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(54) **Title:** METHOD AND DEVICE FOR COOL DRYING A GAS

(57) **Abstract:** Method for cool drying gas by guiding gas through the secondary section (9) of a heat exchanger (2) whose primary section forms the evaporator (3) of a closed cooling circuit (4) in which a coolant can circulate by means of a compressor (5) that is followed by a condenser (6) and expansion means (7) through which the coolant can circulate, whereby use is made of an air-cooled condenser (6) with a frequency controlled fan (19), and the method comprises the step of controlling the speed of the aforementioned fan (19) so that the condenser pressure (p_c) is kept equal to a target value.



Method and device for cool drying a gas.

5 The present invention relates to a method for cool drying a gas.

More specifically, the invention is intended for cool drying a gas, whereby water vapour in the gas is condensed by guiding the gas through the secondary section of a heat
10 exchanger whose primary section forms the evaporator of a closed cooling circuit in which a coolant can circulate by means of a compressor that is installed in the cooling circuit downstream from the evaporator and which is followed by a condenser and expansion means through which
15 the coolant can circulate.

Cool drying is, as is known, based on the principle that by lowering the gas temperature the moisture in the gas condenses, after which the condensate is separated in a
20 liquid separator and after which the gas is again heated such that this gas is no longer saturated.

It is known that in most cases compressed air, supplied by a compressor for example, is saturated with water vapour
25 or, in other words, it has a relative humidity of 100%. This means that in the event of a temperature drop to below the 'dew point' condensation occurs. Because of the condensed water corrosion occurs in the pipes and tools that draw off compressed air from the compressor, and
30 equipment can present premature wear.

It is consequently necessary to dry this compressed air, which can be done in the aforementioned way by cool drying. Air other than compressed air or other gases can also be dried in this way.

5

A method for cool drying is already known whereby the condenser is an air-cooled condenser that is equipped with one or more fans.

10 These fans can be switched on and off depending on the cooling required for the condenser and coolant.

These fans will be switched on at a certain threshold value and switched off again at another threshold value.

15

Hereby more cooling is often done than is strictly necessary in order to have a certain reserve, such that the energy consumption of such a fan is often higher than what is really necessary.

20

The switching on or off of the fan will vary the condenser pressure.

This has the disadvantage that when the condenser pressure
25 rises, the compressor will consume more power.

An additional disadvantage is that the varying condenser pressure affects the expansion means and other valves in the cooling circuit, and consequently also the evaporator
30 pressure and cooling capacity of the cooling circuit.

Consequently the expansion means and other valves must be adjusted in order to prevent fluctuations of the evaporator pressure.

5 This leads to a very complex control of the system.

The purpose of the present invention is to provide a solution to at least one of the aforementioned and other disadvantages.

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The object of the present invention is a method for cool drying a gas, whereby water vapour in the gas is condensed by guiding the gas through the secondary section of a heat exchanger whose primary section forms the evaporator of a closed cooling circuit in which a coolant can circulate by means of a compressor that is installed in the cooling circuit downstream from the evaporator, and which is followed by a condenser and expansion means through which the coolant can circulate, whereby use is made of an air-cooled condenser with a frequency controlled fan, and the method comprises the step of controlling the speed of the
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25
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An advantage is that such a method that makes use of a frequency controlled fan enables the condenser pressure to be kept constant by suitably adjusting the speed of the fan.

This has the advantage that the evaporator pressure will not vary and that the valves in the cooling circuit do not

or almost do not have to be adjusted as a result of changes in the condenser pressure.

This means that the control and adjustment of such a device
5 is much simpler.

Another advantage is that a frequency controlled fan will last longer than a fan that can only be switched on and off.

10

The valves in the cooling circuit will also last longer as they do not have to be constantly adjusted.

The condenser pressure can be kept constant at a
15 precalculated or set value that is preferably chosen such that the combined power absorbed by the fan and the compressor is a minimum.

It is known that the power consumed by the fan can be
20 determined from the speed of the fan. The fan speed will determine the condenser pressure. The compressor power can be determined on the basis of the condenser pressure and the evaporator pressure.

