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**Twin City Fan & Blower Guide Specification
Airfoil Centrifugal Fans: Model BAE-DW Series, Direct or Belt Driven**

**Twin City Fan & Blower Model BAE-DW** is a double-width, double-inlet, centrifugal fan. The BAE-DW fan is designed with a non-overloading wheel with airfoil profile fan blades, making the BAE-DW an efficient and low noise choice for clean air applications. Model BAE-DW fans offer superior air and sound performance and the AMCA certified rating seal for air and sound.

**Application**

Model BAE-DW is suitable for indoor or outdoor locations, with free or ducted inlets and outlets. A split housing option is available, which allows fan wheel and shaft removal without disconnecting the attached ductwork. The BAE-DW mounts horizontally or vertically, allowing for numerous applications with multiple mounting arrangements

Sizes (wheel diameter): 12.25 to 98.25 inches (315 mm to 2,500 mm)

Airflow to 419,500 CFM (712,700 m3/hour)

Static pressure to 14 inches wg (3,500 Pa)

TCF is an industry leading designer and manufacturer of high quality commercial and industrial fans and is a division of Twin City Fan Companies, Ltd. Our extensive product line includes centrifugal fans and blowers, axial fans, and power roof ventilators. For the commercial market, TCF supplies ventilation fans for retail and office buildings, restaurants, schools, hospitals, and government buildings. TCF’s industrial fans are used in a wide variety of process applications for numerous industries including Petrochemical, Nuclear, Cement, Steel, and Air Pollution Control. Special materials, construction, coatings, and accessories are available to fit any application requirements.

TCF has completed thousands of successful installations across the globe and has a proven track record for tackling the most technically complex applications within the fan industry. TCF is also known for its technical design capabilities, comprehensive testing services, and responsive sales team. Due to the company’s extensive expertise and long-standing reputation for proven quality, TCF products continue to be specified around the globe.

TCF occupies over 1,000,000 sq. ft. of manufacturing space across ten facilities in the U.S, with expanded manufacturing and service operations located in South America, Europe, India, China, and Singapore. Headquarters are located in Minneapolis, Minnesota, which houses the management, sales and marketing, accounting, human resources, material management, engineering personnel, as well as a state-of-the-art AMCA accredited testing lab.

We recommend you consult with your Twin City Fan & Blower Sales Representative, who can be contacted through: Twin City Fan & Blower, Minneapolis MN; (763) 551-7600; email: tcf\_sales@tcf.com; [www.tcf.com](http://www.tcf.com).

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SECTION 23 34 16.01 – AIRFOIL CENTRIFUGAL FANS

1. GENERAL
	* + 1. SUMMARY

Specifier: Select direct or belt driven unit in following paragraph.

* + - * 1. Section includes double-width, double-inlet (DWDI) centrifugal airfoil fans, [direct-] [belt-] driven.
			1. REFERENCE STANDARDS

Specifier: Select direct or belt driven unit in following paragraph.

* + - * 1. Anti-Friction Bearing Manufacturers Association (AFBMA): [www.americanbearings.org](http://www.americanbearings.org/):

ABMA 9 – Load Ratings and Fatigue Life for Ball Bearings

ABMA 11 – Load Ratings and Fatigue Life for Roller Bearings

* + - * 1. Air Movement and Control Association International, Inc. (AMCA): [www.amca.org](http://www.amca.org):

ANSI/AMCA Standard 99 - Standards Handbook

ANSI/AMCA Standard 204 - Balance Quality and Vibration Levels for Fans

ANSI/AMCA Standard 205 – Energy Efficiency Classification for Fans

ANSI/AMCA Standard 210 - ANSI/ASHRAE 51 - Laboratory Methods of Testing Fans for Certified Aerodynamic Performance Rating

AMCA Publication 211 - Certified Ratings Program - Product Rating Manual for Fan Air Performance

ANSI/AMCA Standard 300 - Reverberant Room Method for Sound Testing of Fans

AMCA Publication 311 - Certified Ratings Program - Product Rating Manual For Fan Sound Performance

* + - * 1. National Electrical Manufacturers Association (NEMA): [www.nema.org](http://www.nema.org)

MG 1 – Motors and Generators

* + - * 1. National Fire Protection Association (NFPA): [www.nfpa.org](http://www.nfpa.org):

