



FURNACE CO EMISSIONS UNDER NORMAL AND COMPROMISED VENT CONDITIONS

FURNACE #4 - HIGH-EFFICIENCY INDUCED DRAFT

October 2000

Prepared by Christopher J. Brown

Ronald A. Jordan

David R. Tucholski

Directorate for Laboratory Sciences

The United States Consumer Product Safety Commission

Washington, D.C. 20207

1. INTRODUCTION	1
2. TEST EQUIPMENT AND SETUP	1
a. Furnace.....	1
b. Test Chamber and Furnace Closet	2
c. Vent Blockage Device and Vent Disconnect.....	3
d. Measuring Equipment.....	4
i) Furnace Operating Parameters.....	4
ii) Gas Sampling Systems.....	5
iii) Air Exchange Rate	5
iv) Room Temperature, Pressure, and Relative Humidity	5
v) Natural Gas	6
vi) Data Acquisition System	6
3. TEST METHODS AND PROCEDURES	6
a. Furnace Installation.....	6
b. Furnace Input Rate.....	6
c. Test Matrix.....	7
d. Test Procedures.....	7
4. DATA REDUCTION	8
a. Equilibrium Determination	8
b. Air Exchange Rate	8
c. Emission Rate	9
d. CO Air-Free	9
5. RESULTS AND DISCUSSION	10
a. Baseline Tests (Normal Vent).....	10
b. Blocked Vent Tests.....	10
i) Degree of Blockage.....	10
ii) Location of Vent Blockage.....	10
iii) Input Rate.....	11
iv) Cycling.....	11
c. Disconnected Vent Tests	11
i) Location of Vent Disconnect	11

ii) Input Rate.....	13
iii) Cycling.....	13
d. Observations	14
i) Furnace Performance when tested “As Received” and 12 Percent Above “As Received”	14
6. CONCLUSIONS.....	14
ACKNOWLEDGMENTS	15
REFERENCES	16
APPENDIX A: FURNACE SPECIFICATIONS AND SETUP.....	17
APPENDIX B: CHAMBER AND FURNACE CLOSET DESCRIPTION.....	20
APPENDIX C: MEASUREMENT OF FURNACE OPERATING PARAMETERS.....	22
APPENDIX D: GAS SAMPLING SYSTEM.....	24
APPENDIX E: FURNACE TEST MATRIX	26
APPENDIX F: DERIVATION OF AIR EXCHANGE RATE AND EMISSION RATE.....	28
APPENDIX G. TEST DATA RESULTS	32

EXECUTIVE SUMMARY

CPSC began a test program in 1999 to evaluate the carbon monoxide (CO) exposure hazard posed to consumers when a furnace vent pipe is blocked or disconnected. This report describes the test results of a high-efficiency induced draft furnace (Furnace #4); it does not address the associated health effects.

Tests were conducted in an environmentally controlled chamber with the furnace installed inside a closet located within the chamber. The chamber provided a well-mixed environment in which to measure the CO concentration and also allowed for the air exchange rate to be controlled. For each test, the CO concentration and air exchange rate in the chamber were measured. The CO emission rate from the furnace was then calculated using a simple mass balance model.

Three variables were investigated to determine how each affected the CO emissions from the furnace: the condition of the vent pipe, the input rate of the furnace, and the operating mode of the furnace. Tests were conducted with the vent pipe intact, partially or totally blocked, or totally disconnected. The furnace was operated at the manufacturer's specified input rate and at overfire conditions. The furnace was also operated continuously or cycled on and off.

The following is a summary of the test results:

- The furnace “as received” was not overfired.
- With a normal vent pipe (no blockage or disconnect), the average steady-state concentration of CO in the chamber was negligible (≤ 2 ppm).
- When the furnace was fired at 100,000 Btu/hr and 112,000 Btu/hr, the average steady-state CO concentrations in the chamber were relatively low (≤ 6 ppm) for all test conditions (blocked, disconnected vent pipe, continuous or cycled operation).
- During blocked vent tests:
 - The average steady-state concentration of CO in the chamber was 6 ppm or less when the vent was blocked up to 86 percent at a point midway between the furnace and vent outlet.
 - With the vent blocked more than 86 percent, the furnace shut off immediately.
 - The location of the vent blockage did not affect the performance of the furnace. The furnace shut off immediately when the exhaust vent was completely blocked either at the vent outlet, midway between the furnace and the vent outlet, or at the inducer fan outlet.
 - The CO concentrations in the chamber and the air-free flue gas concentrations were comparable for cycling and continuous operation tests, when the vent was partially blocked.
 - Increasing the firing rate of the furnace did not result in high chamber CO concentrations (≤ 6 ppm).
 - Increasing the firing rate resulted in increasingly high air-free CO concentrations in the flue gases.
 - When the furnace was fired at 100,000 Btu/hr and 112,000 Btu/hr, the air-free CO concentrations in the flue gas ranged from 59 ppm to 545 ppm, respectively. When the input rate was adjusted to 118,000 Btu/hr and 128,000 Btu/hr, the air-free CO

concentrations in the flue gas ranged from 399 ppm to more than 3,400 ppm, respectively. The current ANSI Z21.47 standard (1998) requires that an air-free flue gas sample of CO not exceed a maximum of 400 ppm (0.04 percent) when a furnace vent is either partially or completely blocked.

- During disconnected vent tests:
 - The average steady-state concentration of CO in the chamber increased as the firing rate increased.
 - The concentration of CO was generally higher when the vent was disconnected inside the furnace closet as opposed to outside of the furnace closet.
 - The furnace generated more CO when it operated continuously than when it was cycled on and off.
 - When the furnace was fired at 100,000 Btu/hr and 112,000 Btu/hr, the air-free CO concentrations in the flue gas ranged from 6 ppm to 37 ppm, respectively. When the input rate was adjusted to 118,000 Btu/hr and 128,000 Btu/hr, the air-free CO concentrations in the flue gas ranged from 99 ppm to 1,686 ppm. The current ANSI Z21.47 standard (1998) has no requirements for disconnected vents.
 - Depending on the test conditions, the average steady-state concentrations of CO in the chamber ranged from 2 ppm at 100,000 Btu/hr to 159 ppm at 128,000 Btu/hr.

1. INTRODUCTION

CPSC began a test program in 1999 to evaluate the carbon monoxide (CO) exposure hazard posed to consumers when a furnace vent pipe is blocked or disconnected. This test program is part of CPSC's effort to reduce deaths and injuries related to carbon monoxide poisoning. The test program consists of testing several different furnaces under controlled conditions and measuring the amount of CO that accumulates in a room when the vent pipe is partially blocked, totally blocked, or disconnected. The test results will be used to model indoor air concentrations and assess health effects. These modeling results will then be used to support current and potential recommendations to the ANSI/CGA Z21.47 Gas Fired Central Furnace subcommittee. For high-efficiency induced draft furnaces, the current ANSI Z21.47 standard (1998) requires that the air-free flue gas sample of CO not exceed a maximum of 400 ppm (0.04 percent) when the furnace vent pipe is either partially or completely blocked. The ANSI standard does not require the furnace to shut off under any blocked vent conditions and does not address the issue of a disconnected vent pipe.

This report only describes the test results of a high-efficiency induced draft furnace (Furnace #4), it does not address the associated health affects. Tests were conducted in an environmentally controlled chamber with the furnace installed inside a closet located within the chamber. The chamber provided a well-mixed environment in which to measure the CO concentration and also allowed for the air exchange rate to be controlled. The furnace was operated at conditions specified by the ANSI Z21.47 standard (1998) and those that could occur in actual use. For all tests, the CO concentration in the chamber and closet were measured as well as the air exchange rate in the chamber. The CO emission rate from the furnace was then calculated using the equilibrium CO concentration, the air exchange rate, and a simple mass balance model.

2. TEST EQUIPMENT AND SETUP

a. Furnace

Tests were conducted using an induced draft furnace (Furnace #4). Furnace #4 is a condensing, high-efficiency gas furnace with an Annualized Fuel Utilization Efficiency of 92.6%. This furnace was shipped from the manufacturer preset for use with natural gas and with an energy input rate of 100,000 Btu/hr. Furnace #4 received AGA certification (ANSI Z21.47-CAN/CGA-2.3m 1993) as a Category IV unit. The unit is configured for upflow operation (i.e., the circulation air blower is located at the bottom of the unit, blowing supply air upwards, across the primary and secondary heat exchangers). Figure 2.1 shows the furnace as installed for testing. Appendix A provides additional details of the furnace setup and specifications of the furnace.

The unit was purchased from a local heating, ventilation, and air conditioning (HVAC) dealer and installed by CPSC staff. On March 24, 1999, CPSC staff met with furnace manufacturing representatives and a representative from the Gas Appliance Manufacturers Association (GAMA) to obtain their input on the test protocol and setup. On May 2, 2000, a representative from Furnace #4's manufacturer met with CPSC staff to witness the test setup and installation of the furnace and verified that the furnace was installed and operating properly.



Figure 2.1. High Efficiency, Induced Draft Test Furnace

Based on the design of the furnace, it must comply with the test provisions of the ANSI Z21.47 standard (1993) that govern furnaces that are not equipped with draft hoods (Section 2.22). Although this section of the standard includes provisions for conducting blockage testing at various degrees of blockage up to and including complete blockage, there are no requirements for a furnace to shutoff under these conditions. Nevertheless, this unit is equipped with a pressure switch that monitors the static pressure at the inlet side of the unit's inducer fan. If the pressure switch opens during operation, the furnace will shut off and enter into a "lockout" mode. This "lockout" prevents the furnace from restarting until the pressure switch closes. To restart the furnace after "lockout," the furnace must be de-energized and then energized.

b. Test Chamber and Furnace Closet

In order to accurately model room concentrations of CO, it was necessary to measure CO emissions from the furnace in a well-mixed room while controlling the number of air changes in that room. A modified environmental test chamber was therefore used for the tests. The internal volume of the chamber was 837 cubic feet (23.7 cubic meters). The chamber was designed to provide an environment in which the air was well mixed and the temperature, pressure, and air exchange rate could be controlled. In order to prevent back drafting, the differential pressure between the chamber and the laboratory was kept near zero using a pressure control system. Appendix B describes the chamber in greater detail.

A furnace closet was erected within the chamber. The internal volume of the closet was approximately 196 cubic feet (5.55 cubic meters). The closet complied with the National Fuel Gas Code (1996) and the manufacturer's requirements for a "Confined Space" furnace installation. A well-mixed environment within the closet could not be assumed since no fans were used to promote mixing. Fans were not used in the closet in order to prevent interference with the operation of the furnace. The furnace was positioned inside the closet so that the manufacturer's specification for minimum distances to combustible surfaces was met. Appendix B describes the furnace closet in further detail.

c. Vent Blockage Device and Vent Disconnect

An optical iris was used to create various degrees of vent blockage. Figure 2.2 illustrates the iris (black in color) located in the vent system. Different blockages were obtained by adjusting the diameter of the iris. When the iris was totally closed, blockage was 99.6 percent since a small hole was still present. For testing purposes, it was assumed that a 99.6 percent blocked vent was equivalent to a totally blocked vent. The iris was located at a vertical height of 2.87 feet (0.87 meters) above the furnace condensate tee and a horizontal distance of 3.69 feet (1.12 meters) from the furnace condensate tee. Figure C.1 in Appendix C illustrates the general location of the iris relative to the furnace.

To investigate the effect of the blockage location on the CO emission rate from the furnace, several tests were conducted with the outlet of the vent pipe totally blocked. Blockage was created using a vent tee cap. The vent outlet was located approximately at a vertical height of 5.17 feet (1.58 meters) and at a horizontal distance of 4.28 feet (1.30 meters) from the furnace.

