
Contents

Preface	xi
Chapter 1. Re-entrainment of Solid Particle Beds Swept by a Fluid Current	1
1.1. Introduction	1
1.1.1. Significance of the problem	1
1.1.2. Method	2
1.2. Shear velocity	2
1.2.1. Piping	2
1.2.2. Flat plate (edge perpendicular to fluid flow)	4
1.3. Strength and lift	5
1.3.1. Hypotheses	5
1.3.2. Mean thrust velocity	5
1.3.3. Drag force and lift force	7
1.4. Entrainment criteria	7
1.4.1. Attachment forces	7
1.5. Quantity entrained	9
1.5.1. Probability and frequency	9
1.5.2. Results of Wu <i>et al.</i>	10
1.6. Entrainment limit velocity (simplified method)	11
1.6.1. Mean geometry of spherical particles on the surface of the bed	11
1.6.2. Velocity of sweeping for entrainment	12
1.6.3. Angular particles	17
1.6.4. Cleaning speed and non-entrainment velocity	17
1.7. Entrained flowrate	18
1.7.1. Probability of entrainment and entrained flow	18

Chapter 2. Mechanical Conveying of Divided Solids	21
2.1. General	21
2.1.1. Separation due to fall and pouring: dust formation	21
2.1.2. Flowrate and storage capacity combinations (notions)	22
2.1.3. Organization of divided solid circulation	23
2.1.4. Extractors	24
2.2. Chutes and airslides	26
2.2.1. Chutes inclined horizontally	26
2.2.2. Vertical chute	28
2.2.3. Interruption or modulation of chute flow	29
2.2.4. Airslides	30
2.3. Conveyor belts	31
2.3.1. Description	31
2.3.2. Use criteria	32
2.3.3. Flow regulation by belt scale	33
2.3.4. Safeguards	33
2.3.5. Choice of belt width	34
2.3.6. Flowrate	34
2.3.7. Power consumption	36
2.3.8. Effort incurred by the belt	38
2.3.9. Loading systems	40
2.3.10. Discharge systems	42
2.3.11. Metal conveyor belt	42
2.4. Chain conveyor(s)	44
2.4.1. Crossbar conveyor	44
2.4.2. Scraper conveyors	47
2.4.3. Metal pallet conveyors	47
2.5. Vibrating conveyor	48
2.5.1. Operational principle	48
2.5.2. Types of conveyors	49
2.5.3. Progression rate of the product in the trough	51
2.5.4. Flowrate	55
2.5.5. Power consumption	56
2.5.6. Advantages and drawbacks of vibrating conveyors	59

2.6. Elevators	59
2.6.1. Bucket elevator principle	59
2.6.2. Types of elevators and discharge.	59
2.6.3. Methods of filling buckets.	61
2.6.4. Should a belt or chain be used?.	61
2.6.5. Flowrate	62
2.6.6. Power consumption.	63
2.6.7. Vibrating elevator.	64
2.6.8. Screw lifts	64
2.7. Screw conveyor for divided solids	64
2.7.1. General	64
2.7.2. Choice of screw characteristics.	65
2.7.3. Darnell and Mol's theoretical calculations for screw flow	66
2.7.4. Screw power consumption	69
2.8. Transport by loads.	72
2.8.1. Containers and skips	72
2.8.2. Roller conveyor for boxes.	72
2.8.3. Material lifters.	73
2.9. Several properties of divided solids	73
2.9.1. Abrasiveness – classes of abrasiveness	73
2.9.2. Apparent density – friction with wall	74
2.9.3. Relationship between equipment and product flowability.	75
2.9.4. Release of dust	75
2.10. Storage and transport logistics	75
Chapter 3. Pneumatic Conveying of Divided Solids	77
3.1. Pneumatic conveying: introduction.	77
3.1.1. Description of flow	77
3.1.2. Compacting of a sediment (or de-aeration of a fluidized bed)	78
3.1.3. Measurement of stiffness, k	81
3.1.4. Various regimes of horizontal pneumatic conveying	81
3.2. Properties of divided solids	84
3.2.1. Density and porosity	84
3.2.2. Geldart classification.	86
3.2.3. Precautions and choice according to products	87

3.3. Operational curves	90
3.3.1. Types of operational curves	90
3.3.2. Power expression according to Hilgraf in dense state	93
3.4. Velocity and pressure drops	96
3.4.1. Conveying velocity and loading rate – dense and diluted phases	96
3.4.2. Velocity of air for diluted state	98
3.4.3. Velocity for horizontal conveyance in dense phase	99
3.4.4. Yang blockage criteria for a vertical tube in dense phase	100
3.4.5. Power consumption in a tube	103
3.5. Special study of vertical tubes	110
3.5.1. Preliminary study	110
3.5.2. Numerical simulation of Desgupta <i>et al.</i>	110
3.5.3. Minimal length of solid plugs (simplified estimate)	111
3.5.4. Crossing solid plugs with gas	113
3.5.5. Friction of solid plugs on a pipe	113
3.5.6. Practical proceedings	117
3.6. Ancillary equipment for pneumatic conveying	120
3.6.1. Feeding systems for continuous installations	120
3.6.2. Expedition by discontinuous loads (dense phase)	123
3.6.3. Criteria for the correct design of load conveying	126
3.6.4. Separation of the product and carrier gas	126
3.6.5. Conclusion for these systems	127
3.6.6. Block valves	128
3.6.7. Tubes for pneumatic conveyance	128
3.6.8. Receptors (gas–solid receptors)	129
3.6.9. Control of solid flow: starting and stopping	129
3.6.10. Choice of driving machine for the gas	130
Chapter 4. Hydraulic Conveying of Divided Solids: Standpipe and L-valve	133
4.1. Power dissipated in slurry	133
4.1.1. Introduction	133
4.1.2. Agitation of slurry	133
4.1.3. Pumping power of slurry	135
4.1.4. Pressure drop in conveying slurry	137

4.2. Descent tube	137
4.2.1. Standpipe characteristics: use.	137
4.2.2. Description of the divided solid in the tube	138
4.2.3. Operative mechanism of descenders.	139
4.2.4. Slip velocity	141
4.2.5. Flow-pressure cycles.	142
4.2.6. Principle of performance curve calculation.	144
4.2.7. Standpipe simulation by calculation	146
4.2.8. Aeration studies	147
4.2.9. Placing gas injection at the top of the tube	147
4.2.10. Injection study: theory and experience	148
4.2.11. Conclusion: standpipes in industrial processes.	149
4.3. L-valves	150
4.3.1. Description and operation.	150
4.3.2. Uses.	150
Appendices	151
Appendix 1. Mohs Scale	153
Appendix 2. Apparent Density of Loose Divided Solids ($\text{kg}\cdot\text{m}^{-3}$)	157
Bibliography	161
Index	169