Contents

Preface . . . . .

1 Review of Mathematical Principles and Applications in Food Processing 1
1.1 Graphing and Fitting Equations to Experimental Data 1
1.1.1 Variables and Functions 1
1.1.2 Graphs 2
1.1.3 Equations 2
1.1.4 Linear Equations 3
1.1.5 Nonlinear Equations 4
1.2 Linearization of Nonlinear Equations 5
1.3 Nonlinear Curve Fitting 6
1.4 Logarithmic and Semi-Logarithmic Graphs 8
1.5 Intercept of Log-Log Graphs 14
1.6 Roots of Equations 16
1.6.1 Polynomials 16
1.6.1.1 Quadratic Equation 16
1.6.1.2 Factoring 16
1.6.1.3 Iteration Technique 17
1.7 Programming Using Visual BASIC for Applications in Microsoft Excel 18
1.8 Use of Spreadsheets to Solve Engineering Problems 20
1.9 Simultaneous Equations 23
1.9.1 Substitution 23
1.9.2 Elimination 23
1.9.3 Determinants 25
1.10 Solutions to a System of Linear Equations Using the "Solver" Macro in Excel 27
1.11 Power Functions and Exponential Functions 29
1.12 Logarithmic Functions 31
1.13 Differential Calculus 32
1.13.1 Definition of a Derivative 32
1.13.2 Differentiation Formulas 33
1.13.3 Maximum and Minimum Values of Functions 35
1.14 Integral Calculus 38
1.14.1 Integration Formulas 38

1.14.2 Integration Techniques 39
1.14.2.1 Constants 39
1.14.2.2 Integration by Parts 39
1.14.2.3 Partial Fractions 39
1.14.2.4 Substitution 39
1.15 Graphical Integration 41
1.15.1 Rectangular Rule 41
1.15.2 Trapezoidal Rule 42
1.15.3 Simpson's Rule 42
1.16 Differential Equations 43
1.17 Finite Difference Approximation of Differential Equations 44
Problems 46
Suggested Reading 50

2 Units and Dimensions 51
2.1 Definition of Terms 51
2.2 Systems of Measurement 52
2.3 The SI System 52
2.3.1 Units in SI and Their Symbols 52
2.3.2 Prefixes Recommended for Use in SI 53
2.4 Conversion of Units 54
2.4.1 Precision, Rounding-Off Rule, Significant Digits 54
2.5 The Dimensional Equation 55
2.6 Conversion of Units Using the Dimensional Equation 55
2.7 The Dimensional Constant (G_c) 57
2.8 Determination of Appropriate SI Units 57
2.9 Dimensional Consistency of Equations 58
2.10 Conversion of Dimensional Equations 59
Problems 61
Suggested Reading 63

3 Material Balances 65
3.1 Basic Principles 65
3.1.1 Law of Conservation of Mass 65
3.1.2 Process Flow Diagrams 65
3.1.3 System Boundaries 67
3.1.4 Total Mass Balance 67
3.1.5 Component Mass Balance 69
3.1.6 Basis and "Tie Material" 71
3.2 Material Balance Problems Involved in Dilution, Concentration, and Dehydration 72
3.2.1 Steady State 72
3.2.2 Volume Changes on Mixing 73
3.2.3 Continuous Versus Batch 74
3.2.4 Recycle 75
3.2.5 Unsteady State 77
3.3 Blending of Food Ingredients 80
3.3.1 Total Mass and Component Balances 80

5.4 Properties of Saturated and Superheated Steam 138
5.4.1 The Steam Tables 139
5.4.1.1 The Saturated Steam Table 139
5.4.1.2 The Superheated Steam Tables 141
5.4.1.3 Double Interpolation from Superheated Steam Tables 142
5.4.2 Properties of Steam Having Less Than 100% Quality 143
5.5 Heat Balances 143
Problems 149
Suggested Reading 152