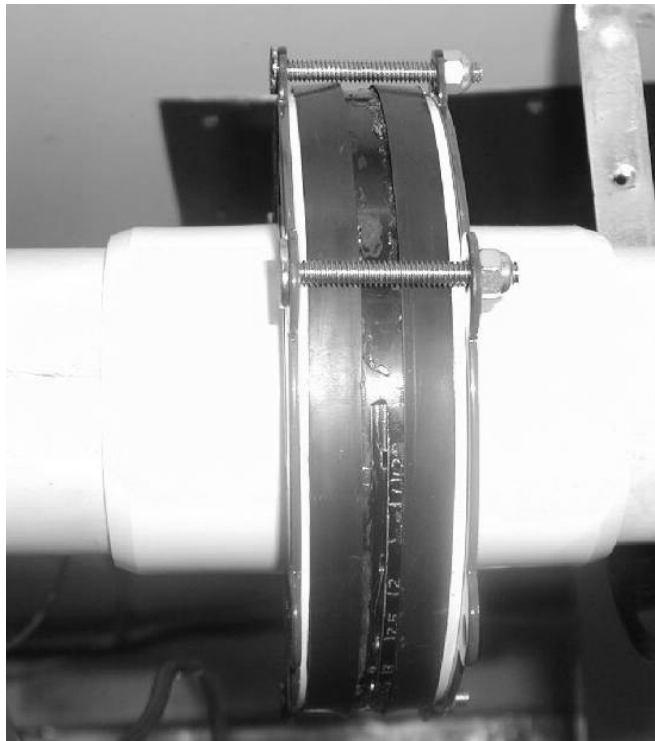


Figure 2.2. Iris Used to Create Vent Blockages

To simulate a disconnected vent pipe, the vent pipe was totally separated from a section of the vent system either inside or outside of the furnace closet. For tests where the vent was disconnected inside the closet, the vent pipe was separated 2.87 feet (0.87 meters) above the furnace condensate tee. Figure 2.3 (a) shows a close up of the vent disconnected inside the furnace closet. For disconnected vent tests where the vent was disconnected outside of the closet, that is, in the chamber, the vent pipe was separated at the 90-degree elbow. Figure 2.3 (b) shows the vent disconnected at the 90-degree elbow. The vent elbow was located at a vertical height of 2.87 feet (0.87 meters) above the furnace condensate tee and a horizontal distance of 4.28 feet (1.30 meters) from the furnace condensate tee. Figure C.1 in Appendix C illustrates the location of the exhaust outlet and the 90-degree elbow relative to the furnace.

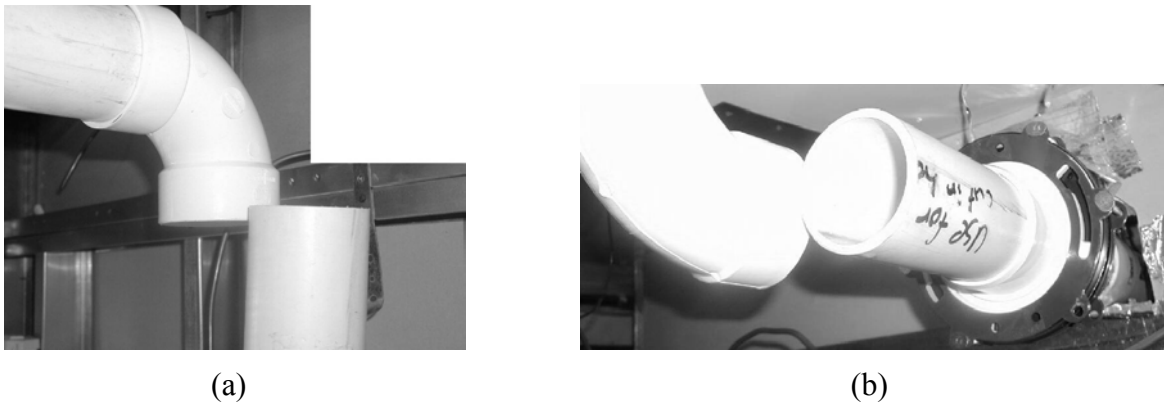


Figure 2.3. Disconnected Vent Pipes in (a) the Closet Above the Furnace Top and (b) the Chamber Near the 90 Degree Elbow.

d. Measuring Equipment

i) Furnace Operating Parameters

The operating parameters of the furnace were measured at different locations using a variety of equipment. Appendix C provides details of the equipment used and the general locations of the measurements. The natural gas flow rate to the furnace was determined using a digital mass flow meter. The gas manifold pressure was measured with a magnehelic pressure gauge. The static pressure in the vent pipe was determined using a piezo ring connected to a magnehelic pressure gauge. The piezo ring was constructed in accordance with Section 2.7 of the ANSI Z21.47 standard (1998). The static pressure between the return and supply ducts was measured with a magnehelic pressure gauge. The temperature rise across the heat exchanger was measured using two thermocouples, one in the return duct and one in the supply duct. The flue gas temperature was measured with a single thermocouple located in the center of the vent pipe. The air temperature in the unit's combustion chamber was measured at two locations: (1) near the flame roll-out switch located on the left wall of the unit's combustion chamber, and (2) near the flame roll-out switch located at the bottom wall of the unit's combustion chamber.

ii) Gas Sampling Systems

Four sampling systems were used to measure the concentration of different chemical species at various locations. Appendix D provides details of the equipment used and a schematic illustrating the sampling systems. The first system was used to obtain CO, CO₂, and O₂ samples from the chamber. The concentrations of CO and CO₂ were measured using non-dispersive infrared (NDIR) gas analyzers, and O₂ was measured using a paramagnetic analyzer. Samples were obtained from five locations inside the chamber. The sampling lines from these five locations fed into a common mixing manifold. The mixing manifold was then connected to the gas analyzers using a single sampling line.

A second sampling system was used to obtain samples from the closet or flue gas. A three-way valve was used to switch between the closet and flue gas sampling lines. Carbon monoxide, carbon dioxide, and hydrocarbons (HC) were measured using NDIR gas analyzers and oxygen was measured using a paramagnetic analyzer. Flue gas samples were taken from a single location downstream of the flue collar. Closet air samples were taken from five locations inside the closet. The sampling lines from these five locations fed into a common mixing manifold. The mixing manifold was then connected to the three-way valve using a single sampling line. To prevent water from condensing inside the gas analyzers during the sampling of the flue gas, the water was condensed out of the sample prior to entering the analyzers. A simple heat exchange system using recirculated chilled water was used to condense the water out of the gas sample.

A third sampling system was used to obtain the concentration of CO in the return and supply ducts. A three-way valve was used to switch between the return and supply duct sample lines. The concentration of CO was measured with a NDIR gas analyzer.

A fourth sampling system was used to obtain the background concentration of CO in the laboratory. A NDIR gas analyzer was used to measure the concentration of CO. The sampling line was positioned near the inlet pipe that brought fresh air into the chamber.

iii) Air Exchange Rate

To determine the air exchange rate in the chamber and closet, the tracer gas sulfur hexafluoride (SF₆) was injected into the chamber. The flow rate of SF₆ was measured using a rotometer and the concentrations of SF₆ in the chamber and closet were measured with an electron capture gas chromatograph analyzer. To ensure that the tracer gas was evenly distributed, the gas was injected above each set of fans used with the four fin-and-tube heat exchangers. Samples were obtained using the existing sampling lines for the chamber and closet (Appendix D). To verify the number of air changes per hour (ACH) obtained with the SF₆ tracer gas, CO was also injected into the chamber during several tests. A mass flow controller was used for the CO injection and the NDIR analyzers for the chamber and closet were used to measure the CO concentrations.

iv) Room Temperature, Pressure, and Relative Humidity

The temperature in the chamber was measured with four thermocouples. The thermocouples were located near each corner in the chamber. The temperature in the closet was measured with a single thermocouple located approximately midway between the floor and the ceiling.

A thermocouple was also used to measure the ambient air temperature entering the chamber. The thermocouple was positioned near the inlet pipe for the fresh air supply to the chamber.

A photohelic pressure gauge was used to measure the differential pressure between the chamber and the laboratory. The pressure gauge was part of the pressure control system used to prevent the chamber from becoming over or under pressurized relative to the laboratory building in which the chamber was located.

The local pressure and temperature in the laboratory was obtained using a barometer with a built in thermometer. The relative humidity of the laboratory air was measured with a digital hygrometer.

v) Natural Gas

The furnace was fired with natural gas obtained from a city supply line. The daily average higher heating value of the natural gas was obtained from the local gas supplier (Washington Gas). In addition, the gas company supplied the daily average chemical composition of the natural gas.

vi) Data Acquisition System

A data acquisition system was used to record the majority of the data. The system consisted of a personal computer running LABTECH® NOTEBOOK data acquisition software that recorded the data every 20 seconds. The data acquisition program recorded the raw voltage output from the various measuring devices (gas analyzers, thermocouples, pressure gauges, and flow meter) into a data file. The program converts these voltage readings directly into the appropriate units for concentration (percent or parts per million), temperature (degrees Fahrenheit), pressure (inches of water column), and flow rate (cubic feet per minute). These converted values were recorded in the data file. The only items not recorded electronically were the SF₆ flow rate from the rotometer, the vent pressure, the differential pressure between the chamber and laboratory, and the barometric pressure, temperature and relative humidity of the laboratory. A second computer was used with the SF₆ analyzer to record the concentrations.

3. TEST METHODS AND PROCEDURES

a. Furnace Installation

The furnace was installed according to the manufacturer's installation instructions and the National Fuel Gas Code (1996) as a one-pipe system. To confirm proper furnace operation, the temperature rise across the heat exchanger and the static pressure between the return and supply ducts were checked for compliance with the manufacturer's specifications.

b. Furnace Input Rate

The furnace input rate was set by adjusting the gas manifold pressure. This was accomplished by turning the adjustment screw of the pressure regulator clockwise to increase the pressure or counter clockwise to decrease the pressure. All input rates reported in this report are within ± 3 percent of the stated values. The input rates were calculated using an average higher heating value of 1040 Btu per cubic feet.

The input rate was initially determined before any adjustments were made to the gas manifold pressure. This input rate, termed “as received” is the input rate that would occur if the furnace installer did not clock the gas flow or adjust the manifold pressure. The “as received” rate was approximately 100,000 Btu/hr, which was in accordance with the manufacturer’s specified rate of 100,000 Btu/hr.

The original test plan included testing the furnace in accordance with the overfire provisions of ANSI Z21.47 (1998). These provisions require that the furnace input rate be adjusted to 12 percent above the manufacturer’s specified rate. Additional tests were conducted at a moderately elevated manifold pressure setting, and at the maximum manifold pressure setting and resulted in firing rates of 118,000 Btu/hr and 128,000 Btu/hr, respectively. Staff decided to test the furnace at the maximum manifold pressure to determine whether the furnace’s CO emissions tended to increase as the firing rate of a furnace increased. CPSC incident data demonstrates that some furnaces involved in CO exposure have, upon inspection, been found to be overfired.

c. Test Matrix

Table E.1 in Appendix E shows the Furnace Test Matrix. It should be noted that not all tests listed in Table E.1 were necessarily performed. The test plan design allowed for omission of some tests within the Baseline, Blocked Vent, and Disconnected Vent tests if certain criteria were satisfied. The criteria for omission were as follows: (1) if a shutoff device or other aspect of a furnace design caused it to shutdown during any of the incremental blockage or disconnected vent conditions; or (2) if the furnace continued to operate under overfire (“as received”), partial blockage or disconnect conditions, but the resultant chamber CO concentrations were negligible; or (3) if the furnace input rate, as installed, was within ± 3 percent of the manufacturer’s specified input rate. If either of the first two criteria were satisfied, then tests involving lesser degrees of vent blockage or disconnect were omitted.

