

**REVERSE FLOW CYCLONES FOR
COLLECTION OF TEA DUST**

M.Sc (Chemical and Process Engineering)

I.M.B.M. De Silva



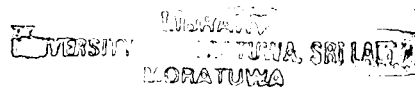
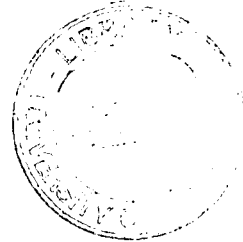
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REVERSE FLOW CYCLONES FOR COLLECTION OF TEA DUST

By

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This Thesis was submitted to the Department of Chemical and Process Engineering of the University of Moratuwa in partial fulfillment of the Degree of Master of Science in Chemical and Process Engineering

**Department of Chemical and Process Engineering
University of Moratuwa
Sri Lanka**

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ABSTRACT

Reverse flow cyclones are used most extensively in the chemical process industries for gas – solid separation. Cyclones are often employed to collect large particles ($>5\mu\text{m}$) that can be used not only as an air pollution control device, but also for recover particulate matter and size separation of particles. Common features found in locally designed cyclones are ineffective and crudely designed. Design of cyclone is more towards realizing a shape of the cyclone than the performance. Customized design approach gives a cyclone with greater collection efficiency, smaller in size or with lower pressure drop that would be found for a conventional standard design. Since the customized design procedure requires trial and error calculations, this research focused on the importance of the development of a computer package: “CycDesign”.

Using this package, a pilot scale reverse flow cyclone is designed and fabricated. This unit was used to examine the suitability of abating the air pollution caused due to dust generated from the fluidized bed dryers in tea industries. Trials were also done for sawdust, cement, quarry dust, talc powder and silica sand. Inlet and outlet particle size distributions were measured. Above 90% Overall collection efficiencies were attained for all the types of dust tested. For tea dust 99.2% collected experimentally which was predicted as 100% by the computer package. Also the computer package can be used to predict performance and dimensionless parameters for a cyclone design. It predicts that a continual decrease of Stokes number based on cut diameter, with increasing Reynolds number Re , for cyclones having different height to diameter ratio H/D . According to predictions, collection efficiency increases with H/D ratio of the cyclone. The declining patterns of fractional efficiency can be visualized with decreasing pressure drop across the cyclone and particle density. A decrease in fractional efficiency can be observed with the increasing of gas flow rate, gas temperature, and gas density.

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NOMENCLATURE

ΔH	Pressure drop expressed as number of inlet velocity heads
ΔP	Pressure drop
μ	Gas viscosity
ψ	Cyclone inertia parameter
η	Efficiency
	Captured fraction
ρ_G	Gas density
ρ_p	Particle density
Stk_{50}	Stokes number based on cut diameter
\bar{v}	Escaped fraction
$\eta_{fractional}$	Fractional efficiency
$\eta_{overall}$	Overall efficiency
a	Gas entry height
A_c	Interior collecting surface of the cyclone
b	Gas entry width
B	Dust outlet diameter
C	Cyclone geometry factor
C_a	Allowable outlet dust concentration
C_i	Inlet dust concentration
C_o	Outlet dust concentration
D	Cyclone cylinder diameter
D_e	Gas outlet diameter
d	Particle diameter
d_{100}	Critical particle diameter
d_{50}	Cut particle diameter
F_c	Centrifugal force acting on particle
F_d	Drag force acting on particle
H	Cyclone overall height
h	Cyclone cylinder height
n	Vortex exponent

