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- (71) Applicant: **ITT MANUFACTURING ENTERPRISES LLC** [US/US]; 1105 North Market Street, Suite 1300, Wilmington, DE 19801 (US).
- (72) Inventor; and
- (71) Applicant : **STAVALE, Anthony, E.** [US/US]; 6965 Morgan Circle, Victor, NY 14564 (US).
- (74) Agent: **BARBER, William, J.**; Ware, Fressola, Maguire & Barber LLP, 755 Main Street, P.O. Box 224, Monroe, CT 06468 (US).
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(54) Title: METHOD OF DETERMINING PUMP FLOW IN ROTARY POSITIVE DISPLACEMENT PUMPS

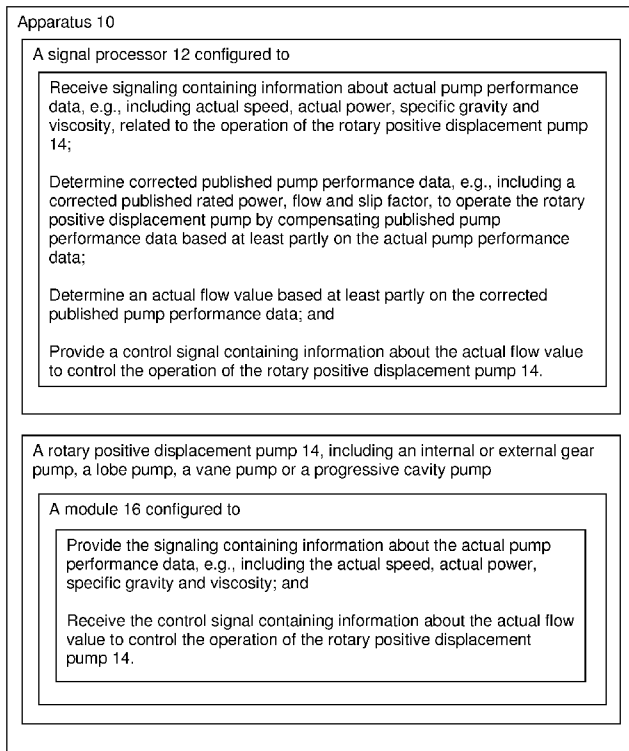


Figure 3

(57) Abstract: Techniques are provided for tuning a rotary positive displacement pump. The techniques include apparatus featuring a signal processor configured to the present invention may take the form of apparatus comprising a signal processor that may be configured to receive signaling containing information about actual pump performance data related to the operation of a rotary positive displacement pump; and determine corrected published pump performance data to operate the rotary positive displacement pump by compensating published pump performance data based at least partly on the actual pump performance data. The corrected published pump performance data may include a corrected published rated power, flow and slip factor, and the actual pump performance data contains information about actual power, specific gravity and viscosity related to the operation of the rotary positive displacement pump and received from a pump controller or controlling device, including a variable frequency drive.



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## METHOD OF DETERMINING PUMP FLOW IN ROTARY POSITIVE DISPLACEMENT PUMPS

### CROSS REFERENCE TO RELATED APPLICATIONS

5           This application claims benefit to provisional patent application serial no. 61/623,155, filed 12 April 2012, which is hereby incorporated by reference in its entirety.

### BACKGROUND OF THE INVENTION

#### 10           1. Field of the Invention

This application relates to a rotary positive displacement (PD) pump, such as an internal or external gear pump, a lobe pump, a vane pump or a progressive cavity pump; and more particularly, relates to techniques for tuning such a rotary PD pump in order to determine pump flow.

15

#### 2. Brief Description of Related Art

Many different type or kinds of pumps, including rotary positive displacement pumps, are known in the art. By way of example, some known pumps and shortcomings associated with the same are set forth below:

20

U.S. Patent no. 6,591,697, entitled "Method for Determining Pump Flow Rates Using Motor Torque Measurements," which is hereby incorporated by reference in its entirety, discloses a methodology that is based on the relationship of torque and speed versus pump flow rate and the ability to regulate pump flow using a Variable Frequency Drive (VFD) to adjust centrifugal pump speed. The technique used by  
25 Mr. Henyan in the '697 patent relies on calibrating pump flow at several speeds and determining a flow value based on calibrated torque vs flow curves at several speeds. An interpolation method is used to determine flow between calibrated

curves. Data for the calibrated flow curves are taken at zero flow (closed valve condition) at several speeds. A positive displacement pump cannot be operated at closed valve condition without pressure relief valves or bypass piping as the pump will continue to increase pressure and power until either a shaft or gear breaks or rupture occurs either in the system piping or pump casing. Another shortcoming is that the '697 patent relies on taking calibrated data at the factory which makes the variable frequency drive specific to the pump tested. Also, the invention has no provision for adjusting flow accuracy as pump wear occurs. Mr. Henyan's invention relates to centrifugal pumps where torque is proportional to the square of the speed change. In a rotary positive displacement pump torque is constant regardless of speed. Therefore mathematical relationships and the equations governing flow between centrifugal and rotary positive displacement pumps are completely different. Therefore, Mr. Henyan's technique is applicable to centrifugal pumps only and cannot be applied to positive displacement pumps.

U.S. Patent No. 7,945,411 B2, entitled "Method for Determining Pump Flow Without the Use of Traditional Sensors" which is hereby incorporated by reference in its entirety, discloses a technique that samples speed and power data at closed valve condition to correct the published pump curve for actual performance. Normalized power curves along with speed and power data taken from a Variable Frequency Drive (VFD) are used to calculate flow. The technique used in the '411 patent by Mr. Kernan utilizes speed and power data at closed valve condition to adjust published pump performance for actual performance. A positive displacement pump cannot be operated at closed valve condition without a pressure relief valve or bypass piping as it will continue to increase pressure and power until either a shaft or gear breaks or rupture occurs either in the system piping or pump casing. Pump

flow is calculated by a polynomial power equation and normalized power curves. In a centrifugal pump pressure varies as the square of the speed change and power varies as the cube of the speed change. A centrifugal pump is not a positive displacement machine and as such the capacity output will vary based on the

5 resistance at the pump outlet. Less resistance will give more flow; more resistance less flow. A rotary positive displacement pump is a positive displacement machine where a defined volume of flow is positively displaced for each revolution of the pump shaft regardless of pressure at the outlet (unless blocked). For a rotary positive displacement pump flow is proportional to a speed change regardless of

10 outlet pressure. There is slip which occurs which reduces the theoretical displacement due to clearances, pressure, viscosity and speed. Power typically is proportional to a speed change in rotary positive displacement pumps at constant pressure; in a centrifugal pump power varies as the cube of the speed change. Mathematical relationships and the equations governing flow between centrifugal

15 and rotary positive displacement pumps are completely different. Therefore, Mr. Kernan's technique is applicable to centrifugal pumps only and cannot be applied to positive displacement pumps.

In the prior art, it is known to use calculations from resource material, e.g., a pump handbook for a positive displacement pump. However, one disadvantage with

20 this approach is that calculation techniques such as those presented in the pump handbook require knowledge of difficult to determine variables such as pump geometry factor and slip coefficient. These calculation techniques cannot compensate for pump performance which deviates from published performance calculations.

In the prior art, it is known to use external flow meters; however, external flow meters can add cost and complexity to the overall drive system.

None of the aforementioned techniques described herein may be used for determining pump flow in rotary positive displacement pumps, as set forth below and  
5 herein.

### SUMMARY OF THE INVENTION

The present invention provides new and unique techniques for tuning rotary positive displacement pumps.

10 This invention overcomes the aforementioned shortcomings by introducing a tune function which corrects the calculated flow value based on published performance data to reflect actual pump performance. Slip coefficients may be automatically adjusted based on slip rules which compensate changes in known variables such as torque, speed and viscosity.

