## **CONTENTS**

Ch	apter	Content	Page
		Title Page	i
		Certificate of Approval	ii
		Certificate	iii
		Declaration	iv
		Curriculum Vitae	$\mathbf{v}$
		Acknowledgement	vi
		List of Symbols	vii
		List of Abbreviations	X
		Abstract	xii
		Contents	xiv
		List of Figures	xxiii
		List of Tables	xxix
1		Introduction	
	1.0	Structural Organizations of the Thesis	1
	1.1	Introduction	1
	1.2	Spices	1
	1.3	Fenugreek	2
	1.4	Black Pepper	4
	1.5	Production Status of Fenugreek and Black Pepper	5
	1.6	Export Status of Fenugreek and Black Pepper	6
	1.7	Physical Properties of Fenugreek and Black Pepper	6
	1.8	Thermal Properties of Fenugreek and Black Pepper	7
	1.9	Flow Behavior of Fenugreek and Black Pepper Powders	8
	1.10	Comparative Study on Grinders	9
	1.11	Degradation Behaviour of Fenugreek and Black Pepper	10
	1.12	Objectives	10
2		Review of Literature	11
	2.0	Review of Literature	11
	2.1	Fenugreek and Black Pepper	11
	2.2	Volatile Compounds Found in Fenugreek and Black Pepper	15
	2.3	Properties of Spice Seeds	16

2.3.1	Geometrical Dimension of Seeds	18
2.3.2	Sphericity and Roundness of Seeds	19
2.3.3	Specific Gravity of Seeds	19
2.3.4	Volume, Surface and Specific Surface Area of Seeds	20
2.3.5	Thousand Seeds Weight	20
2.3.6	Densities and Porosities of Seeds and its Powder	20
2.3.7	Static Coefficient of Friction of Seeds	21
2.3.8	Aspect Ratio of Seeds	21
2.3.9	Terminal Velocity of Seeds	21
2.3.10	Textural Properties	21
2.3.10	(i) Hardness of Seeds	22
2.3.10	(ii) Fracturability of Seeds	22
2.3.10	(iii) Cohesiveness of Seeds	22
2.3.10	(iv) Gumminess of Seeds	22
2.4.0	Thermal properties of Seeds	22
2.4.1	Thermal Conductivity, Specific Heat and Diffusivity of Spices	23
2.4.2	Ambient and Cryogenic Grinding of Spices	24
2.4.3	Various Types of Grinders for Spice Grinding	27
2.4.3	(a) Rotor Mill	28
2.4.3	(b) Hammer Mill	28
2.4.3	(c) Pin Mill	28
2.4.3	(d) Ball Mill	29
2.4.4	Grinding Time	29
2.4.5	Feed Rate of Grinding	29
2.4.6	Total Surface Area before and after Grinding of Seeds	29
2.4.7	Overall Power Consumptions in Ambient and Cryo-Grinding	30
2.4.8	Specific Energy Consumptions in Ambient and Cryo-Grinding	31
2.5.0	Flow Behaviour of Powders	31
2.5.1	Particle Size Analysis of Ambient and Cryogenically Ground	33
	Powders	
2.5.2	Hausner Ratio of Powders	33

