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Produced by the NASA Center for Aerospace Information (CASI)
SOLAR ENERGY SYSTEM INSTALLED AT MOUNT RUSHMORE NATIONAL VISITOR CENTER IN KEYSTONE, SOUTH DAKOTA

Prepared from documents furnished by

South Dakota School of Mines and Technology
Rapid City, South Dakota 57701

Under DOE Contract EX-76-C-01-2399

Monitored by

National Aeronautics and Space Administration
George C. Marshall Space Flight Center, Alabama 35812

For the U.S. Department of Energy

U.S. Department of Energy
FINAL REPORT OUTLINE

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INTRODUCTION

This project is a solar retrofit project of Mount Rushmore National Memorial Visitor Center at Keystone, SD, where over two million tourists visit each year. The Visitor Center has a total space of approximately 6,000 sq. ft. The solar system is designed to furnish approximately 45% of heating for the total facility, and approximately 53% partial cooling of the 2,000 sq. ft. observatory room. There are a total of 112 panels of Lennox liquid circulated collectors, each 3 ft by 6 ft in dimension, with a gross surface of approximately 2,000 sq. ft. Collector panels are mounted in 5½ rows on the roof of the Visitor Center owned by National Park Service of the Department of Interior. The building was designed by the Spitznagel Partners, Inc. The project consists of four team members with South Dakota School of Mines and Technology as program manager; the Spitznagel Partners, Inc. as construction manager and designer; Honeywell as a collector supplier; and the Mount Rushmore National Memorial as the owner.

DESIGN PHILOSOPHY

The first design decision was to install collectors which used liquid rather than air as the heat transfer fluid. There were three factors which indicated that this was the best choice: (1) A liquid medium would integrate easily with the existing system by simply installing a heating coil in the furnace air duct. The liquid could be circulated directly from the collectors to the heating coil for optimum transfer without additional blowers. (2) There is a need for extra air-conditioning in the observatory room which could be met by solar activated lithium bromide absorption refrigeration units. Air collectors do not produce high enough temperatures to activate these units. (3) The limited space to mount the collector array required
collectors with high efficiency and air collectors are generally less efficient than liquid collectors.

Some of the more important design decisions were determined according to the following conditions: (1) The collector area (active area of 1720 sq. ft.) is the maximum which can be fit on the roof and allow enough spacing to avoid shading (5% of total in December). This is also based on the actual total fuel consumed in FY 1975 or 8,721 gallons of No. 2 oil, assuming a heating value of 140,000 BTU per gallon and a furnace efficiency of 50% due to the age of the furnace and an altitude of about one mile, the total annual heating load of about $6.1 \times 10^8$ BTU's is determined. (2) The three 3-ton Arkla units are the maximum number which can be operated with the given collectors. (3) The 3,000 gal. storage tank is a compromise between performance and available space. (4) The solar heat coil, effectiveness = 0.538, is the largest reasonable coil which can fit into the existing furnace duct. (5) The angle at which the collectors are placed is a combination of the orientation of the roof, a 45° angle relative to the roof for ease of construction, and a need for solar collection both in winter and summer. The optimum angle for this particular application was not determined, but other simple models show that the performance is probably only 2% less at this angle than at the optimum of about 55° in winter. The angles used here favor the air conditioning application. (6) The control system is designed to use solar heating or cooling first and then the current conventional system as backup. It will be possible to air condition and solar heat during the same day, even though this feature is not in the computer model for simplification.

Solar energy system calculations were based on climatological data for Rapid City supplied by the National Oceanic and Atmospheric Administration (NOAA). The climatological conditions at Mount Rushmore (25 miles southwest
and 2,000 feet higher than Rapid City) are expected to be more favorable due to the altitude and lack of pollution in the air, making these calculations conservative.

TRNSYS system developed by the University of Wisconsin modified by South Dakota School of Mines and Technology was used to simulate the solar system. The climatological data for 1971-74 was used for the simulation model. The TRNSYS program used here should enable the user to write a workable transient simulation program with a minimal knowledge of computers. TRNSYS has built-in checks to spot obvious errors such as calling for an input from a non-existent unit, failure to specify initial conditions, etc. Other errors such as improper conversion of units, crossing the temperature with the flow rate, etc. can be very difficult to spot. In this case the user must know enough about the system to realize that the answers are nonsense, even though the computer processes the numbers without printing an error message. If the program fails to produce answers which converge within the specified tolerances in the specified number of iterations, the user has recourse to decreasing the time step, raising the tolerances or number of iterations, or sticking the control units after fewer calls in one time step. When these fail to produce convergence, then it is essential to have familiarity with FORTRAN and general knowledge of iterative techniques to trace and correct the difficulty.

The flow rate is calculated on the basis of .3 gpm per collector panel specified by the supplier.

The 3,000 gallon storage tank to provide reasonable heat storage for heating and reasonable period of continuous cooling is housed above the ground with three 3-ton Arkla units, heat exchanger, pumps, and all controls in a building connected to the Visitor Center on the east side. This selec-
tion gives ease in installation of piping, storage tank and other equipment. The length of piping is minimized.

OPERATION OF THE SYSTEM

The whole system was completed in September of 1977. First the system was tested with pure water in the solar collector loop for about a week, and the system seemed to function properly and was then charged with ethelene glycol for continuous operation. The presence of air bubbles in the system was a constant problem. The pressure build-up due to the air bubbles was alleviated by frequent venting on the top of the roof. The system pressure could be in excess of 70 psig. The air venting could be as frequent as once a week.

