

Contents

1	PHYSICAL AND CHEMICAL PROPERTIES OF MILK AND OTHER PRODUCTS	1
	Heat Capacity of Milk; Density of Milk; Freezing of Milk Products; Boiling Point of Milk; Expansion of Milk; Agitation of Milk; Viscosity of Milk; Effect of Metals on Milk; Metals Available for Use; Effect of Metals on Flavor of Milk; Toxicity of Metals; Durability of Metal; Corrosion of Metals; Passivation.	
2	SIMPLE MECHANICAL PRINCIPLES	21
	Elementary Quantities; Compound Quantities; Energy; Centrifugal Force; Torque; Time Rate; Horsepower-Hour.	
3	POWER TRANSMISSION	27
	Horsepower Transmitted by Shafts and Belts; Chains and Gears; Calculations of Shaft Speeds; Drive Troubles.	
4	ELECTRICAL POWER AND EQUIPMENT	34
	Electrical Terms and Units; Electric Motors; Alternating-Current Motors; Single-Phase Universal Motor; Single-Phase Split-Phase Motor; Single-Phase Capacitor Motor; Single-Phase Repulsion-Induction Motor; Polyphase Alternating-Current Squirrel-Cage Motors; Wound-Rotor-Type Motors; Synchronous Motors; Geared Head Motors; 3A Sanitary Standards for Electric Motor and Attachments; Motor Management; The Trouble Light; Motor-Starting Equipment; Circuit Breakers for Electrical Equipment; Fuses; Wiring; Electrical Heating; Electrical Control; Electric Power Costs and Management; Sterilizing with Light; Lighting	

for the Dairy Plant; The RLM Standard Dome Reflector; The Silvered-Bowl Diffuser; The Glassteel Diffuser; The Vapor-Proof Lighting Fixture; Fluorescent Lighting.

5 HYDRAULICS AND PUMPING**59**

Definition of Terms; Classes of Pumping; Types of Pumps; Sanitary Pumps; 3A Standards for Centrifugal- and Positive-Rotary-Type Pumps; Figuring Pumping Problems; Determination of Total Dynamic Head; Simple Pump Calculations; Selection of Pumps; Care and Upkeep of Pumps; Pipe, Pipe Fittings, Fitting, and Soldering; Standard Piping; Cutting and Fitting Ordinary Pipe; Threading Pipe; Assembling Pipe; Brass and Copper Tubing; Sanitary Piping; Glass Pipe and Fittings; Cleaning of Glass Pipelines; Plastic Pipe and Tubing; Sanitary Fittings; Welding of Sanitary Pipe; Flow Characteristics through Sanitary Pipe and Fittings; 3A Standards for Sanitary Pipe and Fittings; Fitting Sanitary Pipe; Solderless or Expanded-Type Fittings; Soldering; Solder; Soldering Flux; Heating the Work; Soldering Procedure; Soldering Sanitary Pipe; Reseating of Sanitary Pipe on Fittings; Care of Sanitary Pipe and Fittings; Flow Meters; General Types of Flow Meters.

6 HEAT MEASUREMENT, TRANSFER, AND CONTROL**104**

Definition of Heat; Kinds of Heat; Heating by Conduction; Calculation of Heat Transfer; Effect of the Surface Film; Heating by Convection; Heating by Radiation; Temperature-Measuring Equipment; Checking the Recording-Thermometer Accuracy; Care and Maintenance of Recording Thermometers; Temperature-Control Equipment; High-Temperature Short-Time Pasteurizer Control; The Automatic Batch Pasteurizer Control; Electrical Controllers; Direct-Acting Controllers; Care of Air-Operated Temperature-Control Equipment.

7 STEAM AND ITS USE IN THE DAIRY**129**

Steam; Physical Properties; Formation of Steam; Forms of Steam; Thermal Properties of Steam; Effect of Pressure on the Boiling Point; Steam Table; Calculating Steam Requirements; Steam Boiler; Classification of Boilers; Steam Generators; Electric Steam Boiler; Capacity and Rating of Boilers; Boiler Strength and Safety; Boiler Accessories and Fittings; Fuels; Coal; Firing Coal-Fired Boilers; Fuel Oil; Gas Fuel; Fuel Storage; Combustion of Fuels; Pounds of Fuel per Pounds of Steam; Maintaining Clean Heating Surface; Water Treatment; Boiler Blowdown; Proper Burning of the Fuel; Carryover; Utilization of Steam; Steam

Piping; Steam Traps; Low-Pressure Steam; Condensate Return; Miscellaneous Components or Auxiliary Devices; Culinary Steam Producers; Figuring Steam Requirements; Steam Power from Process Steam; Economics of Steam Systems.