NFPA 70 - National Electric Code

* + - * 1. Office of Statewide Health Planning and Development (OSHPD): https://www.oshpd.ca.gov/

OSHPD Special Seismic Certification Preapproval OSP-0355-10

ICC-ES AC 156 – Acceptance Criteria for Seismic Certification by Shake-Table Testing of Nonstructural Components

* + - * 1. Underwriters Laboratories, Inc. (UL): [www.ul.com](http://www.ul.com):

UL 705 - Standard for Power Ventilators

* + - 1. ACTION SUBMITTALS
				1. Product Data: Include the following:

Rated capacities and operating characteristics.

Fan Performance Data: Fan performance curves with flow, static pressure and horsepower.

Sound Performance Data: Fan sound power levels in eight octave bands and, A-weighted overall sound power level or sone values.

Motor ratings and electrical characteristics.

Furnished specialty components.

Specified accessories.

Dimensioned standard drawings indicating dimensions, weights, and attachments to other work.

Specifier: If Contractor will be required to provide engineering drawings and calculations for vibration, seismic, or high wind design, insert requirements here.

* + - 1. INFORMATIONAL SUBMITTALS
				1. Source quality-control reports.
				2. Field quality-control reports.
				3. ISO-9001 certificate.
			2. CLOSEOUT SUBMITTALS
				1. Operation and Maintenance Data: Include routine maintenance, adjustment requirements, safety information, and troubleshooting guide.
			3. QUALITY ASSURANCE
				1. Manufacturer Qualifications: Approved ISO 9001-compliant manufacturer listed in this Section with minimum 10 years' experience in manufacture of similar products in successful use in similar applications.

Specifier: Retain paragraph below if Owner allows substitutions but requires strict control over qualifying of substitutions.

Approval of Comparable Products: Submit the following in accordance with project substitution requirements, within time allowed for substitution review:

Product data, including certified independent test data indicating compliance with requirements.

Project references: Minimum of 5 installations not less than 5 years old, with Owner contact information.

Sample warranty.

Substitutions following award of contract are not allowed except as stipulated in Division 01 General Requirements.

Approved manufacturers must meet separate requirements of Submittals Article.

* + - * 1. AMCA Compliance:

Provide fan types tested in accordance with AMCA Standard 210 (air performance) and AMCA Standard 300 (sound performance) in an AMCA-accredited laboratory.

Provide fan units rated according to AMCA Standard 211 (air performance) and AMCA Standard 311 (sound performance) in an AMCA-accredited laboratory.

Provide fan units rated according to AMCA Standard 205 (fan efficiency grade)

* + - 1. COORDINATION
				1. Coordinate sizes and locations of supports required for fan units.
				2. Coordinate sizes and locations of equipment supports, and roof penetrations.
			2. FIELD CONDITIONS
				1. Handling and Storage: Handle and store fan units in accordance with manufacturer's published instructions. Examine units upon delivery for damage. Store units protected from weather.
			3. WARRANTY

Specifier: Consult Twin City Fan & Blower for available special, Project-specific warranties.

* + - * 1. Manufacturer's Warranty: Manufacturer's standard form in which manufacturer agrees to furnish replacement components for fan units that demonstrate defects in workmanship or materials under normal use within warranty period specified.

Warranty Period: 12 months from startup or 18 months from shipment by manufacturer, whichever first occurs.

1. PRODUCTS
	* + 1. MANUFACTURER
				1. Basis-of-Design Manufacturer: Provide fan units manufactured by **Twin City Fan & Blower**, Minneapolis MN; (763) 551-7600; email: tcf\_sales@tcf.com; website: [www.tcf.com](http://www.tcf.com).
				2. Source Limitations: Obtain centrifugal airfoil fans from a single manufacturer.
			2. PERFORMANCE REQUIREMENTS
				1. Fan Performance Ratings: [Project site elevation- based] [Sea level-based].
				2. AMCA Compliance: Provide units that bear the AMCA-Certified Ratings Seal.
				3. Compliance:

Classified under AMCA Standard 205.

Classified under UL 705.

* + - 1. CENTRIFUGAL AIRFOIL FANS
				1. Description: [Direct-] [Belt-] Driven Centrifugal Airfoil Fans: Double-width, double-inlet (DWDI) centrifugal airfoil fans.