The winter of 1977 in South Dakota was one of the severest ones experienced. The National Park Service was quite happy with the saving of many gallons of oil. The system apparently functioned well in solar heating. No major problems were detected except that the main system pump was always running for all modes of operation. Nobody knew exactly how well the system was functioning until the early part of May of 1978 when IBM contracted Site Data Acquisition System (SDAS) to begin to produce some computer printouts. Quite a few anomalies were picked up by the SDAS such as the main system pump was running all the time; the sequence of operations was different from what was originally planned; solar and auxiliary heating have the same control setting; energy from storage is not always being taken to meet the heating load, etc.

The Arkla cooling units were started after mid-July of 1978. The cooling system was never utilized to its full capacity due to the fact that the control of the system was not completely under control. Adjustments and corrections are still being made by the Honeywell people. In general, most
major anomalies have been corrected. It is expected the system will operate properly both heating and cooling in seasons to come.

SUCCESSFUL COMPONENTS OR PROCESSES

Aesthetically the Park Service people were worried that the presence of solar energy heating project might distract from the main attraction. Since the installation of the collector panels, the visitors apparently are not aware of the presence of collector panels on the roof of the building. This seems to satisfy the Park Service. Comments from people who have seen the collector panels are good. Aesthetically, they blend in very naturally with the building.

2. Acceptance Test Data
   a. ACCEPTANCE TEST PLAN

   The basic philosophy of the acceptance test plan will be simply to insure that the entire system functions as designed. The acceptance test will be primarily based on the results provided by the government's Site Data Acquisition System and its on-site monitor. Results of a minimum of one week of continuous operation are required for the acceptance test.

   Referring to the attached diagram, a total of 44 sensors as shown are installed to the whole system. 8 sensors with a prefix of EP are for the measurements of electrical power consumed by pumps; 6 sensors with a prefix of W for the measurements of pump flowrate of liquid; 24 sensors with a prefix of T are for temperature measurements; and 6 remaining sensors are: 4 with a prefix of RH for the measurements of humidity, 1 with a prefix of F for the measurements of fuel oil flowrate, and 1 with a number of 1001 for the measurement of the total solar insolation. Results of the Site Data Acquisition System are obtained from the 44 sensors as shown in the attached diagram.
On a component basis, the items to be tested will be all pumps, motors, heat exchanger, coils, fans, cooling tower, solar collectors, valves, controls and sensors, and ARKLA cooling units. A general visual and physical inspection of all items including leakage and insulation free from any defect will be conducted. Tolerances for various items are to meet within \( \pm 10\% \) of the designed performance, for most of the items, as specified in the attached designed equipment schedule.

The controls will be tested according to the attached sequence of operations.

**GENERAL**

Space heating and cooling is controlled by the existing space thermostats. First stage heating is provided by solar heated water directly from the collectors or from the storage tank to the solar heating coil located in the existing multizone unit. Second and third stage heating are accomplished by firing the existing burner which is sequenced through two firing stages. First stage cooling is provided by the Arkla absorption units. Second stage cooling is accomplished by sequencing the existing multi-zone unit and direct expansion unit.

**FIRST STAGE HEATING FROM COLLECTOR**

On a call for heat from the space thermostats and by the discharge air temperature THD, valve V7 is modulated to control the hot deck temperature. Pump P1 is enabled to run and valve V4 is positioned A to AB if the collector plate temperature (TPH) is greater than 125\(^\circ\)F (adjustable). A time delay will delay pump P1 shut down to prevent short cycling.

**FIRST STAGE HEATING FROM STORAGE**

Heating from storage is accomplished whenever energy is not available from the collectors, heating demand occurs and energy is available from storage. On a call for heat, valve V7 and V5 are in the heating positions.
Valve V4 is B to AB. Pump P2 and P1 are enabled to run if the storage tank temperature TSD is greater than 100°F (adjustable). Valves V1 and V2 are positioned B to AB respectively.

SECOND AND THIRD STAGE HEATING

If first stage heating cannot be satisfied from the collectors or storage as sensed by discharge air sensor THD and the space thermostat, then the existing burner will be sequenced through it's two firing stages.

FIRST STAGE COOLING FROM COLLECTORS

First stage cooling is provided by the Arkla Absorption units A1 through A3. On a call for cooling, valve V5 is positioned A to AB and valve V7 is positioned B to AB. If solar heat is available from the collectors, which is sensed by collector plate sensor TPH, then pump P1, P3 and P4 are enabled to run. Plate temperature TPH must be greater than 180°F (adjustable) for cooling by the absorption units. A time delay will delay Pump P1 shut down to prevent short cycling. A fan aquastat in the cooling tower will cycle the cooling tower fan to hold sump temperature to 85°F (adjustable).

SECOND STAGE COOLING

Second stage cooling is accomplished sequencing the existing multi-zone unit and direct expansion units. When second stage cooling is called, the multi-zone unit will be activated. If the discharge air temperature TCD is greater than 60°F (adjustable) and second stage cooling is on, the direct expansion unit will then operate.

STORAGE TANK CHARGING

Storage tank charging is accomplished only when there is energy available from the collectors (TPH or TPC - set), and TF in is greater than TSC by 20°F (adjustable). Valve V1 and V2 are positioned A to AB respectively and pumps P1 and P2 are enabled to run.
**PURGE UNIT**

The purge or heat rejection unit is activated by positioning valve V3 B to AB whenever TF out is greater than 200°F (adjustable). The fan is under the control of the fan aquastat which cycles the fan on if the discharge temperature is greater than 205°F.

