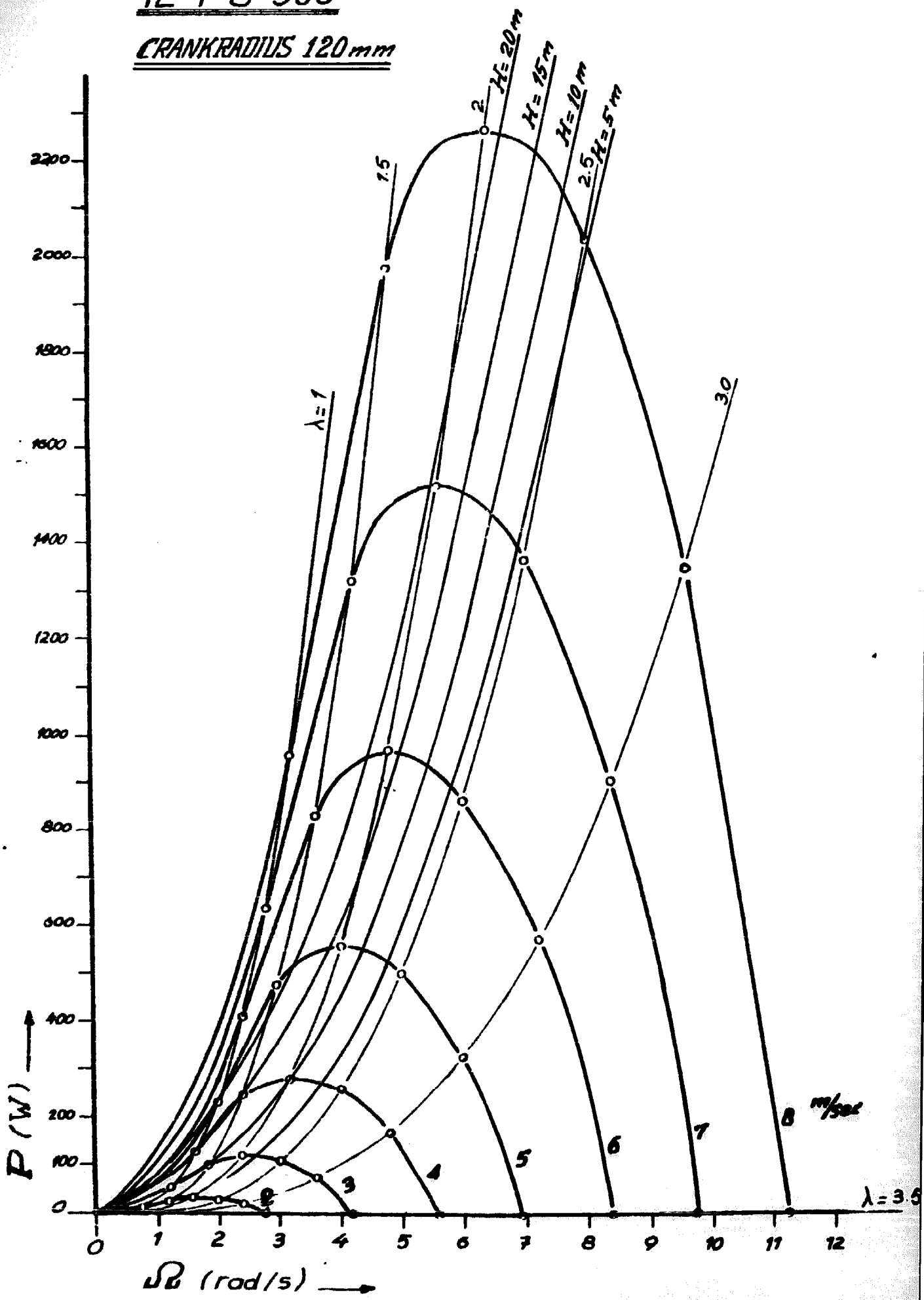
12 PU 500

CRANKRADIUS 90mm

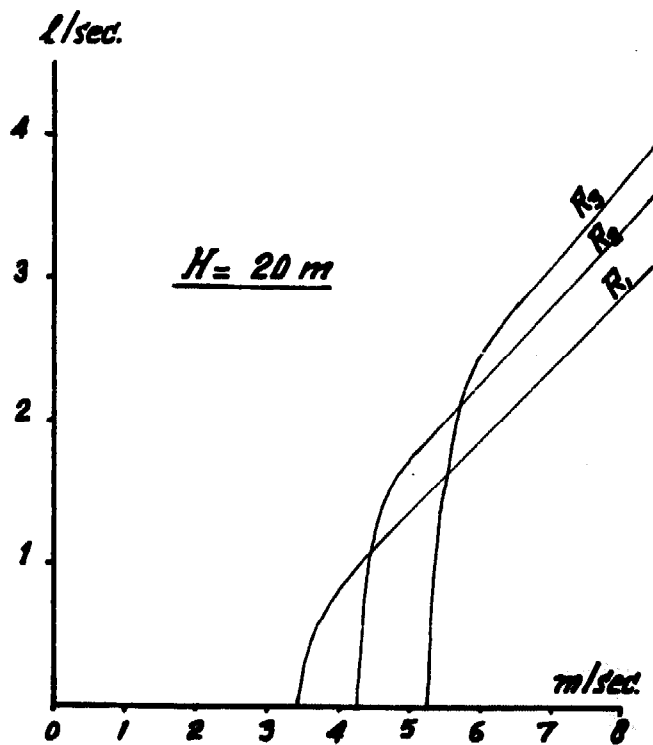
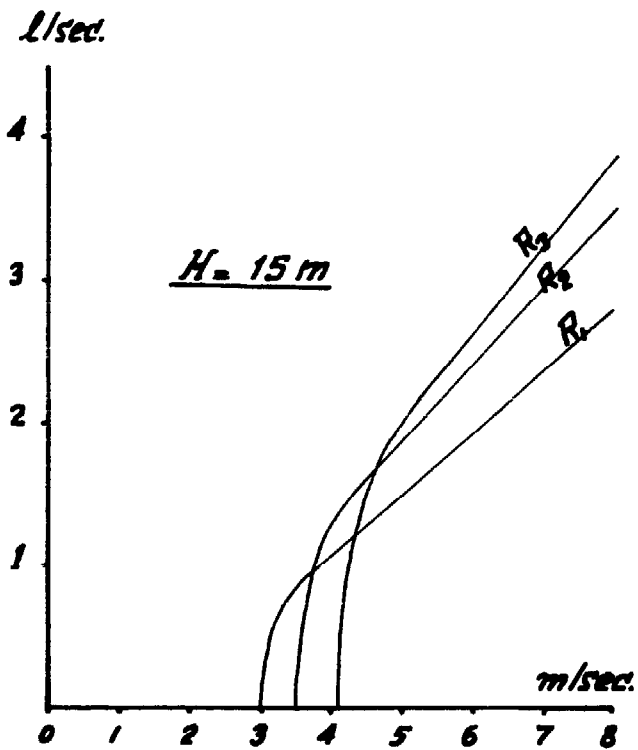
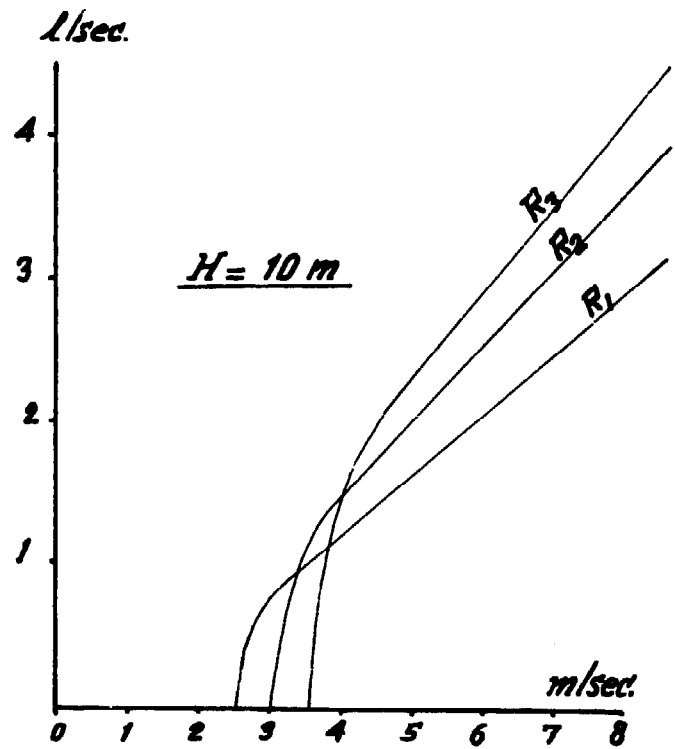
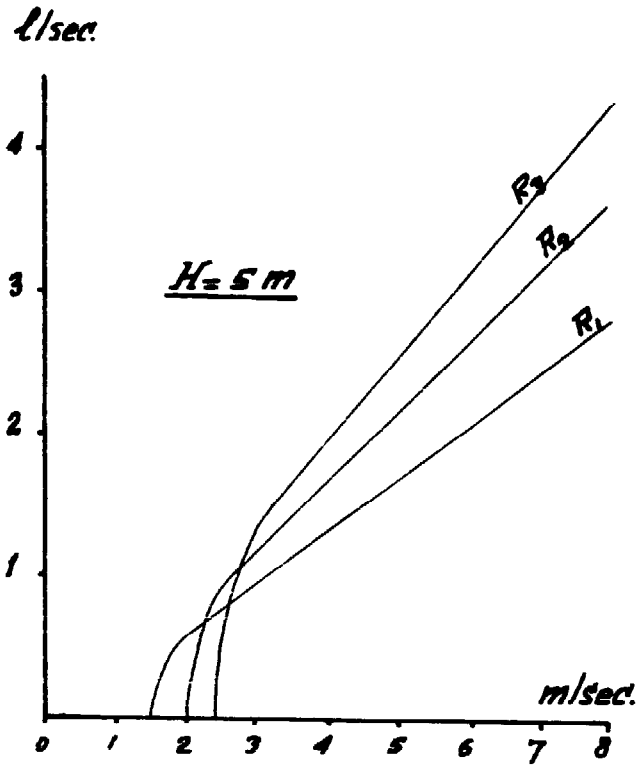


12 PU 500

CRANKRADIUS 120mm



INPUT-OUTPUT RELATIONS (150 mm PUMP)



$H = \text{ELEVATION HEAD}$

$R_1 = 60\text{ mm}$

$R_2 = 90\text{ mm}$

$R_3 = 120\text{ mm}$

CRANK RADIUS

5. Defining optimal starting windspeed, windmill- and pump dimensions

In the former chapter the "mis-match" of the windmill and single-acting piston pump has been fully described for the 12 PU 500 windmill. As a matter of fact the same applies for the other members of 12 PU-family (250, 350 and 700) for their C_p - λ curves are the same.

Apart from the problem which windmill type should be applied also the starting windspeed to be chosen is most essential with regard to the way the windmill is going to perform. To illustrate this we consider the following extreme situations which often occur in practice:

Too low starting windspeed:

Too small a pump applied. Windmill is almost always running (psychologically attractive). Poor output: too low quantity in the long run.