	2.5.3	Carr Index of Powders	33
	2.5.4	Compressibility Index of Powders	33
	2.5.5	Angle of Repose of Powders	33
	2.5.5	(i) Static Angle of Repose of Powders	36
	2.5.5	(ii) Dynamic Angle of Repose of Powders	34
	2.5.5	(iii) Drained Angle of Repose of Powders	34
	2.5.6	Glass Transition of Volatile Oil	34
	2.6.0	Quality Degradation of Powders	35
	2.6.1	Color Loss of Powders	35
	2.6.2	Aroma and Flavor Degradation of Powders	35
	2.6.3	Overall Acceptability of Powders	36
	2.6.4	Change in Weight of Powders	36
	2.6.5	Antioxidant Activities of Powders	36
	2.7	Conclusions from Review of Literature	36
3		Materials and Methods	37
	3.0	Materials and Methods	37
	3.1	Sample Preparation for Physical and Thermal Properties	37
		Determination	
	3.2	Physical Properties of Fenugreek and Black Pepper Seeds	37
	3.2.1	Dimensions of Fenugreek and Black Pepper Seeds	38
	3.2.2	Equivalent Diameter of Fenugreek and Black Pepper Seeds	38
	3.2.3	Sphericity of Fenugreek and Black Pepper Seeds	38
	3.2.4	Roundness of Fenugreek and Black Pepper Seeds	38
	3.2.5	Specific Gravity of Fenugreek and Black Pepper Seeds	39
	3.2.6	Specific Surface Area of Fenugreek and Black Pepper Seeds	39
	3.2.7	Surface Area of Fenugreek and Black Pepper Seeds	39
	3.2.8	Seed Volume of Fenugreek and Black Pepper Seeds	39
	3.2.9	Thousand Seed Weight of Fenugreek and Black Pepper Seeds	39
	3.2.10	Bulk Density of Fenugreek and Black Pepper Seeds	40
	3.2.11	True Density of Fenugreek and Black Pepper Seeds	40
	3.2.12	Porosity of Fenugreek and Black Pepper Seeds	40

3.2.13	Static Coefficient of Friction of Seeds	40
3.2.14	Aspect Ratio of Fenugreek and Black Pepper Seeds	41
3.2.15	Terminal Velocity of Fenugreek and Black Pepper Seeds	41
3.2.16	Determination of Textural Properties of Seeds	42
3.2.17	Hardness of Fenugreek and Black Pepper Seeds	42
3.2.18	Cohesiveness of Seeds	43
3.3	Bulk Thermal Properties of Fenugreek and Black Pepper Seeds	43
3.3.1	Bulk Thermal Conductivity of Fenugreek and Black Pepper	43
3.3.2	Specific Heat of Fenugreek and Black Pepper Seeds	44
3.3.3	Bulk Thermal Diffusivity of Fenugreek and Black Pepper Seeds	45
3.4	Evaluations of Suitable Grinder for Ambient and Cryo-Grinding	45
3.4.1	Sample Preparation for Comparative Study on Grinders'	45
	Suitability Evaluations	
3.4.2	Grinders with Working Principle, Usefullness and Pictures	46
3.4.2	(a) Rotor Mill	47
3.4.2	(b) Hammer Mill	47
3.4.2	(c) Pin Mill	47
3.4.2	(d) Ball Mill	48
3.4.3	Cryo-treatment and Grinding	48
3.4.4	Determination of Particle Size Distribution by Sieve Analysis and	49
	Particle Size Analyzer	
3.4.5	Statistical analysis	50
3.4.5	(a) Arithmatic Mean Diameter of Fenugreek and Black Pepper	51
	Powders	
3.4.5	(b) Geometric Mean Diameter of Fenugreek and Black Pepper	51
	Powders	
3.4.5	(c) Root Mean Square Diameter of Fenugreek and Black Pepper	51
	Powders	
3.4.5	(d) Harmonic Mean Diameter of Fenugreek and Black Pepper	51
2 4 5	Powders  (a) The Standard Designation	50
3.4.5	(e) The Standard Deviation	52
3.4.5	(f) Skew	52

3.4.5	(g) Kurtosis	52
3.4.5	(h) Mean Deviation or Linear Varienace or Mean Square Standard	52
	Deviation	
3.4.5	(i) D[3, 0] The Volume- or Mass-Related Mean Value of the	53
	Quantity Distribution or the Volume Mean Diameter	
3.4.5	(j) D[3, 2] Volume-Related Mean Value of the Area Distribution	53
3.4.5	(k) D[4, 3) Weighted Average of the Volume Distribution	54
	Equivalent Volume	
3.4.6	Fenugreek and Black Pepper Powder Particle Diameter – before	54
	and after Grinding	
3.4.7	Fenugreek and Black Pepper Powder Particle Density	54
3.4.8	Fenugreek and Black Pepper Grinding Time	55
3.4.9	Feed Rate for Fenugreek and Black Pepper Grinding	55
3.4.10	Total Surface Area of Fenugreek and Black Pepper before	55
	Grinding	
3.4.11	Total Surface Area Created in AG and CG of Fenugreek and	55
	Black Pepper	
3.4.12	Power consumed in AG and CG of Fenugreek and Black Pepper	55
3.4.13	Specific Energy Consumption for Fenugreek and Black Pepper	57
	Grinding	
3.4.14	Temperature in AG and CG	56
3.5.0	Flow Behaviour of Fenugreek and Black Pepper Powder	57
3.5.1	Powder Preparation from Fenugreek and Black Pepper Seeds for	57
	Flow Properties Determination	
3.5.2	Particle Size Analysis of AG and CG Fenugreek and Black Pepper	57
	Powder	
3.5.3	Angle of Slide of Fenugreek and Black Pepper Powders	57
3.5.4	Bulk Density of Poured Fenugreek and Black Pepper Powders	58
3.5.5	Bulk Density of Compacted Fenugreek and Black Pepper Powders	59
3.5.6	Porosity of Fenugreek and Black Pepper Powders	59
3.5.7	Hausner Ratio of Fenugreek and Black Pepper Powders	59
3.5.8	Carr Index of Fenugreek and Black Pepper Powders	59