Each test had three main variables: (1) the condition of the vent pipe, (2) the input rate to the furnace, and (3) the operating mode of the furnace. The vent pipe was intact (baseline condition), blocked, or disconnected. For blockage tests, the vent was blocked from 86 to 100 percent. Tests with the vent totally blocked were similar to the blocked vent shut off test required by ANSI Z21.47 standard (Section 2.19, 1998). For disconnected vent tests, the vent was totally separated from the vent system in the closet or in the chamber. The furnace was tested at input rates of 100,000 Btu/hr, 112,000 Btu/hr, 118,000 Btu/hr, and 128,000 Btu/hr for baseline, blocked and disconnected vent tests. The furnace was operated either continuously or it was cycled on for 8 minutes and off for 2 minutes. The cycling rate was based on information obtained from the AGA booklet, “Fundamentals of Gas Appliances” (1996). The booklet states that, as a rule-of-thumb, the optimal cycling rate of a furnace burner is approximately six times per hour. The booklet also states that this optimal cycling rate will be maintained if the furnace is operating 20 to 80 percent of the time. Therefore, a cycle time of 8 minutes on and 2 minutes off was used.

d. Test Procedures

At the start of each day, the gas analyzers were calibrated according to the instructions specified by the manufacturer of the analyzer. In general, the meters were zeroed with nitrogen gas and spanned using a gas of known concentration (EPA protocol). The analyzers were also checked

at mid- and low-range concentrations to verify the performance of the analyzers. To begin an actual test, the data acquisition program was started. The furnace was then started by setting the cycle timer to operate continuously or to cycle on and off. The cycle timer was used to simulate a call for heat by a thermostat. The furnace was allowed to warm up for 15 minutes in order to reach equilibrium. This 15 minute warm up is similar to many test protocols in the ANSI Z21.47 standard (1998). During this warm up period the manifold pressure was adjusted as required to attain the desired input rate. At approximately 15 minutes, the flue gas sample was obtained and the gas flow rate was recorded. If the vent was to be blocked or disconnected, staff entered the chamber and closet (if necessary) and made the appropriate changes to the vent pipe. The closet and chamber doors were closed and the SF₆ tracer gas injection was started. The injection of the tracer gas continued until it had reached an equilibrium concentration in the chamber (approximately one hour). By this time, the concentrations of the other chemical species (CO, O₂, and CO₂) had also reached equilibrium. After reaching equilibrium, the injection of the tracer gas was stopped, and the tracer gas decay was monitored. The test was complete once the concentration of the SF₆ tracer gas was less than 10 percent of the SF₆ analyzer's full-scale value. The data acquisition program and cycle timer were then stopped, and the chamber and closet were allowed to air out before beginning the next test. As a back up to the electronic data, the concentration data were recorded manually at various times during the test. The times at which the three-way valves were switched to toggle between the return and supply duct samples and between the closet and flue samples were also recorded manually.

4. DATA REDUCTION

a. Equilibrium Determination

All data from the data acquisition program were imported into a Microsoft[®] Excel spreadsheet. The SF₆ concentration data were also imported into the same spreadsheet. The concentrations of CO and O₂ in the chamber and closet were then plotted versus time in order to determine the equilibrium period. Once the equilibrium period was established, the average values for all data were calculated during this time interval. For cycling tests, the gas flow rate and the manifold pressure were averaged only during the on time of the cycle. Once the average values were obtained, the CO concentrations were corrected for any background CO present in the laboratory during the equilibrium period and also for any meter offset present at the start of the test. Unless otherwise noted, all reported concentrations are average steady-state values.

b. Air Exchange Rate

The number of air changes per hour (ACH) for the chamber was estimated from the SF₆ equilibrium concentration data in the chamber. The ACH was calculated based on the assumption that the chamber can be modeled as a one-zone system. In the one-zone model, the closet is treated as a non-participating volume. Thus, the actual chamber volume is the total internal volume of the chamber less the volume of the closet and any additional equipment (return duct, vent pipe, etc.) in the chamber. The net volume is 632 cubic feet (17.9 cubic meters). Appendix F provides a derivation of the following equation used to estimate the ACH in the chamber:

$$ACH = \left[\frac{S_{inj}}{C_{eq} V} \right] \quad [4.1]$$

where,

ACH = number of air changes per hour in the chamber, 1/hr

S_{inj} = injection rate of SF₆, cc/hr

C_{eq} = equilibrium concentration of SF₆ in chamber, 0.001 cc/m³ or ppb

V = volume of chamber less volume of closet and any additional equipment, m³

c. Emission Rate

The CO emission rate from the furnace was estimated using the CO equilibrium concentration data in the chamber. The emission rate was calculated based on the assumption that the chamber can be modeled as a one-zone system and that the emission source is the combined closet and furnace. The derivation of the emission rate is similar to the derivation of the ACH described in Appendix F. The CO emission rate is then calculated using the following equation:

$$E_{CO} = C_{COeq} ACH V \quad [4.2]$$

where,

E_{CO} = CO emission rate, cc/hr

C_{COeq} = equilibrium concentration of CO in the chamber, cc/m³ or ppm

ACH = air exchange rate in the chamber, air changes per hour

V = volume of chamber less volume of closet and any additional equipment, m³

d. CO Air-Free

The ANSI Z21.47 standard (1998) sets limits on the amount of CO that may be present in the flue gas. These CO concentrations are specified as “air free”, which is a calculated value to remove excess air from the measured value. Air-free concentrations of CO in the flue gas were calculated using the following equation, which was obtained from the AGA booklet, “Fundamentals of Gas Combustion” (1996):

$$CO_{airfree} = CO \left[\frac{CO_{2,ultimate}}{CO_2} \right]$$

where,

$CO_{air free}$ = air-free sample of CO, ppm

CO = measured CO in flue gas, ppm

$CO_{2, ultimate}$ = ultimate CO₂; the amount of CO₂ produced at stoichiometric conditions, %

CO₂ = measured CO₂ in flue gas, %

Based on the information provided by local gas supplier (Washington Gas), the average ultimate CO₂ was 11.9 percent.

5. RESULTS AND DISCUSSION

a. Baseline Tests (Normal Vent)

Tests were conducted with a normal vent pipe (no blockage or disconnect) to establish the baseline operating conditions of the furnace at different input rates and with the furnace cycling or operating continuously. For all test conditions, the average steady-state concentration of CO in the chamber was negligible (< 2 ppm) as illustrated in Table G.1 (Appendix G). The air exchange rate in the chamber varied from 12.3 to 12.9 air changes per hour. Emission rates ranged from 0 cc/hr to 383 cc/hr.

b. Blocked Vent Tests

Four variables were considered during the blocked vent tests: (1) the degree of vent blockage, (2) the location of vent blockage, (3) the input rate of the furnace, and (4) the operational mode of furnace (continuous or cycling). For all blocked vent tests, the air exchange rate varied from 10.8 to 14.1 air changes per hour. For all test conditions, the average steady-state CO concentrations in the chamber ranged from 0 ppm to 6 ppm. Emission rates ranged from 0 cc/hr to 1,489 cc/hr. Table G.2 (Appendix G) provides a list of the data. The following is a summary of the observations for each test variable.

i) Degree of Blockage

The maximum vent blockage at which the furnace would continue to operate was 86 percent when the vent was blocked midway between the furnace and the vent outlet, using the optical iris. As Table G.2 in Appendix G illustrates, at 86 percent blockage, the average steady-state concentration of CO in the chamber ranged from 0 ppm to 6 ppm for all tests. No tests were run with the vent blocked less than 86 percent. At 86 percent blockage, the air-free CO concentration of the flue gas ranged from 59 ppm to 545 ppm for input rates of 100,000 Btu/hr and 112,000 Btu/hr, respectively. When the input rate was adjusted to 118,000 Btu/hr and 128,000 Btu/hr, the air-free CO concentration of the flue gas ranged from 399 ppm to more than 3,400 ppm. The current ANSI Z21.47 standard (1998) requires that an air-free flue gas sample of CO not exceed a maximum of 400 ppm (0.04 percent) when a furnace vent is either partially or completely blocked. At 88 percent blockage and greater, the furnace shut off within 20 to 40 seconds of being blocked. Each time the furnace shut off, the blockage was removed within 1 to 2 minutes and the furnace resumed operation without having to be manually reset.

Furnace #4 uses a pressure switch to shut off the furnace when the vent becomes blocked. The pressure switch monitors the static pressure at the inlet side of the inducer motor. When the pressure limit of the switch was exceeded, the furnace shut off.

ii) Location of Vent Blockage

Tests were performed with the vent pipe completely blocked at any one of three locations; 1) at the vent outlet, 2) at the inducer fan outlet, or 3) approximately midway between the furnace and vent outlet using an optical iris. Staff blocked the exhaust vent at different locations to investigate whether the blockage location affected the performance of the furnace. Table G.2 (Appendix G) shows the furnace shut off within 20 seconds after the vent pipe was completely blocked at any one of the three locations.

iii) Input Rate

As mentioned in the “Test Methods and Procedures” section, tests were performed at input rates of 100,000 Btu/hr, 112,000 Btu/hr, 118,000 Btu/hr, and 128,000 Btu/hr. The CO concentration in the chamber tended to increase only slightly (0 to 6 ppm) as the firing rate of the furnace was increased (Table G.2, Appendix G). When Furnace #4 was operated continuously, the air-free flue gas sample of CO increased from 59 ppm to more than 3400 ppm, exceeding the measurement range of the CO analyzer, as the firing rate increased from 100,000 Btu/hr to 128,000 Btu/hr.. Many of the air-free CO concentrations exceeded the 400 ppm maximum limit specified in the ANSI Z21.47.2 standard (1998) when the furnace was operated above the manufacturer’s specified input rate.

iv) Cycling

Tests were performed with the furnace operating continuously or cycling at a rate of 8 minutes on and 2 minutes off. Cycling tests were performed only at input rates of 100,000 Btu/hr and 112,000 Btu/hr. The furnace continued to operate with blockages of 86 percent for both cycling and continuous operation tests. The CO concentrations in the chamber and the air-free flue gas concentrations were comparable for cycling and continuous operation tests. No cycling tests were performed at a vent blockage greater than 86 percent, since the furnace shut off.

c. Disconnected Vent Tests

Three variables were considered during the disconnected vent tests: (1) the location at which the vent pipe was disconnected, (2) the input rate of the furnace, and (3) the operational mode of the furnace (continuous or cycling). The air exchange rate in the chamber ranged from 13.7 to 15.4 air changes per hour. For all test conditions, the average steady-state CO concentrations in the chamber ranged from 2 ppm to 159 ppm for all input rates tested. Emission rates ranged from 599 cc/hr to 41,423 cc/hr. Table G.3 located in Appendix G provides a complete list of the data. The following is a summary of the trends observed for each test variable.

i) Location of Vent Disconnect

Tests were performed with the vent pipe totally disconnected inside or outside of the furnace closet. As the data in Table G.3 (Appendix G) and Figure 5.1 illustrate, when the furnace was fired continuously, the average steady-state CO concentrations in the chamber tended to be higher when the vent was disconnected inside of the furnace closet as compared to outside the closet (i.e. inside the chamber). The chamber CO concentrations corresponded to emission rates that were approximately 1.3 to 3.0 times higher when the vent was disconnected inside the closet. When the furnace was cycled, emission rates ranged from approximately 1.5 times higher when the vent was disconnected inside the closet. As with the emission rates, the air-free flue concentration of CO tended to be higher inside the closet rather than outside the closet, when the vent was disconnected and the furnace was operated continuously. However, when the furnace was cycled, air-free CO samples from the flue were sometimes higher for tests where the vent was disconnected in the chamber (outside the closet).