25 Consequently by suitably choosing the condenser pressure the combined power can be kept to a minimum such that the device will consume very little energy.

The invention also concerns a device for cool drying a gas,
30 whereby water vapour in the gas is condensed by cooling the gas, whereby this device is provided with a heat exchanger

with a secondary section through which the gas to be dried is guided in order to cool the gas, and with a primary section that forms the evaporator of a closed cooling circuit in which a coolant can circulate by means of a compressor downstream from the evaporator, whereby downstream between the compressor and the evaporator the cooling circuit successively comprises a condenser and expansion means through which the coolant can circulate, whereby the condenser comprises a frequency controlled fan, whereby the device comprises a control unit and whereby the control unit controls the speed of the aforementioned fan such that the condenser pressure is kept equal to a calculated or set target value.

The advantages of a device according to the invention are analogous to the above-mentioned advantages.

With the intention of better showing the characteristics of the invention, a few preferred variants of a method and device according to the invention are described hereinafter by way of an example, without any limiting nature, with reference to the accompanying drawings, wherein:

figure 1 schematically shows a device according to the invention;

figure 2 schematically shows a matrix that shows the combined power absorbed by the compressor and fan as a function of the evaporator pressure and condenser pressure.

30

The device 1 shown in figure 1 for cool drying essentially consists of a heat exchanger 2 whose primary section forms the evaporator 3 of a closed cooling circuit 4, in which a compressor 5, a condenser 6 and expansion means 7 are also placed in succession.

In this case the compressor 5 is driven by a motor 8 and is used to make a coolant circulate through the cooling circuit 4 according to arrow A. The compressor 5 can be a volumetric compressor for example, while the motor 8 is an electric motor for example.

The coolant can be R404a for example, but the invention is of course not limited as such.

In this case and preferably the expansion means 7 are formed by an expansion valve 7.

The secondary section 9 of the heat exchanger 2 forms part of a pipe 10 for drying moist air whose direction of flow is indicated by arrow B. The entrance of this pipe 10 can be connected to an outlet of a compressor, for example, for the supply of the compressed air to be dried.

After the secondary section 9 of the heat exchanger 2, more specifically at its output, a first liquid separator 11 is installed in the pipe 10.

In this case a section 12 of this pipe 10, before it reaches the secondary section 9 of the heat exchanger 2, extends through a precooler or recovery heat exchanger 13.

After the secondary section 9 a section 14 of this pipe 10 also extends through this recovery heat exchanger 13, with the opposite flow to the aforementioned section 12.

- 5 The heat exchanger 2 is a liquid coolant-air heat exchanger and constructionally can form one unit with any recovery heat exchanger 13 that is an air-air heat exchanger.

10 The output of the aforementioned pipe 10 can be connected to a compressed air network (not shown in the drawings), for example, to which compressed air consumers are connected such as tools that are driven by compressed air.

15 In this case the compressor 5 is bypassed by one bypass pipe 15 that connects the outlet of the compressor 5 to the injection point P that is located upstream from the compressor, but downstream from the outlet 16 of the evaporator.

- 20 The bypass pipe 15 is constructed with a hot gas bypass valve 17 for tapping off coolant from the cooling circuit 4.

25 Downstream from the injection point P and upstream from the compressor, a second liquid separator 18 is incorporated in the closed cooling circuit 4.

30 According to the invention the condenser 6 is an air-cooled condenser that is equipped with a frequency controlled fan 19, whose speed is infinitely adjustable in this case.

The device 1 is further provided with a control unit 20. The control unit 20 is connected to the motor 8 and the fan 19 in order to control them.

- 5 The control unit 20 is also connected to means 21 to determine the condenser pressure and to means 22 to determine the evaporator pressure.

10 It is clear that it is not excluded that means are provided to determine the lowest gas temperature (LAT) of the gas to be dried.

It is clear that the means 22 determine the evaporator temperature instead of the evaporator pressure in view of
15 the unequivocal link between the two.

The method for cool drying by means of a device 1 according to figure 1 is very simple and as follows.