**EQUIPMENT SCHEDULE**

<table>
<thead>
<tr>
<th>Equipment</th>
<th>Details</th>
</tr>
</thead>
<tbody>
<tr>
<td>System Pump</td>
<td>B &amp; G Model PD-35, 33 GPM at 21 H₂O, 1/2 HP, 208V-60-3, Spare set of seals.</td>
</tr>
<tr>
<td>Storage pump</td>
<td>B &amp; G Series 1 3/4, 33 GPM at 5.5' H₂O, 1/6 HP, 115V-60-1, Spare set of seals.</td>
</tr>
<tr>
<td>Chilled water pump</td>
<td>B &amp; G Series HD3, 23 GPM at 17.5' H₂O, 1/3 HP, 115V-60-1, Spare set of seals.</td>
</tr>
<tr>
<td>Condenser Water pump</td>
<td>B &amp; G Series 1522 AB-5&quot;, 36 GPM at 23' H₂O, 1/2 HP, 120V-60-1, Spare set of seals.</td>
</tr>
<tr>
<td>Heat Exchanger</td>
<td>B &amp; G Shell &amp; Tube Heat Exchanger #QWU-88-44 Shell side, 33 GPM, 50% Glycol, 122°EWT, 107°LWT, 6' H₂O P.D. - Tube side, 33 GPM, 90°EWT, 103°LWT, 1.5' H₂O P.D., Heat transmitted at rate of 200 MBH.</td>
</tr>
<tr>
<td>Cooling Tower</td>
<td>Marley Model 46-17, 1/3 HP, 115V-60-1.</td>
</tr>
<tr>
<td>Cooling Coil</td>
<td>MacQuay Model LHD-108, 1 HP, 208V-60-3, 3800 CFM. 33 GPM, 200°EWT, 180°LWT, 4.7' H₂O Water P.D., 0.7 H₂O A.P.D., 100% EAT, 175°LAT, 326 MBH, Coil #5WH 1204C.</td>
</tr>
<tr>
<td>Solar Collector</td>
<td>(112 thus) Honeywell/Lennox #LSC18, .3 GPM/collector, 1.9' H₂O Water P.D., Total Sq. ft. of collectors = 2016 sq. ft.</td>
</tr>
<tr>
<td>Chiller</td>
<td>(3 thus), Arkla/Solaire 36 (WF-36), data for each-cooling capacity 36,000 BtuH, Hot water input requirement 50,000 BTUH at 210°F, Heat rejection requirement 86,000 BTUH. 115 volt 250 Watts electrical.</td>
</tr>
<tr>
<td>Storage Tank</td>
<td>3000 gal. capacity, 7&quot; x 10.5' loop, 7 Gauge steel tank.</td>
</tr>
<tr>
<td>Expansion Tank</td>
<td>B &amp; G 15 gal, 13&quot; x 34 1/2&quot; long, slight glass. AFT-9 Tank fitting, Drain cock.</td>
</tr>
<tr>
<td>Pressure Relief</td>
<td>Located near purge unit, set at approximately 100 PSI.</td>
</tr>
</tbody>
</table>
b. Acceptance test results including corrective action taken for non-conformance. Acceptance test was based on the Instrumented Solar Site Status report dated 9-25-78 put out by IBM. (A copy of the report is attached.) The anomalies and actions involving the grantee are summarized in the following table.

<table>
<thead>
<tr>
<th>System</th>
<th>Anomaly</th>
<th>Action</th>
<th>Activity</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>S/I</td>
<td>Main system pump runs continuously (1/78)</td>
<td>Control adjustment is needed and has been requested from Honeywell. The problem is due to the way hot deck temperature was set. Damper needs to be readjusted as well as the hot deck temperature so that Valve V7 will cycle to open and close.</td>
<td>Grantee</td>
<td></td>
</tr>
<tr>
<td>S/I</td>
<td>Solar energy simultaneously goes to load and storage. Does not agree with control definition (2/78)</td>
<td>Control definition has been changed and drawing has been corrected. Storage is not used for cooling</td>
<td>Grantee</td>
<td></td>
</tr>
<tr>
<td>S</td>
<td>Solar &amp; auxiliary heating (fuel oil) have same control setting. Disagrees with control definition (2/78)</td>
<td>Damper cam should be readjusted to start solar heating prior to auxiliary heating. We have requested Honeywell controls to make due adjustment.</td>
<td>Grantee</td>
<td></td>
</tr>
<tr>
<td>S</td>
<td>Solar energy not being taken from storage to meet heating load (2/78)</td>
<td>See above</td>
<td>IBM/Grantee</td>
<td></td>
</tr>
<tr>
<td>S</td>
<td>Single plate temperature control sensor may cause over heating.</td>
<td></td>
<td>Grantee</td>
<td>It was okayed to delete this.</td>
</tr>
</tbody>
</table>
S/I Pump P-2 is running even when pump P-1 is off. Does not agree with control definition (6/78)

Grantee/IBM It was okayed to delete this.

S Purge unit should come on when TF out is 220°F. T103 indicates purge unit is coming on at 175° to 180°F (6/78)

Grantee Purge unit rarely ran.

Has been corrected to 200°F (V3)

S Collector loop becomes active at 8:30 AM - runs until 8:30 PM. System losing energy from 4:00 PM - 8:30 PM.

Grantee It was okayed to delete this.