Too high starting windspeed:

Too big a pump applied. Windmills is almost never running (psychologically unattractive.) Impressive output, but too low a quantity in the long run.

Somewhere in between an optimum exists for which the most optimal starting windspeed occurs for which the best windmill-pump combination can be composed. To derive this optimal combination there is a need for a simple and systematic procedure by which the following can be calculated:

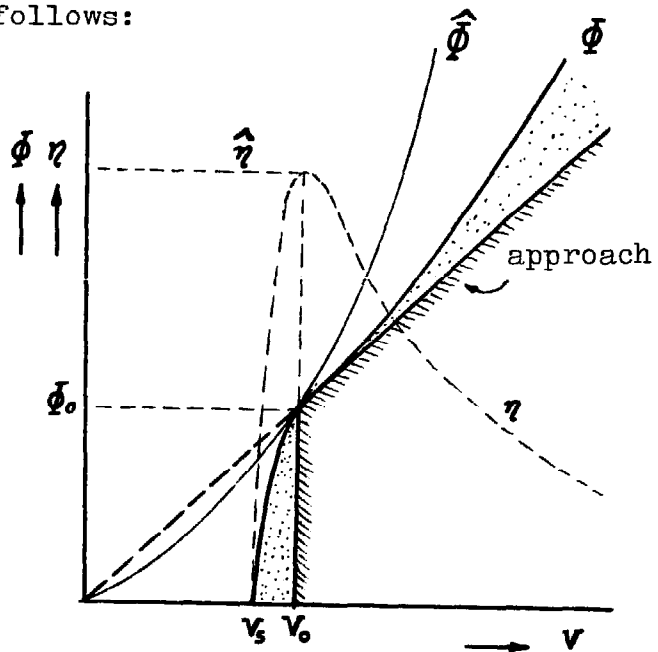
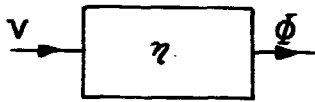
- starting windspeed
- rotor diameter (250-350-500-700)
- pump dimension (3"-4"-5"-6"-8")

Whether such optimizing contradicts for instance social acceptance or required storage capacity cannot be foreseen as yet. However, as all components are available

in a finite number of sizes a certain deviation occurs. The latter provides a margin to create a compromise if necessary.

5.1 Deriving the optimal starting windspeed:

The essential point in power conversion by the windmill, combined with the single acting piston pump, is that the highest efficiency (η) occurs for the optimal (design) windspeed V_0 . The starting windspeed V_s is found slightly less. Further the usefull output of the system is almost proportional to the windspeed and as a matter of fact the total output curve can be suitably approached as follows:



V_s	\approx	V_0
$V < V_0$:	$\Phi = 0$
$V = V_0$:	$\Phi = \Phi_0$
$V \geq V_0$:	$\Phi = \frac{\Phi_0}{V_0} * V$

Of course some deviations occur particularly about the interval $V_s - V_0$ and in case of higher windspeeds but these are supposed to be neglected.

Symbols:

A = rotor area	$[m^2]$
Φ = flow (water delivery)	$[m^3/s]$
V = actual windspeed	$[m/s]$
V_0 = optimal (design) windspeed	$[m/s]$
H = elevation head	$[m]$
$\hat{\eta}$ = peak-efficiency	$[-]$
P = power	$[W]$
ρ_a = specific density of air	$[kg/m^3]$
ρ = specific density of water	$[kg/m^3]$
g = gravity acceleration	$[m/s^2]$

$$P \text{ (windmill)} = \eta * \frac{1}{2} \rho_a V_0^2 A$$

$$P \text{ (pump)} = \rho g H * \Phi_0$$

After equalization:

$$\hat{\eta} * \frac{1}{2} \rho_a V_0^2 A = \rho g H * \Phi_0$$

for $V = V_0$:

$$\Phi_0 = \frac{\hat{\eta} * \frac{1}{2} \rho_a V_0^3 * A}{\rho g H} \quad [m^3/s] \quad (5.1)$$

for $V > V_0$:

$$\Phi_0 = \frac{\hat{\eta} * \frac{1}{2} \rho_a V_0^2 A * V}{\rho g H} \quad [m^3/s] \quad (5.2)$$

for:

$$\left. \begin{array}{l} \hat{\eta} = 0.30 \text{ (12 PU-Serie)} \\ \rho_a = 1.3 \text{ kg/m}^3 \\ \rho = 10^3 \text{ kg/m}^3 \\ g = 9.81 \text{ m/s}^2 \end{array} \right\}$$

$$\Phi = 2.10 \frac{A}{H} V_0^2 * V \quad [m^3/s] \quad (V \geq V_0)$$

In this expression the influence of elevation head, rotor area and windspeeds are quite evident.

We are interested in a maximum total water delivery during the time period considered $t_1 - t_2$: (e.g. January or a critical season):

$$Q = \int_{t_1}^{t_2} \Phi dt = \int_{t_1}^{t_2} 2.10 \frac{A}{H} V_0^2 * V dt = 2.10 \frac{A}{H} V_0^2 \int_{t_1}^{t_2} V dt \quad (V \geq V_0)$$