- 20 The air to be dried is carried through the pipe 10 and thus through the secondary section 9 of the heat exchanger 2 according to arrow B.

In this heat exchanger 2 the moist air is cooled under the
25 influence of the coolant that flows through the primary section of the heat exchanger and thus the evaporator 3 of the cooling circuit 4, 2.

As a result condensate is formed that is separated in the
30 first liquid separator 11.

The cold air that contains less moisture in absolute terms after this first liquid separator 11, but still has a relative humidity of 100%, is heated in the recovery heat exchanger 13 under the influence of the newly supplied air to be dried, such that the relative humidity falls to preferably below 50%, while the new air to be dried is already partially cooled in the recovery heat exchanger 13 before being carried to the heat exchanger 2.

10 The air at the output of the recovery heat exchanger 13 is thus drier than at the input of the heat exchanger 2.

To enable cooling of the moist air to be cooled in the secondary section 9 of the heat exchanger, the coolant is guided through the cooling circuit in the direction of arrow A through the evaporator 3 or the primary section of the heat exchanger 2.

The warm coolant that comes out of the evaporator 3 is in the gas phase and will be raised to a higher pressure by the compressor 5, then cooled in the condenser 6 by the fan 19 and condensed.

Any liquid coolant still present after the evaporator 3 will be held back by the second liquid separator 18.

The liquid cold coolant will then be expanded by the expansion valve 7 and will cool further, before being driven to the evaporator 3 to cool the air to be dried there.

Under the influence of heat transfer the coolant will warm up in the evaporator 3, evaporate and again be guided to the compressor 5.

5 The hot gas bypass valve 17 in the bypass pipe 15 will ensure that when the air in the heat exchanger 2 cools down too greatly, for example in the event of a variable load of the cool dryer, a certain quantity of coolant in the form of a hot gas will be driven across the compressor via the
10 aforementioned bypass pipe 15 in the direction of the arrow A'. In this way the cooling capacity of the device 1 can decrease and prevent the condensate in the heat exchanger from freezing or the temperature of the coolant falling too greatly.

15

In order to keep the control of the cooling circuit 4 as simple as possible, the fan 19 will be controlled by the control unit 20 such that the condenser pressure p_c is kept constant at a calculated or set target value.

20

In order to determine this target value, in this case use is made of a matrix that is stored in the control unit 20, for example.

25 An example of such a matrix is shown in figure 2.

The matrix gives the combined power that is absorbed by the compressor and the fan as a function of the evaporator pressure p_v and the condenser pressure p_c .

30

The control unit 20 receives the value P_{vn} for the evaporator pressure p_v from the means 22. On the basis of this value P_{vn} the control unit 20 determines a target value for the condenser pressure p_c at which the joint
5 combined power is a minimum.

In the example of figure 2, the minimum combined power is equal to x_{nn} and the accompanying target value for the condenser pressure is equal to p_{cn} .

10

The control unit 20 will adjust the speed of the fan such that the condenser pressure p_c reaches and maintains the determined target value p_{cn} .

15 In this way the condenser pressure p_c is kept constant and at such a target value that the combined power absorbed by the compressor 5 and the fan 19 is a minimum, which has the advantage that the device 1 will operate under optimum energy-efficient conditions, as the compressor 5 and the
20 fan 19 are the main consumers of energy in the cooling circuit 4.

It is possible that the control unit 20 is such that the target value of the condenser pressure p_c is determined
25 periodically, in other words the control unit 20 periodically determines a target value for the condenser pressure p_c from the matrix on the basis of the signal from the means 22. The interval with which the target value is determined can be chosen as a function of the variation of
30 the load of the device 1 for example.

Instead of using a matrix, the target value for the condenser pressure p_c can also be determined by means of a preprogrammed control algorithm in the control unit 20.

5 Hereby the control unit 20 will determine the power absorbed by the compressor 5 on the basis of the signal from the means 21 and 22, and determine the power absorbed by the fan 19 on the basis of the current speed of the fan 19 so that the combined power can be determined.