3. Complete set of as-built drawings with wire and piping schematics.
SYSTEM FLOW DIAGRAM
No Scale

FIGURE 1 - Shows the system flow diagram

ORIGINAL PAGE IS OF POOR QUALITY

112 SOLAR COLLECTORS ON ROOF, FOR LAYOUT & PIPING SEE SHEET # 2

3000 GAL STORAGE TANK

EXIST DX COOLING COIL

EXIST CHILLED WATER COIL IN EXIST COOLING ONLY AIR HANDLING UNIT

HEAT EXCHANGER

COLD WATER FILL

DRAIN VALVE

AIR SEPARATOR

CIRCUIT SETTER W/ GAUGE (TYP)
This is a diagram of a cooling system flow. Key components include:

- Expansion Tank (Typ)
- Cold Water Fill
- Glycol Fill Fitting
- Bypass
- 75 PSI Relief Valve
- Big Flow Check Valve
- Air Separator
- Union (Typ)
- Pressure Gauge (Typ)
- Gauge Cock (Typ)
- Existing Burner Unit
- Thermometer (Typ)
- Modulating
- New Heating Coil in Hot Deck of Existing Multi-Zone Unit
- Existing Cold Deck
- Chiller
- Cold Water Make-Up
- Fan Aquastat Cooling Tower
- Cold Water Fill
- Out Setter Gauge (Typ)
- 36 GPM
- 8 GPM
- 12 GPM
- 2"
- FIGURE 2 - Shows roof plan-collector layout with equipment schedule and sequence of operation.
FIGURE 3 - Shows piping system
THE VENT CONTR. SHALL MODIFY EXIST RA DUCTWORK AS REQ'D TO FABRICATE A FILTER SLOT AHEAD OF THE NEW COIL. REUSE THE EXIST FILTERS.
NEW COOLING COIL MOUNTED BY THE VENT CONTR. IN EXIST. RA DUCT TO EXIST SINGLE ZONE COOLING ONLY UNIT MODIFY THE DUCT AS REQ'D & FABRICATE A D R I P P A N.

THE VENT CONTR. SHALL REMOVE & REPLACE THE EXIST 1/2 HP MOTOR IN EXIST. A H.U. W/ NEW 3 HP MOTOR.
PROVIDE VARIABLE SIZE PULEYS ON NEW MOTOR TO INCREASE FAN SPEED BY APPROX 20 TO 40% (ADJ.) VERIFY EXIST MOTOR DIMENSIONS & SPACE CONTROLS.

3,000 GAL STORAGE TANK SET ON 2 REDWOOD 4 X 6'S AT 6' 0" LONG.
TWO EXPANSION TANKS (2 THUS) SUSPENDED FROM STRUCTURE W/ 1/2" ST. RODS & 1/4" LS FOR PIPING SEE DETAIL #5 FOR PIPING OF SYSTEM FOR THIS ROOM, SEE DETAIL #4.

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1/2" C.W.R. & C.W.S. ON TO NEW COOLING COIL PROVIDE 3/4" DRAIN FROM D R I P P A N TO THE EXIST F.D. FOR COIL PIPING SEE DETAIL #4.

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APPRAO 10'0" BETWEEN BREAK LINES.
BURY 2' PURGE UNIT PIPING & CONDENSER WATER PIPING APPROX TO BELOW GRADE.
PATCH W/ ASPHALT (60' MIN) TO MATCH EXIST GRADE.

STORAGE PUMP P-2
2" SUPPLY DOWN TO HEAT EXCHANGER SUPPORT ON PIPE STAND ANCHORED TO FLOOR.
SYSTEM PUMP P-1
R-2 HOAIRTROL SUPPORT FROM STRUCTURE W/ 1/2" STL. RODS.
CHILLED WATER PUMP P-3

2' F D W/C.O.
11/2" V. UP ALONG WALL OFFSET TO 10'-0" FROM EXIST WALLS.
2' SYSTEM SUP & HET UP TO COLLECTORS ON ROOF FOR CONT, SEE ROOF PLAN SHT M-2.

1/2" C.W. 1/2" C.W. 1/4" C.W. 1/4" H.W. SUP & 2" H.W. HET THRU EXIST WALL RUN INSUL. FULL THICKNESS THRU WALL, PATCH & CAULK TO A FINISHED APPEARANCE ON OFFICE SIDE.
CONN 1/2" C.W. TO EXIST EXPOSED 1/2" C.W. TO SHOWER.
CONN 2" W. TO EXIST VERIFY EXACT LOCATION & PATCH AS NOTED.
MOUNT PIPING TIGHT TO EXIST CLG IN NEAT & ORDERLY MANNER.

THE VENT CONTROL SHALL MOUNT THE NEW HEATING Coil IN EXIST MULTI-ZONE HOT DECK BELOW THE EXISTING BURNER UNIT, PROVIDE ALL BRACKETS, FLANGES, ETC. 15
RED TO INSURE A NEAT INSTALLATION; MODIFY EXISTING HOUSING TO ACCOMMODATE COIL & PIPING CONNECTIONS.