15 Published performance for certain types of rotary positive displacement pumps such as progressive cavity pumps have been found to differ from actual performance based on anticipated wear in the stator liner. The published performance for these types of pumps is more indicative of the midpoint in wear than the "as new" pump performance. Figures 1 and 2 shows a comparison for capacity  
20 and power between published performance vs. test data for a typical progressive cavity pump. As shown the "as new" pump performance has inherently less slip than shown in the published pump curve. The tune function according to the present invention can restore flow accuracy by compensating for pump wear.

In summary, the technique according to the present invention requires an  
25 input of pump parameters which are readily accessible to pump users such as pump

type, rated flow, rated speed, rated power, rated viscosity and no slip flow. Speed and power data received in signaling taken from a Variable Frequency Drive (VFD) along with specific gravity and viscosity data may be used to calculate and compensate slip flow at varying conditions. The slip flow can then be deducted from the theoretical displacement flow to determine an actual flow value. In constant temperature applications where specific gravity and viscosity are constant, the method of flow calculation becomes sensorless. For applications with varying temperature, a simple temperature measurement device is required to compensate changing conditions.

10

#### The Apparatus

By way of example, and according to some embodiments, the present invention may take the form of apparatus comprising a signal processor that may be configured to:

15

receive signaling containing information about actual pump performance data related to the operation of a rotary positive displacement pump; and

20

determine corrected published pump performance data to operate the rotary positive displacement pump by compensating published pump performance data based at least partly on the actual pump performance data.

According to some embodiments of the present invention, the corrected published pump performance data may include a corrected published rated power, a corrected published rated flow and a rated slip factor which is compensated for actual rated conditions.

According to some embodiments of the present invention, the actual pump performance data may include information about actual power, actual specific gravity and actual viscosity related to the operation of the rotary positive displacement pump, e.g., in the signaling received from a pump controller or controlling device, such as a variable frequency drive (VFD) or programmable logic controller (PLC).

According to some embodiments of the present invention, the signal processor may be configured to determine an actual flow value for the rotary positive displacement pump based at least partly on the corrected published pump performance data.

According to some embodiments of the present invention, the signal processor may be configured to provide a control signal containing information about the actual flow value to control the operation of the rotary positive displacement pump.

According to some embodiments of the present invention, the signal processor may be configured to determine the corrected published rated power by compensating a published rated power based at least partly on actual power, actual specific gravity and actual viscosity at rated conditions.

According to some embodiments of the present invention, the signal processor may be configured to determine a corrected published rated flow by compensating a published rated flow based at least partly on the corrected published rated power.

According to some embodiments of the present invention, the signal processor may be configured to determine a rated slip factor by compensating for actual rated conditions based at least partly on the corrected published rated flow and the corrected published rated power.

According to some embodiments of the present invention, the signal processor may be configured to determine an actual flow value based at least partly on deducting the corrected rated slip flow based on slip rules for the operating condition as shown in Tables I and II for the PD pump type from a theoretical displacement flow.

According to some embodiments of the present invention, the signal processor may be configured to determine the signal processor may be configured to activate a tune function and replace the published rated power, the published rated flow and the rated slip factor with the corrected published rated power, flow and rated slip factor compensated for actual conditions, and to use the corrected published rated power, the corrected published rated flow and the rated slip factor compensated for actual conditions until another tune function is initiated.

According to some embodiments of the present invention, the signaling may contain information about pump parameters, including some combination of a pump type, a published rated flow, a published rated speed, a published rated power, a published rated viscosity and no slip flow, and information about actual speed and power from a variable frequency drive (VFD) along with actual specific gravity and viscosity; and the signal processor is configured to determine a corrected slip flow (determined from slip rules) or factor based at least partly on the signaling. The signal processor may also be configured to determine an actual flow value based at least partly on deducting the corrected rated slip flow or factor from a theoretical displacement flow or factor.

According to some embodiments of the present invention, the signal processor may be configured to determine the corrected rated slip flow based on slip rules for the operating condition as shown in Tables I and II below for the PD

pump type or factor without using sensors based at least partly on a constant temperature application where specific gravity and viscosity are substantially constant. Alternatively, in applications with varying temperature, the signal processor may be configured to receive a temperature measurement and determine  
 5 the corrected rated slip flow (determined from slip rules) or factor by compensating changing conditions, including specific gravity and viscosity, based at least partly on the same.

According to some embodiments of the present invention, the signal processor is configured to determine the corrected published rated power based at  
 10 least partly on the following equation:

$$\text{RTD HP}_{\text{CORR}} = \text{HP}_{\text{ACT}} \times (\text{SG}_{\text{RTD}} / \text{SG}_{\text{ACT}}) / (\text{VISC}_{\text{ACT}} / \text{VISC}_{\text{RTD}})^N,$$

where:

15  $\text{RTD HP}_{\text{CORR}}$  is the corrected published rated power in the form of rated hp corrected for specific gravity and viscosity,

$\text{HP}_{\text{ACT}}$  is the actual power at rated conditions,

$\text{SG}_{\text{RTD}}$  is the rated specific gravity of the pumped liquid,

$\text{SG}_{\text{ACT}}$  is the actual specific gravity of the pumped liquid,

20  $\text{VISC}_{\text{RTD}}$  is the rated viscosity of the pumped liquid,

$\text{VISC}_{\text{ACT}}$  is the actual viscosity of the pumped liquid, and

N is an exponent which varies by the type of pump.

For rotary PD pumps such as gear, vane and lobe, the exponent N may equal about 0.10; and for progressive cavity pumps, the exponent N may equal about 0.275.

According to some embodiments of the present invention, the signal processor may be configured to determine the corrected published rated flow based at least partly on the following equation:

$$5 \quad Q_{\text{RATEDCORR}} = (\text{RTD HP}_{\text{CORR}} / \text{RTD HP}) \times Q_{\text{RTD}},$$

where:

$Q_{\text{RATEDCORR}}$  is the corrected rated flow,

10  $\text{RTD HP}$  is the corrected published rated power in the form of the rated hp for the application, and

$Q_{\text{RTD}}$  is the rated flow for the application.

According to some embodiments of the present invention, the signal processor may be configured to determine the rated slip factor compensated for actual conditions based at least partly on the following equation:

15

$$\text{KS} =$$

$$(\text{VISC}_{\text{RTD}} \times Q_{\text{NO SLIP}} \times (Q_{\text{NO SLIP}} - Q_{\text{RATEDCORR}})) / (75.415 \times K_G \times (N_{\text{RATED}}) \times T_{\text{RTD CORR}}),$$

where:

20  $\text{KS}$  is the rated slip factor compensated for actual conditions,

$\text{VISC}_{\text{RTD}}$  is the published pump rated viscosity,

$Q_{\text{NO SLIP}}$  is the flow in gpm at rated speed and rated viscosity at 0 psid differential pressure,

$Q_{\text{RATEDCORR}}$  is the corrected rated flow,

25  $K_G = 0.004329$ , a design constant,

$N_{RATED}$  = Rated Pump Speed for the application, and

$T_{RTD\ CORR}$  = Corrected Rated Torque in Ft-Lbs (US), which is determined as follows:  $T_{RTD\ CORR} = (5252 \times RTD\ HP_{CORR})/N_{RTD}$ .

According to some embodiments of the present invention, the signal processor is configured to determine an actual flow value for the rotary positive displacement pump based at least partly on the following equation:

$$Q_{ACT\ CORR} = \frac{(Q_{NO\ SLIP} \times ((N_{MOTOR}/RATIO)/N_{RATED})) - (((75.415 \times K_G \times K_{SCORR}) \times (N_{MOTOR}/RATIO) \times T_{ACT\ CORR}) / (VISCOSITY_{ACT} \times Q_{NO\ SLIP}))}{1}$$

where:

$Q_{NO\ SLIP}$  is the flow in gpm at rated speed and rated viscosity at 0 psid differential pressure,

$N_{MOTOR}$  = the current motor speed,

RATIO = the ratio of speed reduction if a gear reducer is used, . If no gear reducer is used than the value of the RATIO = 1.0.