8 PRINCIPLES OF REFRIGERATION

172

Cooling by Ice and Salt; Cooling by Dry Ice; Artificial Refrigeration; Cooling by Evaporation of a Volatile Liquid; Compression Refrigeration System; Evaporator; Ammonia Pump Circulation; Compressor; Capacity of Vertical Ammonia Compressors; Oil in Refrigeration Systems; Compressor Oil; The Pour Point; The Flash Point; Use of Additives and Other Methods to Improve Natural Characteristics of Oil; Impurities in the System; Condenser; The Evaporative Condenser; Cooling Towers and Spray Ponds; Booster Compressor; Individual Compressors; Factors Affecting the Economy of Operation; First Aid for Ammonia Accidents; Charging Anhydrous Ammonia into a Refrigeration Plant; Withdrawing Anhydrous Ammonia from a Plant into Empty Cylinders; Testing Anhydrous Ammonia; Adjustments on Automatically Controlled Machines; Utilization of Refrigeration; The Direct Expansion System; Thermostatic Expansion Valve; Adjustment of the Thermoexpansion Valve System; Pressure-Type Expansion Valve; Ammonia Back-Pressure Regulator Valve; Low-Pressure Refrigeration; Thermal Electric Refrigeration; Brine System; Brine; Desirable Properties of Brines; Properties of Sodium Chloride; Properties of Calcium Chloride; Calcium Chloride Has a Rather Sharp, Salty, Puckery, Bitter Taste; General Care of Brines; Brine Corrosion; Corrosion Retarders—Sodium Chromate; Electrolytic Action; Foaming of Brine; Sediment in Brine Tank; Ammonia Leakage; Types of Brine Systems; Brine-Circulating System; Brine-Storage System; Calculation of Refrigeration Stored in Brine; Congealing Tank System of Refrigeration; Sweet-Water Cooling System; Flake- or Chopped-Ice Machines; Refrigeration Accessories; Ammonia; Detecting Ammonia Leaks; Specification for Ammonia; Freon; Method of Detecting Leaks; Calculation of Size of Refrigeration-Machine Requirements; Calculation of Amount of Expansion Coils.

9 INSULATION AND COLD-STORAGE ROOMS

246

Rating of Insulation; Insulation Application and Management; Insulation of Refrigeration Pipes; Cold-Storage Rooms; Hardening Room Floors; Application of Insulation; Cold-Storage-Room Coils; Management of Cold Rooms; Defrosting of Coils; Storage Capacity of Hardening Rooms and Milk Cooling Rooms.