It is noted that as far as optimizing is concerned the expression $V_0^2 \int_{t_1}^{t_2} v dt$ ($v \geq V_0$) should reach a maximum. However, the actual windspeed is not presented in continuous functions although Histograms provide time durations of windspeeds belonging to certain ranges. Therefore it is advisable to rewrite the expression in order to facilitate an interval-wise calculation as follows:

$$V_0^2 \int_{t_1}^{t_2} v dt$$

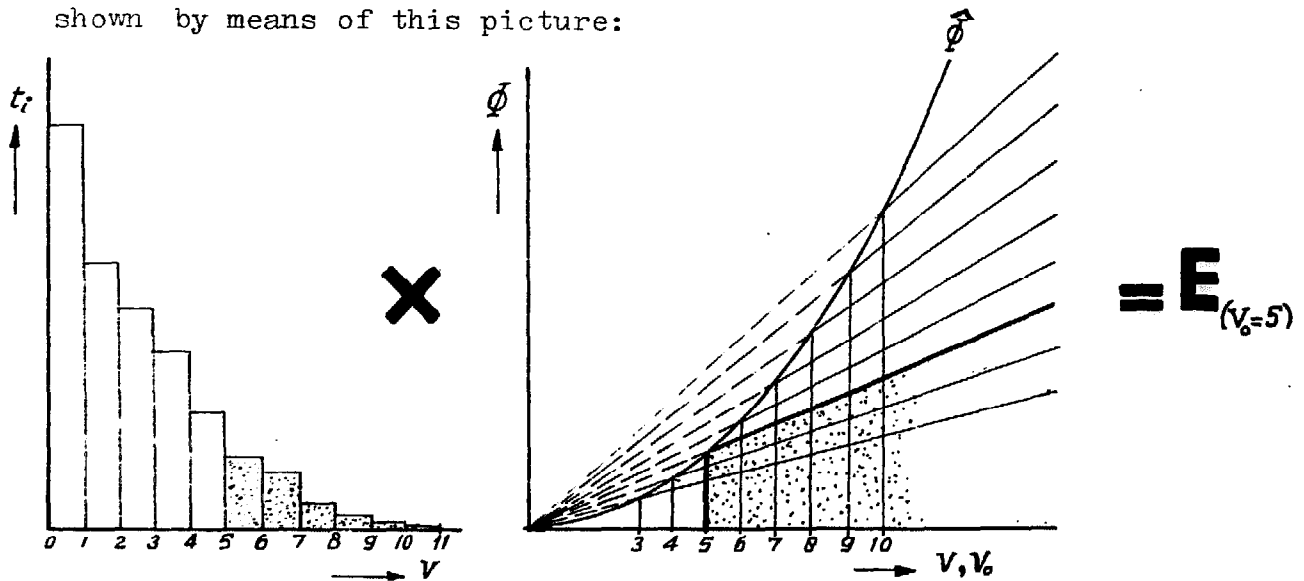


$$V_0^2 \sum_{t_i} v_i t_i$$

Windspeed V_i represents the mean windspeed of a certain interval (e.g. 5-6; $V_i = 5.5$) and t_i is the time of which windspeeds, belonging to the interval concerned, actually occur during the time span:

Note that the expression indicates the extent of useful energy conversion. For convenience it is written in short as E.

As a matter of fact the optimizing problem can be suitably shown by means of this picture:



Many boring multiplications carried out again and again for an other starting windspeed V_0 (as a parameter) are needed

to figure out for which value of V_0 a maximum is found for the expression:

$$E = V_0^2 \sum V_i * t_i \quad (V \geq V_0)$$

Such a process can suitably be computerized, but a systematical calculation is simply carried out in a few minutes only without using any advanced calculation machines. This is done table-wise as follows:

V_0	V_i	t_i	$V_i * t_i$	$\sum V_i * t_i$	V_0^2	E
0						
1						
2						
3						
4						
5						
6						
7						
8						
9						
10						
11						
12						

V_0 -column

Here the whole numbers of the potential starting windspeeds

V_0 are filled out, while these correspond with each start value of the intervals given by the histogram.

The required length of this column depends on relevant duration of intervals of high windspeeds and whether the windmill still functions as the security mechanism might have switched off the windmill. Generally no relevant contribution to the total addition is found for windspeeds which exceed values of 10 up to 12 m/sec.

V_i -column

As mentioned before V_i represents the mean value of the windspeeds which are represented in the interval concerned.

 t_i -column

Time duration of windspeeds represented in the interval are preferably filled out in hours.

 $V_i * t_i$ -column

Values of the two foregoing columns are multiplied and printed here.

 $\sum V_i * t_i$ -column

Here starts a tricky procedure! This column is filled out starting from the bottom adding the value of the foregoing column.

 V_o^2 -column

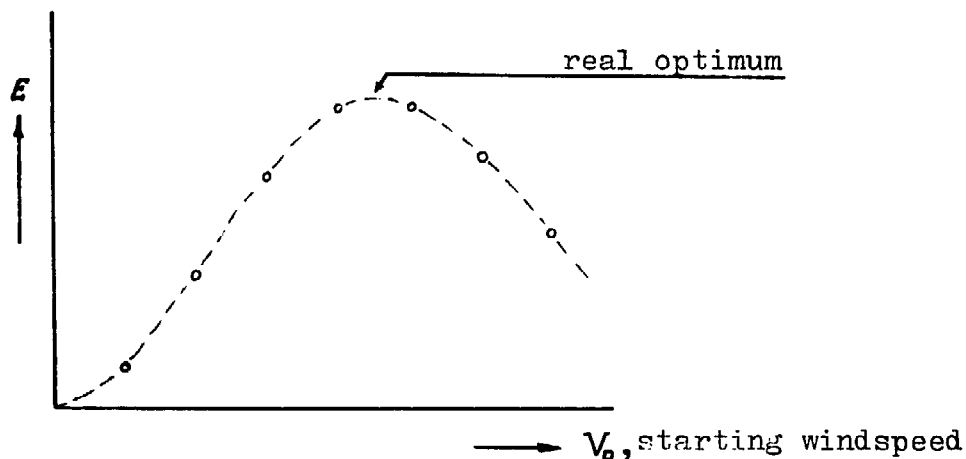
Print values of the first column in square.