$N_{RATED}$  = the Rated Pump Speed for the application,

$K_G = 0.004329$ , a design constant,

$K_{SCORR}$  is the corrected rated slip factor based on the slip rules shown in Tables I and II for the PD pump type,

$T_{ACT\ CORR}$  = Torque in Ft-Lbs (US), where  $T_{ACT\ CORR} = (5252 \times HP_{ACT\ CORR})/N_{ACT}$ , and  $HP_{ACT\ CORR} = HP_{ACT} \times (SG_{RTD}/SG_{ACT})$ ,

$HP_{ACT}$  = Actual motor power,

$N_{ACT}$  = Actual pump speed, and

$VISC_{ACT}$  is the actual viscosity of the pumped liquid.

According to some embodiments of the present invention, the signal processor may also be configured as, or take the form of, a controller or control module that controls the operation of the rotary positive displacement pump.

5           According to some embodiments of the present invention, the apparatus may include the rotary positive displacement pump itself in combination with the signal processor, including where the rotary positive displacement pump takes the form of an internal or external gear pump, or a lobe pump, or a vane pump, or a progressive cavity pump, as well as other types or kind of rotary positive displacement pumps  
10 either now known or later developed in the future.

#### The Method

According to some embodiments, the present invention may take the form of a method comprising steps for receiving with a signal processor signaling containing  
15 information about actual pump performance data related to the operation of a rotary positive displacement pump; and determining with the signal processor corrected published pump performance data to operate the rotary positive displacement pump by compensating published pump performance data based at least partly on the actual pump performance data.

20           According to some embodiments of the present invention, the method may also include implementing one or more of the features set forth above.

## BRIEF DESCRIPTION OF THE DRAWING

The drawing includes the following Figures:

Figure 1 is a graph of power (HP) versus discharge pressure (PSIG) related to a power comparison of published versus test data at 200 Cp, 1750 Rpm for a rotary  
5 positive displacement pump.

Figure 2 is a graph of capacity (GPM) versus discharge pressure (PSIG) for a capacity comparison of published versus test data at 200 Cp, 1750 Rpm for a rotary positive displacement pump.

Figure 3 is a block diagram of apparatus according to some embodiments of  
10 the present invention.

## DETAILED DESCRIPTION OF THE INVENTION

By way of example, as shown in Figure 3, according to some embodiments, the present invention may take the form of apparatus 10 that includes a signal  
15 processor 12 that may be configured to control and protect the operation of a rotary positive displacement pump 14, e.g., which may include, or take the form of, an internal or external gear pump, a lobe pump, a vane pump or a progressive cavity pump.

The signal processor 12 may be configured to receive signaling containing  
20 information about actual pump performance data related to the operation of the rotary positive displacement pump 14 and determine corrected published pump performance data to operate the rotary positive displacement pump by compensating published pump performance data based at least partly on the actual pump performance data.

The signal processor 12 may also be configured to determine an actual flow value for the rotary positive displacement pump based at least partly on the corrected published pump performance data, and to provide a control signal containing information about an actual flow value to control the operation of the rotary positive displacement pump.

The rotary positive displacement pump 14 may include a module 16 configured to provide the signaling containing information about actual pump performance data related to the operation of the rotary positive displacement pump 14, and may also be configured to receive the control signal containing information about the actual flow value to control the operation of the rotary positive displacement pump 14.

By way of example, the signal processor 12 may be implemented consistent with that set forth below:

#### The Implementation

The logic according to the present invention works by compensating published values of rated power, rated flow and rated slip factor for actual rated conditions, as follows:

The published rated power may be compensated for actual power, actual specific gravity and actual viscosity at rated conditions. This becomes the corrected rated power.

The published rated flow may be compensated for actual rated conditions based on the corrected rated power. This becomes the corrected rated flow.

The rated slip factor, calculated from published data, may be compensated for actual rated conditions based on the corrected rated power and corrected rated flow.

Once these values are calculated and a tune function is activated the published values for Rated HP, Rated Flow and Rated Slip Factor are replaced by the corresponding compensated or corrected values. These compensated or corrected values are saved and do not change unless another tune function is initiated. Note the tune function is typically activated while the pump is operating at rated speed and rated conditions.

By way of example, the technique of compensation and flow calculation may consist of the following steps:

a) Rated HP Compensation (RTD  $HP_{CORR}$ )

For instance, the signal processor 12 may be configured to determine the corrected published rated power based at least partly on the following equation:

$$RTD\ HP_{CORR} = HP_{ACT} \times (SG_{RTD} / SG_{ACT}) / (VISC_{ACT} / VISC_{RTD})^N,$$

where:

RTD  $HP_{CORR}$  is the rated hp corrected for specific gravity and viscosity,

$HP_{ACT}$  is the actual power at rated conditions,

$SG_{RTD}$  is the rated specific gravity of the pumped liquid,

$SG_{ACT}$  is the actual specific gravity of the pumped liquid,

$VISC_{RTD}$  is the rated viscosity of the pumped liquid,

$VISC_{ACT}$  is the actual viscosity of the pumped liquid, and

N is an exponent which varies by the type of pump.

By way of example, for rotary PD pumps such as gear, vane and lobe, the exponent N equals about 0.10, and for progressive cavity pumps, the exponent N equals about 0.275.

5           The scope of the invention is not intended to be limited to the specific  
aforementioned equation and parameters set forth above to determine the corrected  
published rated power. For example, embodiments are envisioned in which  
variations of the aforementioned equation and/or parameters may be used to  
determine the corrected published rated power consistent with that now known or  
10 later developed in the future.

b) Rated Flow Compensation ( $Q_{\text{RATEDCORR}}$ )

For instance, the signal processor 12 may be configured to determine the corrected published rated flow based at least partly on the following equation:

15

$$Q_{\text{RATEDCORR}} = (\text{RTD HP}_{\text{CORR}} / \text{RTD HP}) \times Q_{\text{RTD}},$$

Note that  $Q_{\text{RATEDCORR}}$  is calculated at rated speed.

Where:

20

$Q_{\text{RATEDCORR}}$  is the corrected rated flow

$\text{RTD HP}_{\text{CORR}}$  is the rated hp corrected for specific gravity and viscosity,

RTD HP is the rated hp for the application

$Q_{\text{RTD}}$  is the rated flow for the application

The scope of the invention is not intended to be limited to the specific  
25 aforementioned equation and parameters set forth above to determine the corrected

published rated flow. For example, embodiments are envisioned in which variations of the aforementioned equation and/or parameters may be used to determine the corrected published rated flow consistent with that now known or later developed in the future.

5

c) Rated Slip Factor Compensation (KS):

For instance, the signal processor 12 may be configured to determine the rated slip factor KS compensated for actual conditions based at least partly on the following equation:

10

$$KS = \frac{(VISC_{RTD} \times Q_{NO\ SLIP} \times (Q_{NO\ SLIP} - Q_{RATED\ CORR}))}{(75.415 \times K_G \times (N_{RTD}) \times T_{RTD\ CORR})}$$

where:

15

KS is the rated slip factor compensated for actual conditions,

$Q_{NO\ SLIP}$  is the flow in Gpm at rated speed and rated viscosity at 0 psid differential pressure,

$Q_{RATEDCORR}$  is the corrected rated flow,

$K_G = 0.004329$ , a design constant,

20

$N_{RTD}$  = Rated Pump Speed for the application, and

$T_{RTD\ CORR}$  = Corrected Rated Torque in Ft-Lbs (US), which is calculated as follows:  $T_{RTD\ CORR} = (5252 \times RTD\ HP_{CORR})/N_{RTD}$ , where

RTD  $HP_{CORR}$  is the rated hp corrected for specific gravity and viscosity.

25

The scope of the invention is not intended to be limited to the specific aforementioned equation and parameters set forth above to determine the rated slip

factor. For example, embodiments are envisioned in which variations of the aforementioned equation and/or parameters may be used to determine the rated slip factor consistent with that now known or later developed in the future.

