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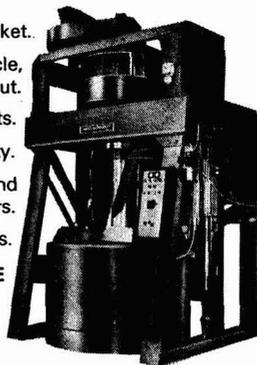
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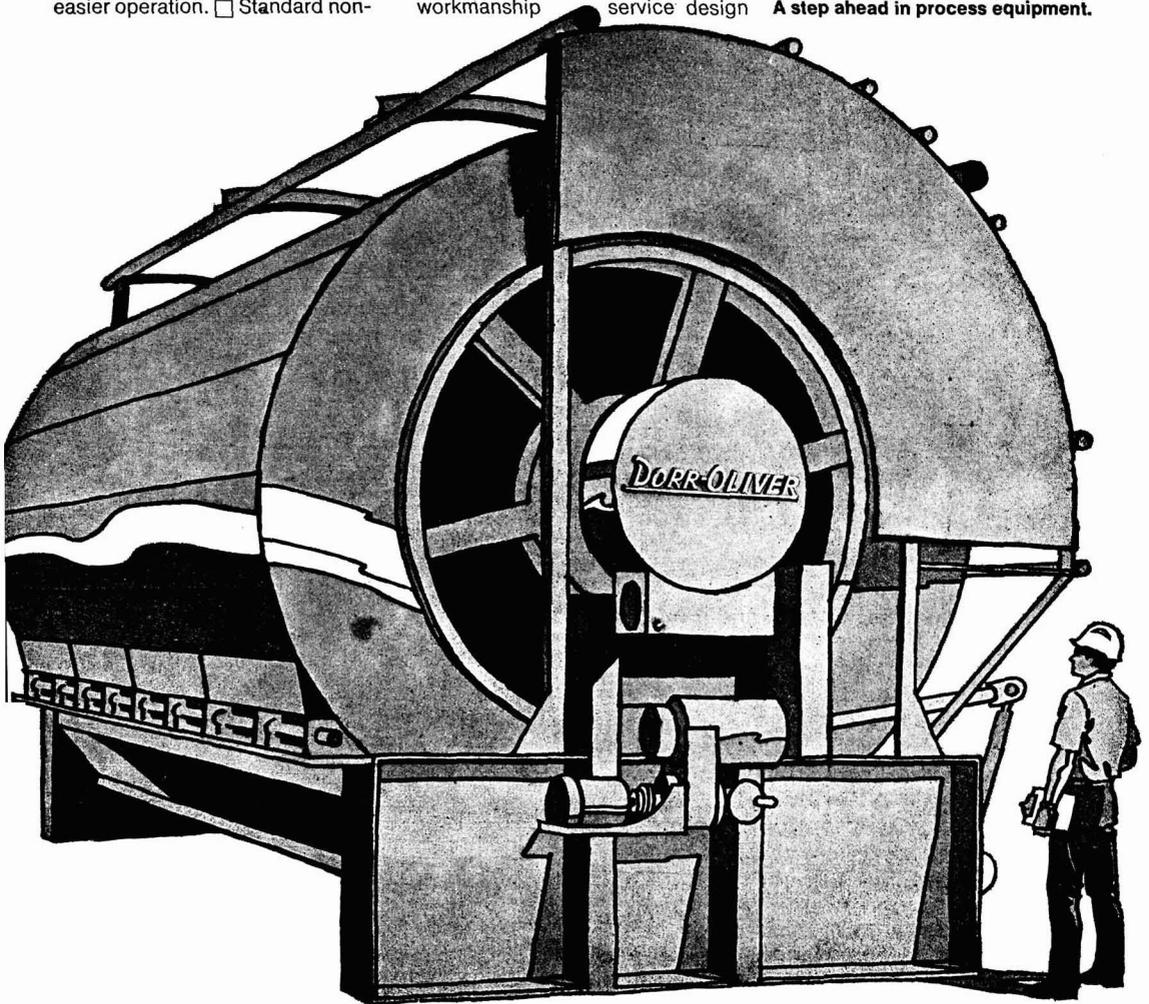
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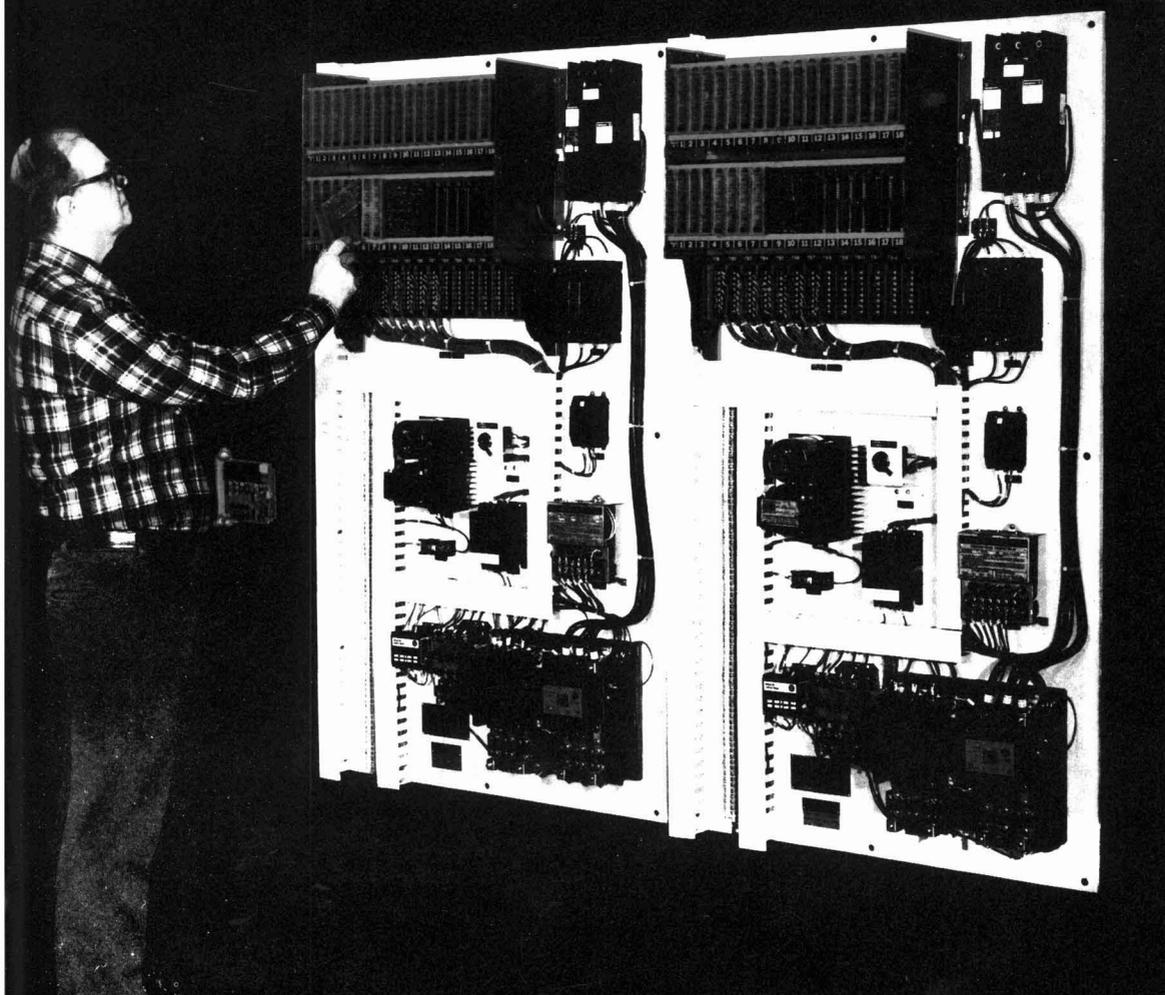
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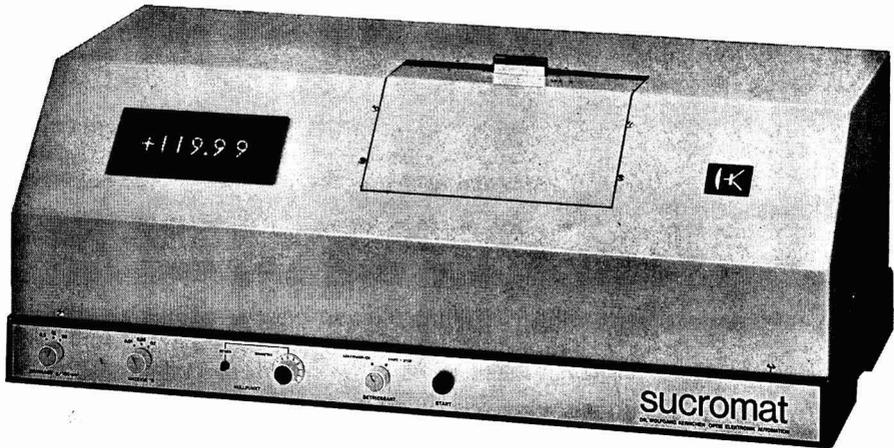


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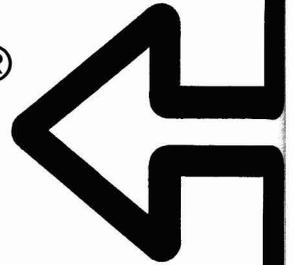
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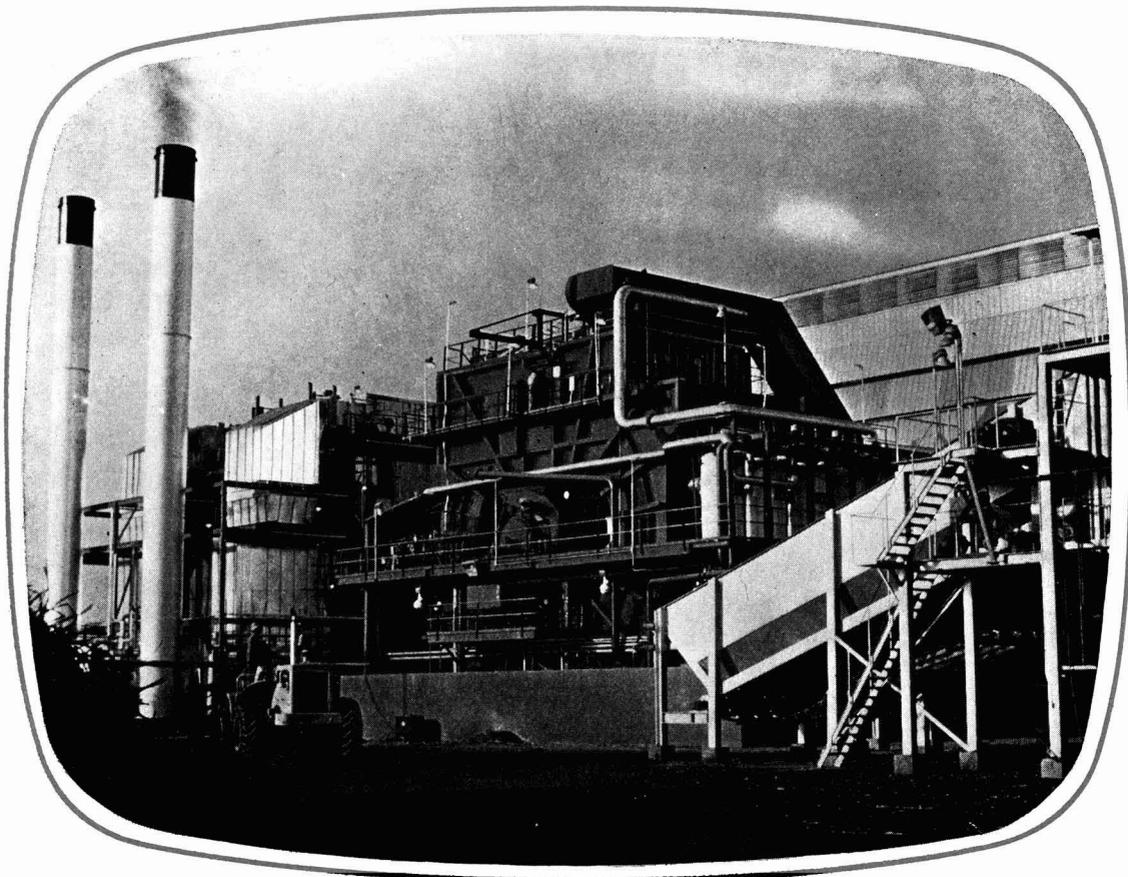


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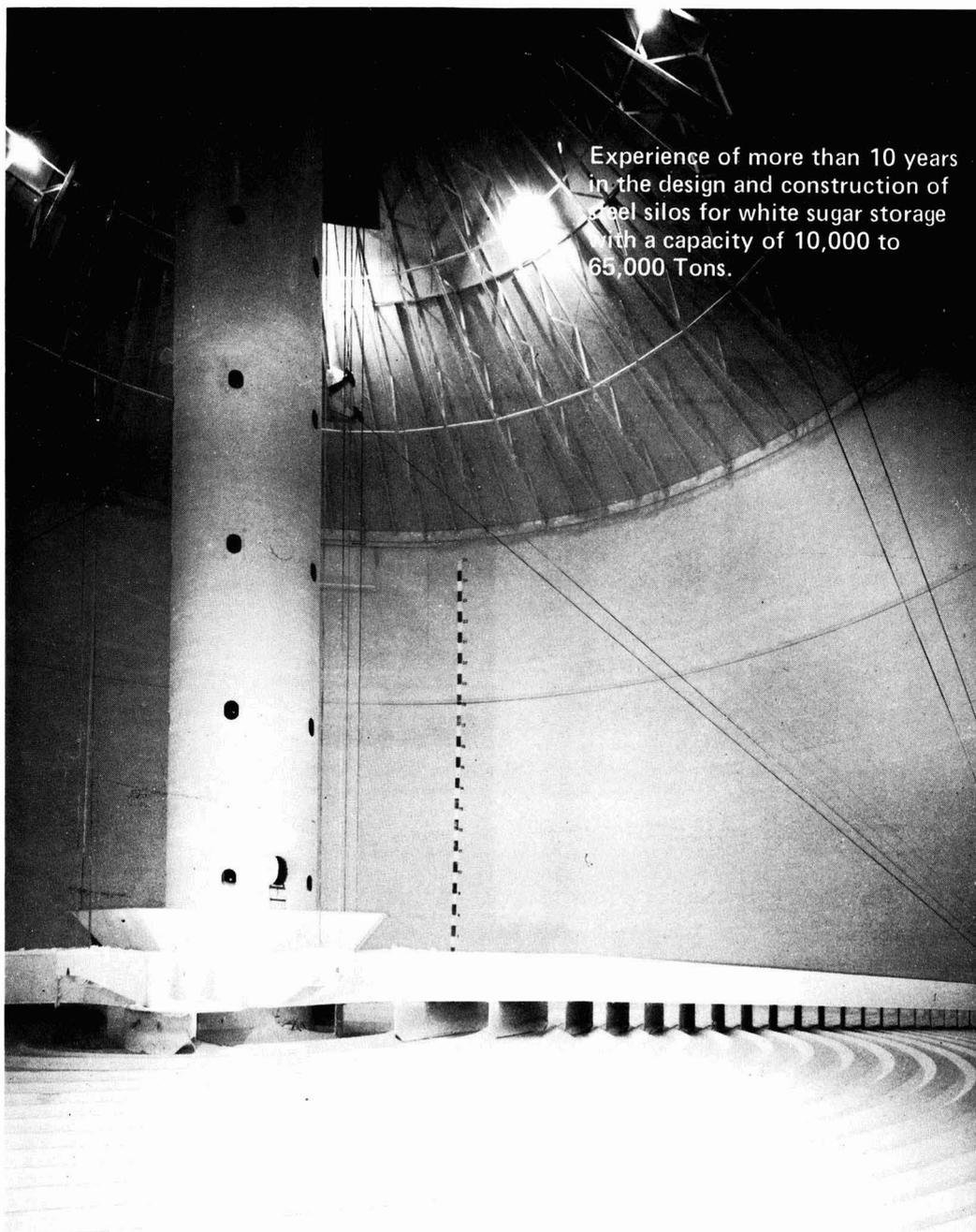
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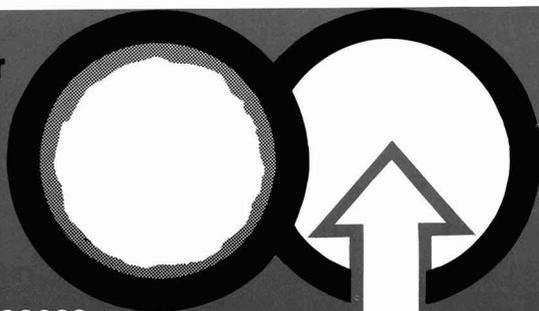


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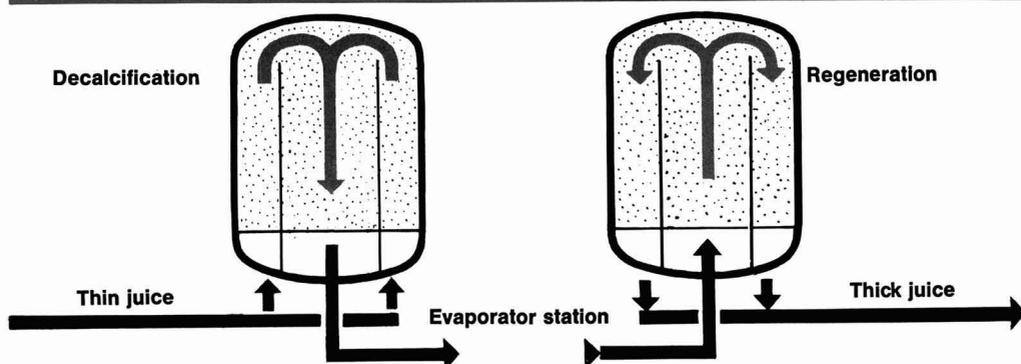
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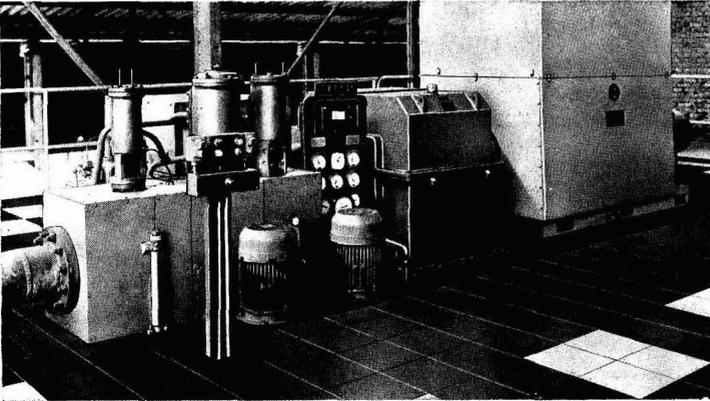
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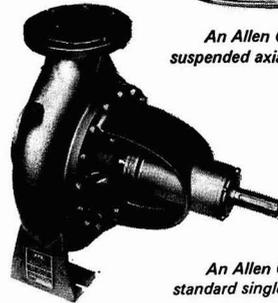
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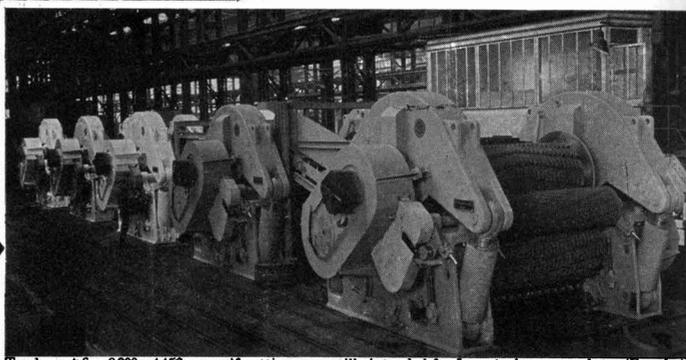
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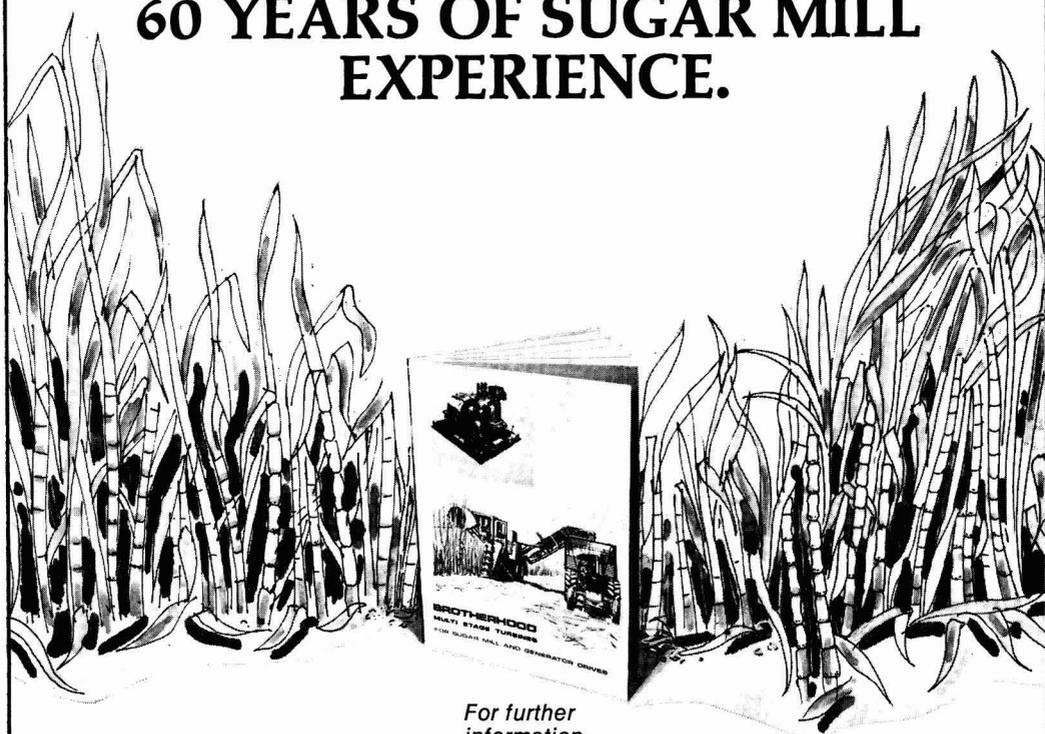
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* * *