10

Then the control unit 20 will increase or decrease the speed of the fan 19 by a certain step and again determine the combined power.

15 The control unit 20 will determine for what fan 19 speed the combined power was a minimum and will adjust the fan 19 to this speed.

If need be the previous steps are repeated iteratively
20 until a minimum combined power is reached.

This control algorithm ensures that the control unit 20 is self-learning as it were and independent of the device 1 and the cooling circuit and consequently can be applied in
25 different devices 1 and cooling circuits 4.

In another preferred embodiment the fan 19 speed is adjusted to the minimum speed whereby the calculated or set target value for the condenser pressure p_c is reached or
30 whereby the condenser pressure p_c is as good as equal to the target value.

This target value may be determined on the basis of the methods described above, or otherwise.

- 5 This has the advantage that the fan speed is no higher than is strictly necessary.

When at a certain speed the target value for the condenser pressure p_c is reached within a certain allowed tolerance,
10 it is not necessary to further increase the speed in order to actually reach the target value. Indeed, it is possible that, in order to actually reach the target value, the speed will still have to increase very substantially. This will be coupled with a strong increase in the consumed
15 power of the fan 19, while the variation of the condenser pressure p_c will only be limited.

It is clear that the calculated or set target value can be determined in many different ways so that the combined
20 power absorbed by the compressor 5 and the fan 19 is a minimum.

It is also clear that the fan 19 speed can be controlled or adjusted in many different ways by the control unit 20 so
25 that the condenser pressure p_c is kept equal to the target value.

Although in the example shown the device 1 is provided with only one heat exchanger 2, it is clear that a number of
30 heat exchangers 2 can also be provided.

The present invention is by no means limited to the embodiment described as an example and shown in the drawings, but such a method and device can be realised in different variants without departing from the scope of the
5 invention.

Claims.

1.- Method for cool drying a gas, whereby water vapour in
5 the gas is condensed by guiding the gas through the
secondary section (9) of a heat exchanger (2) whose primary
section forms the evaporator (3) of a closed cooling
circuit (4) in which a coolant can circulate by means of a
compressor (5) that is installed in the cooling circuit (4)
10 downstream from the evaporator (3), and which is followed
by a condenser (6) and expansion means (7) through which
the coolant can circulate, **characterised in that** use is
made of an air-cooled condenser (6) with a frequency
controlled fan (19), and that the method comprises the step
15 of controlling the speed of the aforementioned fan (19) so
that the condenser pressure (p_c) is kept equal to a
calculated or set target value.

2.- Method according to claim 1, characterised in that the
20 calculated or set target value for the condenser pressure
(p_c) is chosen such that the combined power absorbed by the
compressor (5) and the fan (19) is a minimum.

3.- Method according to claim 2, characterised in that use
25 is made of a predetermined matrix that shows the combined
power absorbed by the compressor (5) and the fan (19) as a
function of the evaporator pressure (p_v) and the condenser
pressure (p_c), whereby the method comprises the steps of:
- the determination of the evaporator pressure (p_v);
30 - on the basis of the aforementioned matrix, the
determination of the target value for the condenser

pressure (p_c), which ensures a minimum combined power at the evaporator pressure (p_v) determined in this way.

4.- Method according to claim 2, characterised in that the method comprises the following iterative steps:

- the determination of the current combined power absorbed by the compressor (5) and the fan (19);
- the increase or decrease of the fan (19) speed by a certain step;
- 10 - the determination of the new current combined power absorbed by the compressor (5) and the fan (19);
- the adjustment of the fan (19) speed to the speed for which the determined combined power is the lowest;
- if need be the iterative repetition of the previous
- 15 steps.

5.- Method according to any one of the previous claims, characterised in that during the step of adjusting the fan (19) speed, the speed is adjusted to the minimum speed

20 whereby the calculated or set target value for the condenser pressure (p_c) is reached or whereby the condenser pressure (p_c) is as good as equal to the target value.

6.- Method according to any one of the previous claims, characterised in that the calculated or set target value

25 for the condenser pressure (p_c) is periodically determined.