5 d) Tune Function Activation

To calculate and save values calculated in steps a – c, the signal processor 12 is configured to activate the tune function process while the pump is stable and operating at rated conditions. The tune function process is seamless to the user. Tuning samples actual conditions without changing operating conditions or pump  
10 speed. Once tuning is completed, the values for  $RTD\ HP_{CORR}$ ,  $Q_{RATED\ CORR}$  and  $KS$  are saved. These values do not change unless another tune function process is re-initiated.

Periodically as wear occurs, pump flow accuracy can be restored by re-activating this parameter when operating at rated conditions.

15

e) The Actual Flow Calculation

For instance, the rated slip factor,  $KS$ , may be corrected for changing variables due to operating conditions by the slip rules for rotary and progressive cavity pumps as shown in Tables I and II. The corrected slip factor becomes  
20  $KS_{CORR}$ .

The signal processor 12 may be configured to determine an actual flow value for the rotary positive displacement pump based at least partly on the following equation:

$$Q_{ACT\ CORR} = \frac{(Q_{NO\ SLIP} \times ((N_{MOTOR}/RATIO)/N_{RTD})) - (((75.415 \times K_G \times K_{SCORR}) \times (N_{MOTOR}/RATIO) \times T_{ACT\ CORR}) / (VISC_{ACT} \times Q_{NO\ SLIP}))}{1}$$

5

where:

$Q_{NO\ SLIP}$  is the flow in Gpm at rated speed and rated viscosity at 0 psid differential pressure,

$N_{MOTOR}$  = current motor speed,

10  $RATIO$  = the ratio of speed reduction if a gear reducer is used (If no gear reducer is used than the value of the  $RATIO = 1.0.$ ),

$N_{RTD}$  = Rated Pump Speed for the application,

$K_G = 0.004329$ , a design constant,

$VISC_{ACT}$  is the actual viscosity of the pumped liquid,

15  $T_{ACT\ CORR}$  = Torque in Ft-Lbs (US), which is calculated as follows:  $T_{ACT\ CORR} = (5252 \times HP_{ACT\ CORR})/N_{ACT}$ , where  $HP_{ACT\ CORR} = HP_{ACT} \times (SG_{RTD}/SG_{ACT})$ , and

$K_{SCORR}$  = corrected slip factor based on slip rules for the operating condition as shown in Tables I and II.

20 For constant temperature applications, a specific gravity value is not required and  $HP_{ACT\ CORR} = HP_{ACT}$ , where

$HP_{ACT}$  = Actual motor power, and

$N_{ACT}$  = Actual pump speed.

Adjustments to the rated slip factor,  $KS$ , may be made by the slip rules shown below, which results in a corrected slip factor, " $K_{SCORR}$ ".

25

Table I: Slip Rules for Rotary PD Pumps and Magnetic Drive Rotary PD Pumps:

<b>Changing Variable</b>	<b>Corrected Slip Factor “K<sub>SCORR</sub>” used in step “e”</b>
Torque	SLIP FACTOR is Constant; $K_{SCORR} = KS$
Speed	$K_{SCORR} = KS * (N_{RATED} / N_{ACT})$
Speed and Torque	SLIP FACTOR is Constant; $K_{SCORR} = KS$
Viscosity	$K_{SCORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Speed and Viscosity	$K_{SCORR} = KS * (N_{RATED} / N_{ACT}) * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Torque and Viscosity	$K_{SCORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Speed, Torque and Viscosity	$K_{SCORR} = KS * (N_{RATED} / N_{ACT}) * (Visc_{ACT} / Visc_{RATED})^{0.5}$

5

Table II: Slip Rules for Progressive Cavity Pumps and Magnetic Drive Progressive Cavity Pumps:

<b>Changing Variable</b>	<b>Corrected Slip Factor “K<sub>SCORR</sub>” used in step “e”</b>
Torque	SLIP FACTOR is Constant; $K_{SCORR} = KS$
Speed	$K_{SCORR} = KS * (N_{RATED} / N_{ACT})$
Speed and Torque	SLIP FACTOR is Constant; $K_{SCORR} = KS$
Viscosity	$K_{SCORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Speed and Viscosity	$K_{SCORR} = KS * (N_{RATED} / N_{ACT}) * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Torque and Viscosity	$K_{SCORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Speed, Torque and Viscosity	$K_{SCORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$

The result of the flow calculation in step (e) is as follows:

$$Q_{ACT\ CORR} = Q_{ACT}, \text{ and}$$

10

the  $Q_{ACT\ CORR}$  is displayed as the actual flow ( $Q_{ACT}$ ) in Gpm.

In the tables, the parameters for actual and rated pump speed are as follows:

$N_{ACT}$  = Actual pump speed, and

$N_{RTD}$  = Rated pump speed of the application.

For magnetic drive rotary and magnetic drive progressive cavity PD pumps:

5  $T_{ACT\ CORR}$  = Torque in Ft-Lbs (US), which is calculated as follows:  $T_{ACT\ CORR} = (5252 \times$   
 $HP_{ACT\ CORR})/N_{ACT}$ , where:

$$HP_{ACT\ CORR} = (HP_{ACT} - (P_{MAG\ CORR} \times (N_{ACT}/N_{RTD})^2) \times SG_{RTD}/SG_{ACT}),$$

$HP_{ACT}$  = Actual motor power, and

$P_{MAG\ CORR}$  is the eddy current loss in Hp at rated speed for the containment  
 10 shell material used. Note for non-metallic containment shells the eddy current loss is  
 0 hp.

The scope of the invention is not intended to be limited to the specific  
 aforementioned equation and parameters set forth above to determine the actual  
 flow value. For example, embodiments are envisioned in which variations of the  
 15 aforementioned equation and/or parameters may be used to determine the actual  
 flow value consistent with that now known or later developed in the future.

### The Signal Processor 12

The signal processor 12 performs the basic signal processing functionality of  
 20 the apparatus for implementing the present invention. The signal processor 12 may  
 be a stand alone signal processing module, form part of a controller, controller  
 module, etc., or form part of some other module of the apparatus 10. Many different  
 types and kind of signal processors, controllers and controller modules for controlling  
 pumps are known in the art. Some examples are variable frequency drives and

programmable logic controllers. By way of example, based on an understanding of such known signal processing modules, controllers and control modules, a person skilled in the art would be able to configure the signal processor 12 to perform the functionality consistent with that described herein, including to receive the signaling  
5 containing information about actual pump performance data related to the operation of the rotary positive displacement pump 14; and to determine corrected published pump performance data to operate the rotary positive displacement pump 14 by compensating published pump performance data based at least partly on the actual pump performance data. By way of further example, based on an understanding of  
10 such known signal processing modules, controllers and control modules, a person skilled in the art would be able to configure the signal processor 12 to perform functionality consistent with that described herein, including to determine an actual flow value for the rotary positive displacement pump based at least partly on the corrected published pump performance data, and to provide a control signal  
15 containing information about an actual flow value to control the operation of the rotary positive displacement pump.

By way of still further example, the functionality of the signal processor 12 may be implemented using hardware, software, firmware, or a combination thereof, although the scope of the invention is not intended to be limited to any particular  
20 embodiment thereof. In a typical software implementation, such a module would be one or more microprocessor-based architectures having a microprocessor, a random access memory (RAM), a read only memory (ROM), input/output devices and control, data and address buses connecting the same. A person skilled in the art would be able to program such a microprocessor-based implementation to perform  
25 the functionality described herein without undue experimentation. The scope of the

invention is not intended to be limited to any particular implementation using technology known or later developed in the future.

The signal processor, controller or controller module may include other modules to perform other functionality that is known in the art, that does not form  
5 part of the underlying invention, and that is not described in detail herein.

