

# Table of Contents

Disclaimer .....	IV
Preface by the editors .....	XLIII
Introduction by ATMOSphere .....	XLV
Abbreviations and units .....	LIII
<b>1 Introduction</b> .....	<b>1</b>
1.1 Ammonia .....	3
1.2 Carbon Dioxide .....	4
1.3 Hydrocarbons .....	6
1.4 Water as a refrigerant .....	7
1.5 Literature .....	8
<b>2 Thermodynamic properties of natural refrigerants</b> .....	<b>9</b>
<b>3 Comparisons of natural refrigerants</b> .....	<b>15</b>
3.1 Literature .....	18
<b>4 Ammonia as a refrigerant</b> .....	<b>19</b>
4.1 Introduction .....	19
4.1.1 General characteristics and manufacture of ammonia .....	19
4.1.2 Use of ammonia .....	21
4.1.3 Use and economic importance in refrigeration .....	22
4.2 Thermodynamics .....	22
4.2.1 Main features .....	22
4.2.2 Impact on the components of the refrigeration system .....	31
4.3 Plant engineering aspects .....	39
4.3.1 Plant systems and types .....	39
4.3.2 Components .....	44
4.3.3 Leakage monitoring .....	54
4.3.4 Contamination by water and inert gases .....	54
4.3.5 Risks from hydraulic pressure surges in refrigerant piping system .....	56
4.3.6 Direct and indirect systems .....	57
4.4 Safety precautions when handling ammonia .....	59
4.4.1 Ammonia in the atmosphere .....	60
4.4.2 Flammability .....	60
4.4.3 Effects on food .....	61
4.4.4 Effects on humans .....	61
4.4.5 Accidents .....	62

## Table of Contents

---

4.4.6	Technical safety equipment . . . . .	64
4.4.7	Personal protective equipment . . . . .	65
4.4.8	Work in plant room . . . . .	66
4.5	Design criteria for ammonia plants . . . . .	70
4.5.1	General basics . . . . .	70
4.5.2	Materials . . . . .	70
4.5.3	Joining techniques . . . . .	71
4.6	Applications of ammonia as refrigerant . . . . .	74
4.6.1	Refrigerated warehouses . . . . .	74
4.6.2	Supermarkets . . . . .	76
4.6.3	Commercial kitchens . . . . .	78
4.6.4	Ice rinks . . . . .	79
4.6.5	Air conditioners . . . . .	80
4.6.6	Heat pumps / heat recovery . . . . .	80
4.6.7	Chillers for process cooling . . . . .	82
4.6.8	CO <sub>2</sub> and NH <sub>3</sub> cascade systems . . . . .	82
4.6.9	Small capacity installations . . . . .	84
4.6.10	Container solutions . . . . .	84
4.7	Standards and regulations . . . . .	85
4.7.1	European regulations . . . . .	85
4.7.2	Safety training of employees . . . . .	86
4.8	Summary of the advantages and disadvantages of ammonia . . . . .	87
4.9	Outlook . . . . .	88
4.10	System examples . . . . .	89
4.10.1	Refrigeration supply for a fruit-and-vegetable wholesaler . . . . .	89
4.10.2	Cooling provision for a commercial kitchen of an automobile manufacturer . . . . .	91
4.10.3	Liquid chiller for air conditioning office and server rooms . . . . .	92
4.10.4	Cooling supply for a company restaurant . . . . .	94
4.11	Literature . . . . .	96
<b>5</b>	<b>Carbon dioxide as refrigerant . . . . .</b>	<b>97</b>
5.1	History of the refrigerant CO <sub>2</sub> . . . . .	97
5.2	CO <sub>2</sub> effects on health, system reliability, and the environment . . . . .	98
5.3	R744 refrigeration system characteristics and their effect on design and operation . . . . .	101
5.3.1	Introduction and definitions . . . . .	101
5.3.2	Importance of the relatively low critical temperature . . . . .	102
5.3.3	Significance of high pressure at the triple point . . . . .	105
5.3.4	Significance of a generally high-pressure level . . . . .	106
5.3.5	Importance of good heat transfer properties . . . . .	111
5.3.6	Provision for the high coefficient of thermal expansion of the liquid . . . . .	112

5.4	Transcritical refrigeration / heat pump process .....	113
5.4.1	The process on the pressure-enthalpy diagram .....	113
5.4.2	Temperature curve in the gas cooler .....	115
5.4.3	Significance of the gas cooler pressure on cooling capacity .....	119
5.4.4	The importance of gas cooler pressure for the coefficient of performance. ....	121
5.4.5	Optimal high-pressure control of CO <sub>2</sub> processes. ....	121
5.5	Technical solutions with CO <sub>2</sub> .....	124
5.5.1	CO <sub>2</sub> as an evaporating coolant .....	124
5.5.2	CO <sub>2</sub> in the conventional refrigeration process – cascade system .....	126
5.5.3	The transcritical process – basic solutions .....	129
5.6	Process improvement methods. ....	135
5.6.1	Intercooling in two-stage systems .....	135
5.6.2	Parallel compression. ....	136
5.6.3	Cooling of the supercritical gas after the gas cooler .....	137
5.6.4	Expansion work recovery .....	138
5.7	Heat recovery with CO <sub>2</sub> installations. ....	142
5.7.1	Heat recovery at one temperature level: a simple solution .....	143
5.7.2	Heat recovery at different temperature levels .....	144
5.8	CO <sub>2</sub> heat pumps .....	147
5.8.1	General. ....	147
5.8.2	Production of industrial hot water. ....	148
5.8.3	Combined space heating and hot water preparation. ....	151
5.9	Safety when using CO <sub>2</sub> .....	152
5.9.1	Pressure and temperature – safety conditions .....	152
5.9.2	Dry ice – safety and operating conditions. ....	153
5.10	Examples for CO <sub>2</sub> refrigeration system applications. ....	154
5.10.1	Cascade refrigeration installations using CO <sub>2</sub> as a refrigerant .....	154
5.10.2	Transcritical systems .....	158
5.11	Literature .....	176
<b>6</b>	<b>Hydrocarbons as refrigerant. ....</b>	<b>179</b>
6.1	Introduction .....	179
6.1.1	Ecological characteristics. ....	180
6.2	Thermodynamic aspects .....	182
6.2.1	Evaporation latent heat .....	183
6.2.2	Evaporation temperature and pressure .....	185
6.2.3	Isentropic expansion exponent $\kappa$ .....	186
6.2.4	Coefficient of Performance / Energy Efficiency Ratio .....	187
6.2.5	Compression or pressure ratio .....	188
6.2.6	Volumetric cooling capacity .....	190
6.2.7	Discharge temperature. ....	190