N	Number of turns gas makes within cyclone
n_1	Vortex exponent at gas temperature at T_1 (usually 283 K)
n_2	Vortex exponent at gas temperature at T_2 K
P	Pressure drop factor
Q	Volumetric gas flow rate
r	Radial distance from cyclone axis
Re	Reynolds number
r_w	Radial distance from cyclone axis to cyclone wall
S	Gas outlet height
t	Time
T_1	Gas temperature corresponding to vortex exponent, n_1
T_2	Gas temperature corresponding to vortex exponent, n_2
u_r	Radial component of particle velocity
u_t	Tangential component of particle velocity
v	Gas velocity
v_i	Gas inlet velocity
v_r	Radial component of gas velocity
v_t	Tangential component of gas velocity
v_{tw}	Gas tangential velocity at cyclone outer wall
w	Migration velocity of the particle
Z	Natural vortex length

CONTENTS

1.	INTRODUCTION	1
2.	LITERATURE SURVEY	3
2.1.	Mechanism.....	4
2.1.1.	Cyclone Types.....	4
2.1.2.	Main Parts of a Reverse Flow Cyclone	6
2.2.	Performance.....	8
2.2.1.	Tangential Gas Velocity	8
2.2.2.	Vertical And Radial Gas Velocity	10
2.2.3.	Pressure Distribution	10
2.2.4.	Overall Gas Flow Pattern	10
2.2.5.	Pressure Drop	11
2.2.6.	Collection Efficiency.....	13
2.2.7.	Fractional Efficiency	15
2.3.	Cyclone Design.....	19
2.3.1.	Necessary Design Information	19
2.3.2.	Standard Designs	19
2.3.3.	Customized Design.....	22
2.3.4.	Theory of Optimization	24
2.4.	Novel Modifications	28
2.4.1.	Cyclones for liquid droplets	31
2.5.	Applications of Cyclone Separators	31
2.5.1.	Main Features of Cyclone Separators.....	31
2.5.2.	Application of Cyclones in Sri Lankan Industries.....	32
3.	A CASE STUDY: DUST PROBLEM IN TEA MANUFACTURING.....	33
3.1.	Introduction.....	33
3.2.	Tea Manufacturing Process	33
3.3.	Fluidized Bed Tea Dryers.....	35

4.	SOFTWARE SOLUTION FOR CUSTOM DESIGN OF CYCLONES	40
5.	EXPERIMENTAL PROCEDURE	43
5.1.	Design and Fabrication	43
5.2.	Testing Procedure	46
6.	RESULTS AND DISCUSSION	48
6.1.	Comparison of performance that predicted by the program and experimental results	48
6.1.1.	Fractional efficiency	48
6.1.2.	Overall efficiency	51
6.2.	Predictions using computer program	53
6.2.1.	Comparison of efficiencies with gas flow rate	53
6.2.2.	Comparison of efficiencies with gas temperature	54
6.2.3.	Comparison of efficiencies with particle density	56
6.2.4.	Comparison of efficiencies with pressure drop	57
6.2.5.	Comparison of efficiencies with the dimensions of the cyclone	58
6.2.6.	Effect of H/D Ratio	59
6.2.7.	Effect of Reynolds number - Dimensional analysis	60
6.2.8.	Customized Design Vs Standard Design	62
6.2.9.	Significance of the Geometry Parameter, C and Inertia Parameter, ψ on Fractional Efficiency	64
6.2.10.	Graphical predictions for various dust applications	67
7.	CONCLUSION	71
8.	SUGGESTIONS.....	73