2" H.W. RET 4 SUP DOWN TO NEW HEATING Coil, FOR PIPING SEE 3/M-4.
FIGURE 5 - Shows floor plan-Electrical
ORIGINAL PAGE IS OF POOR QUALITY

FLOOR PLAN - ELECTRICAL

SCALE: 1/4" = 1'-0"
FIGURE 6 - Shows floor plan-instrumentation
### Temperature Sensors for Piping

<table>
<thead>
<tr>
<th>Sensor Type</th>
<th>Characteristic</th>
<th>Pipe Size</th>
<th>Fitting</th>
<th>Sensor Type</th>
</tr>
</thead>
<tbody>
<tr>
<td>Collector Array Inlet Temp.</td>
<td>50</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Collector Array Differential Temp.</td>
<td>0</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Storage Tank Inlet Temp.</td>
<td>50</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Storage Tank Differential Temp.</td>
<td>0</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Storage Tank Upper Temp.</td>
<td>50</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Storage Tank Lower Temp.</td>
<td>50</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Heating Cell Outlet Temp.</td>
<td>50</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Heating Cell Differential Temp.</td>
<td>0</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Arista Generator Output Temp.</td>
<td>150</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Arista Generator Differential Temp.</td>
<td>0</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Arista Condenser Outlet Temp.</td>
<td>30</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Arista Condenser Water Outlet Differential Temp.</td>
<td>30</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Arista Chilled Water Outlet Differential Temp.</td>
<td>0</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Collector/Heat Exchanger Outlet Temperature</td>
<td>30</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
<tr>
<td>Collector/Heat Exchanger Differential Temperature</td>
<td>0</td>
<td>Copper</td>
<td>1/2&quot;</td>
<td>1/2&quot;</td>
</tr>
</tbody>
</table>

**Notes:**
- Make connections to sensor where it can be easily removed by others.
- Use & #40;#41; compression fitting to tighten sensor into gland.
- Use & #40;#41; compression fitting to tighten sensor into gland.
- Use & #40;#41; compression fitting to tighten sensor into gland.
- Use & #40;#41; compression fitting to tighten sensor into gland.
- Use & #40;#41; compression fitting to tighten sensor into gland.
- Use & #40;#41; compression fitting to tighten sensor into gland.

**Diagram:**
- Flow sensor for piping
- Temperature sensor for piping
- Multiple sensor connections
- Pipe and fitting connections
- Sensor connections at junction points
- Sensor connections at junction points
- Sensor connections at junction points
- Sensor connections at junction points

**Additional Information:**
- Use appropriate fittings for sensor connections.
- Ensure proper sealing of sensor connections.
- Use dedicated cable for each sensor.
- Ensure proper grounding of sensors.
- Use appropriate junction boxes for sensor connections.
### FLOW SENSORS FOR PIPING

<table>
<thead>
<tr>
<th>No.</th>
<th>Name</th>
<th>Range</th>
<th>Cv</th>
<th>Design Pressure</th>
<th>Flow Type</th>
<th>Flow Meter Type &amp; Size</th>
<th>A</th>
<th>B</th>
<th>C</th>
<th>D</th>
</tr>
</thead>
<tbody>
<tr>
<td>W100</td>
<td>Collector Array Flow Rate</td>
<td>20</td>
<td>33</td>
<td>50</td>
<td>Copper</td>
<td>2&quot; Flanged</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>w/4-40 S/8 bolts</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>W101</td>
<td>Storage Tank Supply Flow Rate</td>
<td>20</td>
<td>33</td>
<td>50</td>
<td>Copper</td>
<td>2&quot; Flanged</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>w/4-40 S/8 bolts</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>W501</td>
<td>Chilled Water Flow Rate</td>
<td>20</td>
<td>30</td>
<td>50</td>
<td>Copper</td>
<td>2&quot; Flanged</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>w/4-40 S/8 bolts</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>W502</td>
<td>Chilled Water Flow Rate</td>
<td>15</td>
<td>23</td>
<td>35</td>
<td>Copper</td>
<td>1-1/2&quot; Threaded</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>w/4-40 S/8 bolts</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>F400</td>
<td>Fuel Flow to Multi Zone Heating Unit</td>
<td>0 - 5 G.P.M.</td>
<td>Copper</td>
<td>1-1/2&quot; Threaded</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
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<td></td>
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<td></td>
<td></td>
<td></td>
<td></td>
<td>w/4-40 S/8 bolts</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### GENERAL NOTES

1. **OF POOR QUALITY**

   FIGURE 7 - Shows flow sensors for piping
FIGURE 8 - Shows roof plan-instrumentation
4. Operation and Maintenance Manual

Due to the fact that the O & MM is too bulky to make a part of this report for many reproductions, three complete copies of this manual are available at the following locations. One is located at the site of Mount Rushmore Visitor's Center; one as contractor's file at MSFC; and one in the office of Dr. C. W. Chiang, Mechanical Engineering Department, South Dakota School of Mines and Technology, Rapid City, SD 57701.

5. Pictures of final installation.
COOLING COIL AND PIPING TO EXISTING AIR HANDLING UNIT
HEATING COIL WITH PIPING IN VALVE LEADING TO EXISTING FURNACE
HEAT EXCHANGERS, PUMPS AND PIPING AT THE RIGHT
PART OF STORAGE TANK AT THE LEFT
6. Predicted System Performance Data

Heating load calculations indicate a maximum heating load of 400,000 Btu/hr for severe winter, as shown by Table B. 3-1. The total fuel consumed in FY 1975 was 8721 gallons of No. 2 oil. Assuming a heating value of 140,000 Btu/gal and a furnace efficiency of 50 percent due to the age of the furnace and an altitude of about one mile, the total conventional heat supplied was about $6.1 \times 10^8$ Btu.