6 Flow of Fluids 153
6.1 The Concept of Viscosity 153
6.2 Rheology 155
6.2.1 Viscometry 155
6.2.1.1 Viscometers Based on Fluid Flow Through a Cylinder 156
6.2.1.2 Derivation of the Poiseuille Equation 156
6.2.1.3 Velocity Profile and Shear Rate for a Power Law Fluid 158
6.2.1.4 Glass Capillary Viscometers 160
6.2.1.5 Forced Flow Tube or Capillary Viscometry 161
6.2.1.6 Evaluation of Wall Effects in Tube Viscometry 166
6.2.1.7 Glass Capillary Viscometer Used as a Forced Flow Viscometer 167
6.2.2 Effect of Temperature on Rheological Properties 170
6.2.3 Back Extrusion 172
6.2.4 Determination of Rheological Properties of Fluids Using Rotational Viscometers 178
6.2.4.1 Wide Gap Rotational Viscometer 180
6.2.4.2 Wide Gap Viscometer with Cylindrical Spindles 182
6.3 Continuous Viscosity Monitoring and Control 186
6.3.1 Capillary Viscometer 186
6.3.2 Rotational Viscometer 186
6.3.3 Viscosity Sensitive Rotameter 186
6.4 Flow of Falling Films 187
6.4.1 Films of Constant Thickness 187
6.4.2 Time-Dependent Film Thickness 189
6.4.3 Processes Dependent on Fluid Film Thicknesses 192
6.5 Transportation of Fluids 193
6.5.1 Momentum Balance 193
6.5.2 The Continuity Principle 195
6.6 Fluid Flow Regimes 196
6.6.1 The Reynolds Number 196
6.6.2 Pipes and Tubes 198
6.6.3 Frictional Resistance to Flow of Newtonian Fluids 198
6.6.4 Frictional Resistance to Flow of Non-Newtonian Fluids 202
6.6.5 Frictional Resistance Offered by Pipe Fittings to Fluid Flow 204
6.7 Mechanical Energy Balance: The Bernoulli Equation 205
6.8 Pumps 210
6.8.1 Types of Pumps and Their Characteristics 210

6.8.2 Factors to Be Considered in Pump Selection 211
6.8.3 Performance Curves of Pumps 212
Problems 214
Suggested Reading 221

7 Heat Transfer 223
7.1 Mechanisms of Heat Transfer 223
7.1.1 Heat Transfer by Conduction 223
7.1.2 Fourier's First Law of Heat Transfer 223
7.1.3 Estimation of Thermal Conductivity of Food Products 224
7.1.4 Fourier's Second Law of Heat Transfer 226
7.1.5 Temperature Profile for Unidirectional Heat Transfer Through a Slab 228
7.1.6 Conduction Heat Transfer Through Walls of a Cylinder 230
7.1.7 The Temperature Profile in the Walls of a Cylinder in Steady-State Heat Transfer 230
7.1.8 Heat Transfer by Convection 232
7.1.8.1 Natural Convection 232
7.1.8.2 Forced Convection 233
7.1.9 Heat Transfer by Radiation 233
7.1.9.1 Types of Surfaces 233
7.1.9.2 Effect of Distance Between Objects on Heat Transfer 236
7.1.9.3 Radiant Energy Exchange 236
7.1.10 Microwave and Dielectric Heating 240
7.1.10.1 Energy Absorption by Foods in a Microwave Field 240
7.1.10.2 Relative Heating Rates of Food Components 242
7.2 Temperature Measuring Devices 243
7.2.1 Liquid-in-Glass Thermometers 244
7.2.2 Fluid-Filled Thermometers 245
7.2.3 Bimetallic Strip Thermometers 245
7.2.4 Resistance Temperature Devices (RTDs) 245
7.2.5 Thermocouples 245
7.2.6 Radiation Pyrometers 247
7.2.7 Accurate Temperature Measurements 247
7.3 Steady-State Heat Transfer 248
7.3.1 The Concept of Resistance to Heat Transfer 248
7.3.2 Combined Convection and Conduction: The Overall Heat Transfer Coefficient 249
7.4 Heat Exchange Equipment 251
7.4.1 Heat Transfer in Heat Exchangers 253
7.4.2 The Logarithmic Mean Temperature Difference 254
7.5 Local Heat Transfer Coefficients 257
7.5.1 Dimensionless Quantities 257
7.5.2 Equations for Calculating Heat Transfer Coefficients 258
7.5.2.1 Simplified Equations for Natural Convection to Air or Water 258
7.5.2.2 Fluids in Laminar and Turbulent Flow Inside Tubes 259
7.5.2.3 Heat Transfer to Non-Newtonian Fluids in Laminar Flow 259