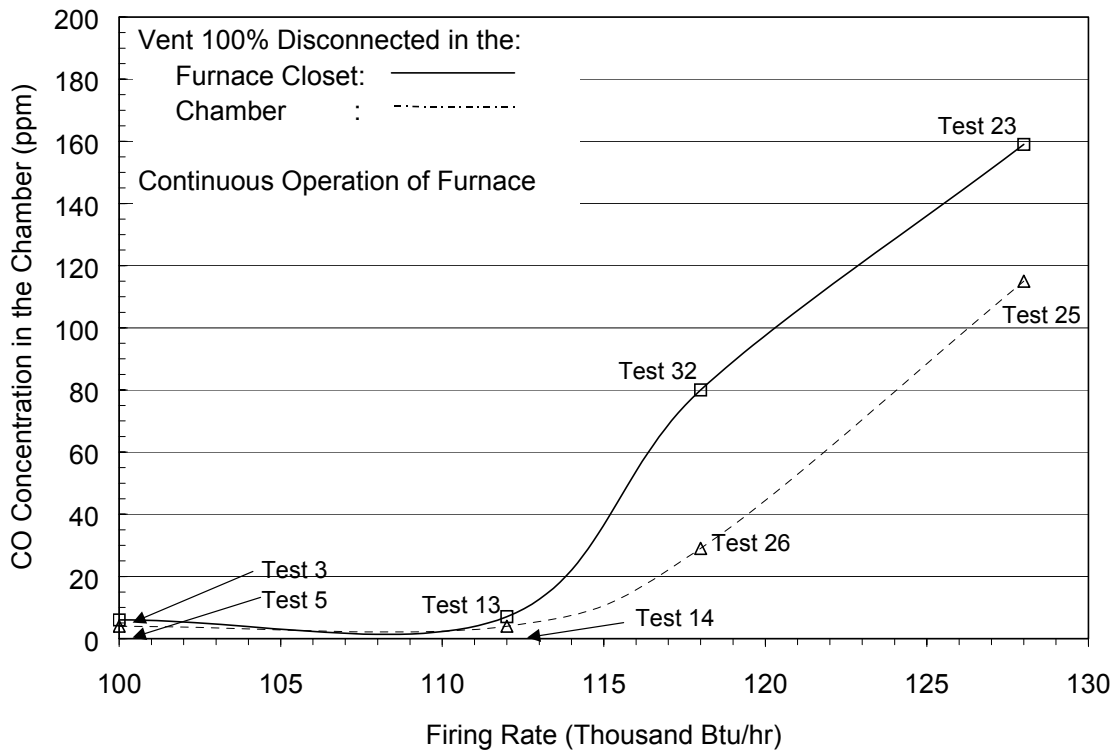


Figure 5.1. Comparison of CO in the Chamber for Furnace #4 as it is Operated Continuously, with the Vent Disconnected in the Closet or in the Chamber

At steady-state, the oxygen concentration in the furnace closet was lower when the vent was disconnected inside of the closet as compared to outside the closet, both when the furnace was fired continuously and when it was cycled. Table 5.1 illustrates the relationship between the oxygen concentration in the closet, and the CO emission rate for Furnace #4 when operated continuously. Table G.3 (Appendix G) provides more complete oxygen concentration data for the disconnected vent tests. In general, reducing the available oxygen concentration during a combustion process is known to adversely affect CO production. As the oxygen concentration is lowered, the CO emission rate tends to increase. When the furnace was fired at 118,000 Btu/hr and 128,000 Btu/hr, the emission rate tended to be higher when the vent was disconnected inside of the closet as compared to outside the closet.

Table 5.1. Oxygen Concentration of the Furnace Closet for Disconnected Vent Tests

Firing Rate (Btu/hr)	Vent Disconnected in the Closet			Vent Disconnected in the Chamber		
	Test Number	Closet Oxygen (%)	CO Emission Rate (cc/hr)	Test Number	Closet Oxygen (%)	CO Emission Rate (cc/hr)
100,000	3	17.2	1,085	5	19.2	599
112,000	13	17.4	1,137	14	19.1	892
118,000	32	17.4	21,736	26	18.8	7,191
128,000	23	17.0	41,423	25	18.5	31,212

ii) Input Rate

As mentioned in the “Test Methods and Procedures” section, tests were performed at input rates of 100,000 Btu/hr, 112,000 Btu, 118,000 Btu/hr, and 128,000 Btu/hr. Figure 5.1 illustrates how the average steady-state CO concentration in the chamber increased as the furnace input rate increased. Figure 5.1 plots the data for Furnace #4 operating continuously with the vent disconnected inside the closet and outside the closet. When Furnace #4 was operated continuously with the vent disconnected in the closet, the average steady-state concentrations of CO in the chamber increased from 2 ppm at 100,000 Btu/hr to 159 ppm at 128,000 Btu/hr. With the vent disconnected outside the closet, the chamber CO concentrations were somewhat lower at the highest firing rates, ranging from 4 ppm at 100,000 Btu/hr to 115 ppm at 128,000 Btu/hr, when the furnace was operated continuously. During disconnected vent tests, CO emission rates ranged from 599 cc/hr to 1,795 cc/hr, when the furnace was fired at the “as received” input rate (100,000 Btu/hr) and 12 percent above the “as received” rate (112,000 Btu/hr), respectively. When Furnace #4 was operated at the firing rates of 118,000 Btu/hr or 128,000 Btu/hr, CO emission rates ranged from 2,481 cc/hr to 41,423 cc/hr, respectively.

iii) Cycling

Tests were conducted with the furnace operating continuously or cycling at a rate of 8 minutes on and 2 minutes off. Figure 5.2 illustrates how the CO in the chamber varied with time as the furnace operated continuously and was cycled on and off. Figure 5.2 plots the data for Furnace #4 operating at an input rate of 128,000 Btu/hr and with the vent pipe disconnected in the closet. When the furnace was fired at an input rate of 112,000 Btu/hr or below, the average steady-state CO concentration in the chamber was less than or equal to 6 ppm for continuous and cycled operation. However, when the firing rate was 118,000 Btu/hr or greater, the average steady-state concentration of CO in the chamber was approximately 2.9 to 8.0 times higher when the furnace operated continuously compared to when the furnace was cycled on for 8 minutes and off for 2 minutes.

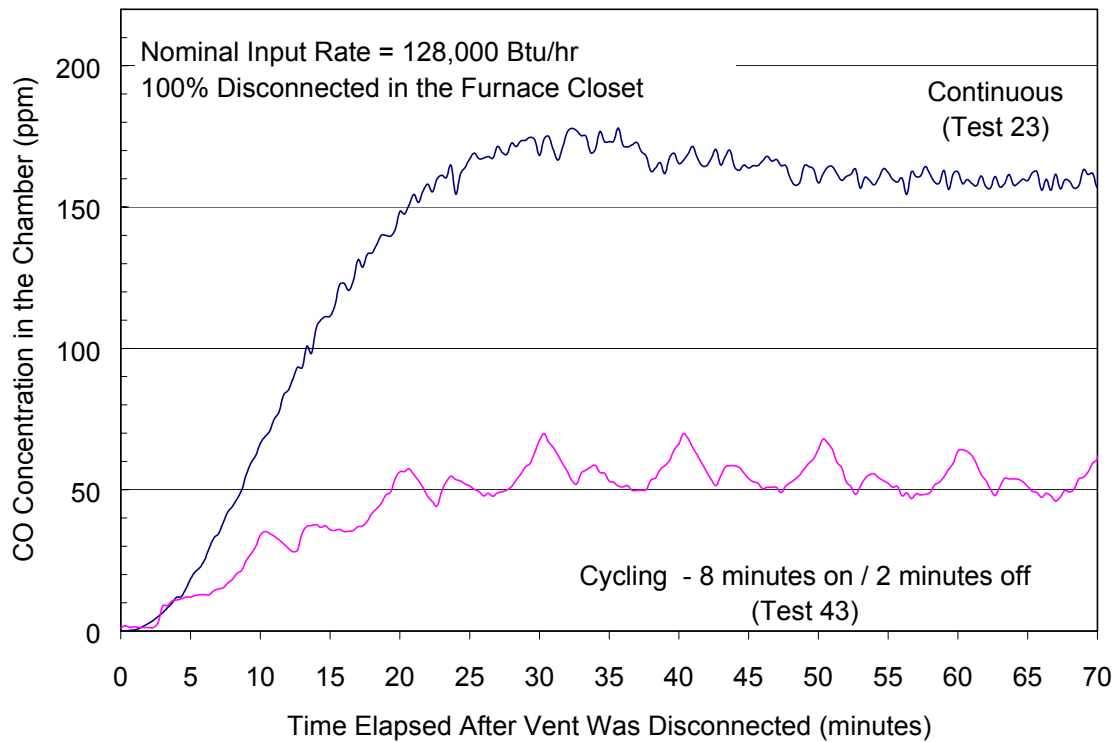


Figure 5.2. Comparison of CO in the Chamber for Furnace #4 as it is Cycled or Operated Continuously

d. Observations

i) Furnace Performance when tested “As Received” and 12 Percent Above “As Received”

When staff operated Furnace #4 at the “as received” firing rate of 100,000 Btu/hr or 12 percent above the “as received” firing rate (112,000 Btu/hr), steady-state CO concentrations in the chamber were relatively low (≤ 6 ppm) for all test conditions (blocked, disconnected, continuous or cycled operation). The “as received” firing rate for Furnace #4 was the same as the manufacturer’s specified firing rate. Only when the furnace was operated at firing rates of 118,000 Btu/hr or greater were the steady-state CO concentrations in the chamber elevated.

6. CONCLUSIONS

The following is a summary of the test results:

- The furnace “as received” was not overfired.
- With a normal vent pipe (no blockage or disconnect), the average steady-state concentration of CO in the chamber was negligible (≤ 2 ppm).
- When the furnace was fired at 100,000 Btu/hr and 112,000 Btu/hr, the average steady-state CO concentrations in the chamber were relatively low (≤ 6 ppm) for all test conditions (blocked, disconnected vent pipe, continuous or cycled operation).

- During blocked vent tests:
 - The average steady-state concentration of CO in the chamber was 6 ppm or less when the vent was blockage up to 86 percent midway between the furnace and vent outlet.
 - With the vent blocked more than 86 percent, the furnace shut off immediately.
 - The location of the vent blockage did not affect the performance of the furnace. The furnace shut off immediately when the exhaust vent was completely blocked at the vent outlet, or midway between the furnace and the vent outlet, or at the inducer fan outlet.
 - The CO concentrations in the chamber and the air-free flue gas concentrations were comparable for cycling and continuous operation tests, when the vent was partially blocked.
 - Increasing the firing rate of the furnace did not result in high chamber CO concentrations (≤ 6 ppm).
 - Increasing the firing rate resulted in increasingly high air-free CO concentrations in the flue gas.
 - When the furnace was fired at 100,000 Btu/hr and 112,000 Btu/hr, the air-free CO concentrations from the flue gas ranged from 59 ppm to 545 ppm, respectively. When the input rate was adjusted to 118,000 Btu/hr and 128,000 Btu/hr, the air-free CO concentrations from the flue gas ranged from 399 ppm to more than 3,400 ppm, respectively. The current ANSI Z21.47 standard (1998) requires that an air-free flue gas sample of CO not exceed a maximum of 400 ppm (0.04 percent) when a furnace vent is either partially or completely blocked.
- During disconnected vent tests:
 - The average steady-state concentration of CO in the chamber increased as the firing rate increased.
 - The concentration of CO was generally higher when the vent was disconnected inside the furnace closet as opposed to outside of the furnace closet.
 - The furnace generated more CO when it operated continuously than when it was cycled on and off.
 - When the furnace was fired at 100,000 Btu/hr and 112,000 Btu/hr, the air-free CO concentrations from the flue gas ranged from 6 ppm to 37 ppm, respectively. When the input rate was adjusted to 118,000 Btu/hr and 128,000 Btu/hr, the air-free CO concentrations from the flue gas ranged from 99 ppm to 1,686 ppm. The current ANSI Z21.47 standard has no requirements for disconnected vents.
 - Depending on the test conditions, the average steady-state concentrations of CO in the chamber ranged from 2 ppm at 100,000 Btu/hr to 159 ppm at 128,000 Btu/hr.

