

Contents

<i>Foreword</i>	v
<i>Preface</i>	vii
<i>Nomenclature</i>	xv

PART 1 GENERAL PRINCIPLES

Chapter 1 Introduction	3
1.1 Advent and aim of freeze-drying	3
1.2 Early history	4
1.3 Developments	5
1.4 Stages of the constant-pressure freeze-drying process	8
1.5 Important analytical theories for the process	14
Chapter 2 Classical theory of sublimation	16
2.1 Introduction	16
2.2 Characteristics of sublimation	21
2.3 Collision theory applied to sublimation problems	31
2.4 Analysis of freezable water in freezing and drying	35
Appendix 2.I Vapour space diffusion	44
Appendix 2.II Vapour-pressure equation	46
Appendix 2.III Kinetic theory of sublimation and condensation	48
Chapter 3 Heat transfer	52
3.1 Internal and surface heat transfer in sublimation	52
3.2 Steady-state model of heat transfer	53

3.3	Transient model of heat transfer	57
3.4	Control of the heat supply	62
3.5	Heat conduction in condensation	65
3.6	Convection heating—atmospheric freeze-drying	68
3.7	Heating methods	71
3.8	Pressure dependence of gas thermal conductivity	79
3.9	Measurement of thermal conductivity	85
	Appendix 3.I Moving-interface boundary theory of heat conduction	89
 Chapter 4 Vapour transfer		 94
4.1	Gas diffusion in porous materials	94
4.2	Cylindrical capillary model	94
4.3	Momentum transfer theory	101
4.4	Measurement of porosity and permeability	106
4.5	Desorption in secondary drying	115
	Appendix 4.I Theory for molecular collisions in a porous material	121
	Appendix 4.II Theory of desorption	125
 Chapter 5 Drying rate		 129
5.1	Introduction	129
5.2	Heat transfer	130
5.3	Vapour transfer	135
5.4	Heat and vapour transport	140
5.5	Shorter solutions for back-face heating	147
5.6	Constant- and falling-rate drying periods in the course of freeze-drying	153
5.7	Superheated vapour	159
 PART 2 CYCLIC-PRESSURE OPERATION		
 Chapter 6 Physical mechanism of cyclic-pressure freeze-drying		 165
6.1	Introduction	165
6.2	Vacuum pressure cycles	169

Chapter 7 Analytical cyclic process	175
7.1 Introduction	175
7.2 Condensation pumping—flash flow	175
7.3 Iterative analysis of cyclic process	178
7.4 Temperature wave: high-pressure heating and vapour flash cooling	183
7.5 Time-constant: optimal pressure cycle	185
Appendix 7.I Analysis of flash flow	189
Appendix 7.II Iterative analysis of flash flow	191
Chapter 8 Drying plant and equipment	197
8.1 Drying plant features and operation	197
8.2 Equipment design	203
8.3 Cyclic process—comments and criticisms	207

PART 3 APPLICATIONS

Chapter 9 Laboratory apparatus and techniques	215
9.1 Introduction	215
9.2 Simple units with traps	215
9.3 Freeze-dryers for microbiological research	217
9.4 Developments in freeze-drying for histology	225
9.5 End-point—control of final water content	234
Chapter 10 Drying plant and equipment for freeze-drying	239
10.1 Pilot freeze-dryers	239
10.2 Tray freeze-dryers	242
10.3 Accelerated freeze-dryers	243
10.4 Tunnel freeze-dryers	246
10.5 Drying plant with “inner” heating	249
10.6 Vacuum-spray freeze-dryer	251
10.7 Drying costs	252

Chapter 11 Foodstuffs	257
11.1 Physical characteristics and preparation of foods for freeze-drying	257
11.2 General preparative treatments	259
11.3 Special preparative treatments	261
11.4 Pre-concentration processes	265
11.5 Vacuum cooling and freezing	276
11.6 Rate of freezing	280
Chapter 12 Effects of freeze-drying	289
12.1 Shrinkage in drying	289
12.2 Flavour retention	294
12.3 Substrate loss—theory of particle entrainment	306
12.4 Rehydration	310
Chapter 13 Miscellaneous aspects of freeze-drying	314
13.1 Process control—crystallization and melting points	314
13.2 Residual moisture	321
13.3 Measurement of end-point	324
Chapter 14 Biological aspects	328
14.1 Living organisms	328
14.2 Chemical degradation in storage	332
14.3 Hazards during drying and storage	337
<i>References</i>	341
<i>Additional research references</i>	362
<i>Author index</i>	367
<i>Subject index</i>	375