7.5.2.4 Adapting Equations for Heat Transfer Coefficients to Non-Newtonian Fluids 260
7.6 Unsteady-State Heat Transfer 267
7.6.1 Heating of Solids Having Infinite Thermal Conductivity 267
7.6.2 Solids with Finite Thermal Conductivity 268
7.6.3 The Semi-Infinite Slab with Constant Surface Temperature 269
7.6.4 The Infinite Slab 271
7.6.5 Temperature Distribution for a Brick-Shaped Solid 271
7.6.6 Use of Heissler and Gurney-Lurie Charts 272
7.7 Calculating Surface Heat Transfer Coefficients from Experimental Heating Curves 275
7.8 Freezing Rates 276
Problems 279
Suggested Readings 282

8 Kinetics of Chemical Reactions in Foods 285
8.1 Theory of Reaction Rates 285
8.2 Types of Reactions 286
8.2.1 Unimolecular Reactions 286
8.2.2 Bimolecular Reactions 287
8.2.3 Reversible Reactions 287
8.3 Enzyme Reactions 289
8.4 Reaction Order 291
8.4.1 Zero-Order Reactions 291
8.4.2 First-Order Reactions 291
8.4.3 Second-Order Reactions 292
8.4.4 *n*th-Order Reactions 292
8.5 Reactions Where Product Concentration Is Rate Limiting 292
8.6 The Reaction Rate Constant 293
8.7 Temperature Dependence of Reaction Rates 294
8.7.1 The Arrhenius Equation 294
8.7.2 The Q_{10} Value 295
8.7.3 The z Value 295
8.8 Determination of Reaction Kinetic Parameters 296
8.9 Use of Chemical Reaction Kinetic Data for Thermal Process Optimization 297
Problems 298
Suggested Reading 299

9 Thermal Process Calculations 301
9.1 Processes and Systems for Stabilization of Foods for Shelf-Stable Storage: Systems Requirements 301
9.1.1 In-Can Processing 301
9.1.1.1 Stationary Retorts 301
9.1.1.2 Hydrostatic Cooker 302
9.1.1.3 Continuous Agitating Retorts 303
9.1.1.4 Crateless Retorts 304
9.1.2 Processing Products Packaged in Flexible Plastic Containers 306

9.1.3 Processing in Glass Containers 308
9.1.4 Flame Sterilization Systems 308
9.1.5 Continuous Flow Sterilization: Aseptic or Cold Fill 308
9.1.6 Steam-Air Mixtures for Thermal Processing 309
9.2 Microbiological Inactivation Rates at Constant Temperature 310
9.2.1 Rate of Microbial Inactivation 310
9.2.2 Shape of Microbial Inactivation Curves 310
9.2.3 Sterilizing Value or Lethality of a Process 314
9.2.4 Acceptable Sterilizing Value for Processes 314
9.2.5 Selection of Inoculation Levels in Inoculated Packs 316
9.2.6 Determination of D Values Using the Partial Sterilization Technique 317
9.2.7 The Heat Resistance of Spoilage Microorganisms 318
9.2.8 F_0 Values Used in Commercial Sterilization of Canned Foods 319
9.2.9 Surface Sterilization 319
9.3 Effect of Temperature on Thermal Inactivation of Microorganisms 321
9.4 Inactivation of Microorganisms and Enzymes in Continuously Flowing Fluids 323
9.4.1 Time and Temperature Used in the Pasteurization of Fluid Foods 323
9.4.2 Microbial Inactivation in Continuously Flowing Fluids 326
9.4.3 Nutrient Degradation 329
9.4.4 High-Pressure Pasteurization 332
9.4.4.1 High-pressure Systems 332
9.4.4.2 High-pressure Pasteurization 334
9.4.4.3 High-Pressure Sterilization 335
9.4.5 Sterilization of Fluids Containing Discreet Particulates 336
9.5 Sterilizing Value of Processes Expressed as F_0 336
9.6 Thermal Process Calculations for Canned Foods 337
9.6.1 The General Method 337
9.6.2 Heat Transfer Equations and Time-Temperature Curves for Canned Foods 340
9.6.3 Plotting Heat Penetration Data 343
9.6.3.1 Determination of f_h and j 343
9.6.3.2 Determination of f_c and j_c 344
9.6.4 Formula Methods for Thermal Process Evaluation 349
9.6.4.1 Stumbo's Procedure 350
9.6.4.2 Hayakawa's Procedure 350
9.6.5 Evaluation of Probability of Spoilage from a Given Process 363
9.6.5.1 Constant Temperature Processes 363
9.6.5.2 Process Temperature Change 364
9.7 Broken Heating Curves 365
9.8 Quality Factor Degradation 371
Problems 374
Suggested Reading 377