	3.5.9	Compressibility Index of Fenugreek and Black Pepper Powders	60
	3.5.10	Angle of Repose of Fenugreek and Black Pepper Powders	60
	3.5.11	Static Angle of Repose of Fenugreek and Black Pepper powders	60
	3.5.12	Dynamic Angle of Repose of Fenugreek and Black Pepper	61
		Powders	
	3.5.13	Drained Angle of Repose of Fenugreek and Black Pepper Powders	61
	3.5.14	Glass Transition Temperature of Fenugreek and Black Pepper	61
		Powders	
	3.6.0	Quality Degradation of Fenugreek and Black Pepper Powder	62
	3.6.1	Degradation of Fenugreek and Black Pepper Powders	62
	3.6.2	Chroma Meter Color Values of Fenugreek and Black Pepper	63
		Powder	
	3.6.3	Aroma and Flavor Degradation observation of Fenugreek and	64
		Black Pepper Powders	
	3.6.4	Overall Acceptability of Fenugreek and Black Pepper Powders	64
	3.6.5	Variations in Moisture Content of Fenugreek and Black Pepper	64
		Powders	
	3.6.6	Variations in Fenugreek and Black Pepper Powders Weight	64
	3.6.7	Antioxidant Activities of Fenugreek and Black Pepper Powders	64
4		Results and Discussion	
	4.0	Results and Discussion	65
	4.1	Physical Properties of Fenugreek and Black Pepper Seeds	65
	4.1.1	Geometrical Dimensions: Seed Size, Shape and Thickness	65
	4.1.2	Sphericity of Fenugreek and Black Pepper Seeds	66
	4.1.3	Roundness of Fenugreek and Black Pepper Seeds	67
	4.1.4	Specific Gravity of Fenugreek and Black Pepper Seeds	68
	4.1.5	Seed Volume of Fenugreek and Black Pepper Seeds	69
	4.1.6	Specific Surface Area of Fenugreek and Black Pepper Seeds	70
	4.1.7	Surface Area of Fenugreek and Black Pepper Seeds	71
	4.1.8	Thousand Seed Weight of Fenugreek and Black Pepper	72
	4.1.9	Bulk Density of Fenugreek and Black Pepper Seeds	72
	4.1.10	True Density of Fenugreek and Black Pepper Seeds	73