#### The Rotary Positive Displacement Pump 14

The rotary positive displacement pump like element 14, and rotary positive displacement pumps in general, are known in the art, e.g., which may include an  
10 internal or external gear pump, a lobe pump, a vane pump or a progressive cavity pump, and not described in detail herein. Moreover, the scope of the invention is not intended to be limited to any particular type or kind of positive displacement machine thereof that is either now known or later developed in the future. By way of example, such rotary positive displacement pumps are understood to include a motor or motor  
15 portion for driving a pump or pump portion, and may include a module like element 16 for implementing some functionality related to controlling the basic operation of the motor for driving the pump 14. By way of example, and consistent with that set forth herein, the motor is understood to receive control signals from the signal processor in order to drive and control the rotary positive displacement pump to  
20 pump fluid. The motor is also understood to provide the signaling containing information about power, torque and speed related to the operation of the pump.

### Other Possible Applications

Other possible applications include at least the following:

Rotary positive displacement pump flow calculations - flow estimations for rotary positive displacement pumps rely upon accurate power curves to estimate pump flow. Published performance for certain types of positive displacement pumps such as progressive cavity pumps have been found to differ from actual performance based on anticipated wear in the stator liner. The tune function described above will correct the calculated flow value based on published performance to reflect actual pump performance for rotary positive displacement pumps.

10 The tune function can also restore flow accuracy by compensating for pump wear.

### The Scope of the Invention

15 It should be understood that, unless stated otherwise herein, any of the features, characteristics, alternatives or modifications described regarding a particular embodiment herein may also be applied, used, or incorporated with any other embodiment described herein. Also, the drawings herein are not drawn to scale.

20 Although the invention has been described and illustrated with respect to exemplary embodiments thereof, the foregoing and various other additions and omissions may be made therein and thereto without departing from the spirit and scope of the present invention.

I CLAIM:

1. Apparatus comprising:

a signal processor configured to

receive signaling containing information about actual pump performance data

5 related to the operation of a rotary positive displacement pump; and

determine corrected published pump performance data to operate the rotary positive displacement pump by compensating published pump performance data based at least partly on the actual pump performance data.

10 2. Apparatus according to claim 1, wherein the corrected published pump performance data include a corrected published rated power, a corrected published rated flow and a rated slip factor compensated for actual conditions.

15 3. Apparatus according to claim 1, wherein the actual pump performance data includes information about actual speed, actual power, actual specific gravity and actual viscosity related to the operation of the rotary positive displacement pump.

20 4. Apparatus according to claim 3, wherein the corrected published pump performance data include a corrected published rated power, a corrected published rated flow and a rated slip factor compensated for actual conditions.

5. Apparatus according to claim 1, wherein the signal processor is configured to determine an actual flow value for the rotary positive displacement pump based at least partly on the corrected published pump performance data.

25

6. Apparatus according to claim 5, wherein the signal processor is configured to provide a control signal containing information about an actual flow value to control the operation of the rotary positive displacement pump.

5           7. Apparatus according to claim 2, wherein the signal processor is configured to determine the corrected published rated power by compensating a published rated power based at least partly on actual power, specific gravity and viscosity at rated conditions.

10           8. Apparatus according to claim 7, wherein the signal processor is configured to determine a corrected published rated flow by compensating a published rated flow based at least partly on the corrected published rated power.

15           9. Apparatus according to claim 8, wherein the signal processor is configured to determine a rated slip factor compensated for actual conditions based at least partly on the corrected published rated flow and the corrected published rated power.

20           10. Apparatus according to claim 9, wherein the signal processor is configured to activate a tune function and replace the published rated power, published rated flow and rated slip factor with the corrected published rated power, corrected published rated flow and the rated slip factor compensated for actual conditions.

11. Apparatus according to claim 10, wherein the signal processor is configured to determine an actual flow value based at least partly on deducting the corrected rated slip flow from a theoretical displacement flow.

5 12. Apparatus according to claim 10, wherein the signal processor is configured to use the corrected published rated power, the corrected published rated flow and the rated slip factor compensated for actual conditions until another tune function is initiated.

10 13. Apparatus according to claim 1, wherein the signaling contains information about pump parameters, including some combination of a pump type, a published rated flow, a published rated speed, a published rated power, a published rated viscosity and no slip flow, and information about actual speed and power from a variable frequency drive (VFD) along with actual specific gravity and viscosity; and  
15 the signal processor is configured to determine a corrected slip flow or factor based at least partly on the signaling.

14. Apparatus according to claim 13, wherein the signal processor is configured to determined an actual flow value based at least partly on deducting the  
20 corrected rated slip flow or factor from a theoretical displacement flow or factor.

15. Apparatus according to claim 14, wherein the signal processor is configured to determine the corrected rated slip flow or factor without using sensors based at least partly on a constant temperature application where specific gravity  
25 and viscosity are substantially constant.

16. Apparatus according to claim 14, wherein, in applications with varying temperature, the signal processor is configured to receive a temperature measurement and determine the corrected rated slip factor by compensating  
 5 changing conditions, including actual speed, specific gravity and viscosity, based at least partly on the same.

17. Apparatus according to claim 2, wherein the signal processor is configured to determine the corrected published rated power based at least partly on  
 10 the following equation:

$$\text{RTD HP}_{\text{CORR}} = \text{HP}_{\text{ACT}} \times (\text{SG}_{\text{RTD}} / \text{SG}_{\text{ACT}}) / (\text{VISC}_{\text{ACT}} / \text{VISC}_{\text{RTD}})^{\text{N}},$$

where:

15  $\text{RTD HP}_{\text{CORR}}$  is the corrected published rated power in the form of rated hp corrected for specific gravity and viscosity,

$\text{HP}_{\text{ACT}}$  is the actual power at rated conditions,

$\text{SG}_{\text{RTD}}$  is the rated specific gravity of the pumped liquid,

$\text{SG}_{\text{ACT}}$  is the actual specific gravity of the pumped liquid,

20  $\text{VISC}_{\text{RTD}}$  is the rated viscosity of the pumped liquid,

$\text{VISC}_{\text{ACT}}$  is the actual viscosity of the pumped liquid, and

N is an exponent which varies by the type of pump.

18. Apparatus according to claim 17, wherein N equals about 0.10 for rotary PD pumps such as gear, vane and lobe, and wherein N equals about 0.275 for progressive cavity pumps.

5 19. Apparatus according to claim 17, wherein the signal processor is configured to determine the corrected published rated flow based at least partly on the following equation:

$$Q_{\text{RATEDCORR}} = (\text{RTD HP}_{\text{CORR}} / \text{RTD HP}) \times Q_{\text{RTD}},$$

10

where:

$Q_{\text{RATEDCORR}}$  is the corrected rated flow,

RTD HP is the corrected published rated power in the form of the rated hp for the application, and

15  $Q_{\text{RTD}}$  is the rated flow for the application.

20. Apparatus according to claim 19, wherein the signal processor is configured to determine the rated slip factor compensated for actual conditions based at least partly on the following equation:

$$KS = \frac{VISC_{RTD} \times Q_{NO\ SLIP} \times (Q_{NO\ SLIP} - Q_{RATED\ CORR})}{(75.415 \times K_G \times (N_{RATED}) \times T_{RTD\ CORR})}$$

where:

KS is the rated slip factor compensated for actual conditions,

VISC<sub>RTD</sub> is the published pump rated viscosity,

Q<sub>NO SLIP</sub> is the flow in gpm at rated speed and rated viscosity at 0 psid differential pressure,

Q<sub>RATEDCORR</sub> is the corrected rated flow,

K<sub>G</sub> = 0.004329, a design constant,

N<sub>RATED</sub> = Rated Pump Speed for the application, and

T<sub>RTD CORR</sub> = Corrected Rated Torque in Ft-Lbs (US), which is determined as follows: T<sub>RTD CORR</sub> = (5252 × RTD HP<sub>CORR</sub>)/N<sub>RTD</sub>.