10 Refrigeration 379
10.1 Mechanical Refrigeration System 379
10.1.1 Principle of Operation: The Heat Pump 379
10.1.2 Refrigerants 380

10.1.3 The Refrigeration Cycle 382
10.1.4 The Refrigeration Cycle as a Series of Thermodynamic Processes 383
10.1.5 The Refrigeration Cycle on the Pressure/Enthalpy Diagram for a Given Refrigerant 383
10.1.5.1 Example Problems on the Use of Refrigerant Charts 386
10.1.6 The Condenser and Evaporator 392
10.1.6.1 Problems with Heat Exchange in Systems Using Zeotropic Refrigerants 393
10.1.7 The Compressor 395
10.2 Refrigeration Load 397
10.2.1 Heat Incursion Through Enclosures 397
10.2.2 Heat Incursion Through Cracks and Crevices 397
10.2.3 Heat Incursion Through Open Doors 398
10.2.4 Heat Generation 399
10.2.5 The Unsteady-State Refrigeration Load 401
10.3 Commodity Storage Requirements 402
10.4 Controlled Atmosphere Storage 402
10.4.1 Respiration 402
10.4.2 CA Gas Composition 404
10.5 Modified Atmosphere Packaging 409
Problems 410
Suggested Reading 411

11 Evaporation 413
11.1 Single-Effect Evaporators 413
11.1.1 The Vapor Chamber 414
11.1.2 The Condenser 415
11.1.3 Removal of Noncondensible Gases 417
11.1.4 The Heat Exchanger 419
11.2 Improving the Economy of Evaporators 422
11.2.1 Vapor Recompression 423
11.2.2 Multiple-Effect Evaporators 423
11.3 Entrainment 427
11.4 Essence Recovery 428
Problems 428
Suggested Reading 429

12 Dehydration 431
12.1 Water Activity 431
12.1.1 Thermodynamic Basis for Water Activity 431
12.1.2 Osmotic Pressure 433
12.1.3 Water Activity at High Moisture Contents 433
12.1.3.1 Gibbs-Duhem Equation 436
12.1.3.2 Other Equations for Calculating Water Activity 438
12.1.4 Water Activity at Low Moisture Contents 439
12.1.4.1 The GAB (Guggenheim-Anderson-deBoer) Equation 440
12.1.4.2 Other Equations for Sorption Isotherms of Foods 442

12.2 Mass Transfer 443
12.2.1 Mass Diffusion 443
12.2.2 Mass Transfer from Surfaces to Flowing Air 446
12.3 Psychrometry 449
12.3.1 Carrying Capacity of Gases for Vapors 449
12.3.2 The Psychrometric Chart 450
12.3.3 Use of Psychrometric Chart to Follow Changes in the Properties of Air-Water Mixtures Through a Process 452
12.4 Simultaneous Heat and Mass Transfer in Dehydration 453
12.5 The Stages of Drying 455
12.6 Prediction of Drying Times from Drying Rate Data 456
12.6.1 Materials with One Falling Rate Stage Where the Rate of Drying Curve Goes Through the Origin 456
12.6.2 Materials with More Than One Falling Rate Stage 458
12.6.3 The Constant Drying Rate 458
12.7 Spray Drying 461
12.7.1 Drying Times in Spray Drying 462
12.8 Freeze Drying 465
12.8.1 Drying Times for Symmetrical Drying 466
12.9 Vacuum Belt Dryer 469
Problems 470
Suggested Reading 473