Basis of Design Product: **Twin City Fan & Blower, Model BAE-DW**.

Specifier: Coordinate fan orientation with notations on drawings.

* + - * 1. Configuration: Provide unit with fan inlet and discharge directions as indicated on Drawings.
				2. Fan Wheels: Provide fabricated wheel with airfoil blades continuously welded to flat rim and backplate. Hub to be keyed to shaft. Partial welds are not acceptable.

Materials of Construction: Manufacturer's standard, based on wheel size and pressure class.

Statically and dynamically balance wheel.

Minimum Balance Quality Grade: G6.3, in accordance with AMCA Standard 204.

* + - * 1. Fan Shaft:

AISI 1045 hot-rolled steel.

Turn, grind, and polish shaft.

Size shaft for first critical speed minimum 1.43 times maximum speed for each fan class.

Apply petroleum based rust preventative coating.

Key shaft to wheel hub.

Include OSHA compliant [shaft] [shaft and bearing] guard.

Specifier: Where required, select option in the following paragraph to include extended grease lines.

* + - * 1. Bearings: Heavy-duty, grease lubricated, spherical roller or anti-friction ball, self-aligning, pillow block type, based on fan size and mounting orientation[, with grease lines extended to outside fan housing].

Minimum Average Bearing Life: ABMA L-50 = 200,000 hours at the maximum fan RPM.

* + - * 1. Housing: Continuously welded [steel] [aluminum] [304 stainless steel] [316 stainless steel], reinforced with rigid bracing. Includes aerodynamically spun inlet cones.

Specifier: Retain the following paragraphs as required by Drawing Schedule

Access Door - [Bolted flush with interior] [Raised Bolted [[4 inches (102 mm)] [6 inches (152 mm)] [8 inches (203 mm)]] [Quick Open Latched]

Drain: 3/4 inch NPT [with plug].

Specifier: When insulated housing required for sound or temperature, retain following paragraph. Select option for insulation type.

Provide [factory fabricated steel wall insulated housing] [aluminum clad insulated housing]; minimum thickness [2 inches (51 mm)] [\_\_\_\_\_]. Anchor housing insulation with weld pins].

Specifier: When connecting flanges are required for ductwork, retain following paragraph. Select option for factory punched holes, when required.

Provide housing with [pre-punched] flanges for making connections to ductwork.

Specifier: Direct drive is available only for Arrangement 3DI and 7DI fans. Delete paragraph and its subparagraphs if only belt-driven units are required.

* + - * 1. Direct Drive:

Specifier: Retain paragraph below for direct drive, Arrangement 3DI and 7DI only.

Provide coupling with service factor of 1.5 x motor HP between motor and fan shaft.

Include OSHA compliant coupling guard.

Specifier: Retain paragraph and subparagraphs below for belt-driven units only.

* + - * 1. Belt Drive:

Drive Components: V-belt drive, rated for minimum 150 percent of motor nameplate horsepower, with machined, cast-iron pulleys, and heat resistant, oil resistant, static-free V-belts.

Motor 10 HP and Smaller: Adjustable pitch.

Motor 15 HP and Larger: Fixed pitch.

Specifier: Retain options in the following paragraph when required.

Belt Guard: Steel, ventilated, OSHA compliant [quick access designed with hinged front and rubber latches].

* + - * 1. Motors: Comply with NEMA MG-1 for designation, temperature rating, service factor, enclosure type, and efficiency requirements for motors specified in Division 23 section "Common Motor Requirements for HVAC Equipment."

Motor Sizes: Minimum size as indicated. If not indicated, large enough so driven load will not require motor to operate in service factor range above 1.0.

Motor Speed: Based upon performance requirements and application.

Specifier: If factory disconnect is required, select NEMA enclosure rating in following paragraph, and select one subparagraph below to specify factory or field mounting. Retain second subparagraph when NEMA 7/9 (explosion proof) option is selected.

Provide unfused disconnect switch, NEMA [1] [3R] [4] [4X] [7/9 explosion proof], selected in accordance with Division 26 section "Enclosed Switches."

Factory mount and wire disconnect switch.

Ship disconnect switch loose for field mounting and wiring.