21. Apparatus according to claim 20, wherein the signal processor is configured to determine an actual flow value for the rotary positive displacement pump based at least partly on the following equation:

$$Q_{ACT\ CORR} = (Q_{NO\ SLIP} \times ((N_{MOTOR}/RATIO)/N_{RATED})) - (((75.415 \times K_G \times K_{SCORR}) \times (N_{MOTOR}/RATIO) \times T_{ACT\ CORR}) / (VISCOSITY_{ACT} \times Q_{NO\ SLIP})),$$

where:

10  $Q_{NO\ SLIP}$  is the flow in gpm at rated speed and rated viscosity at 0 psid differential pressure,

$N_{MOTOR}$  = the current motor speed,

$RATIO$  = the ratio of speed reduction if a gear reducer is used, . If no gear reducer is used than the value of the  $RATIO = 1.0$ .

15  $N_{RATED}$  = the Rated Pump Speed for the application,

$K_G = 0.004329$ , a design constant,

$K_{SCORR}$  is the corrected rated slip factor based on the slip rules for the operating condition for a particular rotary positive displacement pump type,

20  $T_{ACT\ CORR} =$  Torque in Ft-Lbs (US), where  $T_{ACT\ CORR} = (5252 \times HP_{ACT\ CORR})/N_{ACT}$ , and  $HP_{ACT\ CORR} = HP_{ACT} \times (SG_{RTD}/SG_{ACT})$ ,

$HP_{ACT} =$  Actual motor power,

$N_{ACT} =$  Actual pump speed, and

$VISC_{ACT}$  is the actual viscosity of the pumped liquid.

22. A method comprising:

receiving with a signal processor signaling containing information about actual pump performance data related to the operation of a rotary positive displacement pump; and

5 determining with the signal processor corrected published pump performance data to operate the rotary positive displacement pump by compensating published pump performance data based at least partly on the actual pump performance data.

23. A method according to claim 22, wherein the corrected published pump  
10 performance data include a corrected published rated power, a corrected published rated flow and a rated slip factor compensated for actual conditions.

24 A method according to claim 22, wherein the actual pump performance  
15 data contains information about actual speed, actual power, actual specific gravity and actual viscosity related to the operation of the rotary positive displacement pump.

25. A method according to claim 24, wherein the corrected published pump  
20 performance data include a corrected published rated power, a corrected published rated flow and a rated slip factor compensated for actual conditions.

26. A method according to claim 22, wherein the method comprises  
25 determining with the signal processor an actual flow value for the rotary positive displacement pump based at least partly on the corrected published pump performance data.

27. A method according to claim 26, wherein the method comprises providing with the signal processor a control signal containing information about an actual flow value to control the operation of the rotary positive displacement pump.

5

28. A method according to claim 23, wherein the method comprises determining with the signal processor the corrected published rated power by compensating a published rated power based at least partly on actual power, specific gravity and viscosity at rated conditions.

10

29. A method according to claim 28, wherein the method comprises determining with the signal processor a corrected published rated flow by compensating a published rated flow based at least partly on the corrected published rated power.

15

30. A method according to claim 29, wherein the method comprises determining with the signal processor a rated slip factor compensated for actual conditions based at least partly on the corrected published rated flow and the corrected published rated power.

20

31. A method according to claim 30, wherein the method comprises activating with the signal processor a tune function which replaces the published rated power, the published rated flow and the rated slip factor with the corrected published rated power, the corrected published rated flow and the rated slip factor compensated for actual conditions.

25

32. A method according to claim 31, wherein the method comprises determining with the signal processor an actual flow value based at least partly on deducting the corrected rated slip flow from a theoretical displacement flow.

5 33. A method according to claim 31, wherein the method comprises using the corrected published rated power, flow and rated slip factor until another tune function is initiated.

34. A method according to claim 22, wherein the signaling contains  
10 information about pump parameters, including some combination of a pump type, a published rated flow, a published rated speed, a published rated power, a published rated viscosity and no slip flow, and information about actual speed and power from a variable frequency drive (VFD) along with actual specific gravity and viscosity; and the method comprises determining with the signal processor a corrected slip flow or  
15 factor based at least partly on the signaling.

35. A method according to claim 34, wherein the method comprises determining with the signal processor an actual flow value based at least partly on deducting the corrected rated slip flow or factor from a theoretical displacement flow  
20 or factor.

36. A method according to claim 35, wherein the method comprises determining with the signal processor the corrected rated slip flow or factor without using sensors based at least partly on a constant temperature application where  
25 specific gravity and viscosity are substantially constant.

37. A method according to claim 35, wherein, in applications with varying temperature, the method comprises receiving with the signal processor a temperature measurement and determining the corrected rated slip flow or factor by  
 5 compensating changing conditions, including actual speed, specific gravity and viscosity, based at least partly on the same.

38. A method according to claim 23, wherein the method comprises determining with the signal processor the corrected published rated power based at  
 10 least partly on the following equation:

$$\text{RTD HP}_{\text{CORR}} = \text{HP}_{\text{ACT}} \times (\text{SG}_{\text{RTD}} / \text{SG}_{\text{ACT}}) / (\text{VISC}_{\text{ACT}} / \text{VISC}_{\text{RTD}})^N,$$

where:

15 RTD HP<sub>CORR</sub> is the corrected published rated power in the form of rated hp corrected for specific gravity and viscosity,

HP<sub>ACT</sub> is the actual power at rated conditions,

SG<sub>RTD</sub> is the rated specific gravity of the pumped liquid,

SG<sub>ACT</sub> is the actual specific gravity of the pumped liquid,

20 VISC<sub>RTD</sub> is the rated viscosity of the pumped liquid,

VISC<sub>ACT</sub> is the actual viscosity of the pumped liquid, and

N is an exponent which varies by the type of pump.

39. A method according to claim 38, wherein N equals about 0.10 for rotary PD pumps such as gear, vane and lobe, and wherein N equals about 0.275 for progressive cavity pumps.

5           40. A method according to claim 38, wherein the method comprises determining with the signal processor the corrected published rated flow based at least partly on the following equation:

$$Q_{\text{RATEDCORR}} = (\text{RTD HP}_{\text{CORR}} / \text{RTD HP}) \times Q_{\text{RTD}},$$

10

where:

$Q_{\text{RATEDCORR}}$  is the corrected rated flow,

RTD HP is the corrected published rated power in the form of the rated hp for the application, and

15            $Q_{\text{RTD}}$  is the rated flow for the application.

41. A method according to claim 40, wherein the method comprises determining with the signal processor the rated slip factor compensated for actual conditions based at least partly on the following equation:

$$KS = \frac{VISC_{RTD} \times Q_{NO\ SLIP} \times (Q_{NO\ SLIP} - Q_{RATED\ CORR})}{(75.415 \times K_G \times (N_{RATED}) \times T_{RTD\ CORR})},$$

where:

KS is the rated slip factor compensated for actual conditions,

10  $VISC_{RTD}$  is the published pump rated viscosity,

$Q_{NO\ SLIP}$  is the flow in gpm at rated speed and rated viscosity at 0 psid differential pressure,

$Q_{RATEDCORR}$  is the corrected rated flow,

$K_G = 0.004329$ , a design constant,

15  $N_{RATED}$  = Rated Pump Speed for the application, and

$T_{RTD\ CORR}$  = Corrected Rated Torque in Ft-Lbs (US), which is determined as follows:  $T_{RTD\ CORR} = (5252 \times RTD\ HP_{CORR})/N_{RTD}$ .

42. A method according to claim 41, wherein the method comprises determining with the signal processor an actual flow value for the rotary positive displacement pump based at least partly on the following equation:

$$Q_{ACT\ CORR} = (Q_{NO\ SLIP} \times ((N_{MOTOR}/RATIO)/N_{RATED})) - (((75.415 \times K_G \times K_{SCORR}) \times (N_{MOTOR}/RATIO) \times T_{ACT\ CORR}) / (VISCOSITY_{ACT} \times Q_{NO\ SLIP})),$$

where:

10  $Q_{NO\ SLIP}$  is the flow in gpm at rated speed and rated viscosity at 0 psid differential pressure,

$N_{MOTOR}$  = the current motor speed,

$RATIO$  = the ratio of speed reduction if a gear reducer is used, . If no gear reducer is used than the value of the  $RATIO = 1.0$ .