ACKNOWLEDGMENTS

Editors: Andrew Stadnik, Warren Porter, and James Hyatt

Design and Construction of Test Chamber: Mark Eilbert, Han Lim, and Perry Sharpless

General Support: Paula Simon, Dean LaRue, Dwayne Davis, Thomas Hardison, Shing-Bong Chen, and Janet Buyer

REFERENCES

American National Standard/National Standard of Canada for Gas-Fired Central Furnaces, ANSI Standard No. Z21.47-1998, American Gas Association, New York, NY (1998).

Application of Tracer Gas Analysis to Industrial Hygiene Investigations, Grot, R. and Lagus, P., Lagus Applied Technology, Inc. (1991).

Fundamentals of Gas Appliances, Revised, Catalog No. XH8808, American Gas Association, Arlington, VA (1996).

Fundamentals of Gas Combustion, Revised, Catalog No. XH9601, American Gas Association, Arlington, VA (1996).

Guidelines for Modeling Indoor Air Quality, Nagada, N.L., Rector, H.E., and Koontz, M.D., New York, NY: Hemisphere Publishing Corporation (1987).

National Gas Fuel Code, NFPA Standard No. 54-1996, ANSI Standard No. Z223.1-1996, National Fire Protection Association, Quincy, MA (1996).

APPENDIX A: FURNACE SPECIFICATIONS AND SETUP

Table A1 lists some general information about the test furnace.

TABLE A.1. Specifications of the Test Furnace (Sample #4)

Draft Type	Induced Draft
Input Rate	
Specified Rate	100,000 Btu/hr
Specified Manifold Pressure	3.5 inches w. c.
Orifice Size	0.082 inches (No. 45)
Burner Type	In Shot
Combustion Chamber	Open
Vent Type	PVC (3 inch diameter)
Block Vent Shutoff System	Pressure Switch @ inlet side of inducer fan
Annual Fuel Utilization Efficiency (AFUE)	92.6 %
Return/Supply Air	
Temperature Rise	40 - 70°F
Maximum Outlet Air Temperature	170 °F
Maximum Static Pressure	0.5 inches w.c.
Certifying Standard	Z21.47 CAN/CGA – 2.3m 1993

The furnace was installed according to the manufacturer's installation instructions and the National Fuel Gas Code (1996). Three-quarter inch (1.91 centimeter) black galvanized pipe was used to connect the furnace to the main gas line. A pressure tap was added before the pressure regulated so that the supply pressure could be measured. The inlet pressure generally ranged from 6.5 to 7.0 inch w.c. The furnace was placed on a 13 inch (33.0 centimeter) high platform so that the return duct would not contact the chilled water lines that ran along the floor of the chamber.

Flue gases from the furnace were vented using PVC vent material having an internal diameter of 3 inches (7.62 centimeters). The vent pipe had a total rise of 5.60 feet (1.70 meters) and a horizontal run of approximately 4.0 feet (1.21 meters). Figure A.1 illustrates the general vent system. Due to restrictions preventing modifications to the CPSC laboratory, the flue products had to be vented outdoors using an existing vent hood. The vent hood was located at a vertical distance of 5 feet (1.52 meters) from the furnace and a horizontal distance of 17 feet (5.18 meters). Due to the venting restrictions in the National Fuel Gas Code (1996) that states that the horizontal run of the vent pipe can not exceed 75 percent of the vertical height for draft hood equipped furnaces, the vent pipe could not be directly connected to the vent hood. Instead, the vent pipe terminated in a draft hood that was then connected to the vent hood (see Figure A.1). The draft hood was open in the back allowing air to be drawn in with the flue products and a fan was used to transfer this mixture to the vent hood. When the fan for the draft hood was on and the furnace was off, the pressure in the vent pipe was 0.00 inches w.c. Therefore, the vent hood did not affect the operation of the furnace.

The return duct consisted of a duct that was 7.1 feet (2.16 meters) long, 16 inches (40.6 centimeters) high by 19 inches (48.3 centimeters) wide. The duct was attached to the furnace return air opening using flanges and screws. Aluminum tape was used to seal all seams along the duct and at the point of attachment between the duct and furnace. Air for the return duct was obtained from an adjoining room. A vent located at the end of the room prevented the pressure from going negative in this room when the furnace was operating. The supply duct consisted of several sections. The first section was a 16 inch (40.6 centimeters) long transition piece that reduced the 19 inch (48.3 centimeter) by 18 inch (45.7 centimeter) furnace supply air opening to an 8 inch (20.3 centimeter) by 20 inch (50.8 centimeter) opening. The second section consisted of a rectangular duct that was 4.25 feet (1.30 meters) long, 8 inches (20.3 centimeter) high by 20 inches (50.8 centimeter) wide. This section was connected to a 90-degree duct. The final section was an 8 inch (20.3 centimeter) by 20 inch (50.8 centimeter) duct that was 10.6 feet (3.23 meters) long. Screws connected the various sections of the duct together and all duct seams within the closet were sealed with aluminum tape. The heated air from the supply duct was released in the main section of the laboratory. This section of the building contained a vent hood that exhausted to the outdoors and thus prevented a positive pressure from occurring in the room.

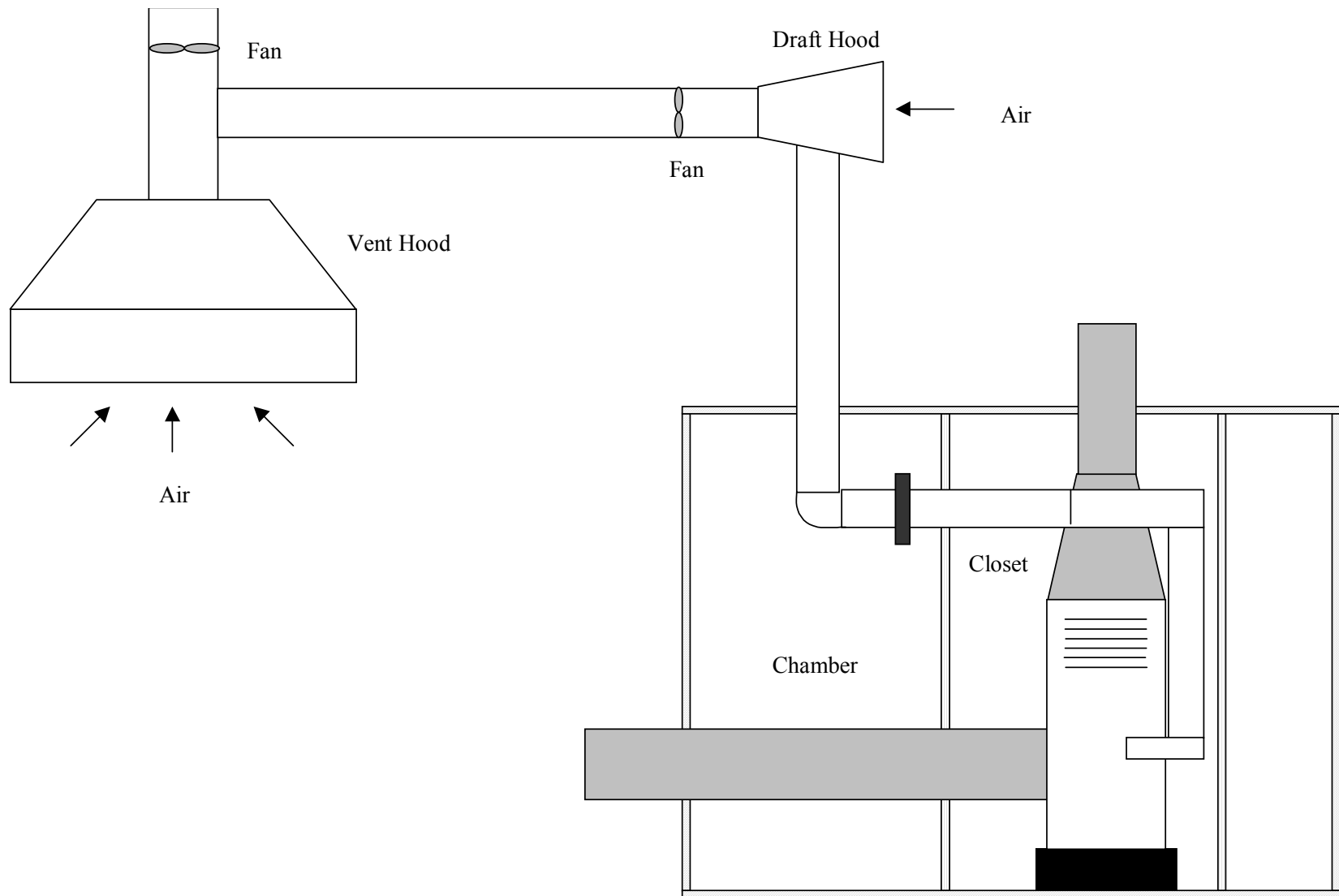


Figure A.1. Furnace Vent System Diagram

APPENDIX B: CHAMBER AND FURNACE CLOSET DESCRIPTION

CHAMBER

The test chamber was a modified environmental room manufactured by Hotpack. The internal dimensions of the chamber were 10 feet (3.05 meters) wide, by 12 feet (3.66 meters) long, by 7 feet (2.16 meters) high. The internal volume was 837 cubic feet (23.7 cubic meters). The inner walls of the chamber were constructed from enamel-coated aluminum. Holes were added through the chamber walls to allow for the return and supply ducts of the furnace and also for the vent pipe. Silicon glue was used to seal any gaps between the chamber walls and the ducts and vent pipe.

The temperature inside the chamber was controlled by removing heat from the chamber. This was accomplished by passing chilled water through four fin-and-tube heat exchangers located in the chamber (Figure B.1). Chilled water was provided by a recirculating chiller (Neslab, HX 750) located outside of the chamber. To assist in the cooling process, three small fans situated over each heat exchanger were used to draw air over the heat exchanger. These fans also ensured a well-mixed environment within the chamber.

The chamber was equipped with two fans to control air infiltration into the chamber. One fan brought fresh air from the laboratory into the chamber and the second fan exhausted air out of the chamber into an exhaust hood that vented outdoors.

The chamber also contained a pressure feedback system to maintain a near zero pressure differential between the chamber and the laboratory. This was done to prevent the furnace from back drafting. The feedback system consisted of the exhaust fan connected to a photohelic pressure gauge with transmitter (Dwyer, model 3000SGT). When the pressure differential exceeded the set pressure limit of ± 0.01 inches w.c., the exhaust fan would cycle off or on accordingly.

