



INDUSTRIAL PROCESS AND  
COMMERCIAL VENTILATION SYSTEMS

## MIXED FLOW INDUCED FLOW EXHAUST FANS

MODEL QIFE, BELT DRIVEN



# MIXED FLOW FANS

## Overview QIFE



Twin City Fan & Blower certifies that the Model QIFE Mixed Flow Induced Flow Exhaust Fans shown herein are licensed to bear the AMCA Seal. The ratings shown are based on tests and procedures performed in accordance with AMCA Publication 211 and 311 and comply with the requirements of the AMCA Certified Ratings Program. The AMCA Certified Ratings Seal applies to Induced Flow Fan Air and Sound Performance tested in accordance with AMCA Standard 260. See Catalog 1081 for sound ratings.



Model QIFE is available with UL/cUL 705 listing, for electrical, File No. E158680.

Twin City Fan & Blower offers a specially modified version of the QSL fan designated as "QIFE" for induced flow laboratory fume hood exhaust applications, available in sizes 90 through 542.

The QIFE fan consists of a vertically mounted QSL unit with one of three different nozzles and specially designed windband to maximize dilution ratio (overall outlet volume/lab outlet volume) and plume height.

Mounted on a modular designed mixing plenum box or curb cap, the QIFE is capable of generating an induced flow to meet stringent roof exhaust requirements.

QIFE fans in a standard configuration utilize a heavy-duty curb cap. An optional modular mixing plenum box includes an integrated curb cap.

### Benefits of Mixed Flow Fans

Twin City Fan & Blower Model QIFE Mixed Flow Induced-Flow Fans combine the benefits of axial flow and centrifugal flow fans with the added benefit of entraining ambient air for a pre-diluted plume. The QIFE has the advantages of an axial fan in its compact design and straight-through airflow combined with a centrifugal fan's preferred acoustical characteristics and high pressure capabilities. QIFE fans offer superior air and sound performance and the AMCA certified rating seal for air and sound.

### Sizes

12.25" to 66" wheel diameters

### Performance

Airflow to 71,000 CFM

Static pressure to 8" w.g.



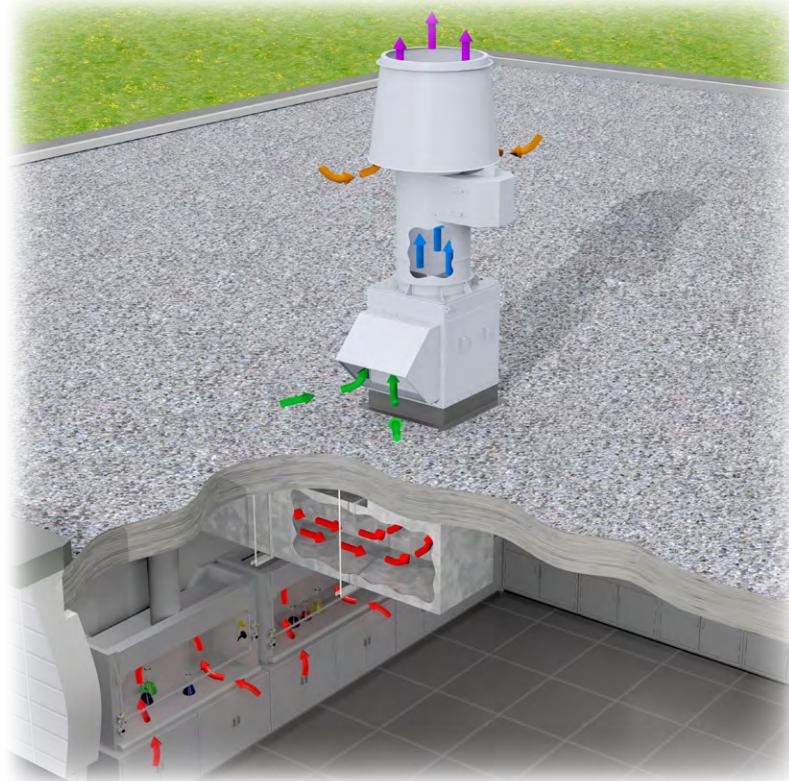
For complete product performance, drawings and available accessories, download our Fan Selector program at [tcf.com](http://tcf.com).

## Application

### QIFE

The QIFE Induced Flow Mixed Flow Exhaust Fan is intended for use in exhausting laboratory fumes and hazardous chemicals in such a manner that diminishes the likelihood of concentrated, contaminant-laden air from being re-entrained into the building's intake or makeup air. This unit is commonly used in exhaust systems for universities, schools, hospitals, research facilities, laboratories and waste water treatment plants.