Specifier: Select motor electrical data in following subparagraphs, or show this data on the drawing fan schedule. Do not show the data in both places.

Electrical Data:

Voltage: [115] [208] [230] [460] [575] [\_\_\_\_\_] V; [1] [3] phase; 60 Hz.

Voltage: [190] [380] [\_\_\_\_\_] V; [1] [3] phase; 50 Hz.

Specifier: Select motor enclosure type in first following subparagraph.

Enclosure Type: [Open, Drip Proof (ODP)] [Totally Enclosed Fan Cooled (TEFC)]

Specifier: For motors located in hazardous locations, select one or the other of the following. If motor is not located in hazardous location, delete subparagraph. Consult TCF for hazardous location classification availability.

[Explosion Proof] [ATEX].

Provide motors that comply with the Energy Independence and Security Act of 2007 (EISA).

Specifier: For motors controlled by VFDs, retain the following subparagraph.

When controlled with a Variable Frequency Drive (VFD), provide premium efficiency motors suitable for inverter duty use.

Specifier: Retain paragraph below for belt-driven units only.

* + - * 1. Motor Mounting Platform: Heavy-duty motor mounting platform that adjusts to allow adjustment of drive belt tension. Motor location per drawing schedule.

Specifier: Retain paragraph and subparagraph below when isolation is required, and coordinate options with project design.

* + - * 1. Vibration Isolation:

Provide isolation of fan from connected piping, duct work and foundation in accordance with fan manufacturer's requirements, and Division 23, Section "Vibration and Seismic Controls for HVAC Piping and Equipment."

Specifier: Retain the following paragraphs for smaller sized Arrangement 9 and 10 fans only. Select options as required. Consult TCF for assistance.

For fans mounted directly to foundation, provide [spring] [neoprene-in-shear] vibration isolators, [and seismic restraints].

Spring Isolators: Select for [1 inch (25.4 mm)] [2 inch (51 mm)] deflection.

Specifier: Retain the following paragraphs if fan is to be mounted on a separate base.

Isolation Type Base:

Specifier: Delete paragraph 1 for fans in Arrangement 3DI, 7DI, or 8. Select options as required.

Spring isolation base: Provide spring isolators [and seismic restraints] with [1 inch (25.4 mm)] [2 inch (51 mm)] deflection.

Inertia type base: Provide spring isolators [and seismic restraints] with [1 inch (25.4 mm)] [2 inch (51 mm)] deflection.

Specifier: The following paragraph is not for standard fan units. Retain paragraph below for fans requiring frequent cleaning and service, or where service through a duct access door is not suitable.

* + - * 1. Interior Access:

Specifier: Paragraph 1 below represents standard construction features for all fans except Arrangement 3DI and 7DI. Delete for Arrangements 3DI and 7DI. Paragraph 2 represents optional access method that might be applied for fans requiring frequent inspection or cleaning.

Design fan to allow for wheel removal through fan inlet opening.

Specifier: Paragraph 2 below represents standard construction features for Arrangement 3DI and 7DI. Delete for sizes 245 and smaller.

Split Housing: Provide two mating sections that lift apart to allow total access to interior of fan wheel. Include bolts, hardware, and full gasketing.

* + - * 1. Coatings:

Specifier: Retain paragraph 1 or 2 based on application requirements. Delete remaining paragraph.

Standard Coating: All carbon steel components shall be cleaned and chemically treated by a phosphatizing process. Fan shall then be coated with blue enamel.

Special Coating: [\_\_\_\_\_]

Specifier: The following paragraph is not for standard fan units. Retain paragraph below for fans requiring frequent cleaning and service, or where service through a duct access door is not suitable.

* + - * 1. Accessories:

Specifier: Accessories listed in subparagraphs below are optional TCF features for this unit. Consult TCF representative for recommended options based upon Project requirements.

Specifier: Where external access to fan wheel is required, select from the access door options in the following paragraph. Note: Arr. 3DI and 7DI are provided with flanged inlet and outlet

Flexible Duct Connections: Provide elastomer round and rectangular flexible connection assemblies with duct flanges matching fan outlet connections.

Outlet flanges[, with pre-punched bolt holes].

Outlet Companion Flanges: Provide slip-on flanges matching fan housing flange size and bolt-hole pattern.