4.1.11	Porosity of Fenugreek and Black Pepper Seeds	74
4.1.12	Angle of Repose of Fenugreek and Black Pepper Seeds	75
4.1.13	Coefficient of Static Friction of Seeds	76
4.1.14	Aspect Ratio of Fenugreek and Black Pepper Seeds	78
4.1.15	Terminal Velocity of Fenugreek and Black Pepper Seeds	79
4.1.16	Hardness of Fenugreek and Black Pepper Seeds	79
4.1.18	Cohesiveness of Fenugreek and Black Pepper Seeds	80
4.2.1	Thermal Conductivity of Fenugreek and Black Pepper	81
4.2.2	Effect of Bulk Density and Temperature on Thermal Conductivity	83
	of Fenugreek and Black Pepper Seeds	
4.2.3	Specific Heat of Fenugreek and Black Pepper Seeds	84
4.2.4	Thermal Diffusivity of Fenugreek and Black Pepper Seeds	85
4.3	Evalutions of Best Grinder Suitabile for Ambient and Cryogenic	87
	Ginding	
4.3.1	Change in Moisture Contents in Powders	87
4.3.2	Equivalent Diameter of Fenugreek and Black Pepper Seeds	88
4.3.3	Particle Size Analysis of Fenugreek and Black Pepper	89
4.3.4	Sieve Analysis of Powders obtained by Grinding in Rotor Mill	89
4.3.5	Particle Sieve Analysis of Powder obtained by Grinding in Ball	93
	Mill	
4.3.6	Particle Sieve Analysis of Powder obtained by Grinding in	95
	Hammer Mill	
4.3.7	Particle Sieve Analysis of Powder obtained by Grinding in Pin	96
	Mill	
4.3.8	Statistical Analysis	96
4.3.9	Moisture Change during Grinding	101
4.3.10	Grinding Time and Number of Revolutions obtained from Energy	101
	Meter	
4.3.11	Feed Rate in Grinding Fenugreek and Black Pepper	102
4.3.12	Total Suface Area before and after Grinding	103
4.3.13	Overall Power Consumption in AG and CG of Seeds	103
4.3.14	Specific Power Consumptions in Fenugreek and Black Pepper	104

	•	Grinding	-
	4.3.15	LN <sub>2</sub> Consumption in Liters per Kilogram of Seeds	105
	4.3.16	Temperature Rise in Ambinet and Cryogrinding	106
	4.3.17	Colour Values of Powders Obtained from different Grinders	106
	4.3.18	Sieve Chocking and Particle Sticking Problems	106
	4.3.19	Beneficial Features and Drawbacks of different Grinders	109
	4.4.0	Flow Behaviour of Fenugreek and Black Pepper Powders	112
	4.4.1	Particle Size Analysis and its Influences on the Powder	113
		Flowability	
	4.4.2	Angle of Slide of AG and CG Fenugreek and Black Pepper	121
		Powders	
	4.4.3	Densities and Volumes of Fenugreek and Black Pepper Powders	122
	4.4.4	Porosity of Fenugreek and Black Pepper Powders	123
	4.4.5	Hausner Ratio of Fenugreek and Black Pepper Powders	124
	4.4.6	Carr Index of Fenugreek and Black Pepper Powders	125
	4.4.7	Compressibility Index of Fenugreek and Black Pepper Powders	126
	4.4.8	Angle of Repose of Fenugreek and Black Pepper Powders	127
	4.4.9	Static Angle of Repose of Fenugreek and Black Pepper Powders	127
	4.4.10	Dynamic Angle of Repose of Fenugreek and Pepper Powders	128
	4.4.11	Drained Angle of Repose of Fenugreek and Black Pepper Powders	129
	4.5.0	Quality Degradation Studies of Fenugreek and Pepper Powders	130
	4.5.1	Selection of Sample Storing Materials, Sample Packing and	130
		Quality Analysis	
	4.5.2	Changes in Color of Fenugreek and Black Pepper Powders	131
	4.5.3	Sensory evaluations (SE)	134
	4.5.4	Changes in MC of Fenugreek and Black Pepper Powder Sample	136
	4.5.5	Changes in Weight of Fenugreek and Black Pepper Powders	136
	4.5.6	Antioxidant Activities of Fenugreek and Black Pepper Powders	136
5		Summary and Conclusions	
	5.0	Summary of results	138
	5.1	Physical and Textural Properties of Fenugreek and Pepper Seeds	138

5.2	Thermal Properties of Fenugreek and Black Pepper Seeds	139
5.3	Comparative Study on Various Grinders used for AG and CG	139
5.4.0	Flow Behavior of AG and CG Powders	140
5.4.1	Flow Properties of Fenugreek Powder	140
5.4.2	Flow Properties of Black Pepper Powders	141
5.5	Degradation Behaviour of Fenugreek and Black Pepper Powders	141
5.6	Conclusions	142
5.7	Suggestions for Future Work	144
	REFERENCESES	145
	Appendices	
	Appendix – A	159
	Appendix – B	160
	Appendix – C	161
	Contribution (Publication)	162