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Contents

	PAGE
Notes and Comments	353

* * *

Physico-chemical properties of Egyptian sugar	355
By Mostafa A. Mohamed, Kamal A. Ham- mady and Salah H. Abou-el-Hawa	

Post-harvest inversion in different cane varieties	358
By R. S. Kanwar and J. K. Kapur	

Corrections at high temperatures to the refractive index of sucrose solutions	359
By Dov Basker	

Milling-cum-centrifuging of sugar cane for higher extraction	361
By M. Sterzinger and J. Zdarsky	
Part II	

* * *

Sugar cane agriculture	365
Sugar beet agriculture	371
Cane sugar manufacture	372
Beet sugar manufacture	375
Laboratory methods and Chemical reports	379
By-products	381
World sugar production estimates 1976/77	383
Philippines sugar exports	384
Trinidad sugar exports	384
Brevities	364, 384

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SOMMAIRES : ZUSAMMENFASSUNGEN : SUMARIOS

Propriétés physico-chimiques du sucre égyptien. M. A. MOHAMED, K. A. HAMMADY et S. H. ABOU-EL-HAWA. p. 355-357

On donne un bref compte rendu d'études sur les propriétés physico-chimiques d'échantillons de sucre blanc et de sucre raffiné égyptien et on discute les résultats. Alors que la qualité du sucre raffiné est comparable à celle du sucre raffiné produit dans d'autres pays, la qualité du sucre blanc est assez mauvaise. On mentionne les facteurs qu'il faut considérer pour établir les standards du sucre en Egypte; on considère que le spectre d'absorption en ultra-violet du sucre est un critère important dans l'évaluation de la qualité.

* * *

Inversion après récolte dans différentes variétés de canne. R. S. KANWAR et J. K. KAPUR. p. 358-359

On a déterminé les variations moyennes de la teneur en sucre, de la pureté, de la teneur en sucres réducteurs et du poids au cours d'un stockage allant jusqu'à neuf jours pour quatre variétés à la station de Recherches sur la Canne à Sucre de l'université agricole de Punjab. On discute les résultats présentés dans des tableaux.

* * *

Corrections de l'indice de réfraction des solutions de saccharose à hautes températures. D. BASKER. p. 359-360

On donne une méthode pour ajuster les valeurs de l'indice de réfraction de solutions de saccharose à 5-90% poids/poids, obtenues à des températures de 30-90°C, aux valeurs correspondantes à une température standard de 20°C. On donne un exemple qui illustre la méthode utilisée pour le calcul.

* * *

Broyage et centrifugation de la canne à sucre pour une meilleure extraction. IIème Partie. M. STERZINGER et J. ZDARSKY. p. 361-364

On décrit l'évaluation biologique de la rupture des cellules de la bagasse par un moulin n° 1 suivant ou précédant un défibreur et/ou un "Gorator" plus une centrifugeuse. On discute les résultats obtenus. On a trouvé que le procédé d'extraction à froid avec broyage et centrifugation était prometteur malgré des imperfections dans l'équipement de l'installation pilote.

Physikalisch-chemische Eigenschaften des ägyptischen Zuckers. M. A. MOHAMED, K. A. HAMMADY und S. H. ABOU-EL-HAWA.

S. 355-357

Untersuchungen über die physikalisch-chemischen Eigenschaften an Proben von ägyptischem Weisszucker und ägyptischer Raffinade werden beschrieben und die erhaltenen Ergebnisse diskutiert. Während gefunden wurde, dass die Qualität der Raffinade der in anderen Ländern vergleichbar ist, war die Qualität des Weisszuckers relativ gering. Es werden die Faktoren aufgeführt, die bei der Aufstellung von Standards für Zucker in Ägypten zu berücksichtigen sind. Das ultraviolette Absorptionsspektrum des Zuckers wird als wichtiges Kriterium für die Qualitätsbestimmung angesehen.

* * *

Inversion bei verschiedenen Zuckerrohrsorten nach der Ernte. R. S. KANWAR und J. K. KAPUR. S. 358-359

Die Autoren haben in der Zuckerrohr-Versuchsstation der Landwirtschaftlichen Hochschule Punjab für vier Zuckerrohrsorten die Durchschnittswerte für Zuckergehalt, Reinheit, Gehalt an reduzierenden Zuckern und Gewicht nach Lagerung bis zu einem Zeitraum von 9 Tagen bestimmt. Die in Tabellen zusammengestellten Resultate werden diskutiert.

* * *

Korrektur des Brechungsindex von Saccharoselösungen bei hohen Temperaturen. D. BASKER. S. 359-360

Der Verfasser gibt eine Methode zur Angleichung der bei Temperaturen von 30 bis 90°C erhaltenen Brechungsindizes von Lösungen mit 5 bis 90 Gew.-% Saccharose an die entsprechenden Werte bei einer Standardtemperatur von 20°C an. An einem Beispiel wird die zur Berechnung benutzte Methode aufgezeigt.

* * *

Kombiniertes Mahlen und Zentrifugieren des Zuckerrohrs zum Zweck der besseren Extraktion. Teil II. M. STERZINGER und J. ZDARSKY.

S. 361-364

Die Verfasser beschreiben die biologische Bewertung der zerstörten Zellen nach dem Durchgang des Zuckerrohrs durch die Mühle Nr. 1, der ein Shredder nach- oder vorgeschaltet ist, und/oder durch den "Gorator" und eine Zentrifuge. Die Ergebnisse der Untersuchungen werden diskutiert. Es wurde gefunden, dass die kalte Extraktion durch kombiniertes Mahlen und Zentrifugieren trotz aufgetretener Störungen in der Versuchsanlage Erfolge verspricht.

Propiedades fisicoquímicas de azúcar del Egipto. H. A. MOHAMED, K. A. HAMMADY y S. H. ABOU-EL-HAWA. Pág. 355-357

Se describen investigaciones de las propiedades fisicoquímicas de muestras de azúcar Egipcio refinado y blanco, y las results se discuten. Aunque la calidad del azúcar refinado se halló comparable con esa de azúcar producido en otros países, la calidad del azúcar blanco fué bastante baja. Se mencionan factores que tienen que considerarse en el establecimiento de normas para azúcar en el Egipto; es considerado que el espectro de adsorción ultra-violeta es un criterio importante en el evaluación de calidad.

* * *

Inversión después de la cosecha en diferentes variedades de caña. R. S. KANWAR y J. K. KAPUR. Pág. 358-359

Los medios cambios en contenido de sacarosa, pureza, contenido de azúcares reductores y peso se determinaron para almacenaje hasta nueve días de cuatro variedades de caña a la Estación Experimental de Caña de Azúcar de la Punjab Agricultural University. Las results tabuladas se discuten.

* * *

Correcciones para temperaturas altas al índice de refracción de soluciones de sacarosa. D. BASKER. Pág. 359-360

Se presenta un método para arreglar valores del índice de refracción de soluciones de sacarosa de 5-90% peso/peso, obtenido a temperaturas en la gama 30 a 90°C, a los valores correspondiente a una temperatura normal de 20°C. Por medio de un ejemplo, se demuestra el método usado para calcular la corrección.

* * *

Molienda-con-centrifugación de caña de azúcar para extracción. Parte II. M. STERZINGER y J. ZDARSKY. Pág. 361-364

Evaluación biológica de la ruptura de células de la bagazo en un primer molino después o antes de un desmenuzadora y/o un "Gorator" más una centrifuga se describe y results de las investigaciones se discuten. Es considerado que el proceso de extracción en el frío por molienda-con-centrifugación tiene promesa a despacho de defectos en el equipo de la planta piloto.

INTERNATIONAL SUGAR JOURNAL

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Notes & Comments

World sugar production estimates, 1976/77

Their first estimates of world sugar production in the current crop year have been published by F. O. Licht KG¹. Their information suggests that 1976/77 world sugar crops may be 6 million tons or 7.5% larger than the record 81.8 million tons of 1975/76, despite the drought in some European countries. The estimated total will certainly result in a considerable production surplus if sugar consumption does not improve drastically—which does not seem very likely, however.

Western Europe's rainfall in recent weeks has given rise to improved prospects, particularly in France, and Licht's latest estimate is for an increase of almost 470,000 tons more than in 1975/76. The figures for East Europe are unchanged from the earlier estimate² although it is recognised that that for the USSR may well be subject to amendment, depending on frost damage. Most other beet areas are much the same as in 1975/76 but a 300,000-ton fall is expected in the US crop.

Most of the increase in production is expected to be cane sugar; this contrasts with 1975/76 when the increase in production was mainly the result of a larger beet area. Good crops are forecast for many areas, although drought has caused serious damage in Cuba while the Brazilian figure, although 20% up on 1975/76 at 7.4 million tons, is less than the originally anticipated bumper crop of 8.1 million tons as a result of heavy rains.

After the frost-affected crop of 1975/76, Argentina's sugar production is expected to return to its normal level, as is the Mauritius crop which was last year devastated by cyclone damage. In South Africa production is expected to recover from the low level of 1975/76 and to exceed the high output level of 1974/75. In India output is expected to recover from the reduced crop of last year but not to reach the peak of two years ago. Good weather and expanded area are expected to provide Australia with a record crop in 1976/77, nearly 16% above that of the previous season.

* * *

International Sugar Organization

A meeting of the Committee called to advise the ISO Executive Director of the further preparations for a new International Sugar Agreement was held in London at the beginning of October. According to C. Czarnikow Ltd.³, representatives of the EEC and the USA took part for the first time in these discussions of the bases and framework of a new

Agreement. If the delegates have been successful their discussions will form the basis on which a new Agreement can be negotiated in Geneva next year. The Executive Director was to report the outcome of his discussions to the Consultative Committee at its meeting scheduled for 18th–19th November.

One particular aspect which the committee examined was the role which must be played by stocks in the context of a new Agreement.

C. Czarnikow Ltd. comment⁴, in this respect, "In any new Agreement it would be most valuable to have the active participation of the United States of America. Indeed, if her future sugar arrangements enable her still to take her supplies as a part of the world market the very size of the tonnage required would make it necessary for her to be a member of the International Sugar Agreement if the latter were to be a feasible proposition. Even if the USA reverted to the old type of Sugar Act under which her supplies were considered to be a special arrangement and thereby precluded from the world market, her active participation in a new International Agreement would certainly ensure that suppliers to her market also adhered to the Agreement.

"For this reason it is particularly interesting to note that the US Assistant Treasury for International Affairs is reported to have stated recently that the US will refuse to join any international commodity agreement which fixes prices or sustains them above the level of the market and that furthermore the USA does not believe that the common buffer stock fund proposed by UNCTAD is necessary. If this is, indeed, the position of the USA on this subject there would seem to be very little likelihood of the possibility of including buffer stock arrangements within a new International Sugar Agreement."

* * *

World sugar prices

Sales on the New York market at the beginning of October left most of the immediately available sugar in the hands of one dealer who was anticipated to have customers since delivery is required within 75 days. This gave a buoyancy to the markets and the LDP rose from £118 to £130 per ton. Little interest was shown during the remainder of the month, however, and prices eroded slowly with a small rise at the end of the month which was due to

¹ *International Sugar Rpt.*, 1976, 108, (29), 1–4.

² *I.S.J.*, 1976, 78, 321.

³ *Sugar Review*, 1976, (1304), 163.

⁴ *ibid.*, (1306), 174.

weakening of sterling, to reach £118 again on the last trading day of October.

The white sugar market was not affected appreciably by the earlier effects on the raw sugar market and the LDP(W) rose only from £162 per ton to £171 during the first two weeks of October. Thereafter it slipped back to £162 in the next week while the weakness of sterling brought about a rise to £167, although the lack of demand produced a renewed fall to £161 by the end of the month.

* * *

Sugar consumption in the EEC

F. O. Licht KG recently published¹ tables of monthly consumption data for individual countries and all-Community data for October/September periods in 1972/73 to 1975/76. The figures for July-September 1976 are preliminary and so subject to amendment; nevertheless, they show that from March 1976 offtake has been consistently higher than a year earlier in contrast to the figures from February 1975 which had been consistently lower than the corresponding figures of a year before. Total consumption for the period October 1975-September 1976 is set at 9,587,500 metric tons, white value, compared with 9,475,800 tons in 1974/75, 10,279,100 tons in 1973/74 and 9,840,900 tons in 1972/73.

Thus, in spite of an increase of 111,700 tons or 1.18% by comparison with 1974/75 the latest figures are still below those of 1972/73. The 1973/74 figures showed a then-normal increase of 4.45%, but the high prices and shortages of the following period brought about a fall of 7.8%. The figures for March-September 1976 show an increase of 17.8% over the corresponding period of 1975; Licht notes that it is certainly not to be expected that such a high rate of increase will persist even during the near future but that the figures are indicative of a good increase in sugar consumption. Licht also points out that an increase of more than 7% will be necessary to reach the consumption level of 1973/74.

* * *

British Sugar Corporation expansion and modernization

The British Sugar Corporation has announced that £26 million will be spent in 1977 on factory expansion and modernization as part of the five-year £100 million expansion plan announced last year.

The aim is to increase home-grown sugar production in a normal year to 1,250,000 metric tons by 1980, making the UK at least 50% self-sufficient for sugar.

During the twelve months beginning September 1976 work on capacity increase will take place at Brigg, Bury, Cantley, Ipswich, Kidderminster, King's Lynn, Newark and Wissington. A total of £7,500,000 will be spent on the completion of the massive reconstruction of Newark factory. This will increase the slice from 1750 to 6100 metric tons a day, making Newark one of the most modern beet sugar plants in the world. The factory will not operate during the 1976/77 campaign to allow the reconstruction to proceed without interruption. Work is to be completed by September 1977 in time for the 1977/78 campaign.

More than £4 million has been earmarked for work at Cantley where a capacity increase from 5000 to

6350 tons per day will be completed for the 1978/79 campaign.

At Wissington £3,250,000 will be spent to increase capacity and almost £2 million will be spent to boost Bury's slice rate. Smaller increases will be completed at Ipswich and Kidderminster.

More than £1 million will be spent on improving beet reception facilities at Bardney, King's Lynn and Spalding. This will include the provision of long platform weighbridges to accommodate larger lorries, new automatic beet sampling units and, in some cases, new road systems to provide a faster turn-round of vehicles. Provision has also been made for smaller projects which are initiated by factories to assist their general running and improve their efficiency.

* * *

US sugar import duty

The recent trebling of import duty on sugar² was modified on the 5th October when President FORD declared exemption from the increase for any sugar on its way to the United States or which had left the warehouse in its country of origin by 21st September and was to arrive by the 8th November. This met the protests of suppliers some of whom had sugar in ships on their way to US ports and, under the terms of their contracts, were responsible for paying all duty.

The International Trade Commission, which has been charged by the President to determine whether sugar is being imported into the country in such quantities as to threaten the domestic industry, was scheduled to commence its hearings in the first week of November, with further hearings later in the month. C. Czarnikow Ltd. note³ that the Committee has been asked to act speedily but meantime there is a great deal of uncertainty and this is acting as a damper on buying interest.

* * *

Sugar exporters' meeting⁴

The Latin American and Caribbean sugar exporters group, GEPLACEA, met in Mexico City in September and, according to informed sources, tried to agree on a minimum price for sugar exports. A minimum price of 12 cents per pound was mentioned (which compares with the actual ISO range of 7.55 to 9.25 cents/lb during September) but no decision was reached. The Group between them supply more than 60% of all sugar finding its way to the world market and has tried for some time to stabilize world market prices to protect export revenues. Although the actions of the Group had some success earlier this year they could not prevent the recent drastic fall in world prices. However, it is understood that the delegates came to the decision that they should refrain from making further sales until prices improve. This will be difficult, however, in view of the fact that some member countries are expecting good crops which might cause storage problems if the cautious selling policy is continued over a longer period.

¹ *International Sugar Rpt.*, 1976, 108, (28), 1-6.

² *I.S.J.*, 1976, 78, 322.

³ *Sugar Review*, 1976, (1307), 180.

⁴ F. O. Licht, *International Sugar Rpt.*, 1976, 108, (26), 14.

Physico-chemical properties of Egyptian sugar

By MOSTAFA A. MOHAMED, KAMAL A. HAMMADY and SALAH H. ABOU-EL-HAWA
(Dept. of Food Technology, Faculty of Agriculture, Assiut University)

Introduction

Up to the present, little information is available in the literature concerning the physico-chemical properties of Egyptian sugar. The investigation described herein was therefore planned to evaluate the gross physico-chemical properties of this sugar. Such analysis will furnish enough data to establish standards and general specifications for sugar. The values obtained in this work may also be of use in improving the quality of sugar produced in Egypt.

Materials and methods

Sampling: Gross samples of 100 kg of both refined and white granulated sugar were obtained at random from the local market. These gross samples were thoroughly mixed and reduced by the standard method of quartering to give a final sample of 3 kg, termed sugar *A* and sugar *B*, respectively. In the same manner, a final sample (sugar *C*) was prepared from the white granulated sugar, obtained from the market by ration card. (In Egypt sugar is obtained with a ration card and also from the free market.)

