FLOW TESTING OF 12" IBC VALVE TESTING STEALTH VALVE & CONTROLS, LTD. JULY 2006 - REPORT NO. 2006-139/C1215

CERTIFIED BY
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INTRODUCTION

A 12" IBC Valve was flow tested with two inserts at Alden Research Laboratory, Inc. for Stealth Valve & Controls, LTD. using Alden's standard test procedures, QA-AGF-7-86 Revision 6.1. Valve performance is presented as Cv versus opening %, in both tabular and graphical format.

VALVE INSTALLATION

The valve was installed in Test Line1 in the Hooper Facility shown in plan view on Figure 1. Water was provided from a 40" penstock from the Laboratory pond head at a head of about 18 feet. An electrically powered pump provided a maximum head of about 170 ft and a maximum flow of 6,000 gpm. The gravimetric method was used to measure flow.

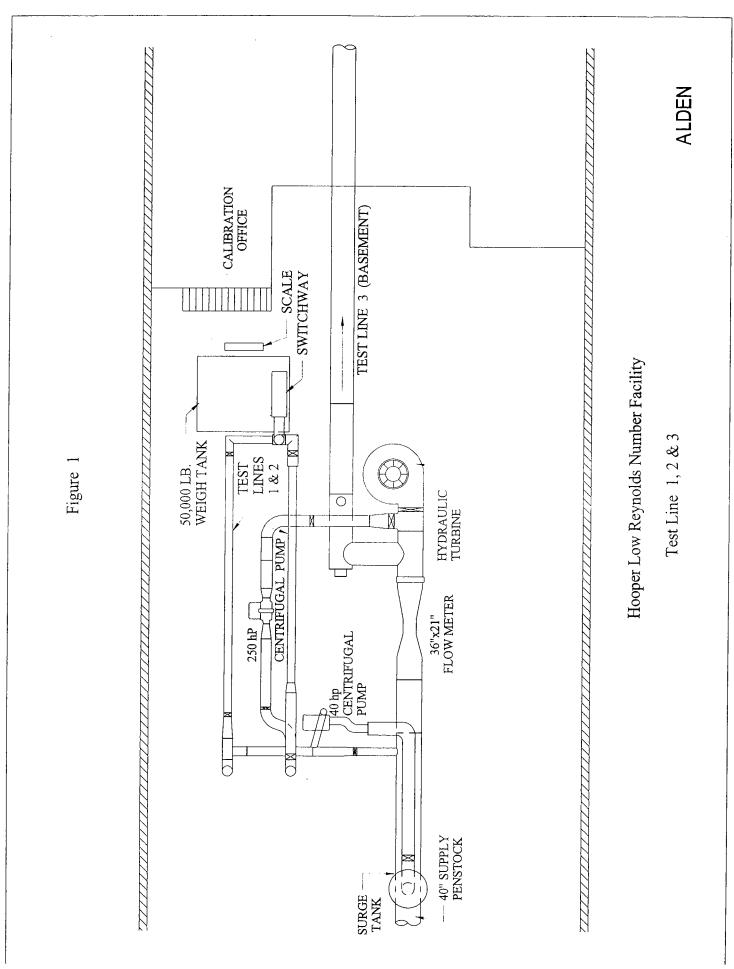
The detailed piping arrangement, immediately upstream and downstream of the flow meter, is shown in Figure 2,

including all significant fittings and pipe lengths. Careful attention was given to aligning the flow element with the test line piping and to assure no gaskets between flanged sections protruded into the flow. Vents were provided at critical locations of the test line to purge the system of air.

TEST PROCEDURE

After checking the installation, water was introduced into the system to equalize line and primary element temperature to water temperature. The downstream control valve was then closed and vent valves in the test line were opened to remove air from the system. With the line flow shut off, the flow meter output was checked for zero flow indication.

Prior to the test run, the control valve was set to the desired flow. For the gravimetric measurement method, the flow was diverted away from the weigh tank. After steady state conditions in the test



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line and instrument readings had been reached, the weigh tank discharge valve was closed and the weigh tank scale indicator and the electric timer were both zeroed. The flow was then diverted into the weigh tank, which automatically started the timer.