FURNACE CLOSET

A furnace closet was erected within the chamber. The closet was constructed using ½ inch dry wall and metal studs for the framing. The outside of the closet was 4.33 feet (1.32 meters) wide by 6.25 feet (1.91 meters) long by 7.08 feet (2.16 meters) high. The closet was positioned on a 0.75 inch (1.91 centimeter) thick piece of wood located on the chamber floor. The internal volume of the closet was 196 cubic feet (5.5 cubic meters). The closet contained a door, a hole for the vent pipe, and holes for the return and supply ducts. The hole for the vent pipe provided a 0.25 to 1.0 inch clearance around the vent pipe. In order to comply with the National Fuel Gas Code (1996) and the manufacturer's installation instructions for a "Confined Space" installation, the closet contained two vent openings. Both vents had a free area of 121 square inches, which met the requirement of a minimum of 1 square inch per 1,000 Btu/hr of the input rating (at 100,000 Btu/hr input, the minimum free area would be 100 square inches). One vent was located within 12 inches of the ceiling and the other was located within 12 inches of the floor, per the instructions. The furnace was positioned inside the closet so that the manufacturer's specification for minimum distances to combustible surfaces was met.

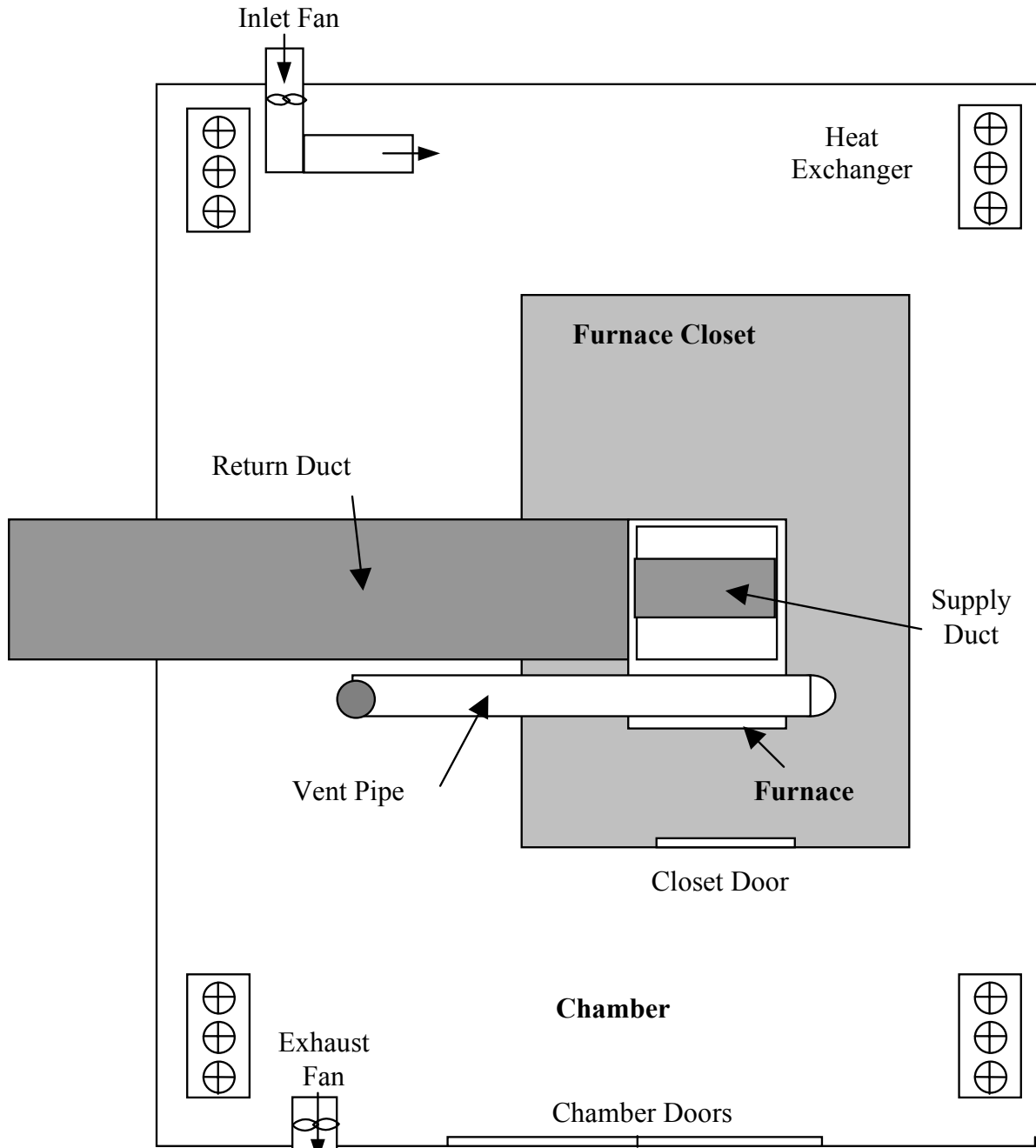


Figure B.1. Test Chamber Diagram (Top View)

APPENDIX C: MEASUREMENT OF FURNACE OPERATING PARAMETERS

Figure C.1 illustrates the general locations where the different operating parameters of the furnace were measured.

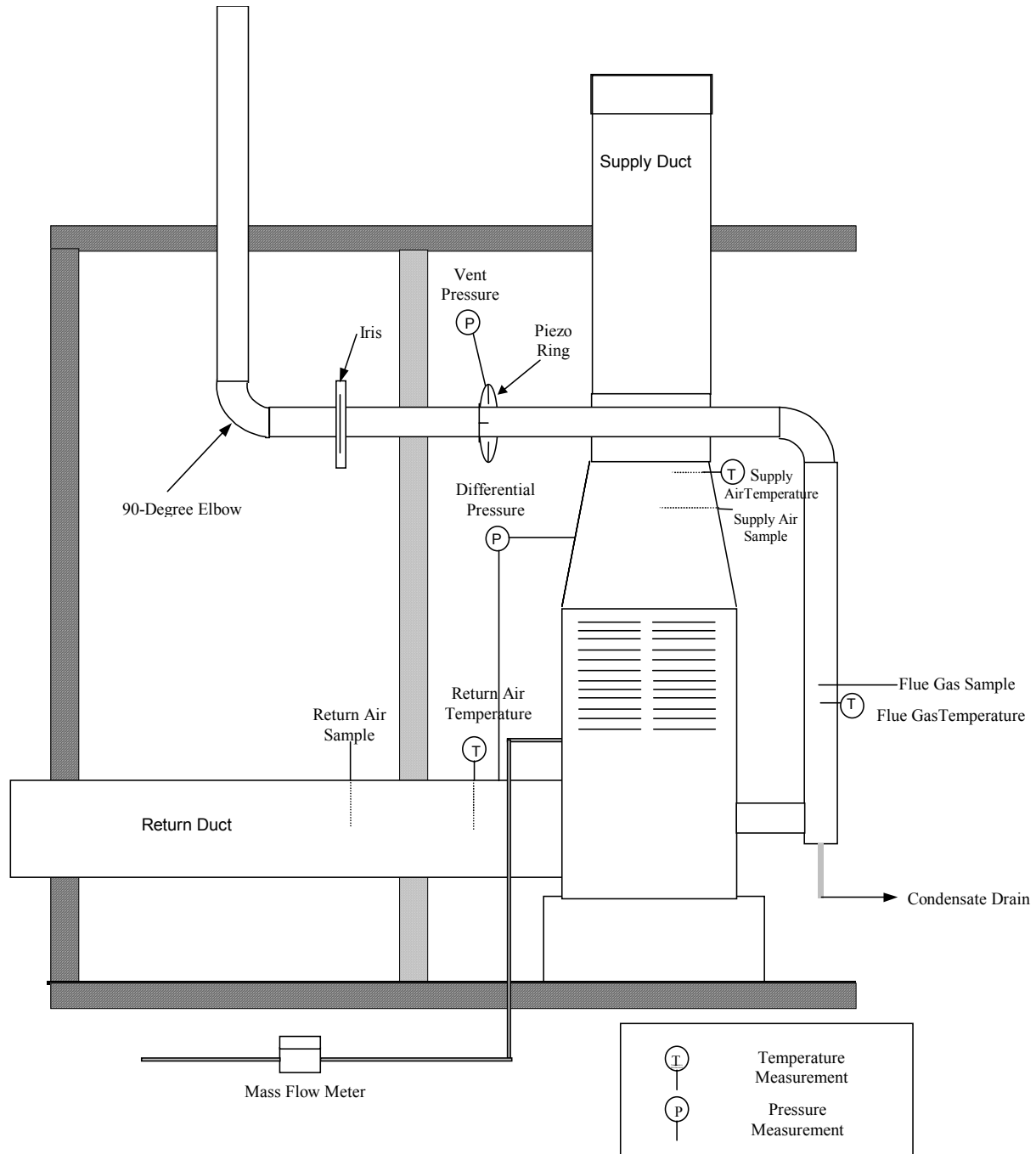


Figure C.1. Location of Measurements on Test Furnace

Table C.1. Equipment Used to Measure the Different Operating Parameters of the Furnace

Parameter Being Measured	Equipment Type	Manufacturer	Model	Range	Accuracy
Gas Manifold Pressure	Magnehelic Pressure Gage with Transmitter	Dwyer	605-10	0-10 inches w.c.	± 2% full scale
Differential Pressure Between the Return & Supply Air Ducts	Magnehelic Pressure Gage with Transmitter	Dwyer	605-1	0-1.0 inches w.c.	± 2% full scale
Vent Pressure	Magnehelic Pressure Gage	Dwyer	2301	0.5 – 0 – 0.5 inches w.c.	± 2% full scale
Gas Input Rate	Mass Flow Meter (methane)	Sierra	826-NX-OV1-PV1-V1	0-2 scfm	± 1.5% full scale
Flue Temperature, Return and Supply Air Temperature, Air Temperature Near Blocked Vent Shutoff System	Thermocouple	Omega	Type K, 28 AWG	-200 to 1250°C	2°C or 0.75% of Reading, which ever is greater