15  $N_{RATED}$  = the Rated Pump Speed for the application,  $K_G = 0.004329$ , a design constant,

$K_{SCORR}$  is the corrected rated slip factor determined from slip rules for the operating condition for a particular rotary positive displacement pump type,

20  $T_{ACT\ CORR}$  = Torque in Ft-Lbs (US), where  $T_{ACT\ CORR} = (5252 \times HP_{ACT\ CORR}) / N_{ACT}$ , and  $HP_{ACT\ CORR} = HP_{ACT} \times (SG_{RTD} / SG_{ACT})$ ,

$HP_{ACT}$  = Actual motor power,

$N_{ACT}$  = Actual pump speed, and

$VISC_{ACT}$  is the actual viscosity of the pumped liquid.

43. Apparatus comprising:

means for receiving signaling containing information about actual pump performance data related to the operation of a rotary positive displacement pump; and

5 means for determining corrected published pump performance data to operate the rotary positive displacement pump by compensating published pump performance data based at least partly on the actual pump performance data.

44. Apparatus according to claim 43, wherein the corrected published pump performance data include a corrected published rated power, flow and slip factor.

45 Apparatus according to claim 43, wherein the actual pump performance data contains information about actual speed, actual power, specific gravity and viscosity related to the operation of the rotary positive displacement pump and received from a pump controller or controlling device, including a variable frequency drive.

46. Apparatus according to claim 1, wherein the signal processor comprises, or takes the form of, a controller or controller module configured to control the operation of the pump.

47. Apparatus according to claim 1, wherein the apparatus comprises the rotary positive displacement pump, including an internal or external gear pump, or a lobe pump, or a vane pump, or a progressive cavity pump.

25

48. Apparatus according to claim 21, wherein the signal processor is configured to determine slip rules for rotary positive displacement pumps and magnetic drive rotary positive displacement pumps based at least partly on Table I below:

<b>Changing Variable</b>	<b>Corrected Slip Factor “KS<sub>CORR</sub>”</b>
Torque	SLIP FACTOR is Constant; $KS_{CORR} = KS$
Speed	$KS_{CORR} = KS * (N_{RATED} / N_{ACT})$
Speed and Torque	SLIP FACTOR is Constant; $KS_{CORR} = KS$
Viscosity	$KS_{CORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Speed and Viscosity	$KS_{CORR} = KS * (N_{RATED} / N_{ACT}) * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Torque and Viscosity	$KS_{CORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Speed, Torque and Viscosity	$KS_{CORR} = KS * (N_{RATED} / N_{ACT}) * (Visc_{ACT} / Visc_{RATED})^{0.5}$

5, and

wherein the signal processor is configured to determine slip rules for progressive cavity pumps and magnetic drive progressive cavity pumps based at least partly on Table II below:

Table II:

<b>Changing Variable</b>	<b>Corrected Slip Factor “KS<sub>CORR</sub>”</b>
Torque	SLIP FACTOR is Constant; $KS_{CORR} = KS$
Speed	$KS_{CORR} = KS * (N_{RATED} / N_{ACT})$
Speed and Torque	SLIP FACTOR is Constant; $KS_{CORR} = KS$
Viscosity	$KS_{CORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Speed and Viscosity	$KS_{CORR} = KS * (N_{RATED} / N_{ACT}) * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Torque and Viscosity	$KS_{CORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$
Speed, Torque and Viscosity	$KS_{CORR} = KS * (Visc_{ACT} / Visc_{RATED})^{0.5}$

10.

49. Apparatus according to claim 48, wherein the signal processor is configured to determine the result of the flow calculation as follows:

$$Q_{ACT\ CORR} = Q_{ACT}, \text{ and}$$

the  $Q_{ACT\ CORR}$  is displayed as the actual flow ( $Q_{ACT}$ ) in Gpm.

5

50. Apparatus according to claim 49, wherein the signal processor is configured to determine the parameters for actual and rated pump speed as follows:

$N_{ACT}$  = Actual pump speed, and

$N_{RTD}$  = Rated pump speed of the application.

10

51. Apparatus according to claim 50, wherein for magnetic drive rotary positive displacement pumps the signal processor is configured to determine the following parameters:

$T_{ACT\ CORR}$  = Torque in Ft-Lbs (US), which is calculated as follows:  $T_{ACT\ CORR} =$

15  $(5252 \times HP_{ACT\ CORR})/N_{ACT}$ , where:

$$HP_{ACT\ CORR} = (HP_{ACT} - (P_{MAG\ CORR} \times (N_{ACT}/N_{RTD})^2) \times SG_{RTD}/SG_{ACT}),$$

$HP_{ACT}$  = Actual motor power, and

$P_{MAG\ CORR}$  is the eddy current loss in Hp at rated speed for a containment shell material used.

20

52. A method according to claim 42, wherein the method comprises determining slip rules for rotary positive displacement pumps and magnetic drive rotary positive displacement pumps based at least partly on Table I below:

<b>Changing Variable</b>	<b>Corrected Slip Factor “K<sub>SCORR</sub>”</b>
Torque	SLIP FACTOR is Constant; K <sub>SCORR</sub> = KS
Speed	K <sub>SCORR</sub> = KS * (N <sub>RATED</sub> / N <sub>ACT</sub> )
Speed and Torque	SLIP FACTOR is Constant; K <sub>SCORR</sub> = KS
Viscosity	K <sub>SCORR</sub> = KS * (Visc <sub>ACT</sub> /Visc <sub>RATED</sub> ) <sup>0.5</sup>
Speed and Viscosity	K <sub>SCORR</sub> = KS * (N <sub>RATED</sub> / N <sub>ACT</sub> ) * (Visc <sub>ACT</sub> /Visc <sub>RATED</sub> ) <sup>0.5</sup>
Torque and Viscosity	K <sub>SCORR</sub> = KS * (Visc <sub>ACT</sub> /Visc <sub>RATED</sub> ) <sup>0.5</sup>
Speed, Torque and Viscosity	K <sub>SCORR</sub> = KS * (N <sub>RATED</sub> / N <sub>ACT</sub> ) * (Visc <sub>ACT</sub> /Visc <sub>RATED</sub> ) <sup>0.5</sup>

5

, and

wherein the method comprises determining slip rules for progressive cavity pumps and magnetic drive progressive cavity pumps based at least partly on Table II below:

10

Table II:

<b>Changing Variable</b>	<b>Corrected Slip Factor “K<sub>SCORR</sub>”</b>
Torque	SLIP FACTOR is Constant; K <sub>SCORR</sub> = KS
Speed	K <sub>SCORR</sub> = KS * (N <sub>RATED</sub> / N <sub>ACT</sub> )
Speed and Torque	SLIP FACTOR is Constant; K <sub>SCORR</sub> = KS
Viscosity	K <sub>SCORR</sub> = KS * (Visc <sub>ACT</sub> /Visc <sub>RATED</sub> ) <sup>0.5</sup>
Speed and Viscosity	K <sub>SCORR</sub> = KS * (N <sub>RATED</sub> / N <sub>ACT</sub> ) * (Visc <sub>ACT</sub> /Visc <sub>RATED</sub> ) <sup>0.5</sup>
Torque and Viscosity	K <sub>SCORR</sub> = KS * (Visc <sub>ACT</sub> /Visc <sub>RATED</sub> ) <sup>0.5</sup>
Speed, Torque and Viscosity	K <sub>SCORR</sub> = KS * (Visc <sub>ACT</sub> /Visc <sub>RATED</sub> ) <sup>0.5</sup>

53. A method according to claim 52, wherein the method comprises determining the result of the flow calculation as follows:

$$Q_{ACT\ CORR} = Q_{ACT}, \text{ and}$$

the  $Q_{ACT\ CORR}$  is displayed as the actual flow ( $Q_{ACT}$ ) in Gpm.