 $E = V_o^2 \sum V_i * t_i$ -column

Multiply the figures of the last two columns to find a maximum and so the optimal starting windspeed V_o as a round figure.

Of course a real optimum is found for a value of V_o which is slightly more or less but as mentioned before the components of the windmill installation are bound to certain series of fixed dimensions.

Therefore better continue the calculations with the "round figure" found sofar but knowing where the real optimum exists. (This saves time and calculations.)



The expected total delivery is calculated as follows:

$$Q_{t_1+t_2} = 2 \cdot 10^{-5} \frac{A}{H} * E \quad [m^3] \quad (5.3)$$

which is only valid if time (t) has been expressed in seconds. In practice winddata are given in hours so far the practical case the foregoing formule turns into:

$$Q_{t_1=t_2} = 7.2 \cdot 10^{-2} \frac{A}{H} * E \quad [m^3] \quad (5.4)$$

5.2 Deriving required rotor dia;

Depending on water requirement and actual elevationhead the minimum rotor area is simply derived by applying the formula:

$$A = \frac{QH}{7.2 \cdot 10^{-2} E} \quad [m^2] \quad (5.5)$$

But in practice only a few windmill designs are at our disposal which means that each choice to be made will be a compromise:

type	rotor area	power
12 PU 250	4.9	P
12 PU 350	9.6	2P
12 PU 500	19.6	4P
12 PU 700	38.5	8P

One should realize that a generous rotor area always provides some margins which, of course, is more attractive than a very critically chosen windmill which will hardly cover the need.

5.3 Pump dimensions

So far we are able to extract the optimal starting windspeed and windmill type to be applied under certain circumstances (winds, waterdepth, water requirement). The final match of pump and windmill should prove the demanded properties of starting behaviour and output.

To find out the optimal pump dimension the equilibrium is to be considered for

$$\text{Windmill: } \Omega_o = \frac{\lambda_o V_o}{R} \quad (5.6)$$

$$\text{Pump: } \dot{Q}_o = \frac{\Omega_o}{2\pi} 2r \frac{\pi}{4} d^2 \eta_v \quad (5.7)$$

Ω_o = angular velocity for $v = V_o$	[1/s]
r = crank radius	[m]
d = pump dia	[m]
η = volumetric efficiency (0,85)	[-]
λ_o = tipspeed ratio (2)	[-]
R = rotor radius	[m]

(5.6) substituted into (5.7):

$$\dot{Q}_o = \frac{1}{2} V_o \frac{r}{R} d^2 \eta_v \quad [m^3] \quad (5.8)$$

$$\text{In paragraph 5.1 was found for } v = V_o : \dot{Q}_o = \frac{\pi}{4} \frac{1}{2} \rho_a V_o^3 A}{\rho g H} \quad (5.1)$$

after equalization of : (5.8) and (5.1)

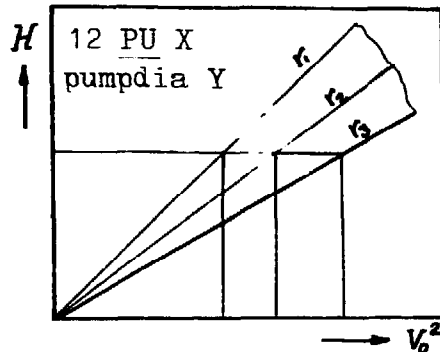
$$H = 4.68 * 10^{-5} \frac{A}{d^2} \cdot \frac{R}{r} * V_o^2 \quad [m] \quad (5.9)$$

It will be useful to create a graphical representation of the forementioned equation which is achieved as follows:

H is proportional to V_o^2 while A, d^2 and $\frac{R}{r}$ (which are fixed figures) can be applied as parameters. As well known the 12 PU - windmills have three crank radia(r) so the ratio leads to:

$$\begin{array}{l} \frac{R}{7} = 41.66 \\ \frac{R}{2} = 27.78 \\ \frac{R}{3} = 20.83 \end{array}$$

The graphical representation will be:

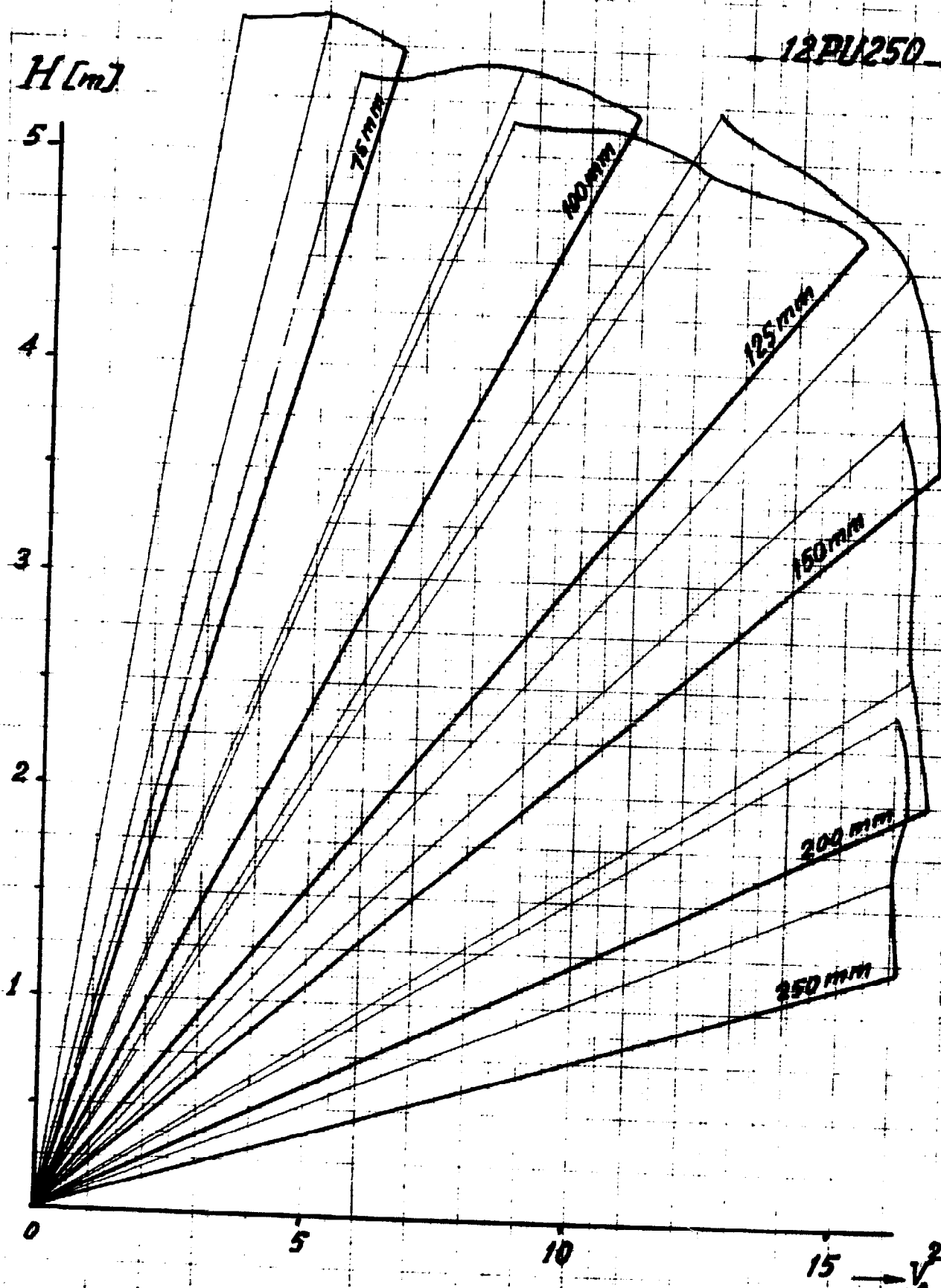


More pump types can be involved, so the H - V_0 -plane will contain several overlapping fan-shaped figures representing the pump size and crank-radius concerned.

Though in principle the choice is made for the biggest radius r_3 an extra possibility is available to give an additional change in the starting windspeed. This is done by re-adjustment of the crank which might be necessary during critical periods.

Next pages show the graphs which are valid for the 12 PU 250-350 and 500 windmills respectively. By means of these graphs the most optimal pump is chosen and of course, most probably, a compromise has to be made. However, in many cases an overcapacity of the windmill will be applied which allows us to deviate from the round figure of V_0 , which was found so far. Preferably the "match point" is chosen which lies just on left side of the V_0 which should be obtained. The reasons for this are:

- A lower starting windspeed proved to be more attractive with regard to social acceptance of the windmill.
- As the windmill is running during a higher percentage of time its delivery will be more regular, which requires a smaller storage tank in case of regular consumption.