Drain with Plug: Threaded pipe coupling, 3/4 inch NPT, welded to lowest point on housing scroll.

Specifier: Where required, include fan inlet boxes as indicated in the following paragraph. Inlet boxes are designed to minimize pressure drop and are recommended for applications where uniform flow is difficult to obtain due to limited space. Inlet boxes can be designed to be either detachable or integral to the fan.

Inlet boxes are available for Arrangement 3DI and 7DI only. When required, provide optional features listed in the subparagraphs below.

Inlet Boxes: Match housing construction with integral configuration with fan housing.

Access Door - [Bolted flush with interior] [Raised Bolted [[4 inches (102 mm)] [6 inches (152 mm)] [8 inches (203 mm)]] [Quick Open Latched]

Drain: 3/4 inch NPT [with plug].

Provide [factory fabricated insulated housing] [aluminum clad insulated housing; minimum thickness [2 inches (51 mm)] [\_\_\_\_\_]. Anchor housing insulation with weld pins].

Volume Control Devices

Specifier: For inlet vane dampers, nested dampers take up less space. External dampers are suitable for hostile environments with dirty air streams. Consult TCF for application recommendations.

Inlet Vane Dampers: Provide pre-rotational inlet vane dampers nested in fan inlet at 70 - 300 deg. F (21 - 148 deg. C)

Outlet Dampers: (Parallel-blade) (Opposed-blade) dampers suitable for modulating fan delivery at discharge static pressure at [70 - 300 deg. F (21 - 148 deg. C)] [301 - 600 deg. F (149 - 316 deg. C)] [601 - 800 deg. F (316 - 427 deg. C)].

Inlet Box Damper: Welded construction, suitable for modulating fan delivery at [70 - 300 deg. F (21 - 148 deg. C)] [301 - 600 deg. F (149 - 316 deg. C)] [601 - 800 deg. F (316 - 427 deg. C)].

Actuators

Specifier: Select applicable paragraph and subparagraphs when actuator is required for volume control device(s).

Actuators listed in subparagraphs below offer various construction features and options. Consult TCF for recommended options based upon Project requirements.

Electric actuator

Double acting pneumatic actuator (air-to-air)

Specifier: Select applicable subparagraph and delete remaining subparagraphs

Two-position

Modulating service with pneumatic positioner

Modulating service with electro-pneumatic positioner

Pneumatic actuator with spring return (air-to-spring)

Specifier: Select applicable subparagraph and delete remaining subparagraphs

Two-position

Modulating service with pneumatic positioner

Modulating service with electro-pneumatic positioner

Specifier: Retain following paragraph if safety screens are required. Select options in paragraph to designate screen locations.

Safety Screens: Provide screens at fan [inlet] [outlet].

UL 705 Compliant Assembly: Provide components required for UL 705 compliance. Affix UL 705 labeling and nameplate to finished unit.

Stainless steel nameplate.

Specifier: Where flow measurement is required, retain following subparagraph. This flow measurement device can be used with instrumentation provided by Twin City Fans, or instrumentation provided as the work of a separate contract.

Piezometer Ring: Provide piezometer ring type differential pressure device with connections for field-installed flow measuring instrumentation.

Pressure Transducer without Display: Provide piezometer ring and transducer to convert differential pressure readings to 4 - 20 mA DC signal proportional to flow.

Specifier: When required, retain enclosure option in following paragraph.

Pressure Transducer/Transmitter with Display [NEMA 4X Enclosure]: Provide piezometer ring and transducer with local digital display to convert differential pressure readings to 4 - 20 mA DC signal proportional to flow. Include two independently adjustable SPDT dry-contact outputs.

Specifier: Where shaft seals are required to limit leakage and protect bearings from the airstream, retain the following paragraph. For lower leakage seals, add requirements to the following paragraph.

Shaft seals are available for Arrangement 3DI and 7DI only.

Shaft Seals: Provide shaft seal constructed of woven fibrous compressed between aluminum cover plate and fan housing.

Special seals are available for low leakage applications requiring more protection.