Methods of analysis: Determinations, using methods described in the literature^{1,2,3}, were run in duplicate and results reported as the mean of the two runs. The following properties were studied: bulk density (as poured, and after compacting); hardness of setting; pH value; reduced buffer power; colour using Bottlers' standards; insoluble matter; crystal purity; % moisture; polarization; % sucrose; % reducing sugars; % ash and % sulphates. Sodium, K and Ca contents were also estimated applying the method described by JACKSON⁴. Waxes, starch, iron and SO₂ contents were studied using the methods described by PLEWS² and MARCHENKO⁵.

The U.V. absorption spectra for aqueous solutions of sugar under study were measured using a "Unicam IV" spectrophotometer.

Results and discussion

In Table I are presented the physico-chemical properties of the sugars investigated. Remarkable differences in the studied properties could be noticed between the three groups of sugar. Data show that sugar *A* and sugar *B* were hardened much less than sugar *C*. DEKKER, WEBSTER and others⁶ found that with higher invert percentage the tendency to harden was greater than with lower invert percentage. Our results agreed with these findings. At any rate, there are other factors affecting the hardness of setting for sugars, such as: sugar quality; temperature at bagging; weather and climatic conditions and storage conditions. The values obtained have a practical importance, since there is very close relation between hardness of setting and keeping quality of sugar.

Fig. 1 shows the buffer power of the investigated sugar. It will be noted that the buffer power of sugars *B* and *C* was respectively 1.5 and 5 times higher than

Table I. Physico-chemical properties of Egyptian sugar

Properties	Sugar A*	Sugar B*	Sugar C*
Bulk density as poured, lb.ft ⁻³	57.2	60.3	55.6
Bulk density after compacting, lb.ft ⁻³	60.7	63.0	60.4
Hardness of setting, g	200†	200‡	500‡
pH value	6.55	6.25	6.30
Reduced buffer power, cm ³ 0.1N HCl	3.80	5.70	18.50
Colour (reference basis colour)	80	170	410
Mean aperture, mm	0.85	1.01	0.70
Coefficient of variation	35.3	47.5	27.9
Crystal regularity in quantitative terms, %	73.2	69.0	78.7
Insoluble matter, mg/100 g	100§	95§	100§
Crystal purity	99.78	99.68	99.61
Moisture, %	0.052	0.215	0.534
Polarization	99.75	99.12	98.16
Sucrose, %	99.82	99.27	98.41
Reducing sugars, %	0.04	0.110	0.380
Carbonated ash, %	0.050	0.135	0.283
Fe, mg/100 g	0.107	0.180	0.280
Na, mg/100 g	2.098	9.252	16.258
K, mg/100 g	5.246	26.092	38.665
Ca, mg/100 g	13.080	48.356	68.269
Waxes, %	0.015	0.048	0.081
Starch, mg/100 g	2.00	2.00	2.500
Sulphates, % SO ₂	0.019	0.038	0.078
SO ₂ , ppm	20.8	20.8	94.1
Safety factor	0.208	0.244	0.290

* Sugar *A* = refined granulated sugar; Sugar *B* = white granulated sugar; Sugar *C* = white granulated sugar obtained under ration.

† within first minute.

‡ within second minute.

§ sugar not clean.

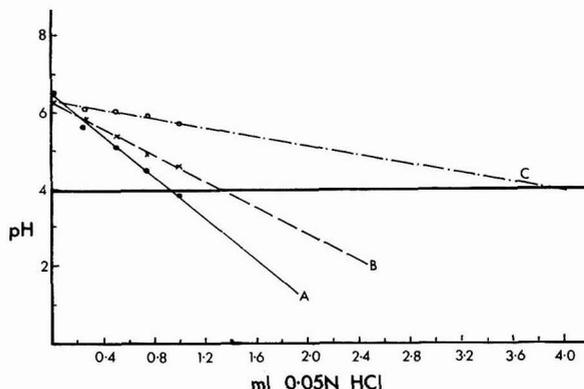


Fig. 1. Buffer power of sugars A, B and C

¹ PAYNE: "Sugar cane factory analytical control". (Elsevier, Amsterdam), 1968, pp. 81-89.

² PLEWS: "Analytical methods used in sugar refining". (Elsevier, Amsterdam), 1970, pp. 63-79, 84-88, 215-217.

³ DE WHALLEY: "ICUMSA methods of sugar analysis". (Elsevier, Amsterdam), 1964, pp. 7-13, 36-45, 84-97.

⁴ "Soil chemical analysis". (Prentice-Hall, London), 1964, p. 285.

⁵ "Photometric determination of elements". (Moscow), 1971, pp. 163-168.

⁶ MEADE: "Cane sugar handbook". (Wiley, New York), 1959, pp. 238-239, 266-278, 418-450, 540-555.

the buffer power of sugar *A*; this is probably due to variations in invert sugar, colloids, coloured matter and other sugar constituents, which may have a buffering action. Attention should be directed to the colour of the sugar under study in Table I. Sugar such as sugar *C*, with a high content of coloured matter, may not be stored or handled for long periods without deterioration. Production of white sugar of such intensive colour indicates that the conditions of manufacture were unsatisfactory.

Among characteristics studied was the size distribution of sugar as a measure of its quality. Data obtained are illustrated in Fig. 2. It was observed that the Egyptian sugar has a mean aperture (M.A.) ranging from 0.85 to 1.01 mm. The high values of coefficient of variation (C.V.) in Table I show the lack of homogeneous crystals in sugar produced in Egypt.

It is agreed that the regularity of crystal form is an important consideration in an estimate of the quality of granulated sugar. The method employed herein provided a means of expressing crystal regularity in quantitative terms (Table I). Photographs of sugar crystals, prepared by the methods described by PLEWS³, are illustrated in Fig. 3. As shown in this figure, the crystals are not perfectly even. There are some twins and a few conglomerates. It was found that sugar *B* contained a large proportion of twins, and sugar *A* comprised a few irregular crystals with excessive proportion of conglomerates, these

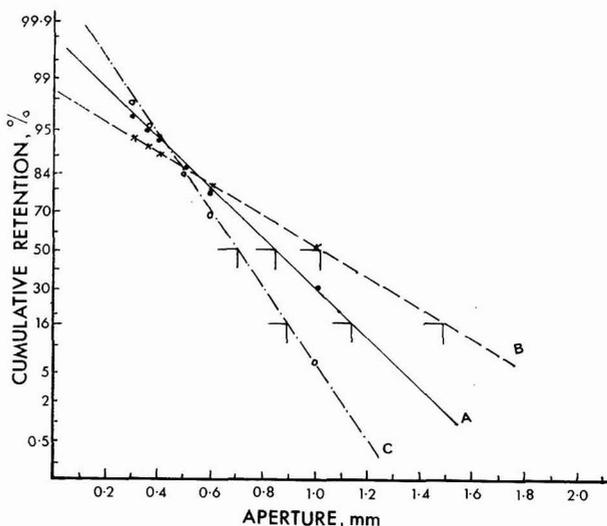


Fig. 2. Size distribution of sugars A, B and C

considerations being reflected on expression of crystal regularity in quantitative terms as shown in Table I. It is important here to point out that regularity of crystals has a great influence on the keeping quality of sugar.

Fig. 4 illustrates the U.V. absorption spectra for aqueous solutions of the sugar under study. A shoulder may be clearly observed in the optical absorption curves for sugar *B* and *C* in the wavelength

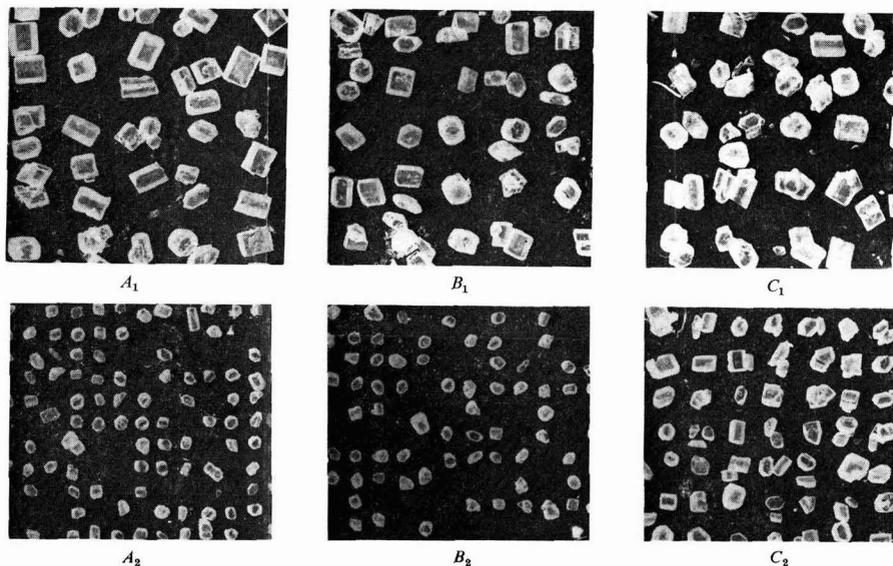


Fig. 3. Crystal regularity of sugar
*A*₁, *B*₁ and *C*₁—crystals coarser than mean aperture
*A*₂, *B*₂ and *C*₂—crystals smaller than mean aperture

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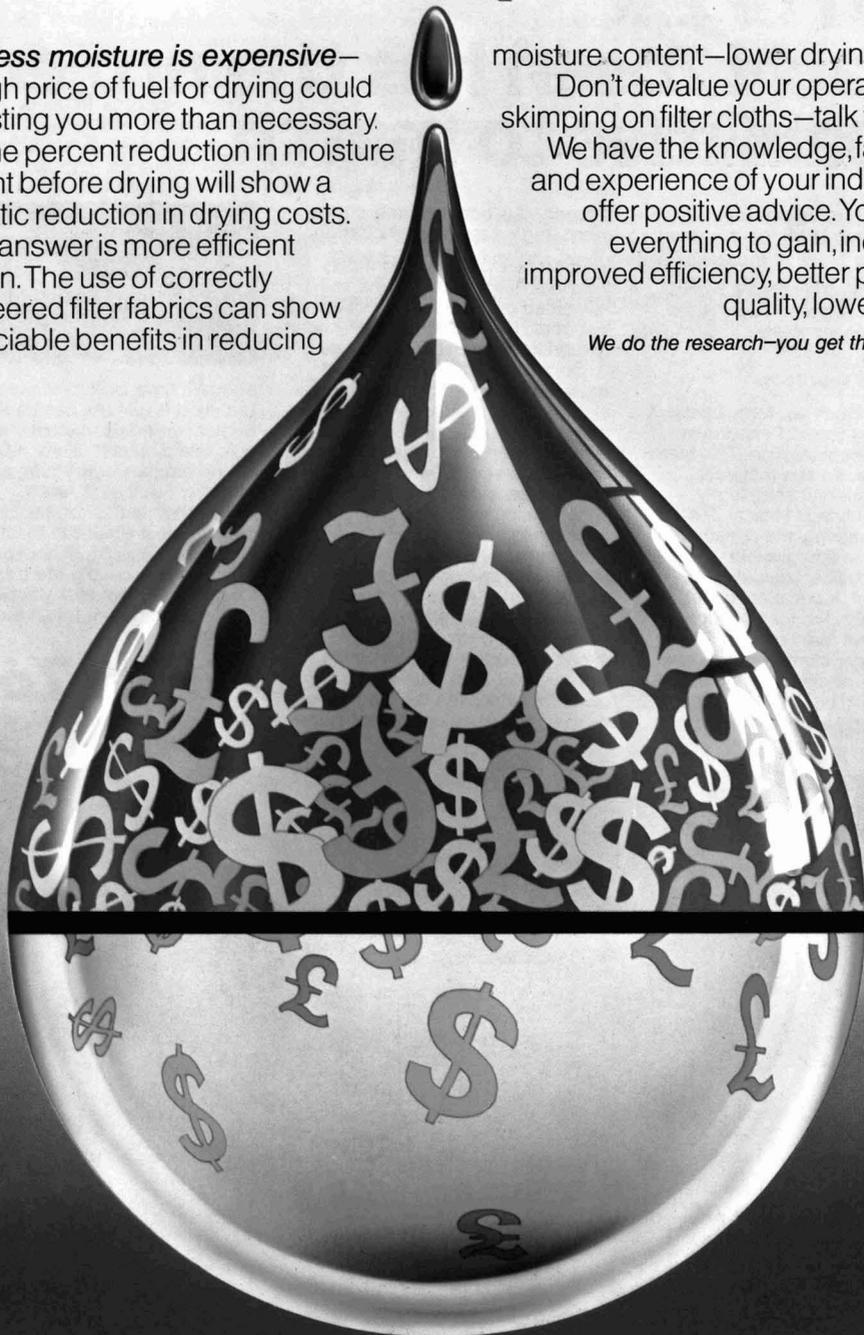
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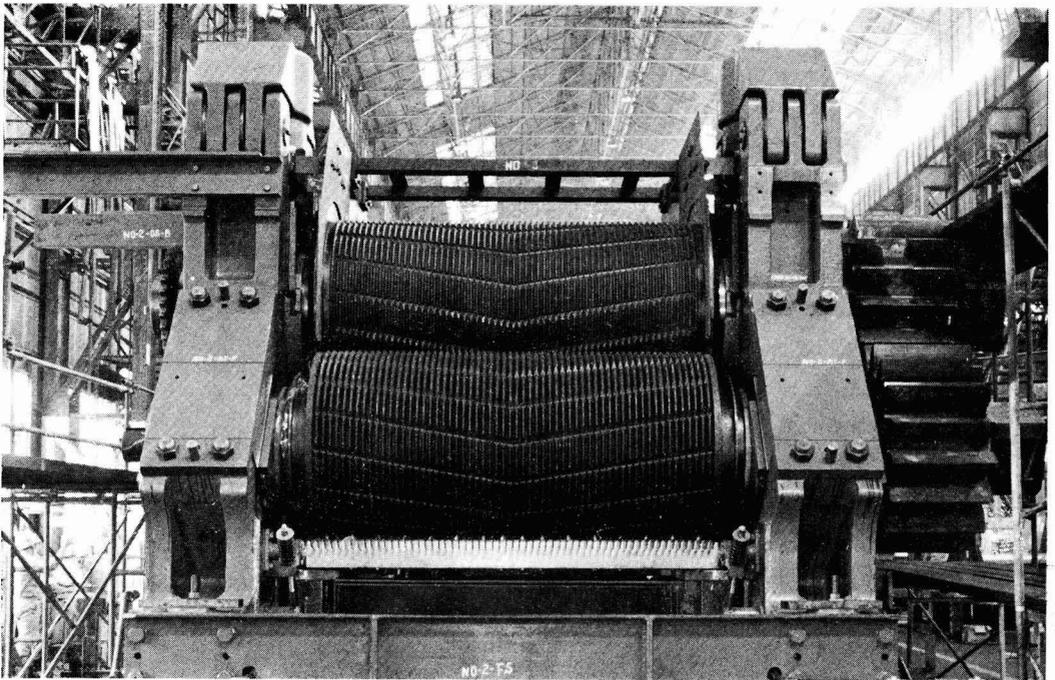


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range 265–270 nm, this shoulder being more obvious in the case of sugar C. It is attributed to the presence of coloured matter in sugar crystals, since coloured products from the alkaline degradation of reducing sugars show an absorption peak in the same wavelength range⁷. The absence of any shoulder in the case of sugar A, which showed the lowest value in colour, confirms our conclusion. This may justify the using of U.V. absorption spectra of sugar as a measure of its quality in Egypt.

With reference to Table I, special significance has to be attached to the chemical analysis of Egyptian sugar. In general, significant differences were observed between the three groups of sugar. It

(2) Certain other factors have also to be taken into account when establishing general specifications for sugar in Egypt; these factors comprise crystal regularity in quantitative terms, size distribution, buffer power and colour.

(3) The U.V. absorption spectrum of sugar is an important consideration for estimating of its quality.

Summary

An investigation has been carried out to furnish enough data to set up standards and general specifications for Egyptian sugar and to be of use in improving its quality. Representative samples of white and refined granulated sugar were obtained from the

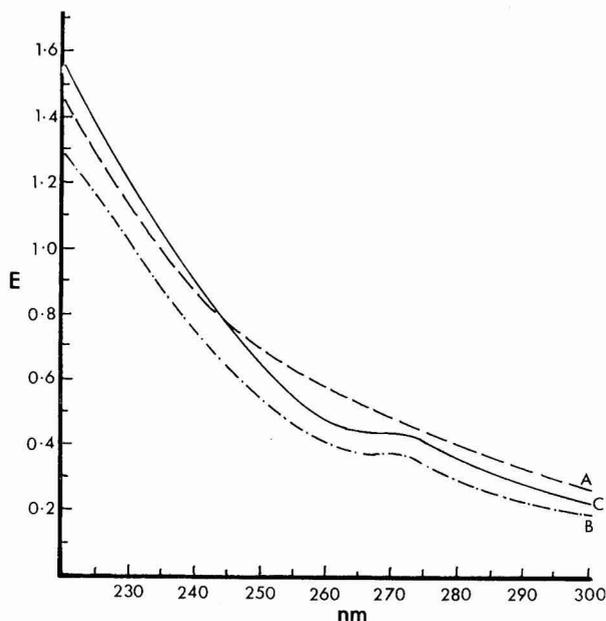


Fig. 4. U.V. absorption spectra of sugar solutions

should be mentioned that the values of insoluble matter, moisture content, reducing sugars, ash content and SO₂ in sugar B and C were considerably higher than the corresponding values recorded for sugar produced in other countries^{8,9,10,11}. This could be attributed to the conditions prevailing in Egyptian sugar factories and also to the handling of sugar in our market. Thus, it seems improbable that sugar with such analysis could be kept for long periods without deterioration.

The relationship between the percentages of water and non-sucrose (safety factor) was calculated for the sugars under study, and recorded in Table I. According to FRIML's chart of safety factor¹¹, both sugar A and B fall within the safety zone, while sugar C falls in the zone of deterioration. From the above discussion it can be concluded that:

(1) The quality of Egyptian sugar is rather low except for refined granulated sugar, which has a good quality comparable to that produced in other countries.

local market and their physico-chemical properties studied. The results obtained lead to the following conclusions:

(1) The quality of Egyptian sugar is rather low, except for refined granulated sugar which has a good quality comparable to that produced in other countries.

(2) Certain other factors have also to be taken into account when setting up general specification standards for sugar in Egypt.

(3) The U.V. absorption spectrum of sugar is an important consideration in an estimation of its quality.

⁷ PREY *et al.*: *Zeitsch. Zuckerind.*, 1966, **91**, 379–385.

⁸ BECKER: "Principles of sugar technology", Vol. III. Ed. P. HONIG. (Elsevier, Amsterdam), 1964, pp. 453–472.

⁹ CARPENTER & BICHSEL: *J. Amer. Soc. Sugar Beet Tech.*, 1969, **15**, 369–378.

¹⁰ CHEN: *Sugar J.*, 1969, **32**, (4), 9–15.

¹¹ FRIML: *CubaAzúcar*, 1969, (March/April), 24–28, 50–54.

Post-harvest inversion in different cane varieties

By R. S. KANWAR and J. K. KAPUR

(Punjab Agricultural University, Sugarcane Research Station, Jullundur, Punjab, India)

Introduction

MUCH stale cane giving low recoveries is crushed by Indian sugar factories, cane being left in the field as a result of transport constraints as well as factory hold-ups. During this period the cane declines in quality. LAURITZEN & BALCH¹, SAYED² and RIZK³ reported inversion of sucrose within a few hours after cutting and diminution in the available sugar (rendement)⁴.