LIST OF FIGURES

Figure 2.1.	Straight-through cyclone.....	4
Figure 2.2.	Reverse flow cyclone with standard dimension notations.....	5
Figure 2.3.	Flow through a reverse flow cyclone separator.....	6
Figure 2.4.	Tangential gas velocity profile for a reverse flow cyclone	9
Figure 2.5.	Vertical gas velocity profile for a reverse flow cyclone.....	9
Figure 2.6.	Radial gas velocity profile for a reverse flow cyclone	9
Figure 2.7.	Static and total pressure profile for a reverse flow cyclone	9
Figure 2.8.	A typical fractional efficiency curve for a cyclone	13
Figure 2.9.	Forces acting on a particle in a cyclone.....	14
Figure 2.10.	Cyclone efficiency vs. w_f/w_f^* from Bath (1956).....	16
Figure 2.11.	Cyclone design parameters vs. pressure drop factor P ($H = 4D$)	23
Figure 2.12.	Cyclone design parameters vs. pressure drop factor P ($H = 5D$)	23
Figure 2.13.	Cyclone design parameters vs. pressure drop factor P ($H = 6D$)	24
Figure 2.14.	Common types of cyclone entry	28
Figure 2.15.	Fines eductor.....	29
Figure 2.16.	Common dust discharge systems.....	30
Figure 2.17.	Inlet duct designs.....	30
Figure 3.1.	Tea Making Process at St. Coombs Factory, Thalawakelle, Sri Lanka	34
Figure 3.2.	Schematic drawing of the TRI-CCC Fluidized Bed tea dryer.....	36
Figure 4.1.	Algorithm of the computer program.....	41
Figure 5.1.	A photograph of Installed laboratory scale cyclone separator system ..	45
Figure 6.1.	Comparison of PSD of Feed & Dust Collected (for Cement)	49
Figure 6.2.	Comparison of PSD of Feed & Dust Collected (for Quarry dust).....	49
Figure 6.3.	Comparison of fractional efficiencies obtained by experiments and predicted with the computer program – for Cement.....	50
Figure 6.4.	Comparison of fractional efficiencies obtained by experiments and predicted with the computer program – for Quarry dust.....	50
Figure 6.5.	Comparison of Overall Efficiency - Experimental and Predicted.....	52
Figure 6.6.	Comparison of efficiencies with particle density	56
Figure 6.7.	Comparison of efficiencies with pressure drop	57
Figure 6.8.	Variation of Geometry Parameter, C with H/D Ratio	59
Figure 6.9.	Relationship between Reynolds number and Stokes number.....	61
Figure 6.10.	Fractional efficiency comparison for customized design and Lapple's design.....	63
Figure 6.11.	Behaviour of Inertia parameter as with the Pressure drop	66
Figure 6.12.	Predictions for dust having $\mu = 6.45$ and $\sigma = 3.08$	67
Figure 6.13.	Predictions for dust having $\mu = 11.53$ and $\sigma = 5.38$	68
Figure 6.14.	Predictions for dust having $\mu = 13.25$ and $\sigma = 5.77$	68
Figure 6.15.	Predictions for dust having $\mu = 8.83$ and $\sigma = 3.44$	69
Figure 6.16.	Predictions for dust having $\mu = 25.28$ and $\sigma = 6.96$	69
Figure 6.17.	Predictions for dust having $\mu = 35.02$ and $\sigma = 16.12$	70

LIST OF TABLES

Table 2.1. Equations for predicting pressure loss as number of inlet velocity heads, ΔH ...	12
Table 2.2. Resultant equations derived and assumptions made for solving Equation (10) .	18
Table 2.3. Comparison of standard designs for reverse flow cyclones.....	21
Table 3.1. Ambient air quality standards	38
Table 5.1. Operating conditions of the pilot scale cyclone separator - Inputs to “CycDesign”.....	43
Table 5.2. Design parameters of the pilot scale cyclone separator - output from “CycDesign”.....	44
Table 5.3. Tested dust samples and collection points	46
Table 6.1. Comparison of overall efficiency - experimental and predicted.....	52
Table 6.2. Comparison of fractional efficiency with the gas flow rate.....	54
Table 6.3. Comparison of fractional and overall efficiency with the gas temperature.	55
Table 6.4. Relationship between gas temperature, gas density and gas viscosity.....	55
Table 6.5. Effect of dimensions and process design changes on pressure drop, efficiency, and cost.....	58
Table 6.6. Operating conditions for the designs in Figure 6.10.....	63
Table 6.7. Increase of fractional efficiency as with H/D ratio	64
Table 6.8. Increase of fractional efficiency as with pressure drop assumed.....	65