Specifier: Retain the following paragraph when OSHPD Seismic Certification is required for the project

Available accessories when OSHPD Seismic Certification is required are limited to the following:

• Shaft and bearing guard • Piezometer Ring

• Pressure Transducer/Transmitter • Extended Lube Lines

• Horizontal Split Housing • UL 705

• Stainless Steel Nameplate • Bearing Upgrades

• Drain: ¾”, W/Plug

• Access Door: Bolted, Hinged

• Flange: Inlet, Outlet; Punched, Unpunched

• Belt Guard: OSHA Type, Quick Access Type

• Outlet Damper: Opposed Blade, Parallel Blade

OSHPD Seismic Certification: Provide unit construction compliant with California’s Office of Statewide Health Planning and Development seismic certification of equipment and components.

The Design will be in Accordance with ASCE 7-10 Chapter 13.

Fan will include a 2” Isolation base with seismic spring isolators.

* + - 1. SOURCE QUALITY CONTROL
				1. Factory Run Test: Statically and dynamically balance each wheel in accordance with AMCA Standard 204 "Balance Quality and Vibration Levels for Fans" to Fan Application Category BV-3, Balance Quality Grade G6.3. Test run assembled fan units prior to shipment at specified operating speed or maximum RPM allowed. Obtain balance readings by electronic equipment in the axial, vertical, and horizontal directions on each set of bearings.
1. EXECUTION
	* + 1. EXAMINATION
				1. Examine areas to receive fans. Notify Engineer regarding conditions that may adversely affect installation, operation, or maintenance of fans. Proceed with installation once conditions are in accordance with manufacturer's published instructions.
			2. PROTECTION
				1. Protect adjacent construction and finished surfaces during installation and testing.
				2. Except for operational testing, do not operate fan during construction.
			3. INSTALLATION
				1. Install fans in accordance with Contract documents and manufacturer's published instructions.

Specifier: Insert applicable installation requirements for vibration, seismic, and high wind design if applicable to installation.

* + - * 1. Install fan units with adequate clearances for service and maintenance.

Specifier: Coordinate duct installation and specialty arrangements with schematics on Drawings and with requirements specified in duct systems. If Drawings are explicit enough, these requirements may be reduced or omitted.

* + - * 1. Duct Connections: Drawings indicate general arrangement of ducts and duct accessories. Where indicated on Drawings, [install factory-furnished companion flanges and] make final duct connections with flexible connectors. Flexible connectors are specified in Division 23 section "Air Duct Accessories."

Install connecting ducts with adequate clearances for service and maintenance.

* + - * 1. Electrical Connections: Connect wiring in accordance with NFPA 70 and Division 26 section "Low-Voltage Electrical Power Conductors and Cables."

Ground and bond equipment according to Division 26 section "Grounding and Bonding for Electrical Systems."

* + - * 1. Equipment Identification: Label units according to Division 23 section "Identification for HVAC Piping and Equipment."
			1. FIELD QUALITY CONTROL

Specifier: Select option in paragraph below to define the party responsible for final tests and inspections to be performed.

* + - * 1. [Owner will retain] [Contractor shall retain] qualified testing agency to perform field tests and inspections.

Specifier: Retain first paragraph below to describe tests and inspections to be performed.

* + - * 1. Tests and Inspections:

Verify that unit is secured to supports, and that duct and electrical connections are complete. Verify that proper thermal-overload protection is installed in motors, starters, and disconnect switches.

Verify that cleaning and adjusting are complete.

Specifier: Retain option in following paragraph for belt driven units. Otherwise, delete option.

[Disconnect fan belt drive from motor.] Verify proper motor rotation direction, and verify fan wheel free rotation and smooth bearing operation. Reconnect fan drive system, align and adjust belts, and install belt guards.

Verify that manual and automatic volume control, and fire and smoke dampers in connected ductwork systems are in fully open position.

Disable automatic temperature-control actuators, energize motor, adjust fan to indicated rpm, and measure and record motor voltage and amperage.

Shut unit down and reconnect automatic temperature-control actuators.

Remove and replace malfunctioning units and retest as specified above.

* + - * 1. Test and adjust controls and safeties. Replace damaged and malfunctioning controls and equipment.
				2. Submit test and inspection reports.
			1. ADJUSTING AND CLEANING
				1. Adjust, clean, and maintain installed fan units in accordance with manufacturer's published instructions.

END OF SECTION