The weigh tank timer switch also activated the computer based data acquisition system to measure differential head while the weigh tank was filling. At the end of the run, flow was diverted away from the weigh tank and the timer and data acquisition system were stopped to terminate the test run. The weight of water in the tank, elapsed time, water temperature, and differential head were recorded on a data sheet. The control valve was then adjusted to the next flow and the procedure repeated. During the time allowed to stabilize the new flow, the data were entered into the computer to determine the flow and the results were plotted so that each test run was evaluated before the next run began.

FLOW MEASUREMENT METHOD

Flow was measured by the gravimetric method using a tank mounted on scales having a capacity of 45,000 pounds (resolution 0.5 lb). Water passing through the flow element was diverted into the tank with a hydraulically operated knife edge passing through a rectangular jet produced by a diverter head box. A Hewlett-Packard 10 MHz Frequency Counter with a resolution 0.001 sec was started upon flow diversion into the tank by an optical switch, which is positioned at the center of the jet. The timer was stopped upon flow diversion back to waste and the elapsed diversion time was recorded. A thermistor thermometer measured water temperature to allow calculation of water density. Volumetric flow was calculated by Equation (1).

$$q_a = \frac{W}{T\rho_w B_c} \tag{1}$$

where

$$q_a = actual flow, \frac{ft^3}{sec}$$

W = mass of water collected, lb_m

$$T = time, sec$$

$$\rho_{\rm w} = \text{water density, } \frac{\text{lb}_{\rm m}}{\text{ft}^3}$$

$$B_c$$
 = buoyancy correction, $1 - \frac{\rho_a}{\rho_w}$

$$\rho_a = \text{air density, } \frac{\text{lb}_m}{\text{ft}^3}$$

The buoyancy correction includes air density calculated by perfect gas laws with the standard barometric pressure, a relative humidity of 75%, and measured air temperature. The weigh tank is periodically calibrated to full scale by the step method using 10,000 lb_m of cast iron weights, whose calibration is traceable to NIST. Flow calculations are computerized to assure consistency. Weigh tank calibration data and water density as a function of temperature, are stored on disk file. Data were recorded manually and on disk file for later review and reporting.

TEST RESULTS

Test results are shown both in tabular form and plotted versus valve opening. The measured flow, line temperature, the transducer average reading used for calculation of the head loss in feet of water at line temperature are shown in the tables. Valve performance is given as the valve coefficient versus opening in percent. Three test flows were run at each 10% valve opening, from 10 to 100%. Tests were conducted with two inserts, standard and enhanced. The Valve Coefficient was measured at 10% openings using three differential pressures and the coefficient is plotted versus opening. Fl tests were conducted for an upstream pressure of 40 psi after the completion of the Cv tests. The effect of air admittance was evaluated for 90% and 50% openings.

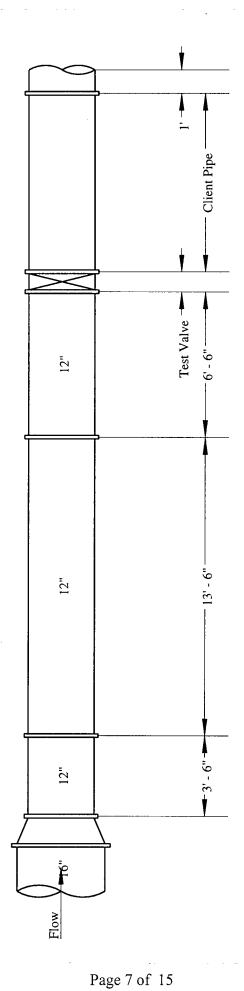
Mr. Zachary Finck and Bruce James of Stealth valve installed the modified plate and witnessed the testing.

Analysis indicates that the flow measurement uncertainty is within 0.25% of the true value for each test run. Calibrations of the test instrumentation (temperature, time, weight, and length measurements) are traceable to the National Institute of Standards and Technology (formerly the National Bureau of Standards) and Alden's Quality Assurance Program is designed to meet ANSI/NCSL Z540-1-1994 "Calibration Laboratories and Test Equipment-General Requirements" (supercedes MIL-STD-45662A).