Load calculations of the observatory room indicate a cooling load of 15-ton refrigeration needed as shown by Table B. 3-2. Solar energy system calculations were based on climatological data of Rapid City supplied by the National Oceanic and Atmospheric Administration (NOAA). The climatological conditions at Mount Rushmore (25 miles southwest and 2000 feet higher than Rapid City) are more favorable due to the altitude and lack of pollution in the air, making these calculations conservative.

The calculations are based on 2000 ft$^2$ of Honeywell LSC-18-1 double-glazed collectors tilting at a slope of 45.7 deg, and facing 18.8 deg west of south. These angles are the result of mounting the collectors at 45 deg with respect to the roof, which has a slope of 9.3 deg facing 28 deg south of east. The collectors have a transmissivity absorptivity product of 0.84 and a heat loss coefficient of 0.08 Btu/hr-ft$^2$-°F. The fluid flow rate is taken to be 40 gpm. The heat demand of the building, based on the actual heating data, was taken to be 2900 (70-$T_{\text{amb}}$) Btu/hr. The heat available from the solar system was taken to be $500 (T_{\text{st}}-90) + 500 (T_{\text{st}}-T_{\text{amb}})$. ($T_{\text{st}}$ = storage temperature, $T_{\text{amb}}$ = outside temperature.) This assumes a heating coil design which allows 200,000 Btu/hr heating with 130°F water and no heating at 90°F and pre-heat coil for 10 percent ventilation. The heat capacity of storage was taken to be 32,000 Btu/°F. The solar insolation was calculat-
Table B. 3-1. Heating Load Calculation

<table>
<thead>
<tr>
<th>Room Name</th>
<th>Dimension ft x ft</th>
<th>Infiltration ft</th>
<th>Glass ft²</th>
<th>Wall ft²</th>
<th>Roof ft²</th>
<th>Floor Btu/hr</th>
<th>Btu/hr</th>
<th>Factor</th>
<th>Subtotal Btu/hr</th>
</tr>
</thead>
<tbody>
<tr>
<td>102 Elect. vault</td>
<td>8 x 12</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>2182</td>
</tr>
<tr>
<td>103 Storage</td>
<td>12 x 12</td>
<td>20</td>
<td>30</td>
<td>96</td>
<td></td>
<td>1260</td>
<td>192</td>
<td></td>
<td>6090</td>
</tr>
<tr>
<td>104 Work Room</td>
<td>20 x 38</td>
<td>60</td>
<td>110</td>
<td>460</td>
<td>760</td>
<td>12760</td>
<td>5720</td>
<td>10%</td>
<td>27600</td>
</tr>
<tr>
<td>107 Work Room</td>
<td>25 x 14</td>
<td>52</td>
<td>64</td>
<td>413</td>
<td>360</td>
<td>12800</td>
<td>700</td>
<td></td>
<td>20110</td>
</tr>
<tr>
<td>108 Women toilet room</td>
<td>13 x 5</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1805</td>
</tr>
<tr>
<td>110 Men toilet room</td>
<td>13 x 5</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td>1805</td>
</tr>
<tr>
<td>201 Men toilet room</td>
<td>28 x 12</td>
<td>44</td>
<td></td>
<td>468</td>
<td>366</td>
<td>12760</td>
<td>5720</td>
<td>10%</td>
<td>24240</td>
</tr>
<tr>
<td>202 Observatory</td>
<td>57 x 35</td>
<td>70</td>
<td>1360</td>
<td>550</td>
<td>2800</td>
<td>12600</td>
<td>2000</td>
<td>15%</td>
<td>135600</td>
</tr>
<tr>
<td>203 Office</td>
<td>20 x 20</td>
<td>40</td>
<td>70</td>
<td>430</td>
<td>200</td>
<td>12600</td>
<td>2000</td>
<td>10%</td>
<td>26440</td>
</tr>
<tr>
<td>204 office</td>
<td>13 x 14</td>
<td>40</td>
<td>53</td>
<td>90</td>
<td>182</td>
<td>12600</td>
<td>2000</td>
<td></td>
<td>10070</td>
</tr>
</tbody>
</table>
### Table B. 3-1. Heating Load Calculation (Concluded)

<table>
<thead>
<tr>
<th>Room Name</th>
<th>Dimension ft x ft</th>
<th>Infiltration ft²</th>
<th>Glass ft²</th>
<th>Wall ft²</th>
<th>Roof ft²</th>
<th>Floor ft²</th>
<th>Btu/hr</th>
<th>Factor</th>
<th>Subtotal Btu/hr</th>
</tr>
</thead>
<tbody>
<tr>
<td>205 office</td>
<td>17x15</td>
<td>20</td>
<td>53</td>
<td>135</td>
<td>255</td>
<td>1260</td>
<td>2760</td>
<td>1170</td>
<td>2805</td>
</tr>
<tr>
<td>206 office</td>
<td>13x11</td>
<td>40</td>
<td>56</td>
<td>136</td>
<td>143</td>
<td>2520</td>
<td>2910</td>
<td>4230</td>
<td>1570</td>
</tr>
<tr>
<td>210 office</td>
<td>12x12</td>
<td>20</td>
<td>32</td>
<td>112</td>
<td>144</td>
<td>1260</td>
<td>1660</td>
<td>2470</td>
<td>1585</td>
</tr>
<tr>
<td>211 office</td>
<td>12x16</td>
<td>40</td>
<td>48</td>
<td>204</td>
<td>192</td>
<td>2520</td>
<td>3400</td>
<td>6330</td>
<td>2100</td>
</tr>
<tr>
<td>212 audio control</td>
<td>4x7</td>
<td></td>
<td></td>
<td>48</td>
<td>28</td>
<td>1485</td>
<td>3080</td>
<td></td>
<td>4565</td>
</tr>
<tr>
<td>213 lobby</td>
<td>36x44</td>
<td>154</td>
<td>470</td>
<td>550</td>
<td>1660</td>
<td>9700</td>
<td>21400</td>
<td>17050</td>
<td>18300</td>
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<td>214 women toilet room</td>
<td>28x12</td>
<td>44</td>
<td>468</td>
<td>366</td>
<td>366</td>
<td>2770</td>
<td>15200</td>
<td>4020</td>
<td>22,040</td>
</tr>
<tr>
<td>215 janitor closet</td>
<td>5x5</td>
<td>45</td>
<td>25</td>
<td>25</td>
<td></td>
<td>1345</td>
<td>275</td>
<td>50</td>
<td>1670</td>
</tr>
</tbody>
</table>