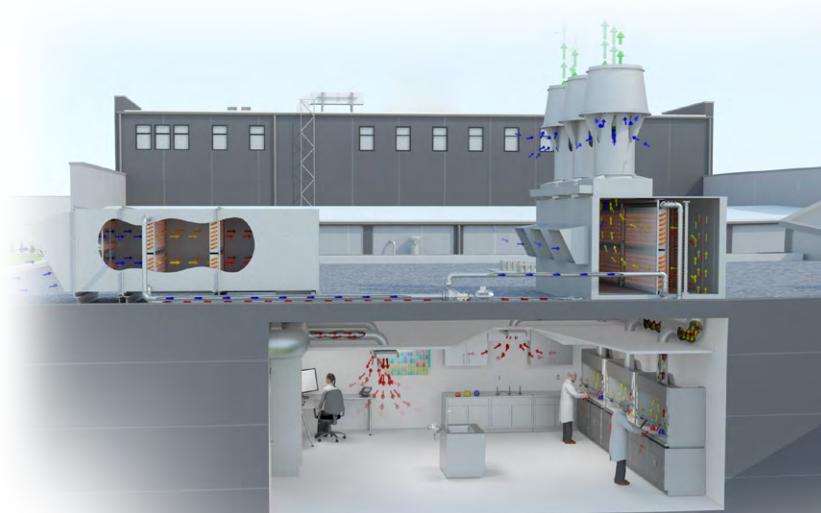
Induced flow exhaust fans dilute contaminated air at the outlet as well as increase the outlet volume of the fan. This accelerates the discharge air, increasing plume height without a tall stack.



### Energy Recovery Systems

Twin City Fan & Blower energy recovery systems for fume exhaust applications combine our line of high efficiency fume exhaust fans with the latest in energy recovery technology. TCF can greatly reduce your energy consumption and carbon footprint while simultaneously increasing your bottom line. Our energy recovery plenums are available in endless configurations to match your specific needs.

TCF's energy recovery systems are designed to extract energy from the conditioned air exiting the laboratory and return the captured energy back into the make-up air unit before it re-enters the building. Energy recovery systems can also be used to pre-cool incoming supply air by removing the heat from the incoming airstream and sending it to the exhaust system.



# CONSTRUCTION



**Inner Cylinder** tube is rigidly constructed to support the shaft and bearings. The removable discharge cone provides full access to the shaft, bearings, and fan sheave.

**Drain** coupling welded to the lowest point of the housing allows drainage of condensate from fan housing.

**Nozzle Drain** A drain tube routed to the outside of the housing allows for drainage of the nozzle tray, reducing the amount of precipitation entering the fan housing.

**NOTE:** While precipitation entry into the fan and duct system is greatly reduced while the fan is in operation, precipitation may enter in while the fan is not operating. Care must be taken by the system designer, building owner, and user to consider precipitation mitigation and moisture draining for the fume exhaust system.

**Windbands** are designed to maximize plume height and entrainment air. Constructed of heavy-gauge steel for strength and rigidity, the windband is mounted directly to the fan housing.

**Straightening Vanes** convert tangential velocity pressure into useful static pressure, reducing turbulence and increasing efficiency. Extensive testing of various shapes and locations has resulted in the most efficient aerodynamic design of the straightening vanes.

**Bolted Access Door** for inspection or cleaning of the wheel.

**Weather Cover** completely encloses the motor and V-belt drive from the elements. Provided with slots for ventilation, covers are easily removable for inspection and maintenance.

**Heavy Duty Motor Mounting Platform** pivots to offer easy and positive adjustment of belt tension.

**Wheel/Impeller** is designed with die-formed, continuously-welded single-thickness or airfoil blades for a stable air performance throughout the operating range.

**Curb Cap** attaches to the fan's flange for curb mounting. Standard accessory on QIFE without mixing plenum box.

**Extended Lube Lines** allow for ease of lubrication on all sizes.

**Stainless Steel Hardware** is standard for corrosion resistance.

**Bearings** are selected to exceed the L-10 life of 200,000 hours at the maximum operating speed.

**Drives** - Cast iron, adjustable or fixed pitch drives are selected for at least 200% of motor horsepower. Adjustable sheaves are provided on motors up to 10 HP, fixed sheaves for 15 HP and above.

V-belt drives with motors and drives mounted by Twin City Fan & Blower are set to the required RPM and test run as a complete assembly and rechecked for balance.

**Sealed Belt Tube** encloses the belts and drive components, protecting them from the airstream.

**Shaft Seal** limits the air entering the inner cylinder and avoid contact of airstream contaminants with the bearings and V-belt drive. Consists of a Teflon wear pad/plate and a rubber chekseal at the wheel end of the inner cylinder. Please note that a shaft seal does not make the inner cylinder gas tight.