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Figure 2 Plan View Hooper Facility Line 1



STEALTH VALVE & CONTROLS LTD Purchase Order Number: DD-11868 12" VALVE

July 18, 2006



4

112.09

112.09

14.996

34.721

0.004

34.725

5.3324

434.6

303.937

18292

6 6 7 8

19 20 21

	Opening %	100	888	08 80	07 07 07	999	50 50	40 40
0	CV Gross	892.31 890.24 887.74	835.52 840.87 844.75	723.43 704.65 690.99	495.79 513.01 519.10	322.35 321.84 321.84	195.43 194.55 192.67	110.50
t 2006 ER = 11.9770	CV Net	896.55 894.60 892.15	839.17 844.52 848.32	725.64 706.75 693.01	496.51 513.80 519.89	322.53 322.03 322.03	195.47 194.59 192.71	110.50
CALIBRATION DATE: July 19, 2006 PIPE DIAMETER =	Net Head Loss psi	5.084 9.924 14.846	14.957 10.000 5.077	5.099 9.928 14.990	15.068 10.079 5.204	5.126 10.150 15.477	14.996 10.168 5.305	5.455 9.926
CA DA PII	Net Head Loss F Feet	11.772 22.977 34.375	34.631 23.153 11.755	11.806 22.988 34.708	34.888 23.336 12.048	11.868 23.500 35.835	34.720 23.541 12.284	12.631 22.983
LTD	Pipe Loss Feet	0.112 0.226 0.342	0.303 0.201 0.100	0.072 0.137 0.203	0.101 0.071 0.037	0.013 0.027 0.042	0.014 0.009 0.005	0.001
	Gross Head Loss Feet	11.884 23.202 34.717	34.934 23.354 11.855	11.878 23.125 34.912	34.990 23.407 12.085	11.881 23.527 35.877	34.735 23.551 12.289	12.632 22.986
	Head Loss Reading F Volts	3.1412 4.2269 5.3312	5.3517 4.2410 3.1381	3.1402 4.2190 5.3498	5.3573 4.2461 3.1601	3.1406 4.2578 5.4424	5.3328 4.2602 3.1799	3.2129 4.2062
TROLS	Flow	2024. 2821. 3441.	3249. 2673. 1913.	1640. 2229. 2686.	1929. 1633. 1187.	731.0 1027. 1268.	757.8 621.2 444.4	258.4 351.6
STEALTH VALVE & CONTROLS LTD Purchase Order Number: DD-11868 12" VALVE Serial Number: STD	Run Duration secs.	163.669 117.513 96.363	102.076 124.033 173.131	201.869 148.633 123.417	171.689 163.865 221.656	181.945 130.634 140.244	176.118 213.122 200.348	260.595 250.600
	Net Weight Ib.	45881 45917 45921	45922 45916 45874	45851 45882 45907	45873 37051 36439	18418 18579 24631	18481 18334 12330	9326
	Line Temp Deg F	78 79 80	80 80 80 80	80 80 80	08 80 80	80 80 80	80 80 79	79
STEALTH Purchase Order Num 12" VALVE Serial Number: STD	Run #	3 2 1	4 % 9	7 8 6	10 11 12	13 14 15	16 17 18	19

