



Canopy hood:  $Q = 250 \text{ cfm/ft}^2 \text{ canopy - single unit}$   
 $150 \text{ cfm/ft}^2 \text{ canopy - double unit}$   
 $h_e = 0.25 VP_d$

Note: Slotted side draft hoods required to remove smoke as hot cores emerge from machine.  
 Minimum capture velocity = 150 fpm

Side draft hood:  $Q = 150(10X^2 + A)$  where A equals hood area  
 $h_e = 1.78 VP_s + 0.25 VP_d$

Note: Conveyor or cooling area require ventilation for large cores. Scrap conveyor or tote boxes may also require additional ventilation.  
 Minimum duct velocity = 3500 fpm



TITLE

SHELL CORE MAKING

FIGURE

VS-20-10

DATE

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