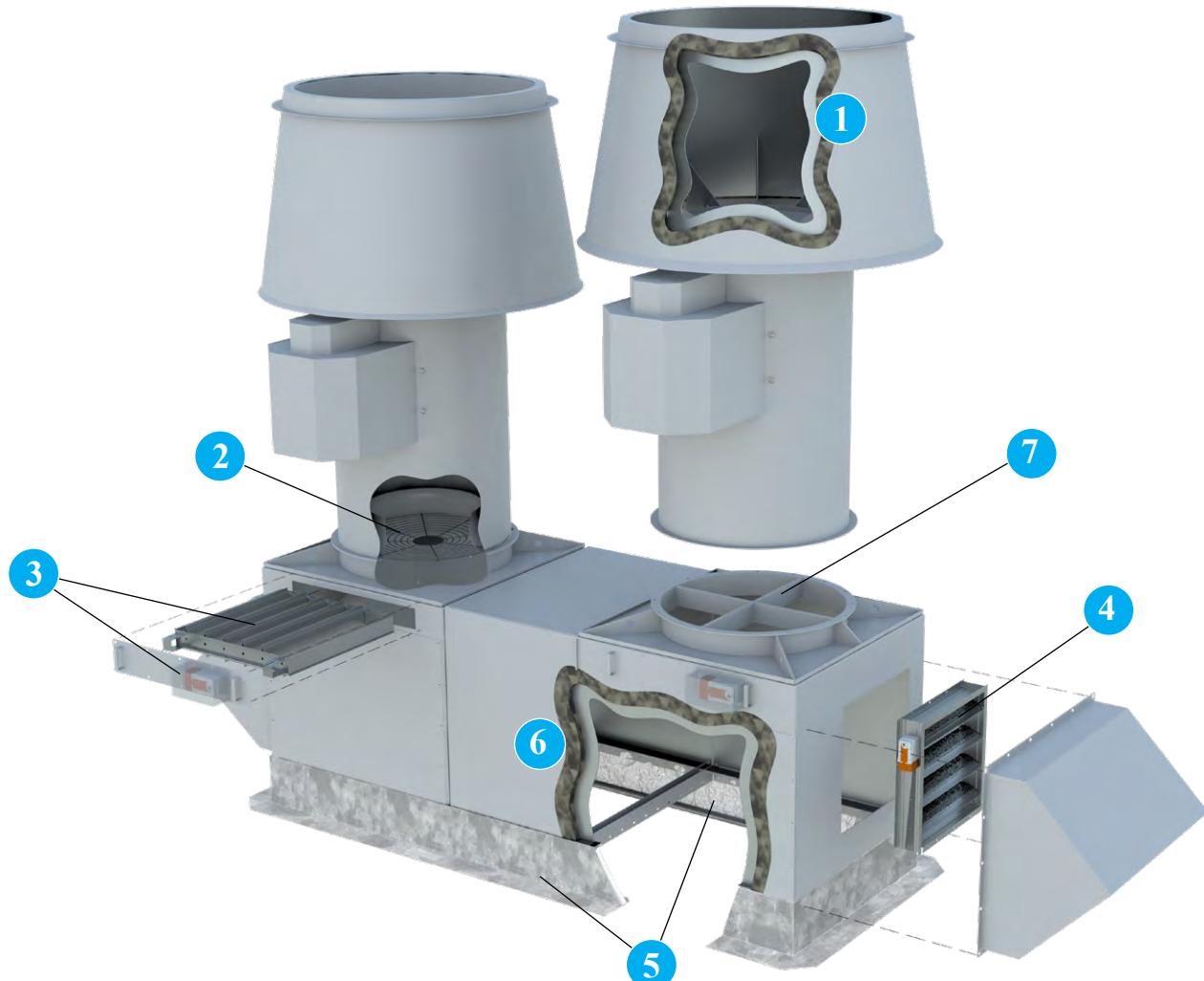
## MOUNTING CONFIGURATIONS



Unique applications require unique configurations. With the Twin City Fan & Blower Modular Mixing Box, multiple configurations are able to be easily created and retrofitted.