STEALTH VALVE & CONTROLS LTD
Purchase Order Number: DD-11868

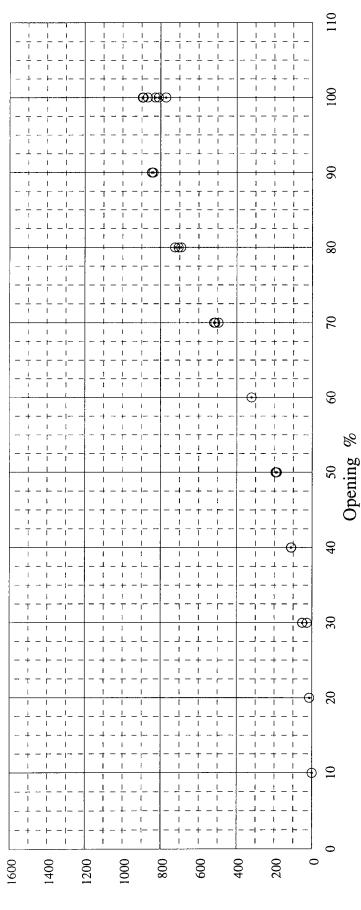
12" VALVE Serial Number: STD

CALIBRATION DATE: July 19, 2006 PIPE DIAMETER = 11.9770

Opening	%	30	30	30	20	20	20	10	100	100	100	100	100	20	20	30
CV		52.79	52.02	51.56	14.68	14.46	14.06	0.34	807.94	824.49	769.94	888.85	864.96	187.31	187.61	27.51
C C	Š	52.79	52.02	51.56	14.68	14.46	14.06	0.34	811.34	828.10	772.88	893.37	869.14	187.35	187.64	27.51
Net Head Loss	psi	15.146	10.024	4.957	15.372	10.225	5.103	15.237	28.107	26.984	30.970	22.494	24.368	36.564	36.565	47.776
	Feet	35.068	23.210	11.477	35.592	23.675	11.816	35.280	62.029	62.478	71.706	52.081	56.421	84.658	84.662	110.619
Pipe Loss	Feet	0.001	0.001	0.000	0.000	0.000	0.000	0.000	0.549	0.549	0.549	0.532	0.546	0.033	0.033	0.001
Gross Head Loss	Feet	35.069	23.211	11.477	35.592	23.675	11.816	35.280	65.627	63.027	72.255	52.612	996.95	84.691	84.695	110.620
Head Loss Reading	Volts	5.3654	4.2277	3.1020	5.4155	4.2723	3.1346	5.3856	8.2961	8.0458	8.9308	7.0469	7.4645	4.9196	4.9197	5.8139
Flow	GPM	205.6	164.9	114.9	57.63	46.29	31.80	1.323	4306.	4306.	4306.	4242.	4295.	1134.	1136.	190.3
Run Duration	secs.	320.685	291.908	380.378	419.711	324.273	471.507	212.847	77.030	77.044	77.056	78.220	77.243	156.615	156.983	460.564
Net Weight	.1b.	9135	9999	6054	3350	2079	2077	39	45933	45938	45939	45938	45936	24593	24690	12137
Line	Deg F	79	79	79	79	79	62	79	80	81	81	81	81	81	81	81
Run #		22	23	24	25	56	27	28	_	7	3	4	2	9	7	∞

The data reported on herein was obtained by measuring equipment the calibration of which is traceable to NIST, following the installation and test procedures referenced in this report, resulting in a flow measurement uncertainty of +/-0.25% or less.

CERTIFIED BYA



STEALTH VALVE & CONTROLS LTD
Purchase Order Number: DD-11868
12" VALVE
Serial Number: STD
July 19, 2006

Certified By: Gond 31 gt



STEALTH VALVE & CONTROLS LTD Purchase Order Number: DD-11868 12" VALVE Serial Number: Enhanced