7.- Method according to any one of the previous claims, characterised in that the method is used for drying gas

30 that originates from a compressor.

8.- Device for cool drying a gas, whereby water vapour in the gas is condensed by cooling the gas, whereby this device (1) is provided with a heat exchanger (2) with a secondary section (9) through which the gas to be dried is guided in order to cool the gas, and with a primary section that forms the evaporator (3) of a closed cooling circuit (4) in which a coolant can circulate by means of a compressor (5) downstream from the evaporator (3), whereby downstream between the compressor (5) and the evaporator (3) the cooling circuit (4) successively comprises a condenser (6) and expansion means (7) through which the coolant can circulate, **characterised in that** the condenser (6) comprises a frequency controlled fan (19) and that the device (1) comprises a control unit (20), whereby the control unit (20) controls the speed of the aforementioned fan (19) such that the condenser pressure (p_c) is kept equal to a calculated or set target value.

9.- Device according to claim 8, characterised in that the control unit (20) is provided with a predetermined matrix that shows the combined power absorbed by the compressor (5) and the fan (19) as a function of the evaporator pressure (p_v) and the condenser pressure (p_c) and that the control unit (20) is also connected to means (22) to determine the evaporator pressure (p_v), whereby the control unit (20) determines the target value for the condenser pressure (p_c) using the aforementioned matrix on the basis of the signal from the aforementioned means (22) so that the combined power is a minimum and adjusts the fan (19) speed so that the condenser pressure (p_c) is equal to this aforementioned target value.

10.- Device according to claim 8, characterised in that the control unit (20) is provided with a control algorithm that enables, by varying the fan (19) speed, an accompanying
5 variation of the combined power absorbed by the compressor (5) and the fan (19) to be determined and the fan (19) speed to be adjusted to the speed at which the aforementioned combined power is a minimum.

10 11.- Device according to any one of the previous claims 8 to 10, characterised in that the control unit (20) adjusts the fan (19) speed to the minimum speed whereby the calculated or set target value for the condenser pressure (p_c) is reached or whereby the condenser pressure (p_c) is
15 as good as equal to the target value.

12.- Device according to any one of the previous claims 8 to 11, characterised in that the control unit (20) periodically determines the calculated or set target value
20 for the condenser pressure (p_c).

13.- Device according to any one of the previous claims 8 to 12, characterised in that the gas to be dried originates from a compressor.