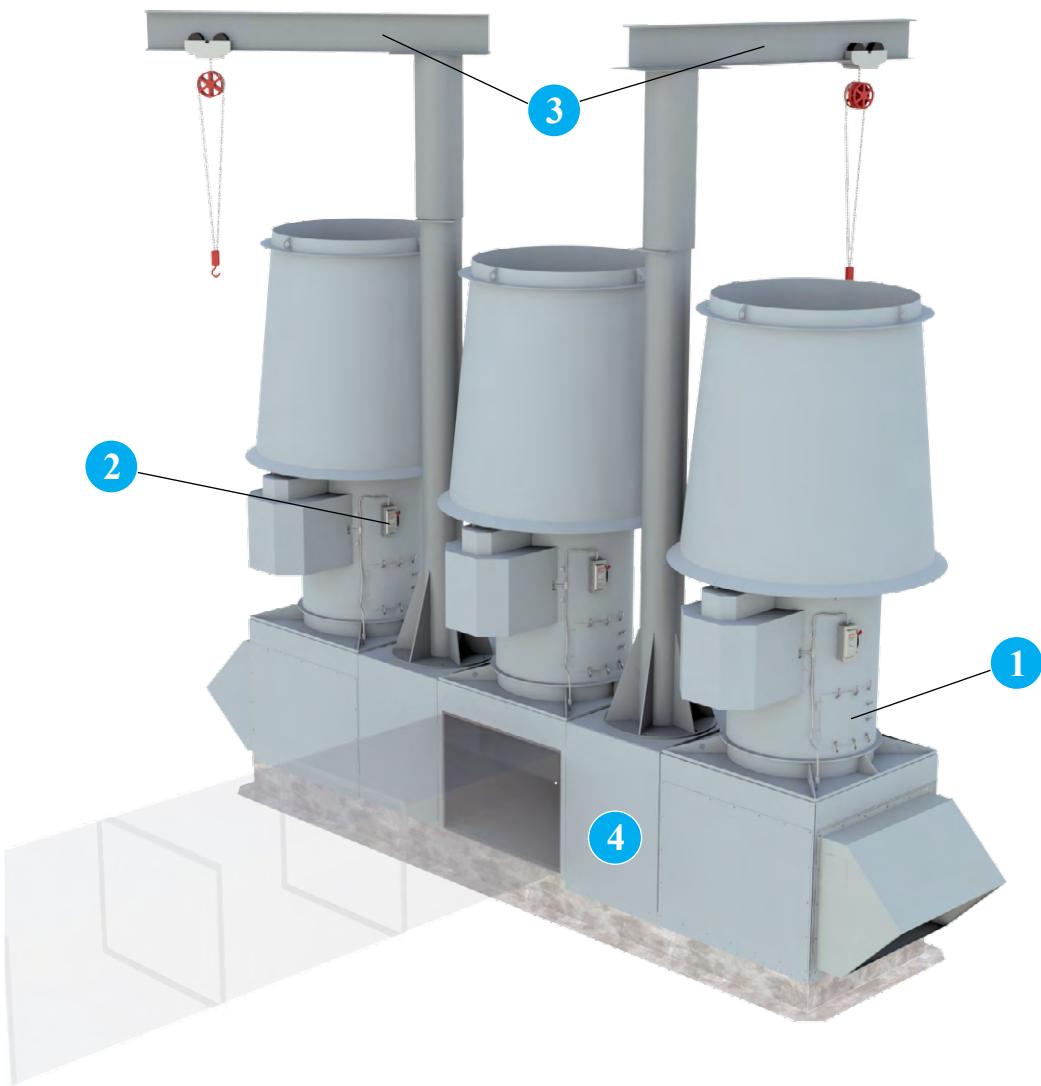


# OPTIONS/ACCESSORIES



- 1 Acoustic Windband** Designed to reduce noise of the fan system by attenuating sound at the fan outlet.
- 2 Inlet Safety Screens** can be provided for installation in the fan inlet.
- 3 Isolation Dampers** are typically used on multi-fan systems to isolate individual fans. Isolation dampers are available with 2-position, spring-return controls and various materials of construction and coating options.
- 4 Bypass Damper** are used to maintain outlet velocities by allowing a constant volume at the fan when exhaust air is reduced. Bypass dampers are available with either a manual, locking quadrant (handle) or with electrical controls and various materials of construction and coating options.

- 5 Insulated Roof Curb** Standard roof curbs are 12" high and are constructed of heavy duty galvanized steel and include 1½" thick insulation. Contact factory for other roof curb options. Note: 125 mph windload ratings require a Twin City Fan & Blower supplied roof curb. Parallel backdraft dampers are available for mounting in roof curbs.
- 6 Mixing Plenum Box w/ Weatherhood; w/ Insulation & Stainless Steel Liner Bottom Intake** The mixing plenum box features modular construction allowing for multiple configurations and effortless retrofitting. Bottom intake is standard, side intake option available upon request.
- 7 Vortex Breaker** Installed in the mixing plenum box at the fan inlet, the vortex breaker minimizes air 'swirl'. Recommended for multi-fan configurations and where mixing box intakes are not directly across from the inlet of the fan.