**Total**

|            | 401,977           |
**Table B. 3-2. Cooling Load Calculation**

**Room 202 observatory:**

**Design conditions**

Outside temp - 95°F, inside temp - 80°F, difference - 15°F

Outside walls: (sq ft)

<table>
<thead>
<tr>
<th>Side</th>
<th>Glass</th>
<th>Net wall</th>
</tr>
</thead>
<tbody>
<tr>
<td>North</td>
<td>150</td>
<td>450</td>
</tr>
<tr>
<td>West</td>
<td>1200</td>
<td></td>
</tr>
</tbody>
</table>

**Cooling load: BTU/HR**

<table>
<thead>
<tr>
<th>Items</th>
<th>Sensible</th>
<th>Latent</th>
<th>Remarks</th>
</tr>
</thead>
<tbody>
<tr>
<td>Sensible heat gain thru glass</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>150 sq. ft. x 23 Btu/ft²/hr</td>
<td>3,450</td>
<td></td>
<td></td>
</tr>
<tr>
<td>(22-3.5) x 54 x 140</td>
<td>140,000</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Transmission gain</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>Walls 450 sq ft x .20 (factor) x 15 (ΔT)</td>
<td>1,350</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Roof 2000 x .80 x 15</td>
<td>24,000</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Internal heat gain: People &amp; lights</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>People: No. Sensible factor Latent factor</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>40 x 200</td>
<td>8,000</td>
<td></td>
<td></td>
</tr>
<tr>
<td>40 x 250</td>
<td>10,000</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Lights: 5000 watts x 3.4</td>
<td>17,000</td>
<td></td>
<td></td>
</tr>
<tr>
<td>Total</td>
<td>149,800</td>
<td>10,000</td>
<td></td>
</tr>
</tbody>
</table>

**Ventilation or infiltration**

450 CFM x 1.08 x 35 = 17,000 Sensible
450 CFM x 1.08 x 35 = 5,700 Latent

Total load = 149,800 + 10,000 + 17,000 + 5,700 = 182,500 Btu/hr

or \[
\frac{182,500}{12,000} \approx 15 \text{ tons}
\]
ed by multiplying a typical direct sunlight reading in Rapid City of 290 Btu/hr-ft\(^2\) by a geometrical factor and also multiplied by the percentage sunlight for the particular day. The geometrical factor was the scalar product of the normal to the collector surface with the sun's rays expressed as a function of tilt of the earth's axis, local latitude, slope of the roof, orientation of the building, slope of the collector with respect to the roof, day of the year and time of day. The geometric factor also includes the shading effect of adjacent collectors.

The model was run using the climatological data for 1971-1974. The results shown in Table B.3-3 are for a typical day using the average high and low temperatures for that month and assuming 100 percent sunshine. This total is multiplied by the average percentage sunshine for the month. This method of approximation was checked by detailed hour-by-hour calculation using February 1973, when the storage temperature dropped to nearly 80°F every night, and October 1973, when the storage temperature rose to around 160°F. In both cases the results were very close to the approximation; for February it was 3 percent low; for October the difference was less than 1 percent.

The percentage heating carried by the solar system is expected to be at least 53 percent since the atmospheric conditions at Mount Rushmore are more favorable than in Rapid City. Based on the current market price of $0.39 per gallon for No. 2 fuel oil, the savings amounts to about $1,710 of the $3,226 worth of fuel consumed in FY 1975.

Solar cooling calculations are based on 165,000 Btu/hr of heat delivered to the cooling units at 210°F from the collectors. The limiting conditions of ambient temperature, percentage sunshine and time of day under which the above criteria could be met were determined. The climatological
<table>
<thead>
<tr>
<th>Month</th>
<th>Percent Sunshine</th>
<th>Tave °F</th>
<th>T max °F</th>
<th>T min °F</th>
<th>Qneed (10^6) Btu</th>
<th>Qsolar (10^6) Btu</th>
<th>Monthly total (10^6) Btu</th>
<th>Cooling Hrs</th>
<th>Cooling *days</th>
<th>Solar Cooling Hrs</th>
<th>Solar Cooling *days</th>
</tr>
</thead>
<tbody>
<tr>
<td>Jan</td>
<td>54.8</td>
<td>20.9</td>
<td>32.7</td>
<td>9.0</td>
<td>3.44</td>
<td>0.99</td>
<td>29.7</td>
<td></td>
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<td></td>
</tr>
<tr>
<td>Feb</td>
<td>63.0</td>
<td>27.0</td>
<td>38.9</td>
<td>15.1</td>
<td>3.01</td>
<td>1.33</td>
<td>39.8</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>March</td>
<td>66.5</td>
<td>33.5</td>
<td>48.4</td>
<td>23.6</td>
<td>2.56</td>
<td>1.51</td>
<td>45.1</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>April</td>
<td>52.0</td>
<td>44.9</td>
<td>57.2</td>
<td>32.5</td>
<td>1.77</td>
<td>1.18</td>
<td>35.3</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>May</td>
<td>58.0</td>
<td>54.1</td>
<td>67.2</td>
<td>41.0</td>
<td>1.12</td>
<td>&gt;1.12</td>
<td>33.6</td>
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<td>323.6</td>
<td></td>
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Heating contribution = \(\frac{3.24 \times 10^8}{6.1 \times 10^6}\) = 53 percent