APPENDIX D: GAS SAMPLING SYSTEM

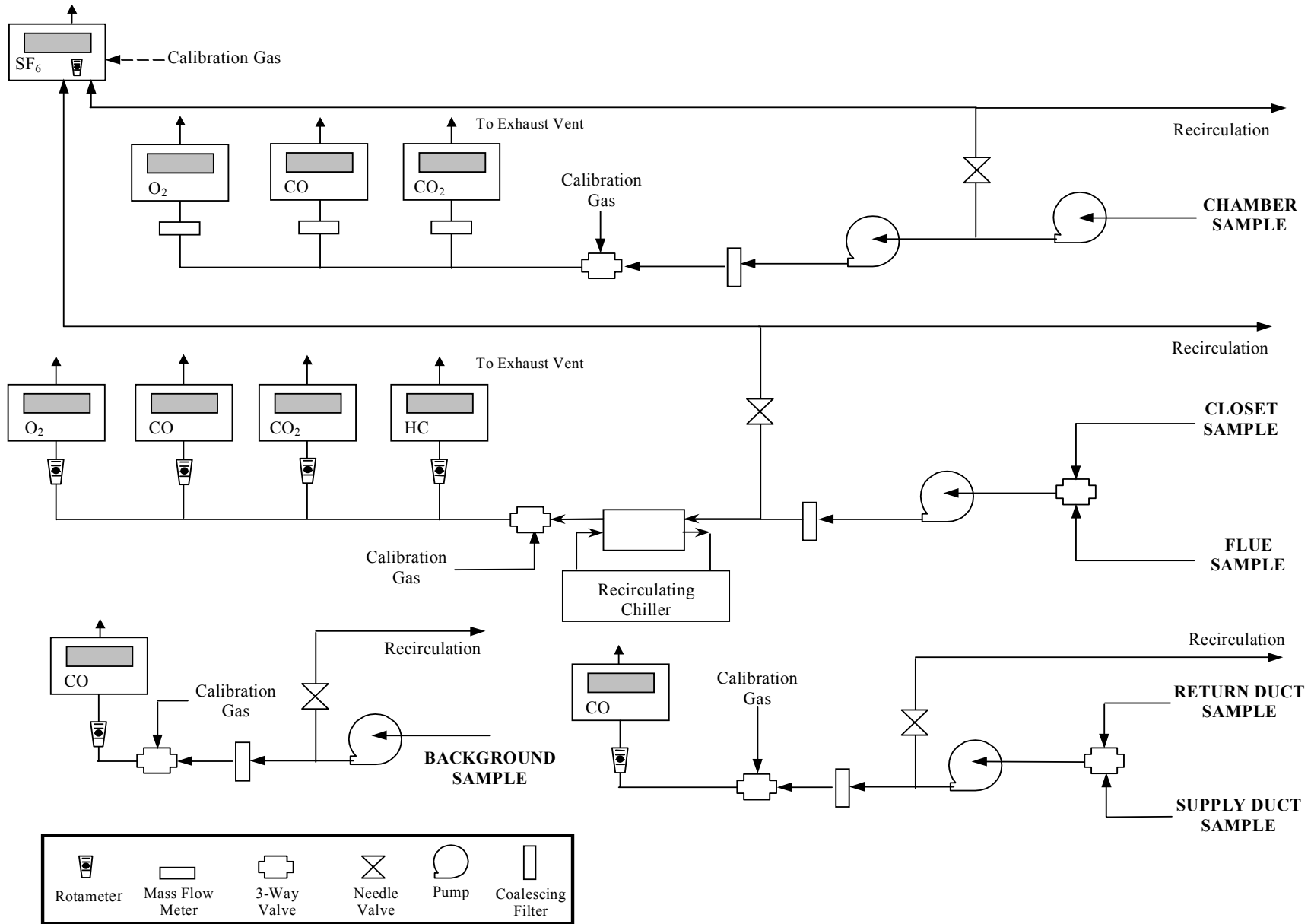


Figure D.1. Schematic of Gas Sampling Systems

Table D.1. Equipment Used with the Gas Sampling Systems

Chemical Species	Location	Measuring Technique	Manufacturer	Model	Range	Accuracy
Carbon Monoxide (CO)	Closet/Flue	Non-Dispersive Infrared	Rosemount	880A	0-200 ppm, 0-1000 ppm	1% Full Scale
Carbon Dioxide (CO ₂)	Closet/Flue	Non-Dispersive Infrared	Rosemount	880A	0-10%, 0-20%	1% Full Scale
Oxygen (O ₂)	Closet/Flue	Paramagnetic	Rosemount	755R	0-25%	1% Full Scale or 0.01% O ₂ , which ever is greater
Hydrocarbon (HC)	Closet/Flue	Non-Dispersive Infrared	Rosemount	880A	0-100% LEL ¹	1% Full Scale
Carbon Monoxide (CO)	Return/Supply Air	Non-Dispersive Infrared	Rosemount	880A	0-100 ppm, 0-1000 ppm	1% Full Scale
Oxygen (O ₂)	Chamber	Paramagnetic	Rosemount	755R	0-25%	1% Full Scale or 0.01% O ₂ , which ever is greater
Carbon Monoxide (CO)	Chamber	Non-Dispersive Infrared	Rosemount	880A	0-200 ppm, 0-1000 ppm	1% Full Scale
Carbon Dioxide (CO ₂)	Chamber	Non-Dispersive Infrared	MSA	Lira 3000	0-10%	1% Full Scale
Carbon Monoxide (CO)	Return/Supply Air	Non-Dispersive Infrared	Beckman	866	0-100 ppm	1% Full Scale
Sulfur Hexafluoride (SF ₆)	Chamber and Closet	Electron Capture Gas Chromatograph	Lagus Applied Technology	101	0-5 ppb	±3% of reading

1. Lower Explosion Limit of Methane (5% by volume)

APPENDIX E: FURNACE TEST MATRIX

Table E.1. Furnace Test Matrix Table

BASELINE TESTS
Normal
1. Baseline @ Specified Rate (continuous)
2. Baseline @ Specified Rate (w/cycling)
3. Baseline @ “As Received” Rate (continuous)
4. Baseline @ “As Received” Rate (w/cycling)
Overfire
5. 12% Over Specified Rate (continuous)
6. 12% Over Specified Rate (w/cycling)
7. 12% Over “As Received” Rate (continuous)
8. 12% Over “As Received” Rate (w/cycling)
BLOCKAGE TESTS
Normal
9. 100 % Vent Blockage @ Specified Rate (continuous)
10. 100 % Vent Blockage @ Specified Rate (w/cycling)
11. 100 % Vent Blockage @ “As Received” (continuous)
12. 100 % Vent Blockage @ “As Received” Rate (w/cycling)
13. Incremental Vent Blockage (80%-95%, 65%, 50%, 25%) (continuous)
14. Incremental Vent Blockage (80%-95%, 65%, 50%, 25%) (w/cycling)
15. Incremental Vent Blockage @ “As Received” Rate (80%-95%, 65%, 50%, 25%) (continuous)
16. Incremental Vent Blockage @ “As Received” Rate (80%-95%, 65%, 50%, 25%) (w/cycling)
Overfire
17. 100 % Vent Blockage @ 12% Over Specified Rate (continuous)
18. 100 % Vent Blockage @ 12% Over Specified Rate (w/cycling)
19. 100 % Vent Blockage @ 12% Over “As Received” Rate (continuous)
20. 100 % Vent Blockage @ 12% Over “As Received” Rate (w/cycling)
21. Incremental Vent Blockage (80%-95%, 65%, 50%, 25%) @ 12% Over Specified Rate (continuous)
22. Incremental Vent Blockage (80%-95%, 65%, 50%, 25%) @ 12% Over Specified Rate (w/cycling)
23. Incremental Vent Blockage (80%-95%, 65%, 50%, 25%) @ 12% Over “As Received” Rate (continuous)
24. Incremental Vent Blockage (80%-95%, 65%, 50%, 25%) @ 12% Over “As Received” Rate (w/cycling)

Table E.1. Furnace Test Matrix Table (continued)

DISCONNECTED VENT TESTS
Normal
25. ¼- Inch Gap @ Specified Rate (continuous)
26. 2-Inch Gap @ Specified Rate (continuous)
27. 100% Disconnected Vent in Closet @ Specified Rate (continuous)
28. 100% Disconnected Vent in Chamber @ Specified Rate (w/cycling)
29. 100% Disconnected Vent in Closet @ “As Received” Rate (continuous)
30. 100% Disconnected Vent in Chamber @ “As Received” Rate (w/cycling)
Overfire
31. ¼- Inch Gap @ 12% Over Specified Rate (continuous)
32. 2-Inch Gap @ 12% Over Specified Rate (continuous)
33. 100% Disconnected Vent in Closet @ 12% Over Specified Rate (continuous)
34. 100% Disconnected Vent in Closet @ 12% Over Specified Rate (w/cycling)
35. 100% Disconnected Vent in Chamber @ 12% Over Specified Rate (continuous)
36. 100% Disconnected Vent in Chamber @ 12% Over Specified Rate (w/cycling)
37. 100% Disconnected Vent in Closet @ 12% Over “As Received” Rate (continuous)
38. 100% Disconnected Vent in Closet @ 12% Over “As Received” Rate (w/cycling)
39. 100% Disconnected Vent in Chamber @ 12% Over “As Received” Rate (continuous)
40. 100% Disconnected Vent in Chamber @ 12% Over “As Received” Rate (w/cycling)

APPENDIX F: DERIVATION OF AIR EXCHANGE RATE AND EMISSION RATE

Air Exchange Rate

The air exchange rate in the chamber can be derived from a simple mass balance on the chamber. Figure F.1 illustrates the different flows into and out of the chamber. The chamber boundaries are displayed using a dashed line. A tracer gas is injected into the chamber (designated as S_{inj}) and the gas concentration (C) is measured inside the chamber over time. The number of air exchanges per hour inside the chamber is controlled by the amount of air brought into (Q_{in}) and out of (Q_{out}) the chamber. An allowance has been made for leakage (Q_{leak}) into the return duct. For this simple model, it is assumed that the furnace closet does not interact with the chamber, but behaves as a “black box”. This assumption can be made if the concentration of the tracer gas in the closet is approximately the same as the concentration in the chamber.

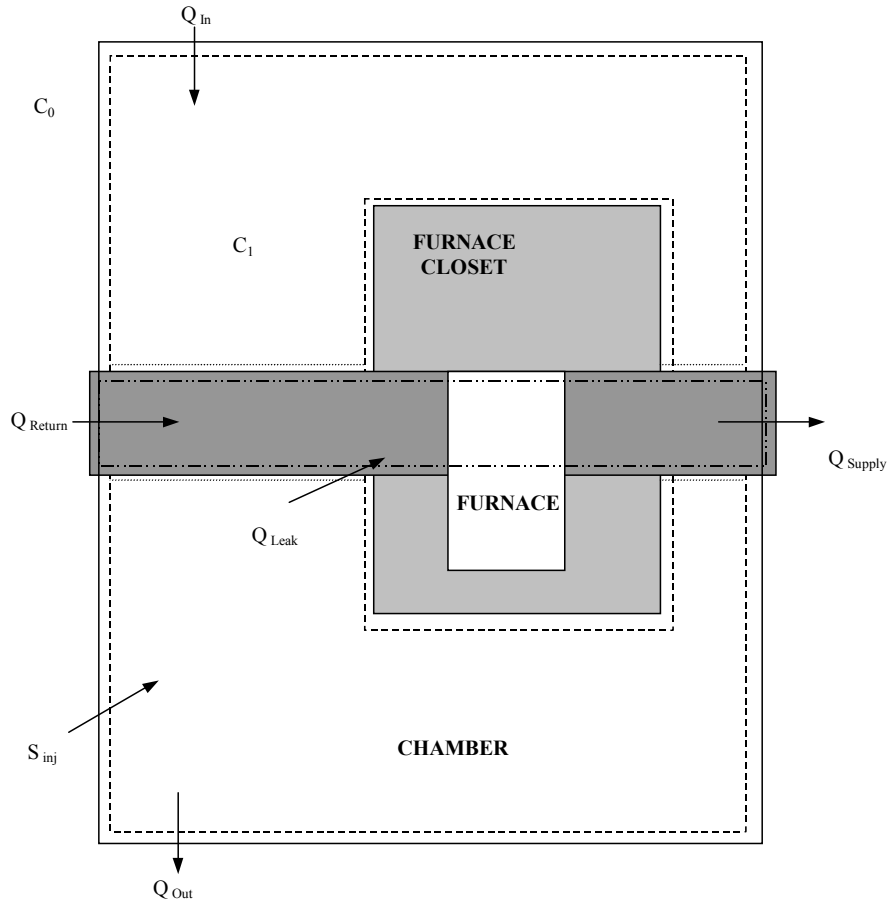


Figure F.1. Model of Test Chamber Used to Derive Air Exchange Rate Equation

Figure F.1 applies to the situation where the vent pipe is totally disconnected or fully blocked. When the vent pipe is intact or partially blocked, a portion of air from the chamber exits through the furnace’s vent pipe. This is the air used in the combustion process (primary and secondary

air) and by the draft hood. Since a pressure control system is used to maintain a zero pressure differential between the chamber and the surrounding laboratory, less air exits the chamber through the chamber's exhaust fan when the furnace is operating. To simplify the model, any air that would be exhausted through the vent pipe to the outdoors will be combined with the term for the flow out of the chamber (Q_{out}).