- 12 PU 350 -

$H[m]$

10

5

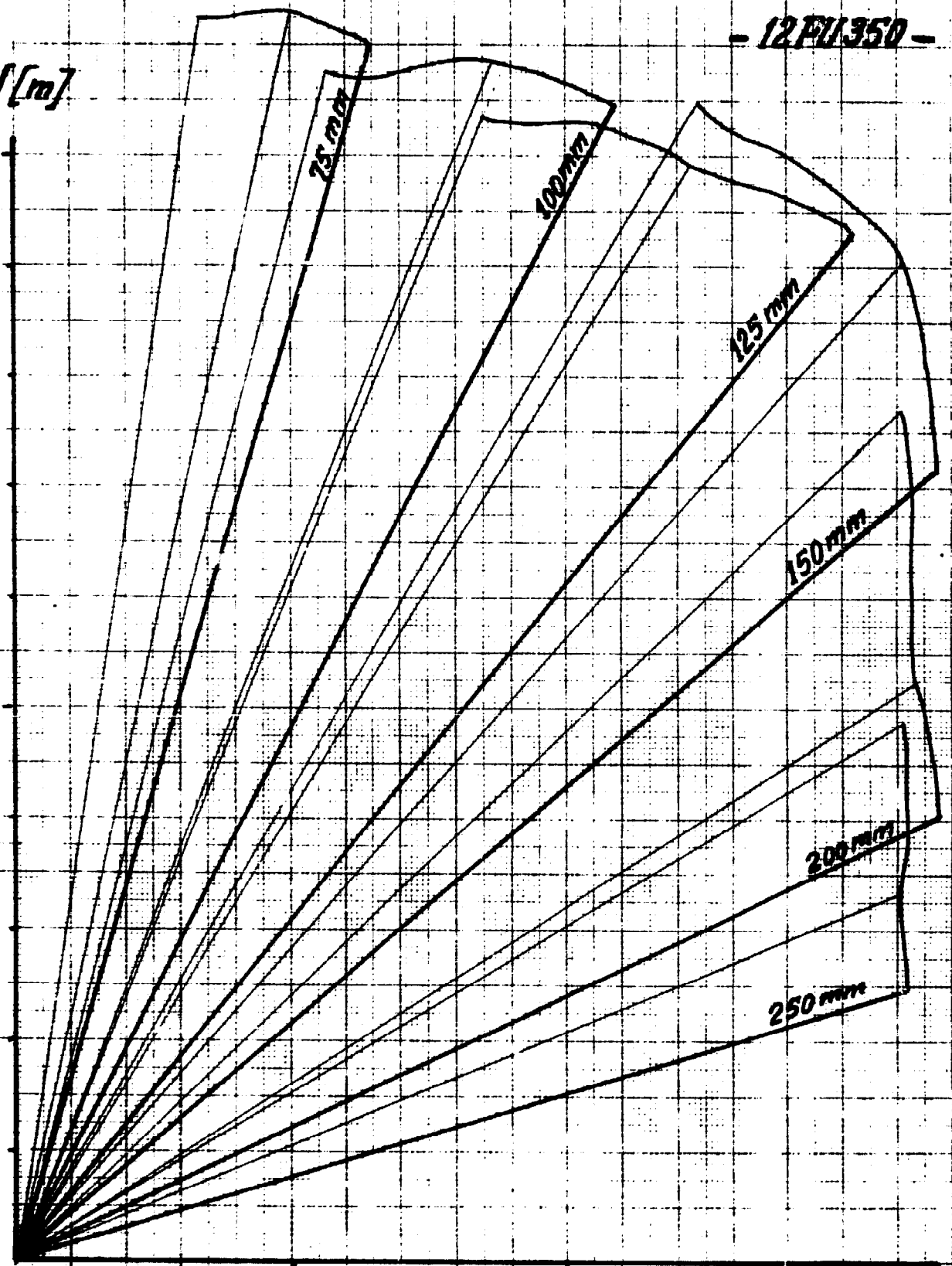
0

5

10

15

V_0^2



12 PU 1500

H [m]