Cooling contribution = \(\frac{225}{550}\) = 41 percent

Table B. 3-3. Heating/Cooling Solar Contribution
data of 1971 were then examined to determine the number of hours that the limiting conditions were exceeded when there was also a demand for cooling in the observatory. This is recorded in Table B. 3-3 as the number of solar hours of cooling. The total number of hours of cooling demand and the number of cooling degree days are also in that table.

The number of degree days when the solar absorption units were operating was found. The percentage of solar cooling was then figured by the ratio of solar degree days to cooling degree days.

\[
\text{Percent solar} = \frac{\text{Solar degree days}}{\text{Cooling degree days}} \times 100
\]

The savings from solar cooling can be approximated by assuming 334 hours of operation replacing a nine-ton conventional-type chiller with a coefficient of performance of 2.5. The savings is about 4230 kW-hr. At an estimated 3¢ per kW-hr, the saving amounts to about $127.00 per year.
7. Major problems encountered and resolutions theretofore

One of the major problems is the air bubbles in the system. As explained in the operation of the system, constant venting with frequencies as much as once a week to prevent a buildup of temperatures and pressures was necessary. The main pump was originally designed at the flow rate of 30 gpm. It was felt that the higher flow rate could solve the problem of pressure buildup or air bubbles problem. A larger pump was installed with the flow rate of approximately 48 gpm. This seemed to solve the air bubble problem. The frequency of air venting has drastically reduced.

Another problem encountered was one transformer was struck by lightning on August 14, 1978. Because of this, the main pump had lost the electric power supply so that the stagnant ethylene glycol solution in the collector loop was overheated and turned into steam. It took more than two weeks to repair the transformer, recharge the system and get it back into operation. This situation rarely happens.

The third major problem encountered was the thermosiphoning. On the last day of 1978, the ambient temperature was extremely low and the cold antifreeze back-flowed into the main heat exchanger through a three way valve V4. Apparently there was a slight leakage through the three way valve V4 even though the three way valve was in a completely shut off position. The cold antifreeze back-flowed into the jacket of the main heat exchanger and froze the water inside the tube bundle. As a result, the cover plate of the main heat exchanger cracked about 5 to 6 inches; there were two cracked lines of about 3/4" in two tubes; and antifreeze began to leak out. The system was drained, the cracks on the tube bundle were brazed, and the cover plate was replaced. The whole system was down for about one month. A check valve was installed in the pipeline to prevent any future back-flow of antifreeze into the main heat exchanger.
The last major problem is the control adjustment. In particular, the cam of all three way valves needs fine readjustment such that the sequence of operations will follow closely.

8. Lessons learned and recommendations

From the major problem of frequent air venting encountered in the operation of the system, the biggest cause may be the wrong locations of the inlet and outlet tubings to each solar panel. The roof on which the collector banks are mounted is sloping towards the east, such that each collector bank axis is tilting toward the east. The outlet tubings are on the lower end of each panel, thus any vapor lock or air bubbles may stay in the upper header tube of each panel and can never escape. This was a negligence on the part of collector supplier in shipping panels which were not according to shop drawings. A lesson learned here was that a close check of the panels before installation could have avoided the frequent air venting problems.

The second lesson learned from this project is that positive stop valves should be used instead of leaky three way valves. With positive stop valves the problem of thermosiphoning of cold antifreeze into the main heat exchanger could have been avoided.

The third lesson learned is that some of the sensor locations should have been at different places to ensure more meaningful results. For example, the inlet and outlet water temperature sensors to collectors were placed too close to the three way valve, V4. When the water is not circulating in the collectors, the two sensors do not represent the true readings due to heat conduction from piping.

The fourth lesson learned is that the current control system is too complex. A slight mal-adjustment of the three way valve cam can easily
cause malfunction of the operation sequence. A simpler control system is needed for the whole system such that any trouble-shooting will be much easier.

The last lesson learned from this project is a definite need of an on-site-monitor (OSM). During the last few months of operation, Mr. Val Fogle of Marshall Space Flight Center, NASA, Huntsville, AL (project monitor) helped install (on short loan basis) an on-site-monitoring system to the system. Through the OSM system, instant monitoring of various temperatures, flow rates, power requirement for various pumps and fans help understand and adjust the control sequence. Thus it enables us to know whether the system is in the right mode of operation.

9. The project manager, Dr. C. W. Chiang, of the South Dakota School of Mines has verified the following:

a. The solar system was installed per the enclosed as-built drawing.

b. The solar system met the acceptance test plan provisions.

c. The solar system met the interim performance criteria (NBSIR-1187) requirements.