13 Physical Separation Processes 475
13.1 Filtration 475
13.1.1 Filtrate Flow Through Filter Cake 476
13.1.2 Constant Pressure Filtration 478
13.1.3 Filtration Rate Model Equations for Prolonged Filtration When Filter Cakes Exhibit Time-Dependent Specific Resistance 482
13.1.4 Exponential Dependence of Rate on Filtrate Volume 482
13.1.5 Model Equation Based on Time-Dependent Specific Cake Resistance 484
13.1.6 Optimization of Filtration Cycles 485
13.1.7 Pressure-Driven Membrane Separation Processes 487
13.1.8 Membrane System Configurations 489
13.1.9 Transmembrane Flux in Pressure-Driven Membrane Separation Processes (Polarization Concentration and Fouling) 491
13.1.10 Solute Rejection 494
13.1.11 Sterilizing Filtrations 495
13.1.12 Ultrafiltration 497
13.1.13 Reverse Osmosis 498
13.1.14 Temperature Dependence of Membrane Permeation Rates 502
13.1.15 Other Membrane Separation Processes 502
13.2 Sieving 502
13.2.1 Standard Sieve Sizes 503
13.3 Gravity Separations 504
13.3.1 Force Balance on Particles Suspended in a Fluid 504

13.3.1.1 Buoyant Force 505
13.3.1.2 Drag Force 506
13.3.2 Terminal Velocity 507
13.3.3 The Drag Coefficient 507
Problems 510
Suggested Reading 511

14 Extraction 513
14.1 Types of Extraction Processes 513
14.1.1 Single-Stage Batch Processing 514
14.1.2 Multistage Cross-Flow Extraction 514
14.1.3 Multistage Countercurrent Extraction 514
14.1.4 Continuous Countercurrent Extractors 515
14.2 General Principles 516
14.2.1 Diffusion 516
14.2.2 Solubility 517
14.2.3 Equilibrium 517
14.3 Solid-Liquid Extraction: Leaching 518
14.3.1 The Extraction Battery: Number of Extraction Stages 518
14.3.2 Determination of the Number of Extraction Stages Using the Ponchon-Savarit Diagram 519
14.3.3 The Lever Rule in Plotting Position of a Mixture of Two Streams in an X-Y Diagram 520
14.3.4 Mathematical and Graphical Representation of the Point J in the Ponchon-Savarit Diagram 521
14.3.5 Mathematical and Graphical Representation of the Point P 521
14.3.6 Equation of the Operating Line and Representation on the X-Y Diagram 522
14.3.7 Construction of the Ponchon-Savarit Diagram for the Determination of the Number of Ideal Extraction Stages 523
14.4 Supercritical Fluid Extraction 528
14.4.1 Extraction Principles 529
14.4.2 Critical Points of Supercritical Fluids Used in Foods 530
14.4.3 Critical Point of Mixtures 530
14.4.4 Properties of Supercritical Fluids Relative to Gases 530
14.4.5 Supercritical Fluid Extraction Parameters 530
Problems 531
Suggested Reading 532

A.1 Conversion Factors Expressed as a Ratio 533

A.2 Properties of Superheated Steam 537

A.3 Saturated Steam Tables: English Units 539

A.4 Saturated Steam Tables: Metric Units 541

A.5 Flow Properties of Food Fluids 543

A.6 Psychrometric Chart: English Units 545

A.7 Psychrometric Chart: Metric Units 547

A.8 Average Composition of Foods (From USDA Handbook 8) 549

A.9 Thermal Conductivity of Construction and Insulating Materials 553

A.10 Thermal Conductivity of Foods 555

A.11 Spreadsheet Program for Calculating Thermophysical Properties of Foods from Their Composition 557

A.12 Correlation Equations for Heat Transfer Coefficients 559

A.13 Visual BASIC Program for Evaluating Temperature Response of a Brick-Shaped Solid 563

A.14 Visual BASIC Program for Evaluating Local Heat Transfer Coefficient from Temperature Response of a Brick-Shaped Solid 567

A.15 Thermal Conductivity of Water as a Function of Temperature 569

A.16 Density of Water as a Function of Temperature 571

A.17 Viscosity of Water as a Function of Temperature 573

Index 575