Variety, climatic conditions after harvest, stage of maturity and cane quality at harvest affect the rate of deterioration. Mean losses reported by previous investigators were as follows:

GUILBEAU <i>et al.</i> ⁵ , Louisiana (1956)	12—50% after 14 days
DIKKER ⁶ , Louisiana (1960)	0.5% per day
BONETA GARCÍA & LUGO LÓPEZ ⁷ , Puerto Rico (1962)	0.127—0.373% per day
RAMAMOORTHY <i>et al.</i> ⁸ , India (1975)	2.0-3.2% over 96 hours

The present studies were made to measure losses under Punjab conditions.

loss of sucrose was in Co 1148, followed by CoJ 46, CoJ 64 and CoJ 67, respectively, after nine days' storage.

Daily losses were as follows:

CoJ 67	0.31%
CoJ 64	0.38%
CoJ 46	0.46%
Co 1148	0.48%

Losses were lowest in CoJ 67 although CoJ 64 was earlier-maturing and had a slightly higher initial quality. Other authors^{6,7} have reported daily pol losses up to 0.5%.

The difference is attributed to the thinner canes of CoJ 67 variety; its cross-sectional area of the cut stalk is smaller than for the thicker variety CoJ 64, resulting in a smaller moisture loss and sucrose inversion in the latter variety. This view would be in accordance with the work of HALL⁹ who found

Table I. Mean changes in sucrose, purity, reducing sugars and weight loss (all in percentage) as a result of staling.

Quality constituent	Variety	Days of storage									
		0	1	2	3	4	5	6	7	8	9
Sucrose %	CoJ 64	19.58	18.90	18.79	18.41	17.93	17.36	17.20	17.43	17.00	16.20
	CoJ 67	19.34	18.93	18.79	18.36	17.83	17.12	17.16	16.61	16.56	16.58
	CoJ 46	16.80	16.61	15.17	14.95	14.57	14.18	13.35	13.91	13.65	12.87
	Co 1148	17.74	17.29	15.86	15.43	14.94	14.67	13.78	13.57	13.63	13.30
	CoJ 64	89.4	84.2	81.7	80.7	77.3	75.2	71.4	73.9	71.9	70.0
Purity coefficient	CoJ 67	87.9	86.5	82.0	80.5	78.3	74.8	71.3	70.7	71.0	70.0
	CoJ 46	83.8	79.2	77.2	75.5	68.6	65.0	64.7	64.7	64.1	64.1
	Co 1148	81.7	79.0	77.6	75.0	69.6	67.8	63.9	63.8	63.5	62.6
	CoJ 64	0.19	0.26	0.39	0.60	1.90	2.10	2.40	2.80	2.80	3.20
	CoJ 67	0.18	0.23	0.56	0.80	1.50	2.40	2.40	2.60	2.90	3.00
Reducing sugars %	CoJ 46	0.71	0.68	1.10	1.65	2.50	3.15	3.20	3.50	3.70	3.75
	Co 1148	0.53	0.64	1.09	1.55	2.45	2.95	3.15	3.10	3.45	3.55
	CoJ 64	0	3.9	4.7	4.7	9.3	9.3	10.1	11.8	12.0	13.6
	CoJ 67	0	1.3	2.3	3.0	5.4	6.8	6.8	8.1	9.0	9.5
	CoJ 46	0	2.4	5.6	5.9	7.1	8.6	10.2	10.4	11.8	13.9
Co 1148	0	3.7	4.2	6.1	7.3	9.4	11.4	11.9	13.8	16.3	

Materials and methods

The investigation was carried out at the Jullundur Research Station in March 1975 and March 1976. During the period, the maximum temperature varied from 21° to 27°C and the minimum from 11° to 15°C. The mean relative humidity was 65%. Four varieties were used: CoJ 64 (early-maturing), CoJ 67 (mid-season), CoJ 46 (moderately late) and Co 1148 (late-maturing). Cane from each variety was topped, cut and stored separately in heaps under natural conditions, i.e. exposed to the sun as usual in farmers' fields. Ten stalks from each variety were crushed daily for nine days after cutting and the expressed juice analysed for Brix, pol % and reducing sugars % and the purity derived. Weight loss was calculated from the daily weight of cane stored separately under similar conditions.

Results

Examination of the data in Table I indicates that CoJ 64 had the maximum sucrose at sampling on Day 0, followed by CoJ 67, Co 1148 and CoJ 46. Sucrose content decreased as the time of storage (staling) increased, regardless of variety. Maximum

that inversion in Java and Argentina varieties was correlated with the thickness and, therefore, cross-sectional area of the cut ends. Between the late varieties CoJ 46 and Co 1148 the above view would explain the relative rates of loss of sucrose.

The net losses of sucrose for 0-3 days, 3-6 days and 6-9 days are presented below in Table II.

Table II. Mean changes in % sucrose during the storage period

Variety	0-3 days	3-6 days	6-9 days	Total drop
CoJ 64	1.17	1.21	1.00	3.38
CoJ 67	0.98	1.20	0.58	2.76
CoJ 46	2.05	1.60	0.48	4.13
Co 1148	2.31	1.65	0.48	4.44

¹ U.S.D.A. Tech. Bull., 1934, (449).

² M.Sc. Thesis, College of Agriculture Library, University of Assiut.

³ Ph.D. Thesis, Louisiana State University Library, 1967.

⁴ SAYED *et al.*: Research Bull. (Egyptian Sugar & Distillation Co., Sugarcane Dept.), 1972, (38).

⁵ Sugar Bull., 1956, 34, 28-30.

⁶ Sugar J., 1960, 22, (8), 15.

⁷ J. Agric. (Univ. Puerto Rico), 1962, 46, (3), 189-194.

⁸ Sugar News (India), 1975, 7, (4), 5-10.

⁹ Rev. Ind. Agric. (Tucumán), 1913, 4, (4), 148-150.

Loss in fresh weight was positively correlated with the loss in sucrose as is evident when sucrose losses (Table II) are compared with weight loss in Table III below.

Table III. Mean weight changes by drying during the storage period

Variety	0-3 days	3-6 days	6-9 days	Total drop
CoJ 64	4.7	5.4	3.5	12.6
CoJ 67	3.0	3.8	2.7	9.5
CoJ 46	5.9	4.3	3.7	13.9
Co 1148	6.1	5.3	4.9	16.3

These observations are in accordance with those reported by ALEXANDER¹⁰ and SRINIVASAN *et al.*¹¹

Mean changes in percentage purity are presented in Table IV. The fall in purity was maximal during the first three days, substantial in the period from the 3rd to 6th day, and much less during the last three days of storage.

The sequence of changes in reducing sugars content for 0-3, 3-6 and 6-9 days are presented in Table V.

Table IV. Mean changes in purity during the storage period

Variety	0-3 days	3-6 days	6-9 days	Total drop
CoJ 64	7.70	9.30	1.40	18.40
CoJ 67	7.40	9.20	1.30	17.90
CoJ 46	7.30	11.80	0.60	19.70
Co 1148	6.75	11.10	0.90	18.75

Table V. Mean changes in reducing sugars % during the storage period

Variety	0-3 days	3-6 days	6-9 days	Total increase
CoJ 64	0.41	1.80	0.80	3.01
CoJ 67	0.62	1.60	0.60	3.02
CoJ 46	0.94	1.55	0.55	3.04
Co 1148	1.02	1.60	0.45	3.07

Those varieties which were mature as indicated by high sucrose and low reducing sugars at the beginning of the trial showed the lowest increase over the first three days of storage; thereafter losses were as high or higher. (Cf. CoJ 64 and CoJ 67 with CoJ 46 and Co 1148).

¹⁰ "Sugar cane physiology" (Elsevier, Amsterdam), 1973.
¹¹ *Sugar News* (India), 1975, 7, (5), 14-15.

Corrections at high temperatures to the refractive index of sucrose solutions*

By DOV BASKER

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Introduction

MANY industrial processes are followed and controlled with in-line instruments, of which the refractometer is an example^{1,2}. In particular, the concentration of solutions, such as fruit juices, by evaporation under vacuum, is typically followed refractometrically, using an instrument graduated in °Brix, equivalent to % by weight of sucrose³. It is known that the refractive index is strongly temperature-dependent^{4,5}, and that industrial processes are frequently carried out at elevated temperatures. However, no tables appear to be available for correcting refractive index readings obtained at temperatures above 30°C, to standard temperature (20°C).

Discussion

In a previous paper⁶, a method was discussed for the determination of density of solutions at various temperatures, as a function of the refractive index. This relationship may also be employed to calculate the refractive index when the density is known. Using subscripts to refer to different temperatures, we have⁶:

$$D_2 = D_1 (R_2 - a_2) / (R_1 - a_1), \dots \dots \dots (1)$$

where *D* = density of solution, *R* = refractive index of solution, *a* = refractive index of solvent, and thus

$$R_2 - a_2 = D_2 (R_1 - a_1) / D_1 \dots \dots \dots (2)$$

The density of aqueous sucrose solutions of different concentrations is known at various temperatures up to 95°C⁷. The refractive index of water is also known⁸ and thus *R*₂ may be calculated.

The experimental data of THIELE⁹ were obtained on solutions the concentrations of which were not integral percentages by weight. In order to interpolate and to construct a table based on integral % w/w, the linear relationship between (*R_t - a_t*) and concentration by weight per unit volume (w/v)⁸ may be used at each experimental temperature⁸ (see Appendix). The regression equations (see Table I) were solved for selected integral concentrations w/w, converting to concentrations w/v according to the specific gravities at 20/20°C⁹. *R_t* was calculated and converted to Brix units⁸ where applicable, and is detailed in Table II; in some instances the values are off the Brix scale (see Appendix).

On theoretical grounds⁸ it would appear more appropriate¹⁰ to calculate the regression equations through the points *a_t*; the constant terms in Table I would then be zero, and the variable terms would have slightly greater factors. However, small in-

* Contribution from the Agricultural Research Organization, Volcani Center, Bet Dagan, Israel. 1975 Series, No. 177-E.
¹ FEINBERG: "Food Processing Operations". Ed. JOSLYN & HEID. (Avi Publishing Co. Inc., Westport) 1964, p. 331.
² MALEY: *Food Technol.*, 1963, 17, 25.
³ "Official Methods of Analysis", 12th edn. (AOAC, Washington), 1975, Sec. 52.012.
⁴ *ibid.*, Sec. 52.015.
⁵ BASKER: *J. Assoc. Off. Anal. Chem.*, 1975, 58, 618-619.
⁶ *Zeitsch. Zuckerind.*, 1962, 87, 424-434.
⁷ WEAST: "Handbook of Chemistry and Physics", 52nd edn., (Chemical Rubber Co., Cleveland), 1971, p. E-203.
⁸ GLOVER & GOULDEN: *Nature*, 1963, 200, 1165-1166.
⁹ "Official Methods of Analysis", 12th edn. (AOAC, Washington), 1975, Sec. 52.008.
¹⁰ BROWNLEE: "Statistical Theory and Methodology" (Wiley, New York) 1965.

Table I. Regression of refractive index (*minus* refractive index of water) at various temperatures, on concentration by volume at 20°C

Temperature, °C	Regression of refractive index	
30	0.000373 + 0.001395262 × % sucrose w/v	
40	0.000377 + 0.001389421 × % sucrose w/v	
50	0.000356 + 0.001383514 × % sucrose w/v	
60	0.000355 + 0.001377686 × % sucrose w/v	
70	0.000346 + 0.001370875 × % sucrose w/v	
80	0.000313 + 0.001364511 × % sucrose w/v	
90	0.000294 + 0.001357968 × % sucrose w/v	
95	0.000269 + 0.001355363 × % sucrose w/v	

accuracies are present¹¹ in the reference table of refractive index³ and/or of specific gravity⁸; in consequence, the residual standard deviations due to the regression lines given in Table I are lower (decreasing from 0.00052 refractive index units at 30°C to 0.00039 at 95°C) than those through the points *a_t* (decreasing from 0.00057 refractive index units at 30°C to 0.00043 at 95°C); the former are therefore preferred. In terms of sucrose, the values of the residuals vary somewhat with temperature, but principally with concentration, being equivalent to approximately 0.3% w/w at concentrations below 45% w/w and approximately 0.2% w/w at higher concentrations.

Table II. Refractive index of aqueous sucrose solutions at various temperatures (Brix scale)

Sucrose, % w/w	Temperature, °C								
	30	40	50	60	70	80	90	95	
5	4.4	3.5	2.4	1.1	—	—	—	—	—
10	9.3	8.4	7.3	6.1	4.6	3.1	1.3	0.4	
15	14.3	13.3	12.2	11.1	9.6	8.1	6.4	5.6	
20	19.2	18.3	17.3	16.1	14.6	13.2	11.5	10.7	
25	24.2	23.3	22.2	21.1	19.7	18.2	16.6	15.8	
30	29.2	28.3	27.2	26.2	24.7	23.3	21.8	20.9	
35	34.1	33.2	32.2	31.2	29.8	28.4	26.9	26.1	
40	39.1	38.2	37.2	36.2	34.8	33.5	32.0	31.3	
45	44.1	43.2	42.3	41.3	39.9	38.6	37.2	36.4	
50	49.1	48.3	47.3	46.3	45.0	43.7	42.3	41.6	
55	54.2	53.4	52.4	51.4	50.2	48.9	47.5	46.8	
60	59.3	58.4	57.5	56.5	55.3	54.1	52.7	52.0	
65	64.4	63.5	62.6	61.7	60.5	59.3	57.9	57.2	
70	69.5	68.7	67.8	66.8	65.6	64.4	63.2	62.5	
75	74.6	73.8	72.9	72.0	70.8	69.7	68.4	67.7	
80	79.8	79.0	78.1	77.2	76.1	74.9	73.6	73.0	
85	85.0	84.2	83.4	82.5	81.3	80.2	78.9	78.3	
90	—	—	—	—	—	85.5	84.2	83.6	

In industrial practice, the differences between Table II and the true Brix provide a more convenient manner of applying these results; the differences are detailed in Table III. To obtain the true Brix of aqueous sucrose solutions, therefore, the corrections

Table III. Corrections to be added for determining the percentage of sucrose in sugar solutions by a refractometer

Sucrose, % w/w	Temperature, °C								
	30	40	50	60	70	80	90	95	
5	0.6	1.5	2.6	3.9	—	—	—	—	
10	0.7	1.6	2.7	3.9	5.4	6.9	8.7	9.6	
15	0.7	1.7	2.8	3.9	5.4	6.9	8.6	9.4	
20	0.8	1.7	2.7	3.9	5.4	6.8	8.5	9.3	
25	0.8	1.7	2.8	3.9	5.3	6.8	8.4	9.2	
30	0.8	1.7	2.8	3.8	5.3	6.7	8.2	9.1	
35	0.9	1.8	2.8	3.8	5.2	6.6	8.1	8.9	
40	0.9	1.8	2.8	3.8	5.2	6.5	8.0	8.7	
45	0.9	1.8	2.7	3.7	5.1	6.4	7.8	8.6	
50	0.9	1.7	2.7	3.7	5.0	6.3	7.7	8.4	
55	0.8	1.6	2.6	3.6	4.8	6.1	7.5	8.2	
60	0.7	1.6	2.5	3.5	4.7	5.9	7.3	8.0	
65	0.6	1.5	2.4	3.3	4.5	5.7	7.1	7.8	
70	0.5	1.3	2.2	3.2	4.4	5.6	6.8	7.5	
75	0.4	1.2	2.1	3.0	4.2	5.3	6.6	7.3	
80	0.2	1.0	1.9	2.8	3.9	5.1	6.4	7.0	
85	0.0	0.8	1.6	2.5	3.7	4.8	6.1	6.7	
90	—	—	—	—	—	4.5	5.8	6.4	

Table IV. Example: Data for calculating regression of refractive index at 60°C on concentration by volume at 20°C

Concentration, % w/v	<i>R</i> _{60°C} — <i>a</i> _{20°C}
0.0	0.0000
1.000	0.0014
2.000	0.0029
3.000	0.0042
4.000	0.0056
5.000	0.0070
10.000	0.0141
20.000	0.0281
30.000	0.0420
40.000	0.0560
50.000	0.0698
60.000	0.0836
70.000	0.0972
80.000	0.1109
88.676	0.1226
96.108	0.1327
122.860	0.1684

(Table III) must be added to the refractometer readings.

The figures now calculated for 30°C differ slightly from those of the International Temperature Correction Table⁴, and are therefore considered to be approximate and tentative only.

Considerable similarity is noted between Table III and the table of temperature corrections to the readings of Brix hydrometers¹².

APPENDIX

An example is given in order to illustrate the method of calculation.

At 60°C, the refractive index of a solution the concentration of which at 20°C is 5.000% w/v (4.91% w/w) is given by [raw data from (6) and (7)]:

$$R_{60°C}^{4.91\%} - 1.3272 = 1.002117 (1.3401 - 1.3330) / 1.017509 \dots\dots\dots (3) = 0.0070;$$

i.e.,

$$R_{60°C}^{4.91\%} = 1.3342 \dots\dots\dots (4) = R_{20°C}^{0.85\%} \dots\dots\dots (5)$$

The remaining data for 60°C are calculated similarly, and can be set up as in Table IV.

The regression equation of refractive index (*minus* the refractive index of water) can then be obtained, and is given in Table I, together with the regression equations at the other experimental temperatures. Thus, the refractive index at 60°C of a solution of concentration 5.0% w/v (5.09825% w/v at 20°C) is given by:

$$R_{60°C}^{5.0\%} - 1.3272 = 0.0074; \dots\dots\dots (6)$$

i.e.,

$$R_{60°C}^{5.0\%} = 1.3346 \dots\dots\dots (7) = R_{20°C}^{1.12\%} \dots\dots\dots (8)$$

while

$$R_{70°C}^{5.0\%} = 1.3324 \dots\dots\dots (9) < R_{20°C}^{0.0\%} \dots\dots\dots (10)$$

Summary

Corrections have been calculated to the refractive index of sucrose solutions at various temperatures up to 95°C. These corrections are expressed on the Brix scale, where applicable.

¹¹ BASKER: *J. Food Sci.*, 1976, **41**, (in press).
¹² KRAMER & TWIGG: "Quality Control for the Food Industry" Vol. 2, 3rd edn. (Avi Publishing Co. Inc., Westport), 1973, p. 540.

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Milling-cum-centrifuging of sugar cane for higher extraction

By M. STERZINGER* and J. ZDARSKY†

PART II

BIOLOGICAL EVALUATION

Material and method

Defibrated cane or bagasse (2 kg) was sampled from each processing operation. For subsequent treatment the moist material was stored in the drying cupboard for 4–5 hours at a temperature of 65–70°C. After drying the sample could be transported. The rupture of individual cells in the bagasse was determined by using a maceration technique^{3,4}.

The bagasse is placed in 20% nitric acid and 5% chromic acid for 5–12 hours according to the ambient temperature, the higher the temperature the shorter the maceration period. If necessary, moderate heating is applied at the end of the maceration. Acids are removed by washing in water. The fibrous mat is stained with methylene blue or safranin (dilute solution); the former gives a blue or blue-green colour and the latter a red or yellowish-red. Excess stain is removed and the mat placed in glycerine, preferably 99%. The fibrous mat is unravelled by gently teasing with a needle mounted on a slide and covered with a cover glass. The samples thus prepared can be stored in Petri dishes for later research.

Bagasse cells are basically made up of three groups. The first and smallest in number are the epidermis cells; these are subjected to longer maceration. The second group is formed by the pith cells, which are subjected to a medium maceration time; the third group is formed of vascular bundle cells and reinforcing fibres which are the easiest and quickest to macerate.

Investigation of the condition, type and number of macerated cells was carried out informatively at a magnification of 100× and definitively at 450×. About 300 cells were counted on each slide and the numbers of ruptured and non-ruptured cells expressed in percentages.