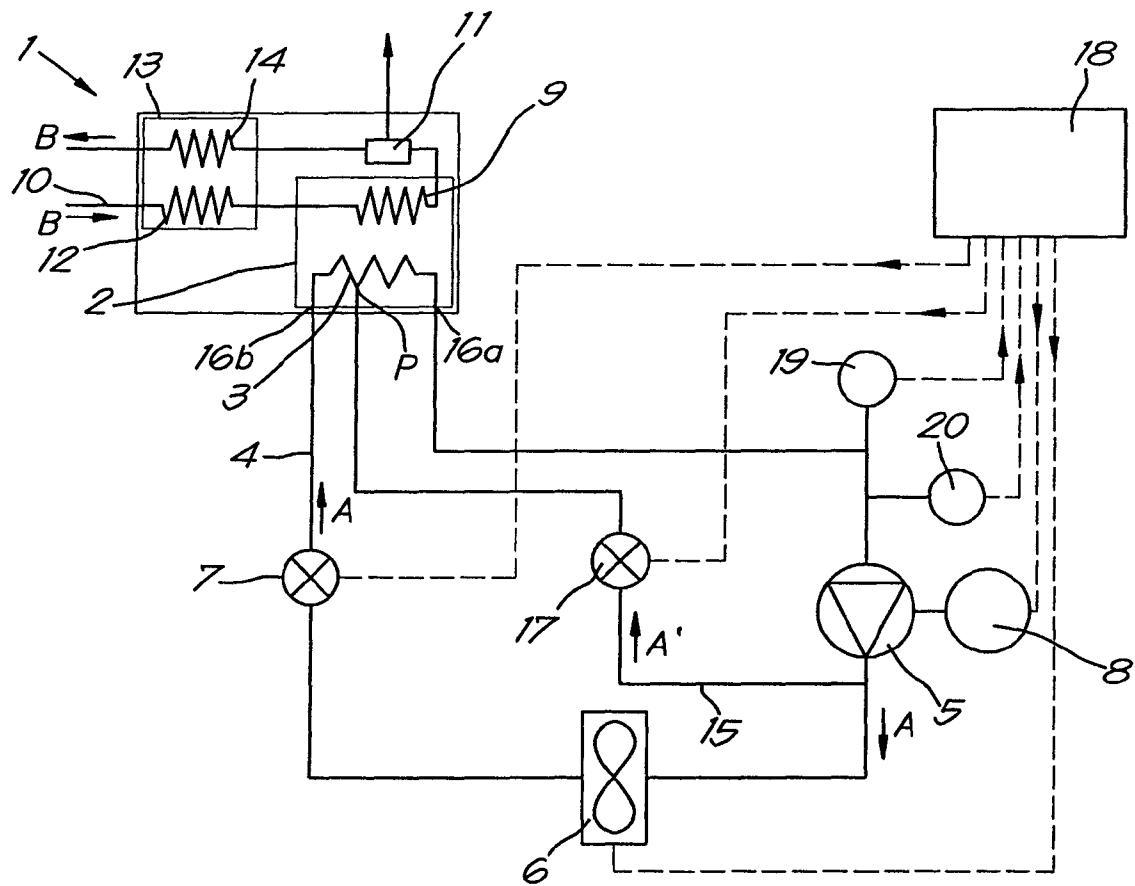


Fig. 1

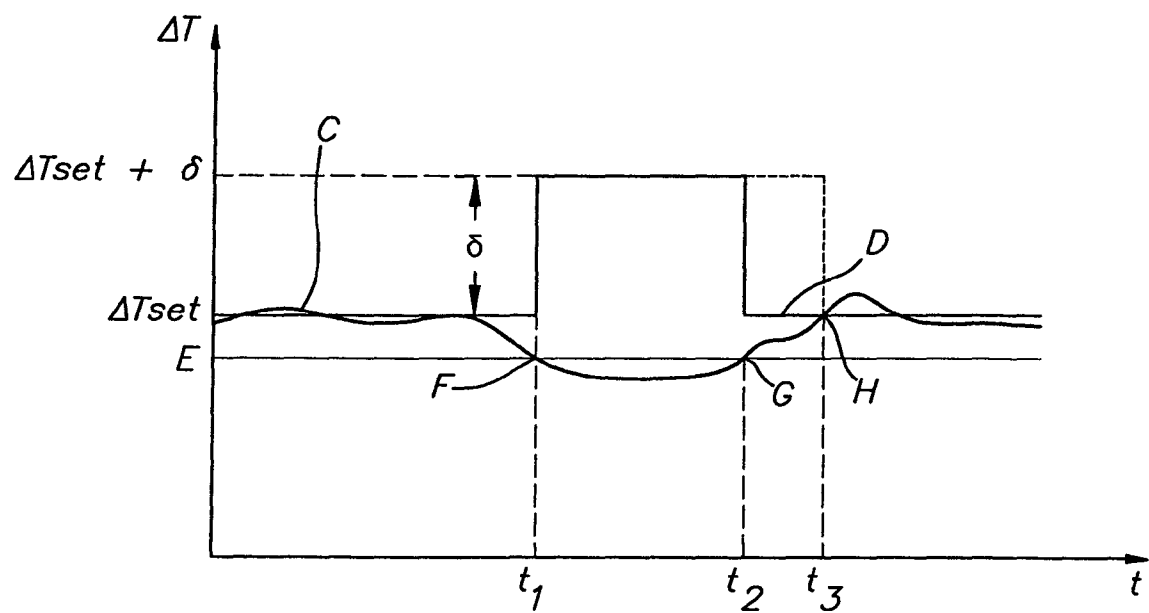


Fig. 2