- 10 HEATERS—COOLERS, HEAT-EXCHANGE EQUIPMENT, AND MILK-STORAGE TANKS** 268
- Types of Heat Exchangers; The Surface Heat Exchanger; Tubular Heat Exchangers; Plate-Heat Exchangers; The Barrel-Type Heat Exchanger; Roswell Heater; Swept or Scraped Surface Heat Exchangers; The Flat-Surface-Type Heat Exchanger; Vat or Tank-Heat Exchangers; The "Cold-Wall" Type of Milk Tank; Direct-Contact Steam Heaters; Management and Care of Heat Exchangers; The Regenerator; Storage Tanks.
- 11 ICE-CREAM FREEZING EQUIPMENT** 297
- Characteristics of the Ice-Cream Mix; Calculation of the Freezing Point of Mixes; Calculation of Refrigeration Requirements of Mixes; Absorption of Air; Resistance to Body Breakdown; Ice-Cream Freezer; The Batch Freezer; Freezing Cylinder; Refrigeration Control; Dasher; Batch-Freezer Performance; Dull Scraper Blades; Removing the Burr; Removing Excess Heel; Freezing Too Stiff; Effect of Special Mixes; Soft Ice Cream; Continuous Freezer; Overrun Control System; Continuous-Freezer Accessories; Piping for Ice-Cream Lines; Automatic Filling; Management of Continuous Freezers; Care of the Ammonia System; Calculation of Refrigeration Done in a Freezer; Conditions Which Affect the Capacity of Ice-Cream Freezers; Refrigeration Required per Pound of Ice Cream; Effect of Power to Drive Dasher; Effect of Refrigerant Temperature on Capacity; Effect of Ice-Cream-Mix Temperature on Capacity; Effect of the Ice-Cream-Drawing Temperature; Effect of Overrun on the Capacity of Ice-Cream Freezers.
- 12 HOMOGENIZERS** 334
- General Effect of Homogenization; Effect of Homogenization on Fat Break-Up and Dispersion; Judging the Efficiency of Homogenization; The United States Public Health Service Standard for Homogenized Milk; Effect of Homogenization on Curd Tension; Other Uses for the Homogenizer; Homogenizing Valve; Theory of Homogenization; Homogenizer Pumps; Lubrication of the Homogenizer; Sanitary Construction of Homogenizers; Effect of Pressure on Power Consumption; Care and Management of Homogenizers; Cleaning the Homogenizer; Homogenizer Accessories; Sonic Vibrator; 3A Standards for Homogenizers.
- 13 PASTEURIZING EQUIPMENT** 359
- Effect of Time and Temperature on Bacterial Reduction; Cream Line and Conditions Affecting It; Long Hold or Vat Pasteurizing;

Agitation in Pasteurizers; Pasteurizer Controls; Special Design Requirements for Vat-Type Pasteurizers; Homogenizing Vat Pasteurized Products; Advantages and Disadvantages of Vat Pasteurizers; High-Temperature, Short-Time Pasteurizers; Ultra-High-Temperature Pasteurizers; Accessory Equipment Integrated into HTST and UHT Pasteurizers; Homogenizers in HTST and UHT Systems; Homogenizer as the Timing Pump; Continuous Ice-Cream Mix Making; Heating and Circulating Apparatus; Care of Pasteurizing and Flavor Treating Equipment; Flavor Treating Systems; The Vacreator; Steam Supply; Milk Sterilization and Canning by Aseptic Methods; Radiation; The Continuous Milk Sterilizing Line.

14 EVAPORATING AND DRYING EQUIPMENT 394

Atmospheric Concentrators; Vacuum Pan; Condenser; The Low-Temperature Concentrator; Concentration by Freezing; Falling Film Evaporator; Multiple-Effect Evaporators; Use of Heat in Condensing; Sensible Heat; Latent Heat of Vaporization; Energy Expanded in the Vacuum Pump; Milk Dryer; Drum or Roller Dryer; Spray Dryer; Cyclone Separator; Bag Filters; Rogers Dryer; The Swenson Dryer; Heat Balance of Drying Equipment; Equipment for Instantizing Milk Powder.

15 CAN WASHING AND STERILIZING EQUIPMENT 426

Receiving-Room Equipment—Bulk Tanks; Principles of Operation of Can Washers; Effect of Stoppage of Jets; Effect of Solution Temperature; Maintenance of Washing Solutions; Water Treatment; Standards for Milk-Can Sterilization; Can-Washer Cleaning; Steaming of Cans; Principal Properties of Steam Which Affect Can-Washing Operations; Effect of Steam Pressure; Uniformity of Heating of Cans; Drying of Cans; Power Requirements of Washers; Care of Can Washers; Selection of Washers; Rotary Can Washer; Straight-Away Can Washer; The "Conservation Washer"; Weigh Cans and Receiving-Room Equipment; 3A Standards for Weigh Cans and Receiving Tanks to Be Used for Raw Milk; Sanitizing Equipment for the Dairy Plant; Sterilizing Procedure; Dairy-Farm-Equipment Sterilizers; Milk Cans; Bulk-Milk Tanks; 3A Standards for Bulk Tanks; Milk Transportation; Tank Trucks; Weighing and Receiving Milk.