Counts for each slide were made in duplicate, while each process operation comprised 10 duplicate tests.

For calculation of the ruptured cells we used pith cells which fill the space between the epidermis and the vascular bundles. Results were evaluated statistically⁵. The arithmetic mean \bar{x} was calculated from Eqn. (1), the standard deviation s from Eqn. (2), the standard deviation of the mean $s_{\bar{x}}$ from Eqn. (3) and the coefficient of variation v from Eqn. (4):

$$\bar{x} = \frac{\sum (x)}{n} \dots\dots\dots(1)$$

$$s = \frac{\sum (x)^2 - \sum (x)(\bar{x})}{N} \dots\dots\dots(2)$$

$$s_{\bar{x}} = \frac{s}{n} \dots\dots\dots(3)$$

$$v = \frac{100.S}{\bar{x}} \dots\dots\dots(4)$$

Symbols used: $\sum (x)$ = total of all values (variants), n = number of values, $\sum(x)^2$ = sum of squares, and N = degrees of freedom (= $n - 1$).

Microscopy of the ruptured cells is a direct method; it can be considered as basic but is time-consuming. In practice indirect determination methods do exist⁶⁻⁹ and involve as a first step the ratio between extraction and pol or pol in juice and in between cane. To the number of ruptured cells is added the cells of all types of fibrous matting. We assume that only pith cells should be considered since they contain most sucrose.

Experimental part and discussion

For the purposes of this work we will define bagasse as the waste after milling (hence, bagasse proper) and chopped, not completely extracted, cane before extraction. From the physical viewpoint, bagasse occurs at various stages of maceration, where individual portions may even have a size measurable in dm. Bagasse is a complex of more or less ruptured cells. The majority are ruptured pith cells which have characteristically the thinnest walls.

Bagasse cells are firmly attached to one another by so-called intermediate lamellae; if these are chemically dissolved, the cells separate—they macerate. Examples are shown in Figs. 7 and 8 and results are given in Table II.

The minimum number of ruptured cells was found in bagasse from the shredder (67.69 ± 1.71%) and the maximum was found with use of the No. 1 mill + shredder + centrifugal (92.38 ± 1.56%). The ruptured cell walls varied considerably for individual cells in both size and form.

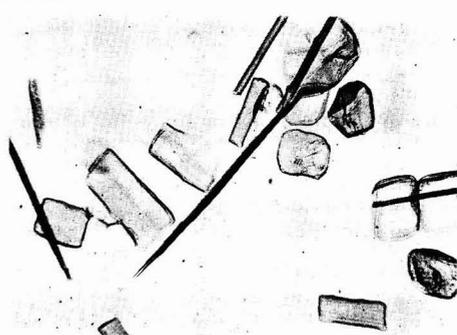


Fig. 7

³ PRÁT: "Rostlina pod drobnohledem" (The plant under the microscope), (Prahá), 1952.
⁴ SHAH *et al.*: *Phytomorphology*, 1968, 18, (1), 102–105.
⁵ HRUBÝ & KONVIČKA: "Poľní pokusy, jejich zakládání a hodnocení" (Field tests, their completion and evaluation), (Olomouc), 1954.
⁶ ALDRICH & RAYNER: *Proc. 11th Congr. I.S.S.C.T.*, 1962, 1004–1013.
⁷ SAXENA & AGARWAL: *Proc. 22nd Conv. Deccan Sugar Tech. Assoc. (India)*, 1967, (1), 17–43.
⁸ GUPTA *et al.*: *Proc. 33rd Ann. Conv. Sugar Tech. Assoc. India*, 1965, 1–10.
⁹ KHAINOVSKY: *Proc. 3rd Congr. I.S.S.C.T.*, 1929, 457–479.

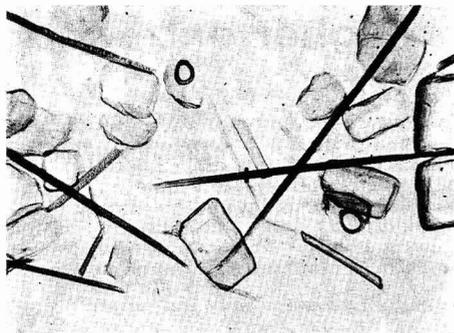


Fig. 8

Table II

Survey of cell rupture for individual technological operations (values in %)

Operation:	\bar{x}	<i>s</i>	<i>s</i> \bar{x}	<i>v</i>
Shredder	67.69	1.71	0.54	2.53
1st mill	74.43	1.85	0.58	2.48
Shredder + 1st mill ..	78.16	1.41	0.45	1.81
1st mill + shredder ..	84.29	4.20	1.33	4.98
1st mill + "Gorator" + centrifugal	81.71	2.08	0.66	2.55
1st mill + shredder + "Gorator" & centrifugal	92.38	1.56	0.49	1.69
Last (6th) mill—control	83.30	1.71	0.54	2.05

From the results we can endeavour to obtain more information on the characteristics of certain operations. If we assess only the shredder, we find that the extent to which it increased cell rupture depended on the arrangement, i.e.:

Shredder followed by 1st mill	78.16%
1st mill alone	74.43%
Cell rupture due to shredder	3.73%
1st mill followed by shredder	84.29%
1st mill alone	74.43%
Cell rupture due to shredder	9.86%

Similarly, the cell rupture due to the 1st mill is 10.47% when it follows the shredder and 16.60% when it precedes the shredder; nevertheless it may be seen that the 1st mill exerts greater cell-rupturing effect than does the shredder:

Shredder followed by 1st mill	78.16%
Shredder alone	67.69%
Cell rupture due to 1st mill	10.47%
1st mill followed by shredder	84.29%
Shredder alone	67.69%
Cell rupture due to 1st mill	16.60%

The difference between cell rupture values for the 1st mill following and preceding the shredder is surprising but statistically proven. From further combinations, the "Gorator"-plus-centrifugal is shown to give a 7.28% or 8.09% increase in the number of ruptured cells depending on whether they follow a mill alone or mill-plus-shredder combination.

1st mill + "Gorator" and centrifugal	81.71%
1st mill alone	74.43%
Cell rupture due to "Gorator" and centrifugal	7.28%
1st mill + shredder + "Gorator" and centrifugal	92.38%
1st mill + shredder	84.29%
Cell rupture due to "Gorator" and centrifugal	8.09%

Our results for number of ruptured cells may be compared with values in the literature:

Equipment	GUPTA <i>et al.</i> ⁸	SAXENA & AGARWAL ⁷
Crusher	48-68	—
1st mill	75-82	55.64-80.62
2nd mill	82-90	60.80-82.25
3rd mill	91-93	66.95-87.12
4th mill	94-96	87.27-88.24
5th mill	96.5-98.5	91.70-91.40
6th mill	—	92.80

Operational information

Operation of the equipment provided much new information and useful experience. The "Gorator" came up to full expectation and carried out the functions of disintegration, simultaneously rinsing the contents of the mechanically ruptured cells, and of conveying. The cane residence time in the "Gorator" governed the degree of defibration. A positive effect on extraction was exerted by two-stage passage through the "Gorator" with gradual reduction in concentration of the transport medium as tested and confirmed with the laboratory centrifuge in Variant (A).

Having found the answer to the question of suitable means for feeding the cane-circulation juice mixture to the first stage of the KO 1000/4 centrifugal and after connecting up and testing all the imbibition circuits, we found it impossible to overcome certain problems directly associated with the centrifugal construction. Its four stages (200, 140, 160 and 100 mm) were too short. Mixing of the juice below the screen and in the distributor was not uniform; as a result, the imbibition pump at the 2nd and 3rd centrifugal stages transferred juice of the same concentration. Imbibition at the 1st stage was provided by cold water. The juice from the first three centrifugal stages was discharged at about the same concentration because the juice was mixed in the basket before entering the distributor.

The end faces of the individual stages entrained juice in the direction of movement of the bagasse, which favoured non-uniform counterflow in the centrifugal. For this reason a multi-stage centrifugal with short stages will not be suitable for future tests. Even with a short bagasse retention in the last (4th) stage (about 4 sec), a good bagasse moisture level was achieved (70-74%), permitting further dewatering in the mills. The peripheral speed of the centrifugal was excessive even after reduction of the main shaft speed to the lowest possible, i.e. 668 rpm. Surging of the spun juice in the basket caused it to foam in the distributor tank. Layer displacement at 60 double-strokes per min took 15 sec at a basket length of 600 mm.

The centrifugal operated on indirect extraction of cane or bagasse at the rate of 10-15 tch (average processing in Variant (D) was 12.27 tch or 5.95 tons bagasse per hr). For a sugar factory processing 1000 tons of cane per day this would mean increasing the centrifugal capacity by approximately 400%, which would present no problems when the merits and demerits of the equipment are considered. Should the centrifugal basket screens deteriorate because of sand, they can be replaced.

Conclusions

Comparison of the individual test variants from the technological viewpoint is shown in a simplified form in Table III. The laboratory tests showed that the

Table III. Comparison of alternative tests

Type	PREPARATION		EXTRACTION						DEWATERING						PURITY OF JUICES						
	Pol. % Fibre %		E% RE%		E% RE%		E% RE%		E% RE%		E% RE%		E% RE%		Primary	1st Centr.	2nd Centr.	Dewatering 1st Mill	Dewatering 2nd Mill	Mixed	
A	* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		
	Pilot Plant 9-71 11-13		63-71 59-44		89-33 87-73		97-69 97-35		74-32 65-42		49-55		51-48		—		—		—		—
B	* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		
	Pilot Plant 10-41 11-26		77-96 75-38		85-84 84-25		97-57 97-31		73-18 61-42		52-20		—		—		—		—		—
C	* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		
	Pilot Plant 13-85 13-75		58-69 62-69		90-33 91-17		86-68 83-97		81-03 78-10		—		—		—		—		—		—
D	* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		* / *		
	Full Operation Plant 12-86 12-94		68-01 68-99		77-72 78-46		91-28 91-60		95-28 95-98		83-22 77-28		73-25 69-93		82-58		—		—		—

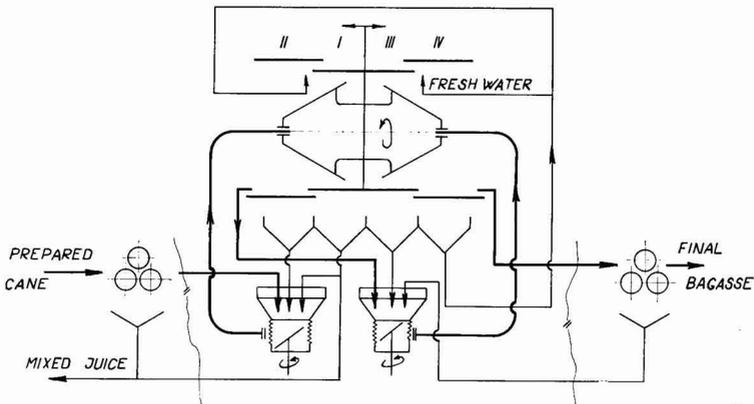


Fig. 9

process is very promising, although there were misgivings about the juice purity at the individual stages. It must be remembered, however, that the laboratory tests were carried out during the inter-campaign period when the cane quality was low and the juice (from the laboratory mill) quality poor (see Variant A—average 74.32%—and Variant B—73.18%). The results were also affected by the prolonged period of operation and evaluation of the individual phases in A and B. On the other hand, pilot-plant operation showed that there was some entrainment of impurities from the juice to the bagasse layer in the centrifugal basket. Table III, Variants C and D, shows that there was no great drop in purity between juice from the cane and from the centrifugal or between juice from the centrifugal and from the final No. 2 mill. Cold extraction and lack of increase in the juice non-sugars also led to a low drop in purity (primary juice—mixed juice). The bagasse retention time in the extractor was about 15 sec, so that the juice passed through the process in a very much shorter time than in other types of extractor.

According to the results in Table III, extraction on a pilot-plant scale was on average lower than in the laboratory tests. The tests for individual variants were compared, and the results obtained as follows: (a) tests on variant C were comparable with laboratory tests for Variant A. It was found that a 4-stage centrifugal having short stages does not meet the requirements of stepwise juice-bagasse counter-flow and only permits use of single-stage imbibition with water (cf. extraction $E_A = 87.73\%$ and $E_C = 62.69\%$). The final mills were unable to reduce the sugar content in the final bagasse sufficiently for $RE_C (91.17\%)$ to reach the 97.35% of RE_A . The final bagasse moisture content was about the same in both cases. For full-scale operation a centrifugal must be designed which would meet the conditions of the arrangement in Variant A, shown schematically in Fig. 9.

(b) The test for Variant D demonstrated the suitability of bagasse extraction as regards the centrifugal dimensions. Where primary extraction is about 75% as in Variant B, or where primary extraction is that such as obtained with the DDS diffuser at Phaltan^{2,3}, total extraction could be greater than 97%. For pilot-plant tests the 1st mill of the tandem was used for primary extraction, and according to the table an

extraction of 68.01% and a reduced extraction of 68.99% were achieved.

(c) Laboratory tests showed that the processes in Variants A and B are technologically practically the same and that with good primary extraction in the mills it would be possible to carry out the process using one single centrifugal and thus reduce production costs with full-scale operations.

Despite the shortcomings in the equipment used for the pilot-plant tests, the results for Variants C and D are good and the new method of cold extraction (milling + centrifuging) can be regarded as promising and encouraging for future full-scale operation.

Yellow wilt-resistant beet research.—A search for sugar beet varieties resistant to yellow wilt, a virus disease, will be accelerated under a cooperative agreement between the Beet Sugar Development Foundation, Fort Collins, Colo., and the U.S. Department of Agriculture (USDA). Yellow wilt stunts, wilts and eventually kills beet plants. It is comparable to severe curly top virus. Because of the wilt, sugar beet production in Argentina has been abandoned. Wilt is now causing damage in Chile, and the agreement is designed to give U.S. beet producers a head start on control if and when the disease strikes the U.S.A. Yellow wilt threatens sugar production in the eastern states where climatic and ecological conditions provide a favourable habitat for leafhoppers, the insect carrier of the disease. Under the two-and-a-half-year \$50,000 agreement with USDA's Agricultural Research Service (ARS), a scientist from the foundation, in cooperation with Chilean scientists, will evaluate varieties and parental lines for tolerance to the disease. They will also select and breed for resistance and study the nature of the organism that causes the disease. While economical methods of control are unknown, previous research has shown that there is a possibility of breeding tolerance into the plants. J. H. FISCHER is the principal investigator for the foundation and Dr. J. S. McFARLANE, Salinas, Calif., is the ARS representative.

* * *

Louisiana cane variety programme.—Scientists at the USDA Sugar Cane Laboratory at Houma, La., will study cane variety improvement and weed control under a trust fund cooperative agreement with the American Sugar Cane League of the U.S.A. Inc. The League will provide USDA's Agricultural Research Service with \$40,000 for the research. The expanded variety improvement programme will include crossing, screening for disease resistance and testing for high sucrose, yielding ability and processing qualities. Intended to provide superior varieties adapted to Louisiana, the research will be planned cooperatively by ARS and the League. It will also include investigations on controlling cane weeds. Dr. JAMES E. IRVINE, Director of the U.S. Sugar Cane Laboratory, is the ARS representative, and GILBERT J. DURBIN is the League representative in New Orleans, La.



Sugar cane agriculture

Cane agriculture in Réunion. ANON. *Rpt. Centre d'Essai de Recherche et de Formation (La Bretagne)*, 1975, 117 pp.—Among aspects of cane agriculture treated in this report are: the setting-up in 1976 of seed cane farms, using setts treated against RSD; mechanical harvesting, with mention of the various types of harvesters and loaders in use and to be introduced; results obtained with the Doucet stone collector which has shown promise, though costs have not been calculated—it is stated that collecting and transporting stones from a field are economically justified only when the quantity is below 100 tons per ha. Otherwise, it is more economical to discharge the stones on hillocks created by bulldozers at the sides of the fields. Gas-liquid chromatography was used to compare the sugar content in burnt standing and burnt chopped cane. Losses were found to be higher than indicated by polarimetry, e.g. 18% in standing burnt cane after 9 days as given by GLC compared with 9% found by polarimetry. On the other hand, GLC is considered too time- and labour-consuming for use as an industrial routine method, and is only recommended as a reference method. Enzymatic analysis for determination of sugar losses in cane is to be tested. Because of the new regulations banning the use of mercurial compounds, "Benomyl" is recommended for the control of pineapple disease, and has proved more effective than "Aretan" in this. A summary is presented of the disease situation in Réunion. Varietal susceptibility to smut has been determined in several regional trials. *Cephalosporium sacchari* (wilt) has occurred in varietal trials and in commercial fields in various regions, but at present it offers no obvious risk to the crop. The reappearance of the pest *Pulvinaria iceryi* is reported. Results are given of herbicide trials, particular mention being made of tests to control *Rottboellia exaltata* (rice grass), which has spread rapidly and is becoming a serious problem. While pre-emergence control is difficult, post-emergence control is possible with "Roundup" at 6 litres.ha⁻¹ for field perimeter treatment, and "Karmex" + "Hyvar X" + "Gramoxone" (3 kg + 1 kg + 3 litres per ha) for infield treatment when the cane is sufficiently developed. Full details are given of varietal trials in the different parts of the island. Interesting photographs depict intercropping with onion and with tobacco plus beans.

* * *

A study on ripening of sugar cane plants. I. The growth pattern of sugar cane and the accumulation of sugar in the ripening period. T. T. YANG and T. S. HSIEH. *Rpt. Taiwan Sugar Research Inst.*, 1975, (69), 9-17.—The effects of N, P and K deficiency on cane quality and growth were determined in greenhouse tests with plants of variety F 160. As control, cane was treated with an adequacy of all three nutrients in a mixture, while other samples were treated with only two out of the three nutrients. Results after 72 days showed

that the juice quality (expressed by Brix, purity, reducing sugar content and pol) for both mother stalks and tillers was highest in the N-deficient cane, followed by the P-deficient cane, control and K-deficient cane in that order. As regards accumulated growth, the maximum was achieved by the control, followed by K-deficient cane, P-deficient cane and finally N-deficient cane which had a growth index less than half that of the control. These results demonstrate that the amount of sugar produced in the growing cane can accumulate in the stalk as growth stops, so that the daily growth pattern of N-deficient cane is of value as a guide for cane ripening control. Similar results to the greenhouse experiments were obtained in field-grown irrigated and unirrigated cane.

* * *

Cane breeding in Louisiana. L. L. LAUDEN. *Sugar Bull.*, 1976, 54, (14), 10-11.—The cane breeding programme in Louisiana and the parts played by Louisiana State University, the US Dept. of Agriculture and the American Sugar Cane League are outlined.

* * *

Sugar cane technology in the past half-century in India. I. Sugar cane production. S. THANGAVELU and K. SUNDARESAN. *Indian Sugar*, 1976, 25, 779-783.—Information is given on the cane area, cane production and yield per acre in India from 1923 to 1974; the proportion of the area under Co canes and the actual area involved are also given up to 1946. Although the proportion of cane not processed (but used as seed cane or for chewing) has tended to fall during the period investigated, the authors consider that the amount (16.5 million tons in 1974) should be drastically reduced so as to increase sugar output.

* * *

The role of Co 449 in the evolution of newer sugar cane varieties. N. BALASUNDARAM, S. THANGAVELU and K. SUNDARESAN. *Indian Sugar*, 1976, 25, 785-790.—The role played by Co 449 (obtained from POJ 2878 × Co 331) as genetic stock is examined. Lists are given of varieties having Co 449 or its progeny as a parent. A total of 249 varieties can trace their ancestry to Co 449.