CALIBRATION
DATE: July 18, 2006
PIPE DIAMETER = 11.9770

50							
Opening %	100 100 100	888	80 80 80	70 70 70	999	50 50 50	04 04 04 04
CV Gross	1039.63 1038.01 1002.71	977.71 965.88 924.20	739.88 795.42 839.81	631.15 604.59 567.20	402.98 423.78 430.97	274.81 276.84 272.41	167.55 166.36 165.18
CV	1046.45	983.35	742.38	632.59	403.36	274.92	167.57
	1045.05	971.51	798.49	605.90	424.22	276.95	166.39
	1009.17	929.20	843.32	568.30	431.41	272.53	165.20
Net	4.989	4.963	15.038	5.035	15.149	5.031	15.075
Head Loss	9.869	9.912	10.019	10.020	10.192	9.982	9.976
psi	15.010	15.016	5.075	14.944	5.176	15.223	5.292
Net	11.552	11.491	34.818	11.658	35.074	11.649	34.903
Head Loss	22.851	22.951	23.198	23.200	23.599	23.112	23.099
Feet	34.754	34.768	11.750	34.601	11.984	35.246	12.253
Pipe	0.152	0.133	0.236	0.053	0.066	0.009	0.010
Loss	0.311	0.268	0.179	0.100	0.048	0.019	0.007
Feet	0.449	0.378	0.098	0.134	0.025	0.029	0.003
Gross	11.705	11.624	35.054	11.711	35.140	11.659	34.914
Head Loss	23.162	23.219	23.377	23.300	23.647	23.131	23.105
Feet	35.203	35.145	11.849	34.734	12.009	35.275	12.256
Head Loss	3.1242	3.1158	5.3630	3.1242	5.3717	3.1193	5.3500
Reading	4.2227	4.2282	4.2430	4.2360	4.2693	4.2197	4.2176
Volts	5.3772	5.3717	3.1374	5.3328	3.1529	5.3846	3.1768
Flow GPM	2340. 3287. 3914.	2193. 3062. 3605.	2882. 2530. 1902.	1421. 1920. 2199.	1571. 1355. 982.6	617.4 876.0 1064.	651.4 526.1 380.5
Run	141.542	151.108	115.084	217.077	210.696	215.451	270.189
Duration	100.914	108.317	131.041	172.541	164.061	153.761	170.517
secs.	84.758	92.049	174.207	150.658	180.233	168.465	235.503
Net	45886	45883	45923	42710	45856	18418	24370
Weight	45929	45929	45907	45876	30803	18652	12425
Ib.	45933	45941	45874	45884	24523	24833	12410
Line	77	81	81	81	80	80	80
Temp	80	80	81	80	80	80	79
Deg F	81	81	81	80	80	80	79
Run #	3 2 1	4 % 9	7 8 6	10 11 12	13 14 15	16 17 18	19 20 21

STEALTH VALVE & CONTROLS LTD Purchase Order Number: DD-11868

12" VALVE Serial Number: Enhanced

CALIBRATION DATE: July 18, 2006 PIPE DIAMETER = 11.9770

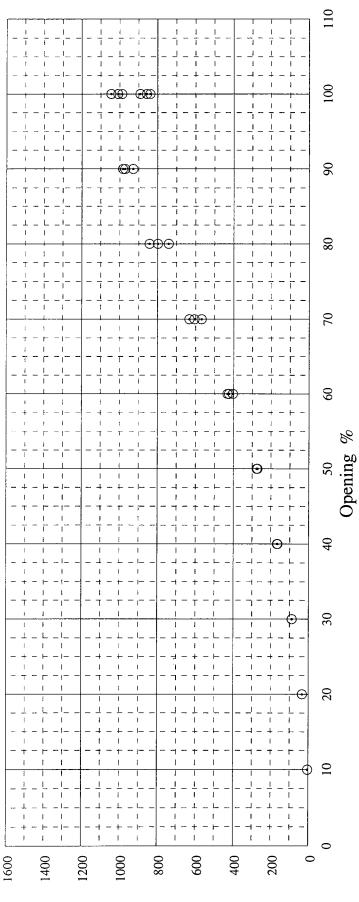
Opening %	30 30 30	20 20 20	10 100 100	100
CV Gross	88.65 88.73 88.05	33.36 33.30 32.92	4.23 835.49 852.86	887.41 981.45 1037.50
CV Net	88.66 88.74 88.06	33.36 33.30 32.92	4.23 839.29 856.90	891.97 987.62 1044.77
Net	10.248	5.164	15.204	28.060
Head Loss	15.054	15.205	31.762	22.849
psi	4.969	9.989	30.401	19.377
Net	23.728	11.956	35.203	64.970
Head Loss	34.855	35.206	73.539	52.904
Feet	11.505	23.127	70.389	44.864
Pipe Loss Feet	0.002 0.003 0.001	0.000	0.000 0.670 0.668	0.668 0.667 0.632
Gross	23.730	11.957	35.203	65.638
Head Loss	34.858	35.206	74.209	53.571
Feet	11.505	23.127	71.058	45.496
Head Loss	4.2775	3.1480	5.3782	8.2953
Reading	5.3451	5.3785	9.1204	7.1373
Volts	3.1048	4.2197	8.8171	6.3630
Flow GPM	284.1 344.7 196.5	75.90 129.9 104.1	16.51 4735. 4730.	4730. 4726. 4604.
Run	310.511	300.471	890.412	70.126
Duration	260.184	335.521	70.045	70.228
secs.	446.626	280.714	70.150	72.085
Net	12219	3158	2037	45920
Weight	12420	6040	45937	45940
Ib.	12155	4050	45948	45937
Line	97	97	79	82
Temp	97	97	79	83
Deg F	97	97	80	83
Run #	22 23 24	25 26 27	28	к 4 х