6.2.8	Density . . . . .	192
6.2.9	Viscosity . . . . .	193
6.2.10	Material compatibility . . . . .	193
6.3	Refrigeration system components . . . . .	194
6.3.1	Compressor . . . . .	194
6.3.2	Piping and fittings . . . . .	194
6.3.3	Heat exchangers . . . . .	195
6.3.4	Throttle device . . . . .	195
6.3.5	Receivers . . . . .	195
6.3.6	Multi-stage systems . . . . .	195
6.4	Safety of refrigeration systems with hydrocarbons . . . . .	196
6.4.7	System tightness . . . . .	197
6.4.8	Charge minimisation . . . . .	198
6.4.9	Determination of limited refrigerant charge . . . . .	198
6.4.10	Mechanical ventilation . . . . .	201
6.4.11	Ventilated enclosures . . . . .	202
6.4.12	Machinery room ventilation . . . . .	203
6.4.13	Gas/leak detection . . . . .	204
6.4.14	Safety devices . . . . .	204
6.4.15	Ignition sources . . . . .	204
6.5	Safe handling of flammable refrigerants . . . . .	206
6.6	Smaller systems . . . . .	207
6.7	Larger systems . . . . .	212
6.7.16	Application examples . . . . .	214
6.8	Outlook . . . . .	220
6.8.1	Differences between purpose of systems . . . . .	221
6.8.2	Assumed leak rates . . . . .	222
6.8.3	Improved tightness systems . . . . .	224
6.8.4	Use of integral airflow to disperse leaks . . . . .	225
6.8.5	Releasable charge . . . . .	226
6.8.6	Equipment enclosures or housing to disperse leaks . . . . .	227
6.8.7	Black box assessment . . . . .	227
6.9	Literature . . . . .	228
<b>7</b>	<b>Water as a refrigerant . . . . .</b>	<b>231</b>
7.1	Introduction . . . . .	231
7.2	Properties and area of application . . . . .	231
7.2.1	Thermodynamic properties and comparison to common refrigerants . . . . .	231
7.2.2	Use as a refrigerant . . . . .	235
7.2.3	Use in vapour compression refrigeration machines . . . . .	236

7.3	Functionality of compression refrigeration systems with the refrigerant water	237
7.4	Application in the low power range	239
7.4.1	Compact water chillers	239
7.4.2	Practical examples	240
7.5	Generation of temperatures below freezing	241
7.5.1	Description of the systems	241
7.5.2	Possible applications	242
7.6	Conclusion	243
7.7	Literature	243
<b>8</b>	<b>Refrigeration systems for temperatures below <math>-50^{\circ}\text{C}</math> (<math>-58^{\circ}\text{F}</math>)</b>	245
8.1	Hydrocarbons and mixtures with $\text{CO}_2$	245
8.2	Nitrous oxide and mixtures with $\text{CO}_2$	245
8.3	Air	246
8.4	Literature	249
<b>9</b>	<b>Lubricants for natural refrigerants</b>	251
9.1	Lubricants for ammonia ( $\text{NH}_3$ – R717)	251
9.2	Lubricants for hydrocarbons (propane – R290, propene – R1270, isobutane – R600a etc.)	252
9.3	Lubricants for carbon dioxide ( $\text{CO}_2$ – R744)	254
9.3.1	Miscibility properties with liquid $\text{CO}_2$	254
9.3.2	Thermal stability	255
9.3.3	Lubrication properties	256
9.3.4	Water content	257
9.3.5	Areas of application for $\text{CO}_2$ refrigeration oils	257
9.4	Selection table – Refrigeration oil type for natural refrigerants	258
9.5	Literature	258
<b>10</b>	<b>Coolants</b>	259
10.1	Requirements for coolants	261
10.2	Types of heat transfer fluids (HTF)	261
10.3	Liquid coolants for medium- and low-temperature applications	264
10.3.1	Cooling of foodstuffs	264
10.3.2	Deep freezing food	266
10.4	HTF with phase change	269
10.4.1	Evaporating carbon dioxide	270
10.4.2	Ice Slurry	270

## Table of Contents

---

10.5	Corrosion protection .....	271
10.6	Case study: Propane – CO <sub>2</sub> cascade ice slurry installation.....	272
10.7	Integral system for cooling goods, air conditioning and heating in supermarkets .....	274
10.8	Literature .....	279
<b>Appendix</b>	.....	281