* * *

Yellowing disease of sugar cane and its control. K. N. GOYAL and R. N. S. TYAGI. *Indian Sugar*, 1976, 25, 791.—Yellowing disease, a severe problem in Rajasthan, causes stunted growth and yellowing of the leaves, which finally die; eventually the entire clump withers. Tests have shown that it is not caused by viruses or nematodes. Application of 1% ferrous sulphate containing citric acid, tartaric acid or an imli fruit extract has proved successful in restoring the green colour to the leaves. A 1% solution of ferrous sulphate containing 2.5 g.litre⁻¹ citric acid is more effective and cheaper than sulphur dust.

A chemical ripener for sugar cane. ANON. *S. African Sugar J.*, 1976, 60, 205–207.—“Ethrel”, a product of Industrial Chemical Products Ltd., has been registered by the South African Government for use as a cane ripener after 5 years of field tests. “Polaris” has not proved as successful as “Ethrel” under South African conditions, similar results being obtained only when 4 times as much “Polaris” as “Ethrel” was applied. Results have indicated a sugar yield increase averaging 0.7 tons.ha⁻¹ following application of 2 litres.ha⁻¹ “Ethrel”; tests are under way to see if 1 litre.ha⁻¹ would be as effective. Advice is given on optimum conditions for application of the ripener, and the economic effects of chemical ripening are briefly discussed.

* * *

Cane trailer braking systems. ANON. *Producers' Rev.*, 1976, 66, (4), 11–13.—Under new regulations in Australia which were to come into force on 1st July 1976, cane trailers used on roads must be provided with brakes. Details are given of the regulations and possible exemptions. Photographs are given of some of the types of cane trailers used by farmers in Queensland.

* * *

Aerated steam as heat source for control of stunting disease. L. L. LAUDEN. *Sugar Bull.*, 1976, 54, (13), 8.—Advantages of steam over hot air for cane sett treatment against RSD include the removal of need for hand stripping, greater adaptability to mechanical handling, a shorter treatment period (4 instead of 8 hours), and greater uniformity of temperature during the last 3 hours of treatment. Good control of the disease is obtained by treatment at 51°C; the setts should be stacked in mats not more than 15 inches tall with a 3-inch gap between the mats. It is emphasized, however, that growers who do not care to use steam but have hot air units should use these, since the virus will still be destroyed and falls in cane yield thus prevented.

* * *

Suggested use of “Asulam” (“Asulox”) in Louisiana sugar cane. ANON. *Sugar Bull.*, 1976, 54, (13), 15. Advice is given on ground or aerial application of “Asulox” post-emergence herbicide to control rhizome Johnson grass in ratoon cane in cases where the level of infestation is moderate-to-high.

* * *

Controlling Johnson grass, Raoul grass (itch grass) and *Equisetum* (“popping” weed) in the Louisiana sugar cane areas. D. T. LOUPE and L. L. McCORMICK. *Sugar Bull.*, 1976, 54, (15), 10, 14.—Advice is given on chemical control of the three weeds named in the title. It is pointed out that the type of vegetation which will grow on ditch banks after control of Johnson grass is governed by the herbicide used, treatment with MSMA usually being followed by an invasion of Bermuda grass, while “Dalapon” treatment is generally followed by growth of various broadleaved weeds and vines; of the two types of weeds, Bermuda grass is considered as probably more effective in reducing soil erosion and in limiting reinfestation by Johnson grass seedlings. On the other hand, if Bermuda grass is invading cane fields from ditch banks, alternation of MSMA and “Dalapon” treatment is recommended.

* * *

Stalk height and number as components of sugar cane yield. J. A. MARIOTTI and I. A. TUROWSKI. *Rev. Agron. Noroeste Argentino*, 1975, 12, (1/2), 7–24.—As

a sufficiently varied group, 126 clones from 5 hybrid progenies bred at Tucumán Experiment Station were studied over a 6-month period. At monthly intervals 5-stalk samples were measured for height, average stalk weight, cane yield by weight and juice sucrose content. Different traits were shown by groups of certain characteristics within the total population, and the heights and stalk numbers in each control strongly determined these characteristics in the following period. On the other hand, no associations were detected between the patterns of increase in height and decrease in stalk number. The final heights and cane yields were strongly affected by the elongation pattern during the ripening period April–June.

* * *

Response of sugar cane genotypes to natural and induced environmental stimuli. J. A. MARIOTTI, D. L. PLOPER, E. S. OYARZABAL, A. R. BULACIO, I. A. TUROWSKI, J. M. OSA, M. T. DIVIZIA and R. A. AVELLANEDA. *Rev. Agron. Noroeste Argentino*, 1975, 12, (1/2), 25–44. The effects on 100 clones of different planting sites, different levels of N fertilization and variable weed competition were examined and the response graded between values of +5 and –5. It was concluded that the scale could be used satisfactorily for the purpose; that the clones responded differently to variation in the environmental stimuli, showing a wide range of interactions; and that this provided a possibility of identifying valuable varietal material. The stability of the clone characteristics in the populations investigated is associated with phenotypes of the same characteristics under certain environmental levels, and the reactions to environmental stimuli shown by several yield components appear not to be inter-associated.

* * *

Studies of clonal selection of sugar cane in conditions of competition with natural weed communities. J. A. MARIOTTI, I. A. TUROWSKI, D. L. PLOPER and E. S. OYARZABAL. *Rev. Agron. Noroeste Argentino*, 1975, 12, (1/2), 45–64.—The effect of weed competition over a 45- and 90-day period on the yield and quality characteristics of a group of 100 clones was examined. The data were analysed, estimating heritability, phenotype and genotype correlations and selection efficiency. Absence of weed competition induced a smaller clonal discrimination for characteristics such as stalk number and weight. Efficiency of indirect selection by environment was 80% of that with greater competition. It was evident that increasing weed competition affects the yield structure, and selection criteria should therefore be modified to relate to normal commercial practice.

* * *

Studies of clonal selection in sugar cane at different levels of nitrogen fertilization. J. A. MARIOTTI and O. GIMÉNEZ L. *Rev. Agron. Noroeste Argentino*, 1975, 12, (1/2), 65–78.—A total of 100 clones were grown in replicated plots having 0, 60 and 120 kg N per hectare applied, and the yield and cane quality data obtained were analysed for repeatabilities, heritabilities and phenotype and genotype correlations. Estimations were also made of theoretical efficiency of cross-selection from a control environment. The bulk of the population investigated showed a response to N similar to that in highly selected commercial varieties. Levels of N did not greatly affect estimates of repeatabilities or heritabilities of most traits,

although the latter were higher for some characteristics with the 120 g N level, and associations were low at the 60 kg N level.

* * *

Genetic variability studies of isoperoxidases and morphological characters in sugar cane sub-clones obtained by means of "in vitro" cultivation. A. M. FRIAS DE F., H. J. ANTONI and M. E. LOZZIA DE C. *Rev. Agron. Noroeste Argentino*, 1975, 12, (1/2), 79-91.—The genetic variation connected with peroxidase isoenzyme was studied as well as some morphological variations which were found in 46 sugar cane clones. These clones were obtained by tissue culture from a commercial variety, NA 56-79. The difference between clones—checked by a statistical test—were in the range of 10–30% of the controls. Morphological features of ligule and auricle showed differences between the commercial clones and the 46 sub-clones, although no significant correlation was observed between enzymatic and morphological variations. Factors possibly responsible for such variations are also discussed.

* * *

Sugar cane weed species in the Argentine Republic. R. A. AREVALO. *Rev. Agron. Noroeste Argentino*, 1975, 12, (1/2), 95–105.—A list of 194 weed species observed during the past ten years is presented, classified by family, genus and whether annual or perennial. The most important are *Sorghum halepense* (L.) Pers., *Cynodon dactylon* (L.) Pers., *Panicum maximum* Jacq., *Brachiaria plantaginea* (Link) Hitchc., *Setaria leiantha* Hackel, *Cyperus rotundus* L., *Eryngium ebracteatum* Lam, *Cucurbitella duriaei* (Nand.) Cogn., *Sicyos polyanthus* Cogniaux and *Ageratum conizoides* L.

* * *

Fiji disease and boron. O. W. STURGEES. *Australian Sugar J.*, 1976, 68, 72.—In answer to a suggestion that boron deficiency gives symptoms similar to those of Fiji disease, and that possibly cane which is destroyed because of Fiji disease infection is in fact not diseased, it is pointed out that all the evidence of infection is irrefutable. Virus particles have been found in infected cane and the leafhopper vector; disease has been transmitted to uninfected canes only when leafhoppers have been placed on them but not otherwise (even when infected and healthy canes are growing side by side); Fiji disease was controlled years ago by systematic measures but has reappeared in the same areas, despite non-boron fertilization under both disease and disease-free conditions; and boron application to healthy and Fiji-disease infected cane had no effect on the disease in investigations. Mention is made of two varieties which have proved to be resistant to Fiji disease in field tests and may help to contain the disease.

* * *

Plant-parasitic nematodes associated with sugar cane in Barbados. C. W. D. BRATHWAITE. *Plant Disease Reporter*, 1976, 60, 294–295.—Of 20 genera of plant-parasitic nematodes found in soil and root samples from 45 cane fields in scattered areas of Barbados, the most widely distributed were: *Aphelenchus* spp. (89% occurrence), *Helicotylenchus* spp. (77%), *Pratylenchus* spp. (64%), *Tylenchus* spp. (61%), *Rotylenchus* spp. (35%), *Criconeimoides* spp. (30%), *Meloidogyne* spp. (27%), *Trophurus* spp. (25%), *Tylenchorhynchus* spp. (16%), *Aphelenchoides* spp. (14%), *Ditylenchus* spp. (11%) and *Trichodorus* spp. (9%). Important species

identified were: *Aphelenchus avenae*, *Helicotylenchus curvatus*, *H. concavus*, *H. dihystra*, *Pratylenchus zeae*, *Hemicriconeimoides cocophilus*, *Rotylenchus reniformis*, *Boleodorus thylactus* and *Paratrophorus loofi*. The high frequency and high densities of lesion nematodes (*Pratylenchus* spp.), which cause dark brown-to-black lesions on buttress roots and were particularly numerous in older crops, suggest that they may contribute to yield decline, although spiral nematodes (*Helicotylenchus* spp.) may also play a part. Leaf chlorosis and poor cane growth were observed in areas of high spiral and lesion nematode densities; these areas also suffered from low rainfall. It is suggested that nematode infestation may affect the ability of roots to absorb water under moisture stress conditions. Root-knot nematodes (*Meloidogyne* spp.) were less abundant than lesion or spiral nematodes, but did occur at high densities in some areas, although severe galling of roots was generally not obvious.

* * *

The development of farming mechanization on TSC plantations. ANON. *Taiwan Sugar*, 1976, 23, 49–52. Developments in mechanical cane planting and harvesting on farms of the Taiwan Sugar Corporation during the 30 years of the Corporation's existence are surveyed.

* * *

Switching to road transportation. ANON. *Taiwan Sugar*, 1976, 23, 63–66.—The gradual changeover from rail to road transportation of cane and other factory raw materials in Taiwan is discussed and future developments indicated.

* * *

Sugar cane breeding (between 1946 and 1976). I. S. SHEN. *Taiwan Sugar*, 1976, 23, 83–86.—A survey is presented of 30 years of cane breeding at the Taiwan Sugar Research Institute, which up to 1975 had resulted in the release of 43 varieties in the F series, which are now grown on 98% of the total cane area of Taiwan. Developments in breeding techniques, the characteristics of certain F varieties, and mutation breeding are discussed.

* * *

Thirty years' research and development in sugar cane cultivation. S. J. YANG. *Taiwan Sugar*, 1976, 23, 89–92.—Work conducted at the Dept. of Agronomy, Taiwan Sugar Research Institute, is described, covering establishment of the special nursery system for cane cuttings, ratooning, paddy sugar cane growing, intercropping, field mechanization, cane ripeners, irrigation and drainage, weed control and the agricultural meteorological service.

* * *

Research progress in plant protection. Y. S. PAN. *Taiwan Sugar*, 1976, 23, 93–96.—The author describes disease and disease control research in Taiwan, work on cane entomology, and chemical control of soil-inhabiting insects and rats.

* * *

Our groundwater research. Y. CHU. *Taiwan Sugar*, 1976, 23, 101–103.—The irrigation well construction programme in Taiwan is surveyed. It is pointed out that 75% of the combined agricultural and industrial water requirement in the sugar industry is met by groundwater.

Agro-industrial characteristics of some commercial varieties. A. I. BASSINELLO. *Brasil Açuc.*, 1976, 87, 320-322.—Descriptions are given of the varieties CB 41-76, IAC 51/205, IAC 52/150, NA 56-62, CB 46-47, CB 56-126, CB 40-69, IAC 48/65, IAC 51/201, CO 40-77, CB 61-80 and CB 47-89.

* * *

Contribution to the study of the system of mechanized harvesting of sugar cane. T. C. RIPOLI and L. A. BALASTREIRE. *Brasil Açuc.*, 1976, 87, 323-329. Equations are developed by means of which a number of factors are taken into account in assessing the minimum number of transport vehicles to be used in conjunction with a single cane harvester.

* * *

Effect of growth regulators on growth, juice quality and yield of sugar cane in CoJ 64. G. SINGH and K. SAREEN. *Indian Sugar*, 1976, 25, 911-915.—Investigations were made of the effect of gibberellic acid (GA) and of ascorbic acid (AA) on stalk formation, tillering, number of millable canes and juice quality of CoJ 64 cane. Tabulated results showed that GA applied at 75 and 100 ppm in the pre-monsoon period caused significant stalk elongation, while lower concentrations were less effective. However, GA had no beneficial effect on stalk length in the monsoon and post-monsoon periods, but rather inhibited growth. AA had no effect on stalk elongation at any time, and neither GA nor AA affected the other factors studied.

* * *

Influence of foliar application of potassic fertilizer on chemical composition of sugar cane foliage. S. SITHANANTHAM, T. K. SRINIVASAN and T. K. G. RAO. *Indian Sugar*, 1976, 25, 917-918.—Spraying with 3% KCl solution three times at 3-week intervals starting 35 days after planting (giving a total of 33.75 kg.ha⁻¹) caused a reduction in leaf P, Na, Si and total sugars contents compared with the controls (sprayed only with water), while N, K, Ca and Mg were increased. When 0.1% "Endrin" was applied with the KCl, the P and Na contents were increased by comparison with the controls, while the Ca content fell. The decrease in total sugars and Si was markedly reduced by the "Endrin", while the increases in N and Mg contents were greater than with KCl alone. "Endrin" had been found earlier to have growth-promoting effects on cane. The increase in N content caused by the insecticide may also add to the borer-controlling effects of "Endrin".

* * *

Drip up-date. W. S. HAINES. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 19-28.—Progress made with drip irrigation in Hawaii since its introduction on test plots in 1970 is surveyed. To prevent plugging of the orifices in the plastic piping, sterilization with chlorine is used as well as periodical flushing—it was found that small particles were agglomerating, probably as a result of bacterial growth in the water. Damage by pests has proved to be insignificant as a consequence of the use of insecticide and rodent bait. The possibility of incorporating repellents in future tube materials is suggested. Capital costs of drip irrigation systems have varied widely; variables affecting costs are listed. While harvest data for 1974 and 1975 indicate that sugar yields should be as high with drip irrigation as with furrow irrigation used previously, there is insufficient material to indicate water utilization efficiency.

Harvesting up-date: Amfac concepts. A. S. HALL. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 29-30. Examination of the cane material in a push-raked windrow showed that about two-thirds of the extraneous matter occurred in the bottom third of the pile, so that delivery of cane from the top two-thirds of the pile would reduce the extraneous matter transported as well as halve the waste at present removed (and needing disposal) by cleaning plant. On rocky, flat land tests were conducted on the use of high-pressure water to cut cane; a system using 100 gal.hr⁻¹ at a pressure of 45,000 psi is suggested, and further tests are, it is hoped, to be carried out. Cane cutting with a flail was also tested. The cut was not sufficiently clean, so that stalk material was lost, although the leaves were easily removed without stalk damage. However, there is potential danger from flying stones when a flail is used, and power requirements are probably much higher than for a sharp blade. A Thomson-Duncaña two-row cut-windrow harvester has shown promise.

* * *

Mechanical harvesting up-date. C. C. MONTGOMERY. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 31-33.—The author describes the system used by the Hawaiian Sugar Co. in whole-stalk harvesting and cleaning. Chopped cane harvesting has been abandoned because of certain problems, particularly the inability to take the cane trailers into the field and the high costs resulting from this.

* * *

Sub-surface irrigation—engineering research. S. LANTING. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 57-62.—Research on sub-surface drip irrigation at the HSPA Experiment Station is reported. An experimental "plough injector" for insertion of piping at a required depth in a furrow has given good results in well-prepared soil; a packing wheel helps to firm the disturbed soil. Large stones must be avoided, and a method must be found for maintenance of an adequate tube depth at field ends, where access to the tube is required. Interruption of flow of flushing water through the tubing was caused by pinching where tube depth had not been maintained, although irrigation flow may not be affected by pinching. After seed cane harvesting, pinching was found in 22 out of 24 laterals, but after several weeks of operation and a short period with increased water pressure, pinching nearly disappeared and germination of the ratoon crop was excellent.

* * *

Single-chamber drip irrigation laterals on various field slopes and contours. U. BUI and W. GIBSON. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 63-68.—Advantages and disadvantages of the dual-chamber distribution tube, as used on most of the Hawaiian cane land under drip irrigation, are discussed. The principal defect is its proneness to orifice plugging, which has been found to be reduced in single-chamber tubes. While unplugging can be easily accomplished by increasing water pressure and single-chamber tubes are cheaper than the dual-chamber types, problems arise with the uneven contours on the downhill slopes which are typical of the irrigated cane land in Hawaii. The single-chamber tubing has been adopted by several plantations on land with low and generally uniform slopes, and investigations are under way with a computerized model to see if water distribution and

A black and white photograph of a spoon pouring a stream of white sugar granules into a white cup. The sugar is captured mid-air, creating a dynamic, cascading effect. The background is dark, making the white sugar stand out.

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vigorous tube flushing can be obtained with such tubing under the more adverse conditions of variable gradients and irregular contours.

* * *

Flushing valve for drip irrigation tubes. W. GIBSON and U. BUI. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 69–72.—Information is given on a special valve developed by the HSPA and manufactured under licence by Wisdom Industries, Honolulu, which is intended for flushing drip irrigation tubing with water and chlorine. Details are given of the procedure used in installation and operation of the valves.

* * *

Recommendations for avoiding plugging of drip irrigation tubing. R. BELEW. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 73–74.—A list of recommendations is given for prevention of plugging of drip irrigation tubing.

* * *

Drip irrigation: problems and solutions on the island of Hawaii. R. M. BADER. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 75–78.—Experience with drip irrigation on two cane plantations, one owned by Ka'u Sugar Co. and the other by Honokaa Sugar Co., is reported. The Ka'u plantation plans to use sub-surface drip irrigation for all of its seed cane, while the Honokaa system has shown considerable improvements on the previous sprinkler system despite a number of problems.

* * *

Drip irrigation—problems and solutions. McBryde's experience. G. WILLIAMS. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 79–82.—Experience with drip irrigation on cane land belonging to McBryde Sugar Co. Ltd. is discussed. Despite a number of problems mentioned, the company planned to increase the area under drip irrigation to 1076 acres by the end of 1976. Brief mention is made of ratooning in drip-irrigated fields.

* * *

"Polaris" response in 1975. L. OUDMAN. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 87–92.—From examination of the results of a number of block trials with "Polaris" as cane ripener, it is concluded that the poor result (an increase of only 0.11 tons of sugar per acre over that from untreated cane) was the outcome of harvesting during heavy rain and that such results are unreliable where the difference between the rainfall in the area of treated cane and that in the control area exceeds 2 inches.