The data reported on herein was obtained by measuring equipment the calibration of which is traceable to NIST, following the installation and test procedures referenced in this report, resulting in a flow measurement uncertainty of +/- 0.25% or less.

CALIBRATED BY: THL

CERTIFIED BY:





STEALTH VALVE & CONTROLS LTD
Purchase Order Number: DD-11868
12" VALVE
Serial Number: Enhanced
July 18, 2006

Certified By: And Oth

CV Net



STEALTH VALVE & CONTROLS LTD Purchase Order Number: DD-11868

12" VALVE

Serial Number: Enhanced Plates

CALIBRATION DATE: July 19, 2006 PIPE DIAMETER = 11.9770

Open- ing %	50 50 50 50 50	50
CA	985.70 828.05 289.22 238.40	236.76
Head Loss Feet	6.5740 8.2488 13.3360 14.1837	41.0732
Head Loss Feet	6.5740 8.2488 13.3360 14.1837 39.4234	41.0732
Head Loss Reading Volts	2.6317 2.7923 3.2804 3.3617 5.7831	5.9414
Flow	1662. 1564. 694.9 590.7	998.4
Run Duration secs.	104.697 111.262 187.891 221.035	130.787
Net Weight Ib.	24111 24111 18083 18083	18083
Air Admittance Valve	Closed Open Open Closed	Open
Line Temp Deg F	97 97 97 97	62
Run #	1 2 6 4 9	9

The data reported on herein was obtained by measuring equipment the calibration of which is traceable to NIST, following the installation and test procedures referenced in this report, resulting in a flow measurement uncertainty of +/-0.25% or less.

CALIBRATED BY: THL

CERTIFIED BY:

WATER DENSITY

Temperature Fahrenheit	Density lb _m / ft ³	Temperature Fahrenheit	Density lb _m / ft ³	Temperature Fahrenheit	Density lb m / ft 3
32	62.4179	62	62.3549	92	62.0903
33	62.4201	63	62.3489	93	62.0788
34	62.4220	64	62.3427	94	62.0671
35	62.4235	65	62.3363	95	62.0552
36	62.4246	66	62.3296	96	62.0432
37	62.4255	67	62.3228	97	62.0311
38	62.4260	68	62.3157	98	62.0188
39	62.4262	69	62.3084	99	62.0063
40	62.4261	70	62.3010	100	61.9937
41	62.4257	71	62.2933	101	61.9810
42	62.4250	72	62.2855	102	61.9681
43	62.4240	73	62.2774	103	61.9551
44	62.4227	74	62.2692	104	61.9419
45	62.4211	75	62.2608	105	61.9286
46	62.4193	76	62.2522	106	61.9151
47	62.4171	77	62.2434	107	61.9015
48	62.4147	78	62.2344	108	61.8878
49	62.4121	79	62.2252	109	61.8739
50	62.4092	80	62.2159	110	61.8599
51	62.4060	81	62.2063	111	61.8458
52	62.4025	82	62.1966	112	61.8315
53	62.3988	83	62.1868	113	61.8172
54	62.3949	84	62.1767	114	61.8027
55	62.3907	85	62.1665	115	61.7880
56	62.3863	86	62.1561	116	61.7733
57	62.3816	87	62.1456	117	61.7584
58	62.3768	88	62.1348	118	61.7434
59	62.3716	89	62.1239	119	61.7284
60	62.3663	90	62.1129	120	61.7132
61	62.3607	91	62.1017	121	61.6978