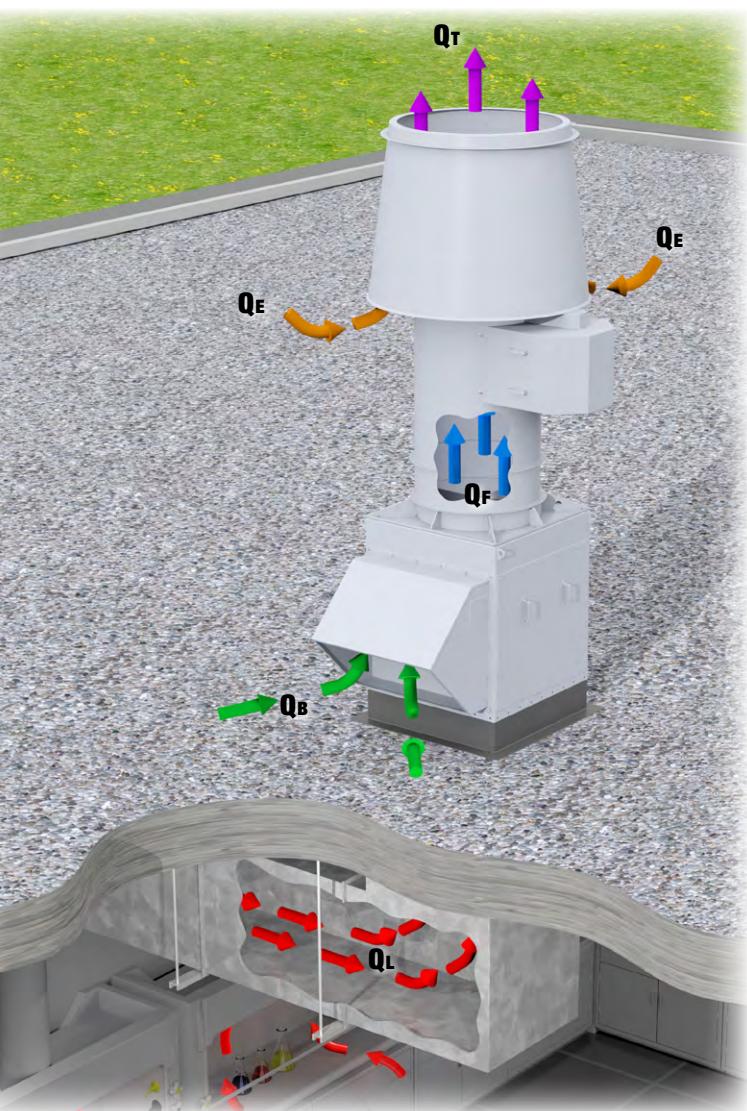
- 1 Quick Open Access Doors** are designed for quick wheel inspection and maintenance. Access doors are specified where examination and cleaning of the fan interior is frequently required.
- 2 NEMA 3R Disconnect Switch**, rain proof, disconnect is available shipped loose for field mounting and wiring or factory mounted and wired. Also available with a NEMA 4 or 7/9 switch.
- 3 Jib Crane** Heavy duty jib crane is designed to handle the weight of the heaviest individual component. The mount is connected to the specially reinforced mixing box spacer mixing box structure. Single and double mixing boxes receive one (1) jib crane. 3x1 and 4x1 configurations receive two (2) jib cranes.

- 4 Mixing Plenum Box w/ Weatherhood; Side Intake** The mixing plenum box features modular construction allowing for multiple configurations and effortless retrofitting. Bottom intake is standard, side intake option available upon request.

## OTHER ACCESSORIES:

- Mixing Box Blank-Off Panel
- Piezometer Ring and Pressure Transducer
- Spark Resistant Construction: Type C
- Stainless Steel Nameplate
- Backdraft damper

# FUME EXHAUST DEFINITIONS



$Q_B$  = Bypass Flow

$Q_E$  = Entrained Flow

$Q_F$  = Fan Flow

$Q_L$  = Laboratory Flow (Contaminated Air)

$Q_T$  = Total Flow

$$Q_T = Q_E + Q_F$$

$$Q_F = Q_B + Q_L$$

$$\therefore Q_T = Q_E + Q_B + Q_L$$

$$\text{Dilution Ratio} = D.R. = \frac{Q_T}{Q_L}$$

$$\text{Entrainment Ratio} = E.R. = \frac{Q_T}{Q_F}$$

## Bypass Air

Ambient air that is drawing through the bypass air plenum and mixed with the lab exhaust to increase dilution and plume rise. Bypass air is primarily used in variable volume applications to maintain a constant discharge volume.

## Dilution Ratio

The ratio of the total fan outlet volume to the lab exhaust volume. (Total Volume/Lab Exhaust Volume).

## Entrainment Air

Air that is entrained (induced flow) through the windband and mixed with the lab exhaust to increase the dilution ratio and plume rise.

## Fume Exhaust

Caustic or noxious air that is being exhausted from laboratory or fume hood.

## Nozzle

Device located internal to the fan housing, providing fume exhaust air to accelerate upon entrance to the windband. Three nozzles per fan size are available on the QIFE; low-velocity, medium-velocity and high-velocity. Each nozzle provides different flow characteristics. Nozzle should be selected based on the application requirements.

## Plume Rise

The height of the fume exhaust and entrainment air above the discharge of the windband.

## Plume Height

Overall height of the discharge plume rise, plus the added height of the exhaust system above the roof-deck level. (See diagram on page 9).

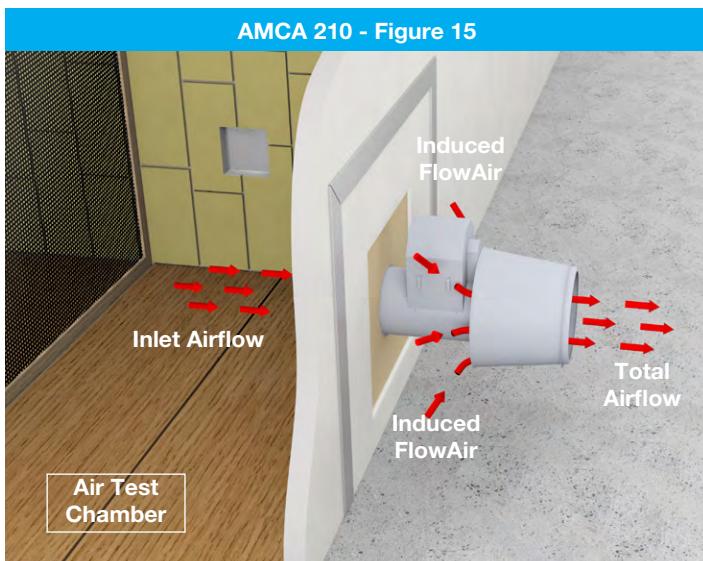
## Total Airflow

The total airflow exiting the windband, including fume exhaust, bypass air, and entrainment air.