* * *

Basic cane growing at Gay & Robinson. W. S. ROBINSON. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 96–100.—The agricultural techniques used on the smallest cane plantation in Hawaii (consisting of 2800 acres) are described.

* * *

Basic cane growing at Waialua. M. UEHARA. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 101–105.—Cane agriculture on the 15,000 acres of land owned by the Waialua Sugar Co. is described.

* * *

How drip irrigation affects cultural practices at Oahu Sugar Company. S. M. TUTTON. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 106–108.—The type and quantity of equipment required for drip irrigation as it is

being gradually extended over all the cane land owned by Oahu Sugar Co. are indicated for each year of expansion, and the costs are shown.

* * *

The effect of drip irrigation on cultural practices and equipment on Maui. C. T. FISHER. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 109–112.—The effect of drip irrigation on cane agricultural practices on the three plantations owned by Hawaiian Commercial and Sugar Co. is examined, with particular mention of soil preparation, replanting and ratooning, but also with briefer references to problems associated with other aspects of cane growing.

* * *

Cultural practices for drip irrigation for Kauai. J. B. THOMSON. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 113–114.—Information is given on the agricultural practices used in conjunction with drip irrigation on cane plantations on the island of Kauai.

* * *

Sugar cane harvester and transport developments in Florida, Texas and Louisiana. J. E. CLAYTON and B. R. EILAND. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 115–121.—A survey is presented of progress with mechanical cane harvesting and transporting in the three US mainland cane-growing states.

* * *

Methods of removing trash from sugar cane on chopper harvesters. J. E. CLAYTON, B. R. EILAND and G. N. FRANKS. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 122–127.—After discussing the effect of the chopping system on cane cleaning, the authors examine the role of spiked-tooth cylinders (found to give good preparation of the cane for pneumatic cleaning) and then discuss cane losses caused by suction fans used to remove extraneous matter. Tests are reported, and research on fan blade design is described. Mention is made of experiments to screen trash before it enters the fan blades so as to reduce cane losses. A device for separating trash from air comprised an open-mesh conveyor belt 3 ft below the fan blade; trash on the belt passed through the fan housing and was released when the suction was reduced. Any light trash on the returning section of the belt (which was closer to the fan blade than the outgoing section) was "lifted" through the blade. A small quantity of unburnt cane was still held by the trash and discharged with it, giving a loss of 1–2% cane; this loss would be lower in the case of burnt cane. The trash was discharged by a chute to a point beside the harvester but at a level at which it would not blow onto the cane transport. A rotary perforated disc is being tested for trash screening; the advantage would be a reduction of the number and complexity of the moving parts.

* * *

The use of rubber-tyred four-wheel drive tractors in sugar cane operations. J. LYONS. *Rpts. 1975 Meeting Hawaiian Sugar Tech.*, 191–195.—A representative of Steiger Tractor Inc. discusses the advantages of the title tractors in cane field operations.

* * *

Dactyloctenium aegyptiacum, an additional host of sugar cane mosaic virus. S. SINGH. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 1–2.—*D. aegyptiacum* growing in the vicinity of cane fields in Coimbatore,

India, has revealed symptoms of mosaic. (See also SINGH & BHARGAVA: *I.S.J.*, 1976, **78**, 143.)

* * *

Current status of sugar cane mosaic virus strains in Louisiana sugar cane fields. H. KOIKE. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 3-5.—Surveys of the mosaic strains in Louisiana have shown that strain H predominates, infecting 75-97% of the cane in three areas. The incidence of strain I has varied during the past 8 years, but does not appear to have increased. This strain is more severe in its effects on stands and yields than is strain H.

* * *

Association of unusual symptoms with smut of sugar cane in the Sudan. I. A. NASR. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 6-8.—The author reports unusual symptoms of culmicolous smut on N:Co 310 cane in the Sudan. The symptoms took the form of flower derangement; the flower had seven glumes which were converted into green foliar structures, while the stamens were either suppressed or absent. The gynoeceum terminated in a miniature curved or convoluted whip 1.5-8.0 cm long. The symptoms were found on many stalks in different parts of the same field.

* * *

Fodder sorghums as hosts of *Perkinsiella saccharicida*. R. OUTRIDGE and D. S. TEAKLE. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 9-10.—*P. saccharicida* adults were caged with wild and cultivated seedlings of *Sorghum sudanense* and *S. bicolor* in greenhouse tests, and the numbers of the leafhopper (a vector of Fiji disease) were counted after 11 and 56 days. Most of the 15 adults added to each seedling pot died within 11 days, but oviposition sites were clearly visible in the midribs of the leaves, and small numbers of first instar nymphs were seen. Counts after 56 days showed that on three of the sorghums some nymphs had reached adult stage. To determine if field-grown sorghum might support the leafhopper, a number of plants were collected and investigated. Although many insects hatched from oviposition sites in the plants, only one nymph from a cultivated fodder sorghum proved to be *P. saccharicida*.

* * *

Nature of the bacterium associated with ratoon stunting disease of sugar cane. A. G. GILLASPIE, R. E. DAVIS and J. F. WORLEY. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 11-15.—It is stated that, while most workers agree that the RSD agent is probably a bacterium, the exact nature of the organism and its size remain controversial. Ultrafiltration and phase-contrast, dark-field and electron microscopy have been used to increase the knowledge on the pathogen, and it is concluded that it is a non-motile coryneform bacterium measuring approximately 0.3-0.4 μm \times 3-10 μm . Regarding reports that *Xanthomonas albilineans* or *X. vasculorum* is the agent, the authors point out that these pathogens do produce symptoms which are similar to RSD in certain stages.

* * *

A sclerotial disease of the basal stem and root in sugar cane. K. C. ALEXANDER. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 16-17.—A fungal disease

found on Co 419 cane in 1972-74 caused complete stunting of the stools, while the cane stalks were pale, shrunk and dying in many cases. In earlier stages of infection, the plants appeared to be wilted during late afternoon, but the leaves regained turgor during the cooler hours. In advanced stages, the stalks were dead, and the roots were found to be completely infected and stubby, while no young roots were found. Lower sheaths, wherever present, were shredded and easily removed. Diseased stools were easily pulled out of the ground; white mycelia covered the underground parts and up to 6 internodes above ground, while sclerotia were formed on dead roots just below ground level. Affected stalks, when split open longitudinally, revealed light brown, water-soaked sunken lesions which later turned dry. The pathogen is a basidiomycete with white mycelium having clamp connexions; no sporophore was noticed, and attempts to induce any were unsuccessful. The disease was reproduced with all the symptoms in pot culture studies; it was controlled by drenching with 0.25% "Ceresan" followed by copious irrigation. The fungus did not appear to belong to the *Marasmius* genus.

* * *

***Digitaria adscendens* Henrand—a natural host of sugar cane mosaic virus in the Bhabhar belt of Nainital District (of India).** R. D. JOSHI and U. P. GUPTA. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 18-19.—*D. adscendens*, an important fodder grass in the title area, has been found to be a natural host of cane mosaic. Symptoms of the disease and transmission tests involving a large number of different plants are reported.

* * *

Bacterium associated with ratoon stunting disease in Louisiana. K. E. DAMANN and K. S. DERRICK. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 20-22.—Details are given of two techniques used to obtain bacterial extracts from RSD-infected cane for use in electron microscopy. A bacterium having distinctive morphological features was found, while healthy cane yielded no such bacterium. From the evidence, it is concluded that the bacterium is the same as that described by GILLASPIE *et al.*¹. Staining with phosphotungstate revealed the presence of mesosomes, whereas *Xanthomonas* spp., associated by some authors with RSD, should not exhibit mesosome structure when stained.

* * *

Anti-fungal property of mosaic virus-affected sugar cane leaf extracts. L. N. DUBEY and R. D. JOSHI. *Sugarcane Pathologists' Newsletter*, 1976, (15/16), 23-25.—Investigations to determine if extracts of cane mosaic-infected leaves inhibited germination of spores of *Colletotrichum falcatum* (the red rot pathogen) and *Ustilago scitaminea* (smut pathogen) are reported, details being given of the technique used. Results showed that the leaf sap from the infected cane significantly inhibited spore germination, the effect on *U. scitaminea* being greater. Strain B of the mosaic virus had the greatest effect on germination of *C. falcatum*, followed by strains A, F and D; strain A of the virus had the greatest effect on *U. scitaminea*, followed by strains B, D and F.

¹ *I.S.J.*, 1976, **78**, 370.



Sugar beet agriculture

Variety tests pinpoint the best hybrids. R. C. ZIELKE. *Sugar Beet J.*, 1976, 39, (3), 5-7.—The beet characteristics determined in varietal trials as conducted in the USA are listed, and details are given of the various types of trials conducted. Results obtained in 1975 are briefly discussed, and general trends for the future are indicated.

* * *

Increased information from Saginaw Valley Research Farm. D. R. CHRISTENSON. *Sugar Beet J.*, 1976, 39, (3), 8-10.—Results of experiments obtained at the Saginaw Valley Bean and Sugar Beet Research Farm in Michigan are reported. Comparison of beet yields in four 3- and 4-year rotation systems showed that maximum was achieved with a corn-corn-beet system, followed by beans-beans-beet and corn-corn-beans-beet, although corn-corn-corn-beet yielded the lowest of all systems; while oats-beans-beet gave the lowest beet yield of the 3-crop systems, oats-alfalfa-beans-beet gave the second highest yield of the 4-crop systems. *Rhizoctonia* crown rot was found to be affected by crop rotation and was 4 times greater when beans were grown immediately before the beet crop. The organism survives on bean residue but not on corn stalks, although the incidence of the disease is so small that it has not affected yields. Beet and sugar yields per acre were greater with 19-inch row spacing than with a 14-inch spacing, while results for a 28-inch spacing were the poorest of the three. Moreover, beet quality tended to be better with the narrower rows. While broadcast application of 200 lb diammonium phosphate plus banding of 100 lb gave the highest beet yield of the various combinations tested (all based on a total application of 300 lb), increase in the amount applied by banding caused a general fall in yield, but the lowest yield was given by broadcast application of all 300 lb. Beet and sugar yield were higher when 60 lb N was carried over from a previous corn crop, and 80 lb was applied to the beet, than when 160 lb N was carried over. On the other hand, 160 lb N carried over plus 40 lb applied gave the highest sugar yield per acre. However, juice purity fell with the quantity of N carried over and/or applied. The extent of N carry-over depends on the type of previous crop.

* * *

A long look at sugar beet quality at harvest. M. G. FRAKES. *Sugar Beet J.*, 1976, 39, (3), 11-15.—The growth stages of the sugar beet are described, with particular attention focused on the physiological processes taking place at maturation, when the cell walls harden and sugar is accumulated. Agronomic and climatic factors affecting beet growth and quality are discussed, and recommendations are given on how the grower can achieve maximum results by optimizing soil condition, nitrogen application and harvest time.

Trials of commercial varieties of sugar beet. D. S. KIMBER and S. F. H. MCCULLAGH. *British Sugar Beet Rev.*, 1976, 44, (2), 8-9.—Details are given of beet varietal trials conducted by the National Institute of Agricultural Botany (NIAB) in 1973-75. Data for 10 varieties include root number and yield, sugar content, sugar yield, clarified juice impurities content, and bolter percentage. A new variety, "Amber", has been added to the list of recommended varieties, since it has higher than average sugar content and low impurities content, gives above-average sugar yield and suffers from only a low incidence of bolting. "Sharpes Klein E", more widely grown than any other variety in the UK during the past 40 years, has suffered from a drop in performance in recent years and has been removed from the recommended list.

* * *

Group harvesting. D. CHARLESWORTH. *British Sugar Beet Rev.*, 1976, 44, (2), 11-13.—Information is given on three farmers' groups in Suffolk, made up of 5, 5 and 6 members, who pool labour resources and equipment for beet harvesting and transportation to Ipswich sugar factory. The pattern of operation in each group is explained and advantages of the system are indicated.

* * *

Effective subsoiling. G. SPOOR. *British Sugar Beet Rev.*, 1976, 44, (2), 28-29.—In a discussion of subsoiling, it is pointed out that there is a critical depth, below which operation of a subsoiler may cause compaction rather than the desired loosening of the soil. The critical depth can be increased by widening the share point on the subsoiler or by loosening the surface layers before subsoiling, the second method being regarded as the more efficient. Various aspects of subsoiler operation are discussed, and a number of points listed, consideration of which is recommended so as to ensure that the maximum effect of subsoiling is obtained for the large amount of energy expended.

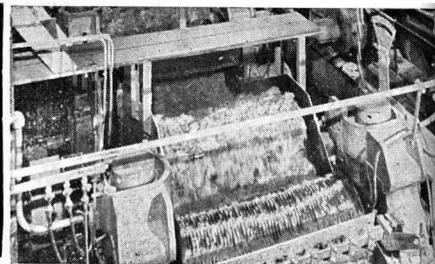
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The wild beet danger—bolters must be removed. ANON. *Die Zuckerrübe*, 1976, 25, (4), 13.—The problem of "wild" beet and the need to eliminate these bolters are briefly discussed. Best remedial means is considered to be removal of the flower heads. Advantages of bolter removal are indicated.

* * *

Straw—what is to be done with it? ANON. *Die Zuckerrübe*, 1976, 25, (4), 13.—Where cattle breeding is not practised or stubble not burnt (because of discouragement by local authorities), the question of what to do with straw is important. Its incorporation in the soil is one answer, but a number of measures need to be carried out in this case, and these are discussed.

Cane sugar manufacture



Pulverized coal firing of small boiler plant. A. G. HURTER. *S. African Sugar J.*, 1976, 60, 217-229. See *I.S.J.*, 1976, 78, 183.

* * *

Classified crystal recycle with continuous pans. A. D. RANDOLPH and E. T. WHITE. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 179-181. Of major concern in continuous boiling is the crystal size distribution, which tends to increase as a result of the differences in residence times. While the usual approach is to use a large number of units in series or a multi-compartmented vessel, and thereby give a residence time distribution approaching that of a batch pan, such multiple units are costly to construct and pose certain operational problems. An alternative solution is to pass the final product through a classifier which would remove the large crystals as product and recycle the under-sized crystals for further growth. Advantages of such a scheme are discussed, and mention is made of a computer programme developed for calculation of continuous boiling parameters where classified crystal recycle is used. The model was used to compare two systems, one with and the other without classified crystal recycle; the classifier was found to permit considerable reduction in the coefficient of variation. Use of the model to examine other variables, such as the effect of crystal breakage on steady-state operation, and seeding rate, is also mentioned.

* * *

Sugar crystallization: a pan stage advisory scheme. J. A. FREW and P. G. WRIGHT. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 191-198. The application of a mini-computer and visual display at Racecourse factory to decision making in the pan station is reported. Two out of four levels of generally increasing complexity into which the decision system is divided were implemented in 1975. In the first level, the cycle is largely pre-determined and all the advice is based on measurements available at the time of decision, so that no prediction is involved. The starting procedure is divided into requirements which are mandatory and those that are recommended. The recommendations relate to the level in the feed tanks; while values of the parameters are selected to maintain the stage in balance and to minimize pan idling, when the level in any one tank falls below a minimum, the advice is given to place all the pans fed by that tank on idle. Advice on the rate of pan feeding is handled in a similar way, the rate being directly related to the level in the feed tank. If the level in a pan exceeds the normal value when full (plus a tolerance) and is continuing to rise, warning is given to terminate the feeding period and start heaving-up. Advice on centrifugal operation is on a first-come, first-served basis. The second level extends the recommendations for starting of the pans by replacing the feed tank level parameter with

a prediction of feed requirements and supplies over the feeding period, which involves forecasting centrifugal operation and the likely pan dropping time. Results obtained from 4 months of operation are discussed. The Level 1 starting advice was only of help when pan operation was according to plan, and, while it could be useful in eliminating some erratic behaviour, it did not consider enough of the factors to be of assistance when abnormal conditions arose. The Level 2 scheme was a considerable improvement in this respect and could match the supervisors over a much wider range of conditions. However, its shortcomings lay in the determination of the massecuite receiver and centrifugal status, since the system assumed a fixed boiling cycle with maximum feeding, whereas the station at Racecourse allows for considerable flexibility in the boiling cycle arrangement.

* * *

Final actuators—there is a choice. P. J. PIETILA. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 199-203.—Of importance in a control loop is the final actuator, which provides motive power for operation of valve, damper, etc. Desirable features of an actuator are listed, and the basic types of final actuators described. Advantages and disadvantages of each type (pneumatic, electric and hydraulic) are indicated.

* * *

Control of a clarification station. R. L. MULLER. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 215-218.—At Millaquin, the mud level in the clarifier is controlled by ultrasonic interface probes, signals from which are transmitted to pre-set timers controlling the draw-off valve, so that flow rate can be increased or decreased or maintained constant (for which the timers are adjustable) according to requirements. The mud flows by gravity to a receiver and thence to a positive-displacement air pump which transfers it to a surge tank mounted above the bagacillo mixer. From this mixer, the mud gravitates to the mud filter. Possible future controls are also briefly discussed.

* * *

Flocculant:juice ratio control. D. J. HALE and B. PARTRIDGE. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 219-225.—For control of the flocculant:juice ratio in a clarifier, a Fischer & Porter magnetic flowmeter in the juice line transmitted signals to a flow recorder and to a Foxboro ratio station which in turn fed signals to a variable-speed drive unit controlling the pump used to transfer the stock solution of flocculant to the juice line. The open loop system used operated satisfactorily in tests within a range of 1.6-4.0 ppm flocculant at an average clarifier feed rate of 250 m³ per hour with fluctuations of ± 50 m³.hr⁻¹. Costs are briefly discussed.

Clarification of cane juice between inclined surfaces. G. A. BROTHERTON. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 227-234.—Experiments on juice clarification in inclined tubes are reported, in which it was found that the same efficiency could be attained as in a vertical tube at a much higher upward flow velocity. It was subsequently found that inclined surfaces could give the same effect as tubes, and a test unit was set up having a slope of 60° to the horizontal (at which angle the greatest increase in upflow rate was achieved compared with vertical surfaces). Results showed a similar performance to vertical surfaces but at a 100% increase in flow rate. However, a commercial unit would need a number of tubes or surfaces, and the distribution of feed in such equipment has yet to be examined. The question of mud blockage also requires more investigation.

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Improved mud centrifuge performance at Mossman. P. N. STEWART, A. G. NOBLE and G. A. BROTHERTON. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 235-240.—Investigations of cane mud treatment in the "MercoBowl 22 L" centrifuge at Mossman¹ showed that cane treatment by a new shredder installed at the factory provided finer bagacillo and thus improved centrifuge performance, particularly when the shredder speed was raised from 750 to 900 rpm. The pol loss and mud retention compared favourably with the results obtained with a filter. Wax and nitrogen removal was also the same in the centrifuge as in the filter. While mud solids retention was improved by adding dilution water to the feedline, this was at the expense of an increased pol loss, and it is therefore preferable to add all or most of the wash water in the bowl. While the centrifuge is easier to operate and there is less ancillary equipment needed, the economics still do not favour the centrifuge because of its limited capacity, although future availability of larger machines could alter the situation.

* * *

Characteristics of a louvre-type bagacillo separator. P. C. IVIN and R. N. CULLEN. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 241-247. Tests on a pilot-scale louvred bagacillo separator, such as is being used in South Africa, are reported. Bagasse is fed across a louvre screen by means of a metering roll which controls feed rate. The bagacillo is sucked through an adjustable gap between the louvres and is conveyed pneumatically to a cyclone. At an optimum louvre pivot angle of 80°, a gap of 38 mm between louvres and a drum speed of 2 rpm (corresponding to a bagasse feed rate of about 77 kg.min⁻¹.m⁻¹), 98% of the bagacillo obtained was of 14 mesh size. If the air capacity was increased and hence the collection rate (from 550 to 1300 kg.hr⁻¹.m⁻¹), the proportion of 14-mesh bagacillo was reduced to 92%. Reduction in the number of louvres from 8 to 6 reduced bagacillo quality and considerably decreased recovery.