20

15

10

5

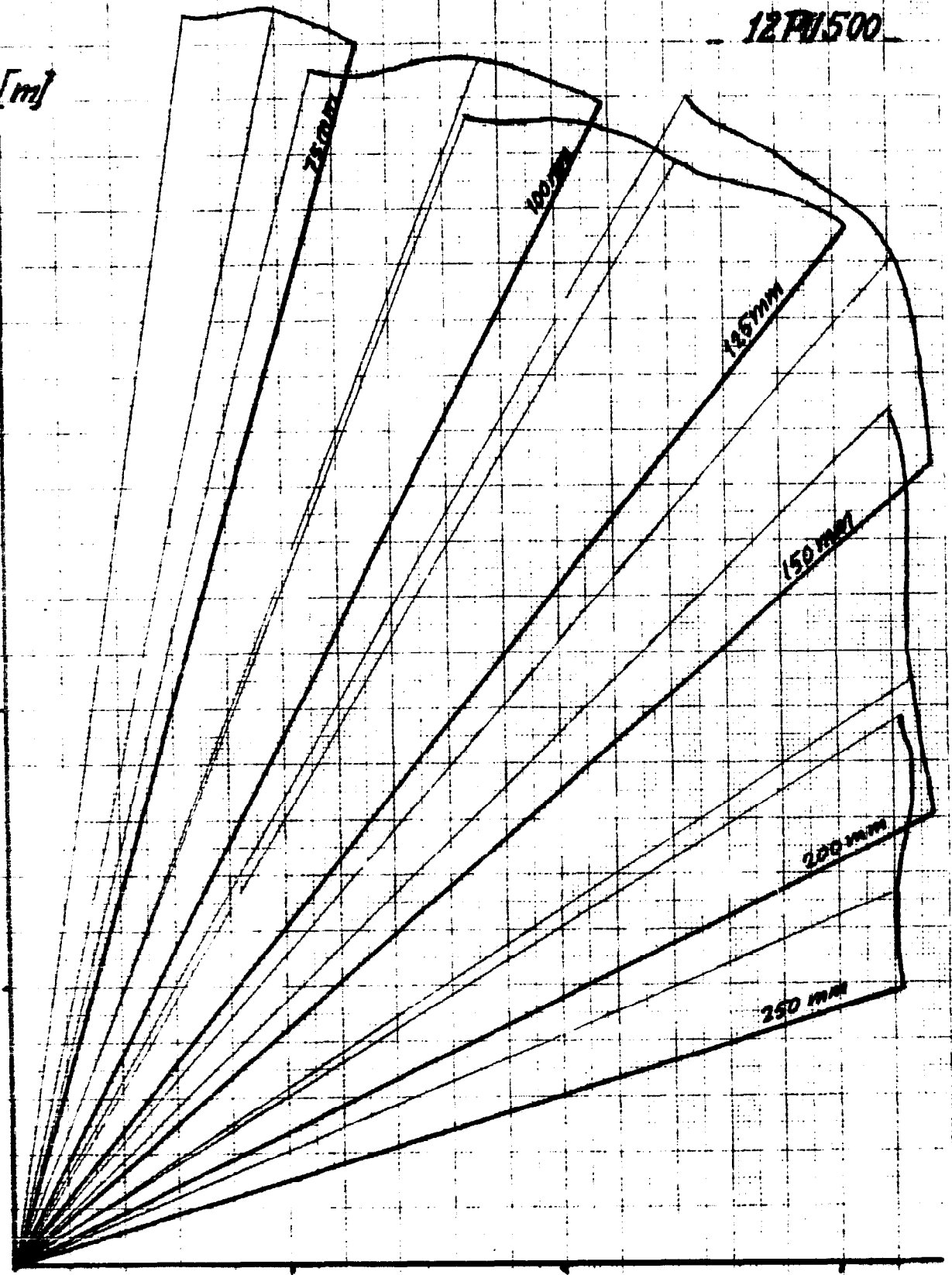
0

5

10

15

V_0^2

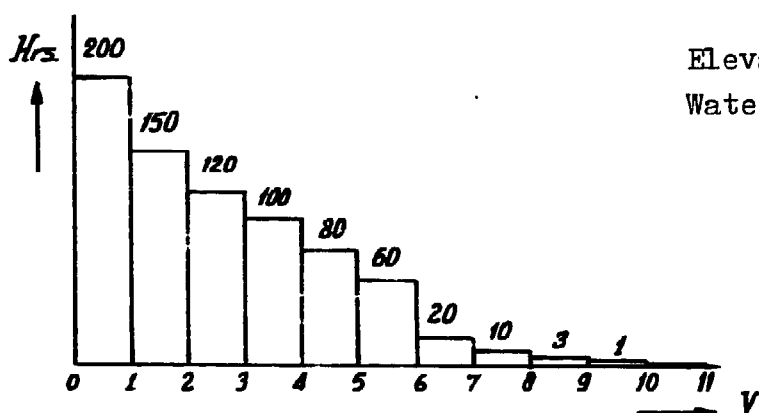


- The forces transmitted acting on the moving parts are less in case of lower starting windspeeds. To a certain extent a less quicker wear of such components and a lower probability of breakdowns occur.

This might seem contradictory for the windmill has a higher degree of running, but such indications have been noticed in practice.

5.4 Numerical example

In a certain project area the following winds appear during the most critical period of water requirement.



Elevation head = 10 m

Water requirement = 1,500 m³

1. What is the optimal starting windspeed (round figure)?
2. Which windmill is applied to cover the water requirement?
- 3a. Which pump dia should be applied to approach the maximum output possible?
- 3b. What will be the starting windspeed?
- 3c. What is the maximum output to be expected?
- 3d. How many running- hours and -percentage are expected?
- 4a. Which minimum pump dia is possible to obtain at least the required output and what will be the starting wind-speed then?
- 4b. How many running- hours and -percentage are expected?

1.	V_0	V_i	t_i	$V_i * t_i$	$\sum V_i * t_i$	V_0^2	E
	0	0.5	200	-	-	-	-
	1	1.5	150	225	1805	1	1,805
	2	2.5	120	300	1580	4	6,320
	3	3.5	100	350	1280	9	11,520
	4	4.5	80	360	930	16	14,880
	5	5.5	60	330	570	25	14,250
	6	6.5	20	130	240	36	8,640
	7	7.5	10	75	110	49	5,390
	8	8.5	3	25.5	35	64	2,240
	9	9.5	1	9.5	9.5	81	770
	10	10.5	-	-	-	100	-
	11	11.5	-	-	-	121	-

← maximum

The optimal starting windspeed amounts to 4 (round figure)

$$2. \quad Q = 7.2 * 10^{-2} * \frac{A}{H} * E = 7.2 * 10^{-2} * \frac{A}{10} * 14880 = 1500 \quad \Rightarrow \quad A = 14.0 \text{ m}^2$$

$$\Rightarrow \quad 12 \text{ PL} 1500$$

3a/3b.

By graphs: $H = 10\text{m}$

$$(\text{pump dia} = 150) \quad V_0^2 = 11.7 \quad \rightarrow \quad V_0 = 3.42 \text{ m/s}$$

$$(\text{pump dia} = 200) \quad V_0^2 = 21^* \quad \rightarrow \quad V_0 = 4.58 \text{ m/s}$$

* Actually this figure is not represented at the V_0^2 -scale, but the graph reads half the value of V_0^2 for half the value of H.

Though the second match (pump dia = 200) is not desirable as explained before it is considered here to illustrate the consequences of such a choice.

3c. Recalculation of E by means of proportional interpolation.

$$E(150) \cong 11520 + (14880 - 11520)(3.42 - 3) = 12931.2$$

$$E(200) \cong 14250 + (14880 - 14250)(5 - 4.58) = 14514.6$$

Obviously the second match is closest to the optimum.

$$Q(150) \cong 7.2 * 10^{-2} * \frac{19.6}{10} * 12931.2 = 1825 \text{ m}^3$$

$$Q(200) \cong 7.2 * 10^{-2} * \frac{19.6}{10} * 14514.6 = 2048 \text{ m}^3$$

3d. Total hours of functioning: (from table)

$$T(150) = 1+3+10+20+60+80+(4-3.42)100 = 232 \text{ hrs.}$$

$$T(200) = 1+3+10+20+60+(5-4.38)80 = 127.6 \text{ hrs.}$$

Percentages:

$$P(150) = \frac{232}{744} * 100\% = 31\%$$

$$P(200) = \frac{127.6}{744} * 100\% = 17\%$$

$$4a. Q = 7.2 * 10^{-2} * \frac{A}{H} * E = 7.2 * 10^{-2} * \frac{19.6}{10} * E = 1500$$

$$E = 10629 \implies V_0^2 \approx 9 \text{ (see table)}$$

pump dia = 125 mm (see graphs)

with $V_0^2 = 8.2$ and $V_0 = 2.86 \text{ m/s}$

Recalculation for E:(from table)

$$\bar{E}(125) \geq 6320 + (11520-6320)(2.86-2) = 10792$$

This is slightly more than was demanded:

$$Q(125) \geq 7.2 * 10^{-2} * \frac{19.6}{10} * 10792 = 1523 \text{ m}^3$$

A 125 mm pump will serve the purpose so the starting windspeed of 2.86 m/s is confirmed.

4b. Running hours: (from table)

$$T(125) = 1+3+10+20+60+80+100+120*(3-2.86) = 288.4 \text{ hrs}$$

Running percentage:

$$P(125) = \frac{288.4}{744} * 100\% = 39\%$$