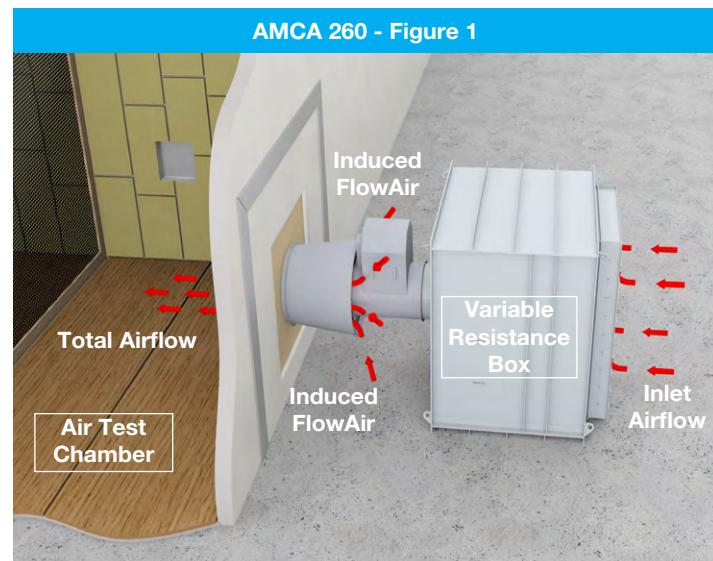
## Windband

Device used to direct the fume exhaust as it leaves the housing of the exhaust fan and entrain dilution air. Also available with an acoustically attenuated option.

The following illustrations describe the procedure for determining the total laboratory exhaust fan discharge flow. The total discharge flow is the sum of inlet airflow and entrained airflow. The key requirement to AMCA 260 is the variable resistance box. This box allows the measurement of total discharge flow ( $P_s = 0$  in. w.g. to simulate discharging the fan to atmosphere) at all points along its fan curve.



Without the variable resistance box, the entrained airflow can only be measured at the free air point of its fan curve. The entrained airflow obtained can be used to calculate an effective plume height. Therefore, AMCA 260 certification is necessary to ensure the laboratory exhaust fan specified is providing the plume rise and entrainment submitted.



## PLUME HEIGHT CALCULATION

$$h_e = h_r + h_s^*$$

$$h_e = [3.0 \times (V \times d/U)] + h_s$$

$h_e$  = Effective plume height (ft)

$h_r$  = Plume rise (ft)

$h_s$  = Stack height (height from roof to outlet of windband) (ft)

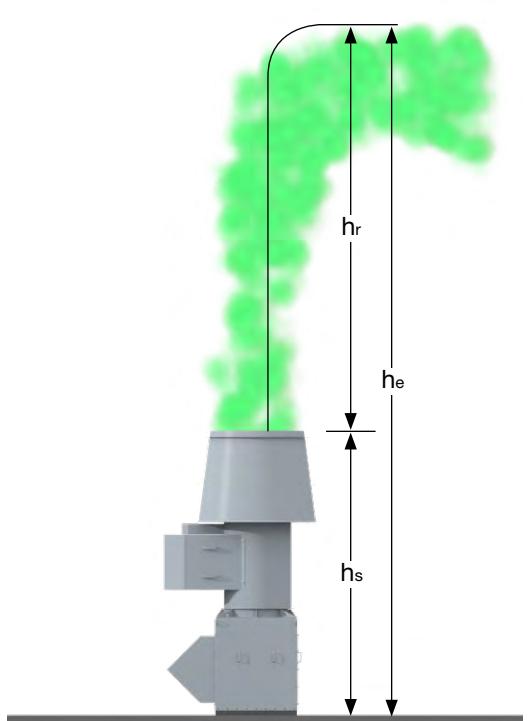
V = Windband exit velocity (ft/min)

d = Windband outlet diameter (ft)

U = Crosswind speed (ft/min)

\* Equation taken from ASHRAE Laboratory Design Guide, Equation 9-2.

Note: Plume height calculations are typically calculated with a 10 mph (880 ft/min) crosswind.































