

Contents

Chapter		Page
	List of Tables	v
	List of Figures	vi
	List of Plates	viii
	List of Symbols and Abbreviations	ix
	Abstract	xii
I	INTRODUCTION	1
II	REVIEW OF LITERATURE	5
	2.1 Parboiling of Rice	5
	2.1.1 Parboiling process	5
	2.1.2 Quality characteristics of parboiled rice	7
	2.1.3 Physical Properties of parboiled paddy	8
	2.1.4 Equilibrium moisture content	8
	2.1.5 Characteristics of parboiled paddy	9
	2.1.6 Drying of parboiled paddy	10
	2.1.7 Recirculation type dryers	12
	2.1.8 Multi stage drying of paddy	12
	2.1.9 Theory of fluidization of the particles	14
	2.1.10 Diffusion coefficient	14
	2.1.11 Heat and mass transfer	15
	2.1.12 Mathematical models for drying	15
	2.1.13 Shrinkage behavior of rice kernels	17
	2.2 Infrared Drying	17
	2.3 Vibration assisted drying	19
	2.3.1 Common industrial dryers using vibration	20
	2.3.2 Advantages of vibro-fluidized bed dryers	21
	2.3.3 Vibration Mechanics	21
	2.3.4 Mathematical models for vibration assisted dryers	23
	2.3.5 Thermal processes	24
	2.3.6 Applications of vibro-fluidized bed dryer (VFB)	26
	2.4 Summary of the Literature Review	27
III	THEORETICAL CONSIDERATIONS	28

3.1	Mechanical dryers	28
3.2	Heated Air Dryers	29
3.3	Mechanism of hot air drying	29
3.4	Drying Rate Periods	30
	3.4.1 Constant-rate-drying period	31
	3.4.2 Critical moisture content	31
	3.4.3 Falling Rate Drying Period	32
3.5	Theoretical drying equations	32
3.6	Method of slopes	35
3.7	Semi-theoretical drying equations	39
3.8	Temperature dependence of moisture diffusivity	40
3.9	Heat and Moisture Transfer Coefficients	40
	3.9.1 Heat transfer coefficient	41
	3.9.2 Mass transfer coefficient	41
3.10	Fluidization of paddy	42
3.11	Working Principle of a Vibration Assisted Dryer	42
	3.11.1 Features of vibration assisted dryer	42
3.12	Vibration Assisted Dryers	43
3.13	Vibration of Granular Material	44
IV	MATERIALS AND METHODS	46
4.1	Raw Materials	46
	4.1.1 The physical properties of the Swarna parboiled paddy	46
4.2	Moisture content determination	47
4.3	Still Air Drying of Parboiled Paddy	47
	4.3.1 Drying of Parboiled Paddy	48
4.4	Analysis of drying data	48
4.5	Still Air Drying of Parboiled Paddy with Vibration	49
	4.5.1 Cam mechanism for vibration	49
	4.5.2 The experimental design vibration assisted dryer in a still air	50
4.6	Drying of Parboiled Paddy with Vibration by convection	51
	4.6.1 Design of the vibration assisted dryer	51
	4.6.2 Drying chamber dimensions	51
	4.6.3 Design for the Air blowing unit	56

4.6.4	Calculation of heat requirement	57
4.6.5	Development of the experimental set up for the vibrating platform assembly for the dryer	57
4.6.6	Selection of the Motor	59
4.7	Design of spring and selection of motor for the still air drying with cam	60
4.8	The dryer assembly	60
4.9	Instrumentation	63
4.10	The Experimental Design of Vibration Assisted Dryer with Changing Air velocity	63
4.11	Response Surface Methodology and Optimization	64
4.11.1	Analysis of data	65
4.11.2	Optimization	65
4.12	Infrared drying of Paddy	66
4.12.1	Infrared moisture analyzer.	67
4.12.2	Preparation for drying in Infrared moisture analyzer	
4.13	Experimental Procedure	67
4.13.1	Parameters involved in the study	68
4.13.2	Data Analysis	68
4.13.3	Milling Quality Evaluation	69
4.13.4	Cooking quality	70
4.14	Optimization of process parameters	70
	RESULTS AND DISCUSSION	71
5.1	Still Air drying	71
5.1.1	Variation of moisture content with drying time	71
5.1.2	Variation of moisture ratio with drying time	76
5.1.3	Variation of drying constant and diffusivity with drying temperature	79
5.1.4	Activation energy	86
5.1.5	Heat and moisture transfer coefficients	88
5.2	Infrared Moisture Analyzer Drying	89
5.2.1	Infra red drying experiment 1.	90
5.2.2	Infra red drying experiment 2	92
5.2.3	Time Required for Drying of Parboiled Paddy	95

5.3	Vibration Assisted Still Air Drying	98
5.3.1	Drying of parboiled paddy with vibration	98
5.3.2	The drying data analysis with exponential model and Page model	98
5.3.3	Quality evaluation of dried rice	101
5.3.4	Optimization of vibration assisted drying of paddy in 3 mm layer	110
5.3.5	Response models for 6 mm and 9 mm layer	112
5.3.6	Optimization of vibration assisted drying of paddy in 6 mm layer and 9 mm layer	113
5.4	Drying of parboiled paddy with vibration under forced convection	114
5.4.1	Analysis of the drying data for vibration dryer with changing Air flow rate	114
5.4.2	Response 1 Drying time required to reduce to the moisture up to 22 % db	117
5.4.3	Percentage of broken- response 2	120
5.4.4	Response 3 Cooking time required for the grain dried up to 22 % db in the	123
5.4.5	Optimization of the vibration assisted drying	126
VI	SUMMARY AND CONCLUSIONS	131
	BIBLIOGRAPHY	141
	APPENDICES	157
	Appendix A Specifications of instruments/equipments used in experimentation	157
	Appendix B The experimental drying data of parboiled paddy	159
	Appendix C Analysis of experimental drying data parboiled paddy	199
	Appendix D Analysis of Experimental Parboiled Paddy Drying Data	219
	Appendix E Details of the Statistical Terms	224