16 BOTTLE WASHERS, FILLERS, AND CAPPERS 458

Milk Bottles; Paper Milk Containers; Bottle Washers; Jet-Type Washer; Soaker-Type Washer; Types of Soaker Washers; Bottle-

Washer Solutions; Care and Management of Washers; Use of Cleaners; Sterilization; Bottle Fillers; Bottle Capper; Paper-Bottle Fillers; Care of the Bottle Filler and Capper.

- 17 CREAM- AND BUTTER-HANDLING EQUIPMENT 476**
- Churning Equipment; Principles of Churning; Churn Construction; Churn Barrel; Whipped Butter; Churn Drive; Types of Churns; Care of Churns; Cleaning the Churn; Setting the Churn; Continuous Buttermaking Equipment; Centrifugal Cream Separator; Types of Separators; Milk Clarifiers; Care of the Cream Separator and Clarifier; Centrifugal Equipment; Cream and Milk Filters; 3A Sanitary Standards for Milk and Milk-Product Filters; 3A Sanitary Standards for Seamless and Welded Tin-Coated Can-Type Milk Strainers; Butter Cutter.
- 18 CHEESE PLANT EQUIPMENT 498**
- Cheese Manufacture; Cheese Vats; Cheese Curd Mill; The Agitator; The Cheese Press; Care of Cheese Vats and Equipment; Automated Cheese Manufacture; Casein Manufacture System.
- 19 MATERIALS HANDLING FLUID MILK PLANT 509**
- Systems Analysis; Installation of Infloor Pan; Onfloor Conveyor; Types of Floors for Areas Using Infloor or Onfloor Conveyor; Conveyor Chain and Drives; Power Unit Horsepower Calculations; Take-up Units; Special Conveyor Components; Automatic Case-Stacking Equipment; Case Unstackers; Automatic Bottle Casers; Filling and Casing Area; The Refrigerated Storage Area; The Hollywood—or “Island Cooler” Storage Box; The “Long Dock” Method; Case Storage and Bottle-Washing Area; How the Basic Principles Were Applied; Distribution Stations; Stack Handling in the Small Plant; Top Chain-Loop Systems for Stack Handling in Refrigerated Storage and Empty Case Storage Areas; Palletizing Milk Cases; Handling of Dispenser Milk Containers; Handling of Ice Cream; Vending Machines
- 20 FOOD PLANT AUTOMATION 555**
- Piping System Design for In-Place Cleaning; Process Piping Requirements; CIP Circuits; Supply-Return System; Materials and Connections; Installation; Recirculating Equipment; Automatic CIP Systems; Air-Actuated Valves and Controls; Management Considerations.

21	EQUIPMENT MAINTENANCE	584
	Economical Maintenance; Importance of Following Manufacturer's Instructions; Operators Should Be Responsible for Their Machines; Common Maintenance Problems; Lubrication; Indications of Faulty Operation of Antifriction Bearings; Corrosion of Equipment; Tools; Stuffing Boxes; Packing; Care of Tinned Surfaces; Retinning of Surfaces; Care of Milk Cans; Setting of Machinery.	
22	DAIRY PLANT DESIGN, CONSTRUCTION, MATERIALS, AND UTILIZATION	600
	Plant Site; Building; Functional Design; Space Requirements for Milk Plants; Space Required for Hardening Rooms; Floors; Walls; Drains; Windows; Doors; Insulation of Cold Rooms; Mold Prevention; Lighting; Ventilation; Condensation; Conveyors; Secondary Equipment; Bulk Milk Receiving; Arrangement of Processing Equipment; Checking the Layout; Time and Motion Studies on Labor Efficiency; Suggested Design Check List; Selection of the Equipment; Water Supply; Water Defects; Testing for the Hardness of Water; Difficulties Due to Use of Hard Water; The Base-Exchange or Zeolite Treatment; Water Containing Iron; Silica and Gases in Water; Hot-Water Requirements; Water Piping; Utilization of Water; Cost of Water; Disposal of Dairy-Plant Wastes; Calculation of Size of Treatment Plant.	
	APPENDIX	641
	INDEX	661

Note. References from the proceedings of the various Dairy Engineering Conferences and the Food Engineering Conference may be obtained from copies on file in the Engineering Society's Library, 345 E. 47 St., New York 18, N.Y., or from Library Michigan State University, East Lansing, Mich.