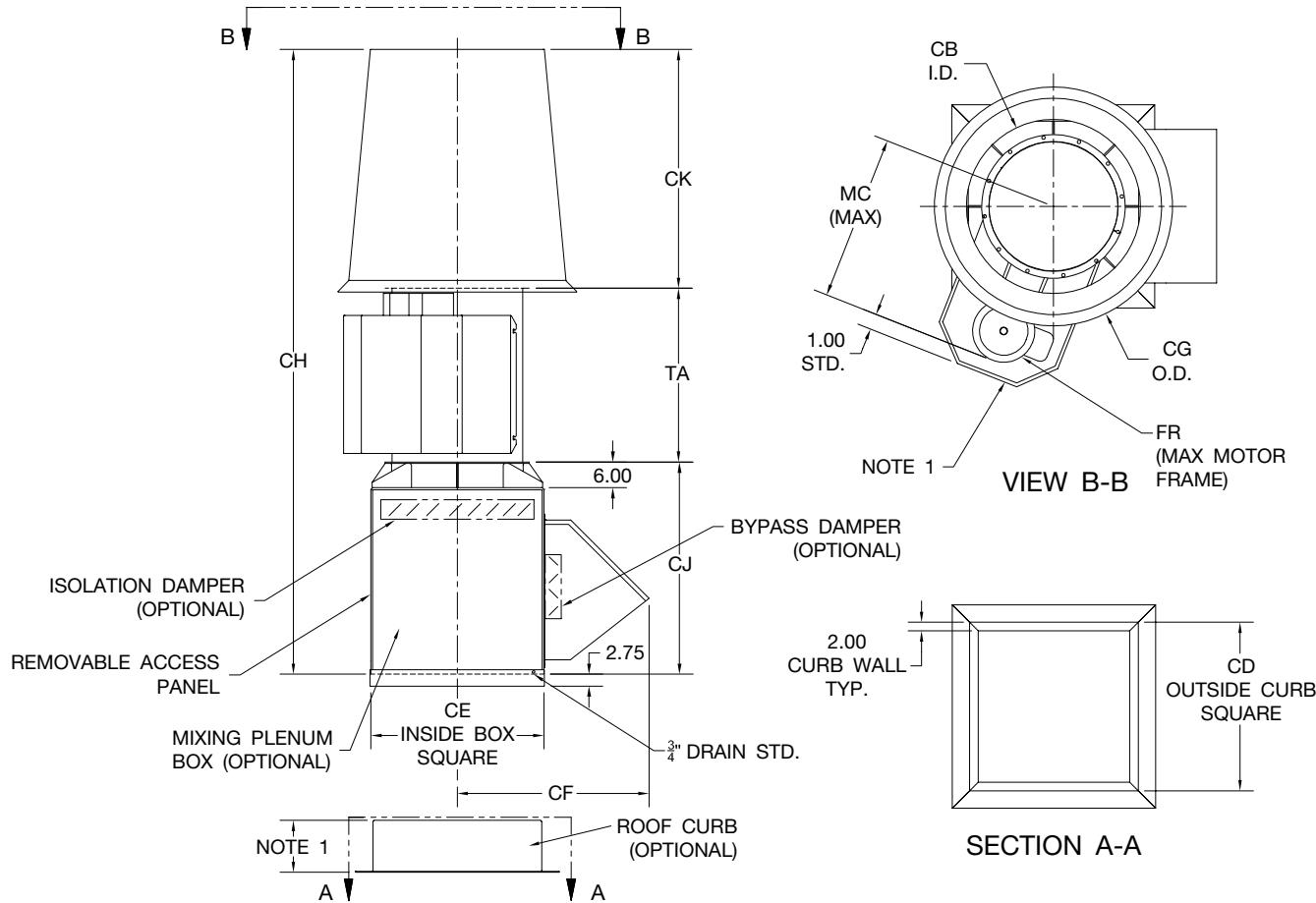








# DIMENSIONAL DATA



SIZE	CB	CD	CE	CF	CG	CH	CJ	CK	FR	MC	SHAFT DIAMETER		TA
											CL I	CL II	
90	18.13	23.00	24.00	28.13	25.00	102.00	33.09	49.44	184T	22.88	0.75	-	19.44
122	22.25	27.00	28.00	32.13	30.63	120.03	37.09	60.69	184T	24.25	0.75	-	22.25
135	24.44	27.00	28.00	32.13	33.69	128.09	37.09	66.87	184T	26.88	0.75	-	24.13
150	27.06	32.00	33.00	37.13	37.25	119.78	42.09	49.81	215T	25.75	1.00	1.19	27.88
165	29.63	33.00	34.00	38.13	40.50	128.54	43.09	54.69	256T	27.75	1.00	1.44	30.76
182	32.69	35.00	36.00	40.13	45.38	140.04	45.09	60.94	256T	34.44	1.00	1.44	34.01
200	36.31	36.00	37.00	41.13	50.00	150.60	46.09	67.19	256T	36.19	1.19	1.44	37.32
222	40.00	39.00	40.00	44.13	55.06	141.16	49.09	51.75	256T	37.63	1.19	1.44	40.32
245	44.44	45.00	46.00	50.13	67.19	157.35	55.09	57.81	286T	37.88	1.44	1.69	44.45
270	48.88	46.00	47.00	51.13	67.31	168.48	56.09	63.44	286T	42.13	1.44	1.69	48.95
300	54.06	52.00	53.00	56.13	74.44	185.10	60.09	70.31	326T	45.13	1.44	1.94	54.70
330	59.63	59.00	60.00	59.63	82.13	197.41	60.09	77.31	326T	46.56	1.69	2.19	60.01
365	65.94	64.00	65.00	62.13	90.75	184.14	60.09	57.81	365T	51.50	1.94	2.19	66.51
402	72.56	70.00	71.00	65.13	99.94	196.97	60.09	63.75	365T	59.75	1.94	2.19	73.13
445	80.38	79.00	80.00	69.63	110.69	211.85	60.09	70.69	405T	62.25	1.94	2.44	81.07
490	88.88	86.00	87.00	73.13	122.38	227.59	60.09	78.31	405T	67.69	2.19	2.44	89.19
542	97.75	94.00	95.00	77.13	134.63	245.15	60.09	86.19	445T	71.50	2.44	2.69	98.87