Based on Figure F.1, a mass balance for chemical specie C inside the chamber yields the following equation:

$$V \frac{dC_1}{dt} = C_0 Q_{in} - C_1 Q_{out} - C_1 Q_{leak} + S_{inj} \quad [F.1]$$

where,

V = volume inside the chamber less the closet and the return duct, m^3

C_1 = concentration of the tracer gas in the chamber, $0.001 \text{ cc}/m^3$ or ppb

C_0 = concentration of the tracer gas present in the background, $0.001 \text{ cc}/m^3$ or ppb

Q_{in} = flow rate of air into the chamber, m^3/hr

Q_{out} = flow rate of air out of the chamber, m^3/hr

Q_{leak} = leak rate of air into the return/supply duct, m^3/hr

S_{inj} = injection rate of tracer gas, cc/hr

In equation F.1, the following has been assumed: the air in the chamber is well mixed, the tracer gas does not get absorbed inside the chamber, any leakage from the supply duct to the chamber has been neglected, and the tracer gas does not get consumed in the burner flame.

Since a pressure control system is used to maintain a zero pressure differential between the chamber and the surrounding laboratory, the following equation can be written for the mass flow of air into and out of the chamber.

$$Q_{in} = Q_{out} + Q_{leak} \quad [F.2]$$

Equation F.1 can be rewritten using the relationship in Equation F.2 as follows:

$$V \frac{dC_1}{dt} = C_0 Q_{in} - C_1 Q_{in} + S_{inj} \quad [F.3]$$

or

$$\frac{dC_1}{dt} = \frac{C_0 Q_{in}}{V} - \frac{C_1 Q_{in}}{V} + \frac{S_{inj}}{V} \quad [F.4]$$

At steady-state, the rate of change of the chemical specie C inside the chamber is zero.

$$\frac{dC_1}{dt} = 0 \quad [F.5]$$

The number of air changes per hour (ACH) in the chamber can be defined by the following equation:

$$ACH = \frac{Q_{in}}{V} \quad [F.6]$$

Assuming that the background concentration of the tracer gas is zero, Equations F.5 and F.6 can be substituted into Equation F.4 to yield the following equation:

$$0 = 0 - C_1 ACH + \frac{S_{inj}}{V} \quad [F.7]$$

Solving for ACH in Equation F.7 yields,

$$ACH = \frac{S_{inj}}{C_{1eq} V_{chmb}} \quad [F.8]$$

where C_{1eq} is the equilibrium concentration of the tracer gas.

CO EMISSION RATE

The equation for the CO emission rate from the furnace can be derived using a method similar to that used to derive the air exchange rate equation (Equation F.8). Figure F.2 illustrates the different flows into and out of the chamber. The only difference between Figures F.1 and F.2 is that the term for the injection rate (S_{inj}) of the tracer gas is replaced with a term for the CO emission rate (E_{CO}) from the furnace. For this simple model, the furnace closet and furnace are combined to form a single “black box” emission source.

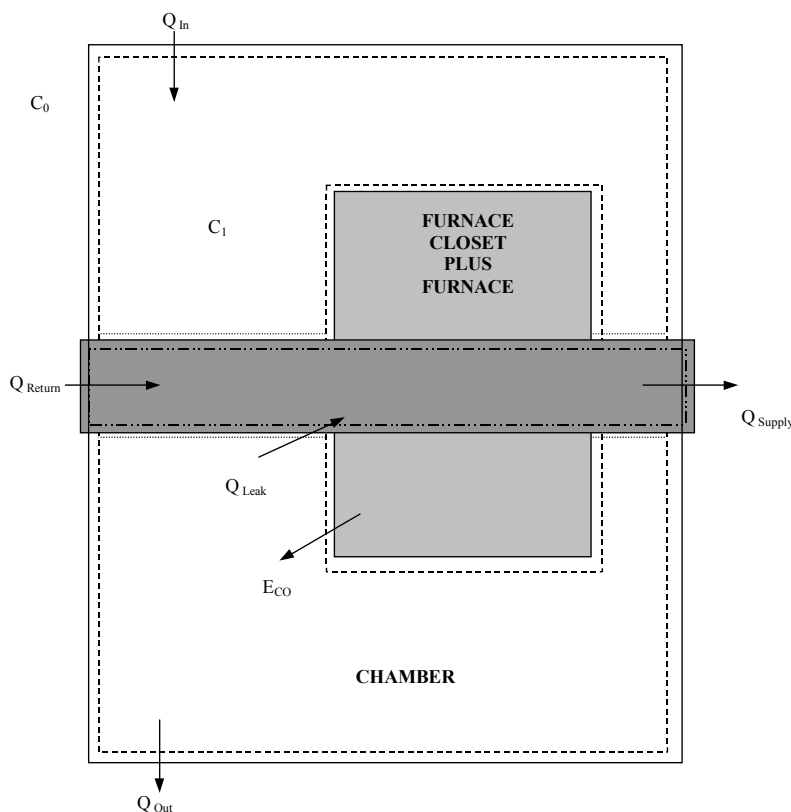


Figure F.2. Model of Test Chamber Used to Derive CO Emission Rate Equation

Based on Figure F.2, a mass balance for chemical specie C inside the chamber yields the following equation:

$$V \frac{dC_1}{dt} = C_0 Q_{in} - C_1 Q_{out} - C_1 Q_{leak} + E_{CO} \quad [F.9]$$

where,

V = volume inside the chamber less the closet and the return and supply ducts, m^3

C_1 = concentration of carbon monoxide in the chamber, cc/m^3 or ppm

C_0 = concentration of carbon monoxide present in the background, cc/m^3 or ppm

Q_{in} = flow rate of air into the chamber, m^3/hr

Q_{out} = flow rate of air out of the chamber, m^3/hr

Q_{leak} = leak rate of air into the return/supply duct, m^3/hr

E_{CO} = emission rate of carbon monoxide from the furnace/furnace closet, cc/hr

Following a method similar to that used to derive the air exchange rate equation, Equation F.9 can be reduced and rearranged to yield the CO emission rate.

$$E_{CO} = C_{CO_{eq}} ACH V \quad [F.10]$$

where $C_{CO_{eq}}$ is the equilibrium concentration of CO in the chamber.

APPENDIX G. TEST DATA RESULTS

Table G.1. Baseline Test Results

Test Number ¹	Input Rate ² (Btu/hr)	Mode of Operation ³	Average Stead-State CO Concentrations (ppm)				Air Exchange Rate (1/hr)	CO Emission Rate (cc/hr)
			Chamber	Closet	Supply Air	Flue Gas ⁴		
1	100000	Continuous	2	0	0	16	12.74	383
9	112000	Continuous	0	0	0	17	12.59	15
28	118000	Continuous	0	0	0	47	12.38	0
33	128000	Continuous	0	0	0	198	12.26	0
2	100000	Cycling	0	0	0	15	12.83	0
10	112000	Cycling	0	0	0	14	13.76	56
29	118000	Cycling	0	0	0	32	12.62	14
30	128000	Cycling	0	1	0	145	12.88	0

1. Test Numbers correspond to the order in which the test was performed and do not relate to the numbers in the Test Matrix (Appendix E).
2. Actual input rates are $\pm 3\%$ of the stated values.
3. Cycling rate is 8 minutes on and 2 minutes off.
4. The CO present in the flue gas is specified on an air-free basis.

Table G.2. Blocked Vent Test Results

Test Number ¹	Degree of Vent Blockage (%)	Location of Blockage	Input Rate ² (Btu/hr)	Mode of Operation ³	Did Furnace Shut Off?	Time of Shut Off (seconds)	Average Steady-State CO Concentrations (ppm)				Air Exchange Rate (1/hr)	CO Emission Rate (cc/hr)
							Chamber	Closet	Supply Air	Flue Gas ⁴		
7	86	Iris ⁵	100000	Continuous	No	N/A	0	0	0	99	10.80	58
12	86	Iris	112000	Continuous	No	N/A	0	2	0	545	14.08	123
30	86	Iris	118000	Continuous	No	N/A	3	5	0	399	12.27	722
18	86	Iris	128000	Continuous	No	N/A	4	14	0	>3,336	13.20	903
19	86	Iris	128000	Continuous	No	N/A	6	17	0	>3,400	13.20	1,489
36	86	Iris	128000	Continuous	No	N/A	6	21	1	>3,325	12.29	1,397
8	88	Iris ⁵	100000	Continuous	Yes	40	N/A	N/A	N/A	N/A	N/A	N/A
11	88	Iris ⁵	112000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
8	90	Iris ⁵	100000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
11	90	Iris ⁵	112000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
8	95	Iris ⁵	100000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
11	95	Iris ⁵	112000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
7	100	Iris ⁵	100000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
11	100	Iris ⁵	112000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
17	100	Inducer Exhaust ⁵	112000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
17	100	Vent Outlet ⁵	112000	Continuous	Yes	20	N/A	N/A	N/A	N/A	N/A	N/A
41	86	Iris	100000	Cycling	No	N/A	0	0	0	59	12.77	56
38	86	Iris	112000	Cycling	No	N/A	0	3	0	650	13.80	0

1. Test Numbers correspond to the order in which the test was performed and do not relate to the numbers in the Test Matrix (Appendix E).
2. Actual input rates are $\pm 3\%$ of the stated values.
3. Cycling rate is 8 minutes on and 2 minutes off.
4. The CO present in the flue gas is specified on an air-free basis.
5. Incremental Blockage Test

Table G.3. Disconnected Vent Test Results

Test Number ¹	Size of Disconnect (%)	Location of Vent Disconnection	Input Rate (Btu/hr)	Mode of Operation ³	Did Furnace Shut off?	Average Steady-State CO Concentrations (ppm)					Air Exchange Rate (1/hr)	CO Emission Rate (cc/hr)
						Chamber CO (ppm)	Closet CO (ppm)	Closet Oxygen (%)	Supply Air CO	Flue Gas ⁴ CO		
5	100	Chamber	100000	Continuous	No	2	2	19.2	0	21	15.1	599
3	100	Closet	100000	Continuous	No	4	7	17.2	0	36	15.2	1,085
14	100	Chamber	112000	Continuous	No	3	3	19.1	8	29	14.5	892
13	100	Closet	112000	Continuous	No	4	8	17.4	0	37	14.6	1,137
26	100	Chamber	118000	Continuous	No	29	39	18.8	2	400	13.7	7,191
32	100	Closet	118000	Continuous	No	80	125	17.4	5	776	15.1	21,736
25	100	Chamber	128000	Continuous	No	115	137	18.5	7	1,369	15.2	31,212
23	100	Closet	128000	Continuous	No	159	245	17.0	14	1,686	14.5	41,423
6	100	Chamber	100000	Cycling	No	5	4	19.9	0	17	15.4	1,241
4	100	Closet	100000	Cycling	No	6	10	18.3	0	6	15.4	1,550
16	100	Chamber	112000	Cycling	No	5	5	19.7	0	22	15.2	1,229
15	100	Closet and Chamber (minor) ⁵	112000	Cycling	No	6	12	18.2	0	31	15.9	1,795
27	100	Chamber	118000	Cycling	No	10	11	19.5	0	115	14.6	2,481
42	100	Closet	118000	Cycling	No	10	15	18.3	0	99	15.0	2,556
24	100	Chamber	128000	Cycling	No	34	37	19.6	1	467	14.3	8,818
43	100	Closet	128000	Cycling	No	54	92	17.9	2	918	14.0	13,487

1. Test Numbers correspond to the order in which the test was performed and do not relate to the numbers in the Test Matrix (Appendix E).
2. Actual input rates are $\pm 3\%$ of the stated values.
3. Cycling rate is 8 minutes on and 2 minutes off.
4. The CO present in the flue gas is specified on an air-free basis.
5. The vent was completely disconnected in the closet and later found to be slightly disconnected in the chamber.