5

54. A method according to claim 53, wherein the method comprises determining the parameters for actual and rated pump speed as follows:

$N_{ACT}$  = Actual pump speed, and

$N_{RTD}$  = Rated pump speed of the application.

10

55. A method according to claim 54, wherein for magnetic drive rotary positive displacement pumps the method comprises determining the following parameters:

$T_{ACT\ CORR}$  = Torque in Ft-Lbs (US), which is calculated as follows:  $T_{ACT\ CORR} = (5252 \times HP_{ACT\ CORR})/N_{ACT}$ , where:

15

$$HP_{ACT\ CORR} = (HP_{ACT} - (P_{MAG\ CORR} \times (N_{ACT}/N_{RTD})^2) \times SG_{RTD}/SG_{ACT}),$$

$HP_{ACT}$  = Actual motor power, and

$P_{MAG\ CORR}$  is the eddy current loss in Hp at rated speed for a containment shell material used.

20

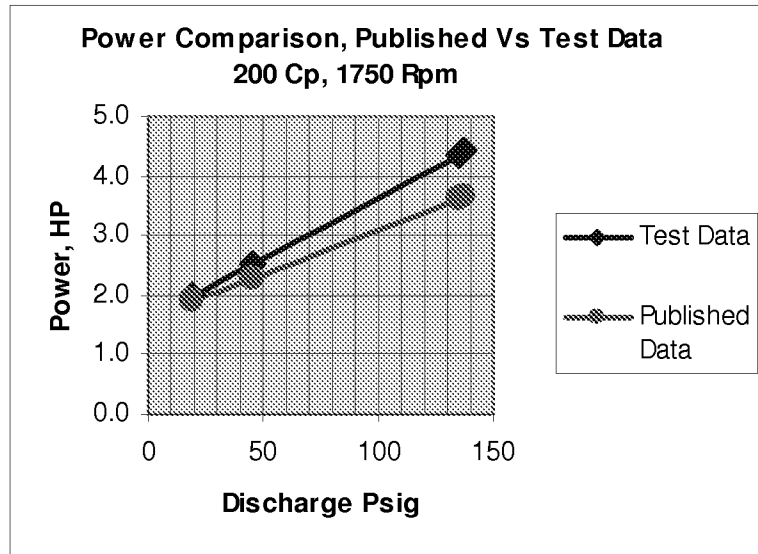


Figure 1

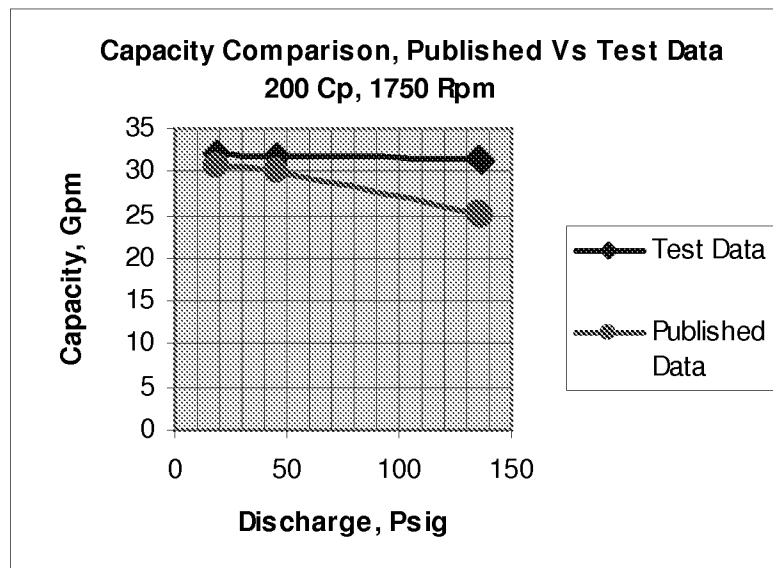


Figure 2

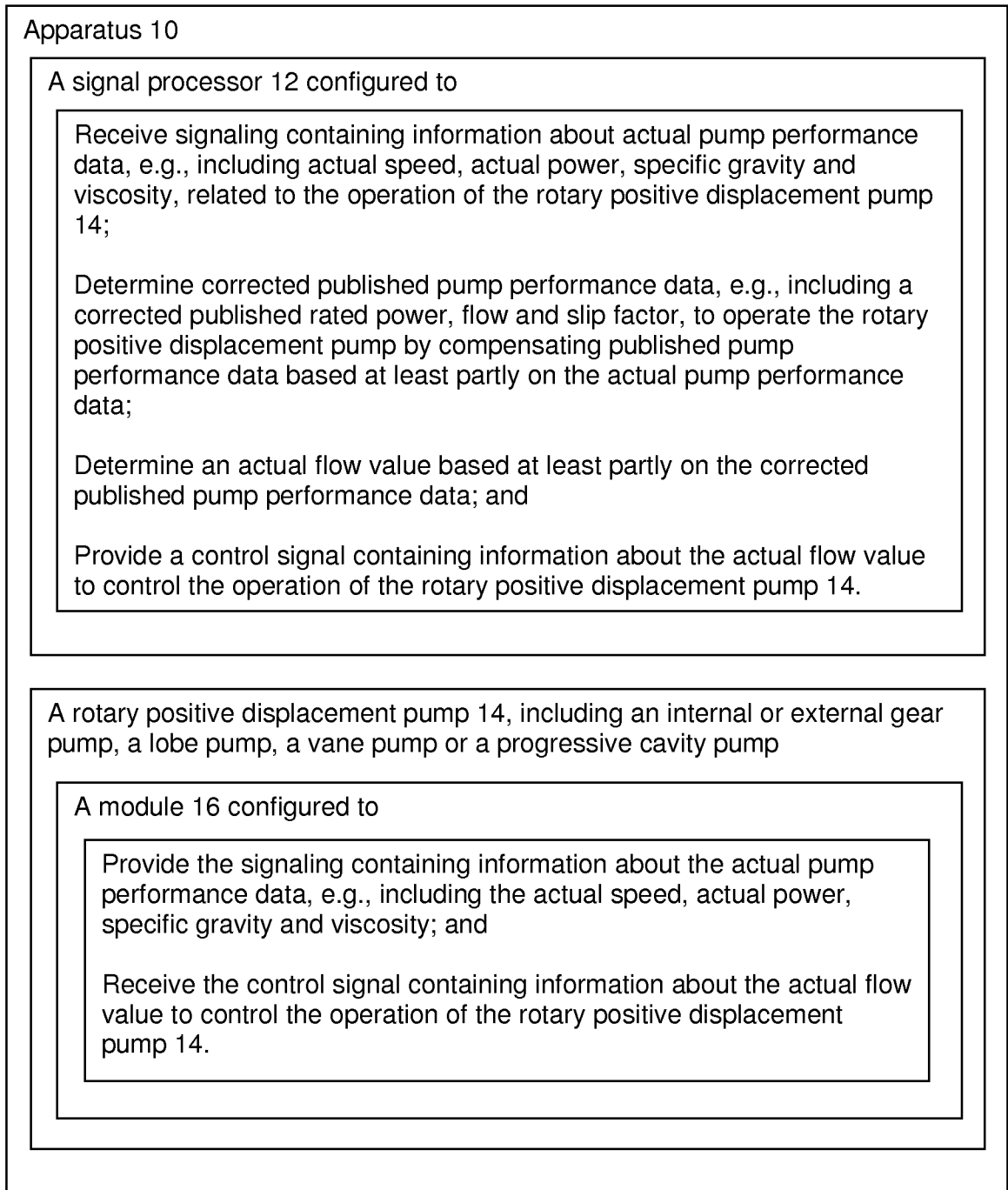


Figure 3