BC1003133C

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



## Model

### QIFE

Model QIFE Induced Flow Exhaust Fans, where indicated on drawings and schedules, shall be of the non-overloading design, and shall be of the size and capacity as indicated in the fan schedule. Induced flow exhaust fans shall be as manufactured by Twin City Fan and Blower, Minneapolis, Minnesota.

Fans shall be designed for maximum efficiency. Fans shall have a sharply rising pressure characteristic extending through the operating range and continuing to rise well beyond the efficiency peak to assure quiet and stable operation under all conditions. Horsepower characteristics shall be truly self-limiting and shall reach a peak in the normal selection area.

**PERFORMANCE** — Fans shall be tested in accordance with AMCA test codes for air moving devices and shall be guaranteed by the manufacturer to deliver rated published performance levels. Model QIFE shall be licensed to bear the AMCA certified ratings seal for air, sound and induced flow. Sound certification shall apply to both inlet and outlet sound power levels. Model QIFE shall be UL/cUL 705 listed for electrical.

**HOUSING** — Housings shall be cylindrical and welded steel throughout. Inlets shall be fully streamlined. Housings shall be suitably braced to prevent vibration or pulsation. Totally enclosed weather cover shall enclose motor and V-belt drives. Punched inlet flange shall be equipped for curb cap or mixing plenum box mounting. Extended lube lines shall be provided for ease of lubrication. Model QIFE shall include outlet nozzle, windband, heavy duty coated steel curb cap, access door, shaft seal and weather cover, and a sealed belt tube for the protection of belts and drive components from the airstream.

**WHEEL** — Fan wheels shall have die-formed blades designed for maximum efficiency, and quiet and stable operation. Blades shall be continuously welded to the back plate and wheel cone. Wheels shall be statically and dynamically balanced and the complete fan assembly including motor and drive shall be test balanced at or near the operating speed at the factory prior to shipment.

**SHAFT** — Shafts shall be AISI 1045 hot rolled steel, accurately turned, ground, polished, and ring gauged for accuracy. Shafts shall be sized for the first critical speed of at least 1.43 times the maximum speed.

**BEARINGS** — Bearings shall be heavy duty, grease lubricated, anti-friction ball or roller, self-aligning, pillow block type and selected for a minimum L-10 life of 200,000 hours at the maximum fan RPM. Bearings shall be equipped with extended lubrication lines with grease fittings outside of the fan housing.

**DRIVE** — Motor sheaves shall be cast iron, variable pitch on applications 10 HP and smaller, and fixed pitch on 15 HP and larger. Drives shall be sized for at least 200% of motor horsepower.

**CURB CAP** — A heavy-duty, coated steel or galvanized curb cap shall be included to provide for a weather-tight transition between the roof curb and the fan. The curb cap shall allow discharge height up to 10 feet from roof without the need for guy wire support.



## Model

### QIFE (cont'd.)

**NOZZLE AND WINDBAND** — A nozzle and windband combination shall be provided to efficiently induce ambient airflow from outside the fan housing and increase discharge velocities to be a recommended minimum of 3,000 FPM without significantly affecting BHP requirements. The windband shall provide a minimum discharge height of between 84" and 120" from roof surface.

**WEATHER COVER** — A raintight, easily removable weather cover shall be provided to completely enclose the motor and exposed parts of the V-belt drive.

**OPTIONAL ACCESSORIES** — Where required the fans shall be provided with:

- AMCA "B" or "C" spark resistant construction
- Modular mixing plenum box
- Bypass damper with actuator
- Isolation damper with actuator
- Disconnect switches
- Roof curb
- Vortex breaker
- Special coatings (Epoxy, Air-Dry Phenolic, Synthetic Resin) on airstream parts or entire unit
- Special materials of construction

**SUBMITTALS** — Submittals for approval of equipment shall include copies of outline drawings, AMCA Certified Ratings, and percentage pressure-volume performance curves showing point of operation.

**GUARANTEE** — The manufacturer shall guarantee the workmanship and materials for its QIFE Mixed Flow Induced Flow Exhaust Fans for three (3) years from shipment.



# **INDUSTRIAL PROCESS AND COMMERCIAL VENTILATION SYSTEMS**

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CENTRIFUGAL ROOF & WALL EXHAUSTERS | CEILING VENTILATORS | GRAVITY VENTILATORS | DUCT BLOWERS  
RADIAL BLADED FANS | RADIAL TIP FANS | HIGH EFFICIENCY INDUSTRIAL FANS | PRESSURE BLOWERS  
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