* * *

Residence time of crystals in a continuous centrifugal. R. J. SWINDELLS and E. T. WHITE. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 249-253. So as to improve the accuracy with which estimation is made of the massecuite layer thickness on the wall of a continuous centrifugal basket, measurements were made of the velocity of the layer by means of a

cine camera filming at stroboscopic speed (i.e. one exposure per revolution); this enabled a picture to be taken each time the basket rotated through one revolution, so that the same crystal could be captured on a number of frames and its motion up the basket traced. Velocities were plotted for a massecuite throughput of 5-8 tons.hr⁻¹; wide scattering occurred (reasons for this are suggested), and only 60% of the basket height could be photographed because of the stroboscope light dimness and the presence of steam. Velocity did not seem greatly affected by crystal position on the screen, so that extrapolation for the whole basket was considered valid. From the crystal velocity profile, both layer thickness and residence time can be estimated by means of an expression which is given. Calculation showed that at a mean crystal size of 0.35 mm, the layer varied from 17 crystals thick at the bottom of the screen to 7 crystals thick at discharge, i.e. an approximate ratio of 2.5:1.

* * *

Massecuite heating by finned tubes. L. K. KIRBY, J. N. NESS and E. J. STEWART. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 255-262. Experiments with a finned-tube massecuite reheater of 75 m² heating surface are reported in which massecuite temperature was raised from 41.3-51.1°C to 54.8-62.3°C at a throughput averaging 5.55 tons per hour. The overall molasses purity rose by 1.08 units from unheated massecuite to centrifugal discharge. The results are tabulated from 27 trials. Possible applications include a single-stage scheme in which massecuite is heated in individual units, one per centrifugal, from 38° to 55°C, and a two-stage system in which the cold massecuite is first heated in a common finned-tube heater and then in individual heaters; the authors favour the single-stage system. Also suggested is the installation of a finned-tube heater just after the crystallizer to raise the temperature to 45°C before existing resistance heaters. The results also indicate the possibility of raising the temperatures in the centrifugals so as to gain the advantage of reduced molasses purity with higher loading.

* * *

Effect of crystal on the viscosity of massecuites. M. AWANG and E. T. WHITE. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 263-270.—The effects of crystal properties (amount, size range and shape) and properties of the mother-liquor (total solids, purity and type of impurities) as well as temperature and shear rate on the apparent viscosity of a massecuite were investigated; the importance of each variable is indicated by the increase required to cause a 20% drop in viscosity, showing that temperature, molasses total solids content and crystal content are the major variables. Correlations between the last two parameters and viscosity were established and plotted for molasses from various sources, but it is stated that they are based on limited data and apply to deaerated samples; air bubbles have marked effects on results.

* * *

Comparisons of a reciprocating-element crystallizer with a coil-type crystallizer. J. N. NESS and E. J. STEWART. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 271-282.—Comparative tests were

¹ STEWART *et al.*: *I.S.J.*, 1976, 78, 85.

conducted on a new, patented crystallizer with reciprocating element, designed and manufactured by the Bundaberg Foundry Co. Ltd., and a Burnett crystallizer with rotating coil. While comparison of the crystallizers cooling the same massecuite was possible, assessment of the relative performance of the same crystallizer from test to test was more difficult because of the effects of uncontrolled variables, principally the change in massecuite properties. The new crystallizer gave substantially higher cooling rates than did the Burnett crystallizer, chiefly because of the greater surface area per unit volume, but an increase in the heat transfer coefficient was also established. The quantitative effects of the speed of reciprocation and of water flow rate on the coefficient could not be measured because of other uncontrolled variables. The new crystallizer also provided a greater molasses purity drop, viz. a 1.5 units decrease after 8 hours, compared with the Burnett crystallizer.

* * *

Rapid "dextran" formation in stale cane and its processing consequences. W. D. WELLS and G. P. JAMES. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 287-293.—The situation at South Johnstone, where a mill breakdown lasting some 29 hours caused a 3400% increase in cane dextran content and a c.c.s. loss greater than 14%, is described. Since the 5400 tons of cane affected could not be processed efficiently, a loss of \$A1800 per hour was estimated. In view of this, enzymatic removal of dextran is recommended for such cases of rapid juice deterioration.

* * *

Dextranase. II. Practical application of the enzyme to sugar mills. P. A. INKERMANN and G. P. JAMES. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 307-315.—The use of "Glucanase D-1" enzyme to hydrolyse dextran was tested at South Johnstone and Babinda. Full details are given of the investigations. Results indicated a 95-97% removal of dextran, leading to major improvements in factory performance and sugar quality despite the crushing of seriously deteriorated cane. However, it is stressed that the process is not to be recommended for general use because of the high cost of the enzyme and the possible introduction of inefficiency into harvesting, but it is of value where mill breakdowns or unavoidable delays occur. Complete removal of dextran is not considered essential in order to obtain major benefits.

* * *

Treatment of sugar mill waste by shallow ponding. J. F. BOND and K. E. MCNEIL. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 317-318. The scheme used at Pleystowe for treatment of effluent consists of five shallow ponds (1 m deep) of 15.31 ha total surface area; waste water (containing oil, grease and large quantities of fly-ash as well as the normal impurities) of 300-1200 mg.litre⁻¹ BOD₅ is discharged to the ponds at a maximum rate of 90 m³.hr⁻¹, while at the weekend a maximum of 227 m³ of effluent of 5000 mg.litre⁻¹ BOD₅ is also transferred, the ponds taking 1-3 weeks to fill. In 1975, the longest treatment period was 9 weeks, and the temperature was 20-27°C. Anaerobic treatment lasted for the first 3 weeks, during which 70-90% of the BOD was removed, after which aerobic treatment took place, with growth of algae. The BOD,

of the treated effluent was below 26 mg.litre⁻¹, while the dissolved oxygen content of the emptied ponds was 1-9 mg.litre⁻¹; however, the oil and grease contents as measured at three discharges were above the permitted level, so that traps to prevent these substances entering the ponds are necessary. Mechanical aeration was found necessary for some ponds to cope with the load; otherwise, for a factory of 400 t.c.h. capacity and producing 140 m³.hr⁻¹ effluent, the minimum total pond surface area should be almost double that at Pleystowe.

* * *

The water cycle in a sugar mill. K. A. STUART. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 319-321.—A typical hot water balance for a factory crushing 100 t.c.h. is presented and means of reducing water outflow are examined. Since the major source of effluent is excess hot water, the logical approach is to cool this water and recycle it where possible, thus reducing outflow and decreasing cold water requirements.

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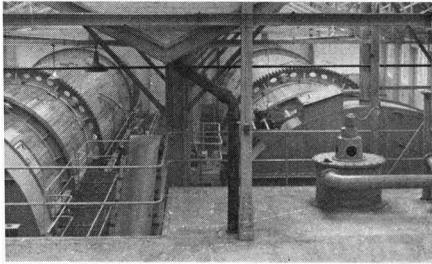
What every sugar mill owner should know—and is afraid to ask. A. L. WEBRE. *Sugar J.*, 1976, 38, (12), 15-16.—The two cane sugar factory processes where there is greatest scope for increasing efficiency, i.e. milling (with its effect on bagasse losses) and sugar-house work (with its effect on molasses losses) are examined. Failure of cane mill top rollers to float may be an indication of too rapid a throughput, leading to reduced extraction, or of excessive hydraulic pressure, which may also reduce extraction by compressing the bagasse and causing reabsorption. The author advocates that all mills be fitted with float indicators, and also recommends restricting the speed of the rollers to 5-6 rpm as is generally considered advisable. The value of the glucose:ash ratio as a criterion of molasses exhaustibility is discussed. Where final molasses purity is too high, attention should be paid to boiling, crystallization and centrifugal performance. Determining the molasses purity in the massecuite after the crystallizers but before spinning, and comparing the result with the purity of molasses discharged from the centrifugal, is recommended as a means of deciding whether centrifugal operation is responsible for poor results. Possible causes of inefficiency in boiling and cooling are briefly mentioned.

* * *

The progress of TSC's engineering. ANON. *Taiwan Sugar*, 1976, 23, 55-60.—Modernization of Taiwan Sugar Corporation's sugar factories in the 10-year period starting in 1958 is discussed, with details given of the number of new pieces of equipment installed. The crushing capacities of certain mills in 1967 are compared with 1976 figures, and the fuel consumption and surplus bagasse over the 30 years of TSC's existence are given. Improvements in processing techniques and control are indicated, and other measures introduced to increase efficiency are discussed.

* * *

Thirty years' research achievements of the Sugar Technology Department. C. J. LU. *Taiwan Sugar*, 1976, 23, 105-106.—The research and development work undertaken by the Department of Sugar Technology at the Taiwan Sugar Research Institute is surveyed.



Beet sugar manufacture

Purity determination by on-line method in sugar factories. J. PONANT and G. WINDAL. *Papers presented at 23rd Tech. Conf., British Sugar Corporation Ltd.*, 1976, 14 pp.—From investigations of factors governing conductivity of sugar solutions, it has been found that a linear relationship between temperature and conductivity is valid for only a limited temperature range, since temperature rise is accompanied by a rise in the Brix at which conductivity is maximum. As temperature rises, it increases the ionic dissociation and ionic mobility, so that the viscosity falls and affects the conductivity measurement at temperatures far greater than 20°C but not yet approaching boiling point. The increase in conductivity is not proportional to the rise in Brix, however, because of the associated decrease in ionic dissociation and mobility (viscosity being linked to Brix). However, conductivity increases with fall in purity, and purity P is related to the maximum conductivity y_{max} thus: $P = 100 - ky_{max}$, where k is a constant. (Tabulated values of k obtained by continuous measurements at 10 factories during the 1975/76 campaign showed that the value changes only slowly.) Formulae have been derived which relate conductivity to Brix and purity at a given temperature as well as to the non-sugars:water ratio, including an exponential term to cover ionic dissociation and viscosity. The expressions apply to a wide range of sugar factory products.

* * *

Purity determination in sugar factories. Realization of an on-line measuring device. G. WINDAL. *Papers presented at 23rd Tech. Conf., British Sugar Corporation Ltd.*, 1976, 16 pp.—The studies reported in the preceding abstract were applied to investigation of a method for purity determination based on the relationship between purity and maximum conductivity. Since a change in Brix causes the conductivity to pass through a comparatively "flat" maximum, a type of "landing" being reached when the temperature is fairly high, measurement of the conductivity "landing" was selected as being simple and inexpensive. The equipment consisted of an electronic box (containing conductimeters and temperature and speed controllers) connected to 1-3 hydraulic boxes, each containing two pumps for controlled dilution to give a Brix of 30° (at which variation in conductivity is minimal), a preheater, decanter, measuring cell and rinsing device. Eleven sets were installed in sugar factories for the 1975/76 campaign. Results were completely satisfactory, with an indication accuracy usually greater than 0.5 units. Some improvements have been made to the equipment and are briefly described.

* * *

Patterns of work—factory operations. P. M. S. DIXON. *Papers presented at 23rd Tech. Conf., British Sugar Corporation Ltd.*, 1976, 13 pp.—The social aspects of sugar factory work are discussed, and trends in

staffing requirements and in employee demands under the effect of modern developments in equipment and processing are indicated.

* * *

Micro-processor control of sugar boiling. R. J. BASS and J. DONOVAN. *Papers presented at 23rd Tech. Conf., British Sugar Corporation Ltd.*, 1976, 17 pp. The use of mini-computers using direct digital control techniques for vacuum pan operation is discussed. It is stated that the cost of an installation was so high as to make its use for one pan economically unjustifiable, but that the mini-computer had the potential to control many pans and would, in addition, offer the service of logging factory process parameters and provide alarm monitoring throughout the factory. For such a task, the computer needed a relatively large memory, a comprehensive plant interface system and an extensive network of interconnecting cable; the design, construction, installation and commissioning of such a project is a major undertaking. The hardware and software used for the system introduced at Bury St. Edmunds to control a C-massecuite pan on the basis of conductivity measurement is explained. Centred around an Intel 8080 micro-processor, the system monitors all the measurements from the pan every 100 milliseconds, checks interlocks and calculates the new outputs. The memory device is a programmable read only memory (PROM) which is erasable by ultra-violet light. Electrons are injected into a floating gate and the charge held until it is irradiated with U.V. light, resulting in a flow of photo-current from the floating gate and return of the memory to its original unprogrammed state. The system has achieved very good control of pan boiling, as demonstrated by a trace of massecuite level, conductivity and absolute pressure.

* * *

Schemes for mechanization of loading, unloading, conveying and storage operations with basic goods at sugar factories. N. M. KICHIGIN, N. A. EMEL'YANOV, I. B. SOMOROV, A. V. BALAKAN and A. A. KOZYAREVICH. *Trudy Vsesoyuz. Nauch.-Issled. Inst. Sakhar. Prom.*, 1974, 22, 3-22.—A survey is presented of the present level of and future trends in development of mechanical schemes for handling beet, pulp, limestone and sugar at factories in the USSR, and a number of suggestions are put forward on the basis of technical and economic analysis.

* * *

Determination of the level of loading, unloading, conveying and storage mechanization at sugar factories. N. A. EMEL'YANOV. *Trudy Vsesoyuz. Nauch.-Issled. Inst. Sakhar. Prom.*, 1974, 22, 22-27.—A mathematical method for determination of the level of mechanization in the title operations is explained.

Present-day technical and technological requirements of beet pilers. I. A. MAROCHKO, L. A. KUZNETSOVA and V. A. NOVIKOV. *Trudy Vsesoyuz. Nauch.-Issled. Inst. Sakhar. Prom.*, 1974, 22, 28-43.—The desirable features of modern beet piling systems, as used in the USSR, are discussed, and results are given of trials to evaluate the extent to which the values of given parameters approach theoretical values.

* * *

Determination of the optimum distance of beet delivery by pneumatic-tyred front-end loaders. I. B. ROMASHKEVICH and V. A. NOVIKOV. *Trudy Vsesoyuz. Nauch.-Issled. Inst. Sakhar. Prom.*, 1974, 22, 43-47.—The economics of beet recovery and loading by front-end loaders and tipper trucks are briefly discussed.

* * *

An improved mechanization scheme and equipment for bagged sugar storage. V. I. VASIL'EV *et al.* *Trudy Vsesoyuz. Nauch.-Issled. Inst. Sakhar. Prom.*, 1974, 22, 47-59.—The present state of mechanization in bagged sugar storage is described and details are given of a modern scheme for conveying the sugar in bags and stacking it in the warehouse.

* * *

Pneumatic conveying of white sugar. T. K. VASIL'eva. *Trudy Vsesoyuz. Nauch.-Issled. Inst. Sakhar. Prom.*, 1974, 22, 59-68.—A survey is presented of pneumatic conveying of white sugar to and from transporters, and recommendations are given on the basis of results achieved in various countries.

* * *

Examination of pneumatic conveying of white sugar at high air mixture concentrations in an experimental pilot-scale unit. T. K. VASIL'eva, A. F. ZABORSIN, A. P. FEDOROV and N. F. KOSOGOR. *Trudy Vsesoyuz. Nauch.-Issled. Inst. Sakhar. Prom.*, 1974, 22, 69-77. Details are given of an experimental pneumatic conveying unit for transferring white sugar at a sugar: air weight ratio greater than 10:1. Trials showed that crystal breakage over a distance of 150 m was within the limits corresponding to attrition in modern dryers.

* * *

White sugar bulk carriers. N. M. KICHIGIN, I. I. NOVOGURSKII, V. A. PROSTIBOZHENKO and V. I. GRUSHCHENKO. *Trudy Vsesoyuz. Nauch.-Issled. Inst. Sakhar. Prom.*, 1974, 22, 78-84.—The design of a road carrier for bulk white sugar with gravitation discharge is described and some tests are reported.

* * *

Adsorption of colorants during carbonatation of sugar-lime solutions. S. Z. IVANOV, M. V. GONCHARUK and N. P. KOZEL'TSOVA. *Izv. Vuzov, Pishch. Tekh.*, 1976, (2), 17-21.—In studies of colorant adsorption by CaCO_3 , aqueous solutions of caramels, melanoidins and reducing sugar alkaline decomposition products were added separately to a 2% CaO solution with and without the presence of sucrose. The solutions were heated to 80°C and subjected to controlled laboratory carbonatation. Results showed that at a pH corresponding to 11-12 at 20°C, the presence of sucrose greatly increased adsorption compared with the lime solution alone; increase in the sucrose concentration from 10% to 20% affected only caramel adsorption, which rose by 25-30%, but, since 98% of carbonatation juice colour is caused by the other colorants investigated, this effect is considered un-

important. Adsorption of melanoidins and caramels was not affected by addition of 1-2% pure CaCO_3 before gassing; only at 3% did the carbonate cause a drop in adsorption, while reducing sugar alkaline decomposition products remained unaffected. Addition of washed recirculated carbonate mud caused a 15-20% fall in caramel adsorption and a 3-5% fall in adsorption of the other colorants; absence of washing led to even less effect on adsorption, which was thus confirmed as practically irreversible, so that juice and mud can be recycled with the aim of improving filtration. Oversaturation (to a pH below 11 at 20°C) led to an increase in optical density, indicating colorant desorption and pointing to the need to maintain the 1st carbonatation pH at optimum. The mechanism of colorant adsorption during carbonatation for 20-22 minutes is explained for each colorant with the aid of curves showing the progress of decolorization and alkalinity. Wide fluctuation in colorant adsorption was observed, maximum effect being achieved at greatest accumulation of colloidal CaCO_3 .

* * *

Method of controlling continuous centrifugals. G. M. CHUDAKOV, V. A. MASLIKOV and V. I. PUGACHEV. *Izv. Vuzov, Pishch. Tekh.*, 1976, (2), 96-99.—In an investigation of the possibility of stabilizing low-grade sugar quality in a continuous blade-type centrifugal similar to that described earlier¹, the weight ratio between the 1st and 2nd run-offs was used as control parameter, with two slit-type flowmeters acting as ratio-regulating means by altering massecuite feed under the effect of an electronic control linked to a differential manometer measuring system. Mathematical expressions are written for the various relationships involved in control under non-steady conditions, viz. mother-liquor viscosity and effective sugar crystal size, and run-off level in the collector.

* * *

Mathematical simulation of continuous multi-compartmented vacuum pans. I. S. GULYI, I. M. FEDOTKIN and E. M. BRUSILOVSKAYA. *Izv. Vuzov, Pishch. Tekh.*, 1976, (2), 114-118.—Response curves were plotted for the continuous vacuum pan at Gnivan with the aim of establishing the effect of the number of crystal growth chambers (up to 10) on boiling of *A*- and refined massecuites. The mathematical simulation method used was based on the Markov circuit theory whereby each compartment is represented as a non-ideal mixing vessel definable by a stochastic mixing model. Each compartment is sub-divided into ideal mixing zones and it is assumed that the residence times of a marked particle in each zone will be identical. Three variants were calculated by computer. The probability matrices for each are given. Calculated and experimental results were in agreement.

* * *

Statistical method of establishing optimum conditions for intensification of heat transfer to sugar solutions of high concentration. S. M. KONSTANTINOV and N. N. BEZPAL'KO. *Izv. Vuzov, Pishch. Tekh.*, 1976, (2), 119-123.—Investigations were conducted with a single-tube circulation circuit in which steam was injected into 70°Bx sugar solution in order to increase heat transfer. The tube was separated into 8 equal sections, and the amount of condensate formed on the tube wall during 20 minutes' heating was deter-

¹ OPLT & PRIDAL: *I.S.J.*, 1976, 78, 312.

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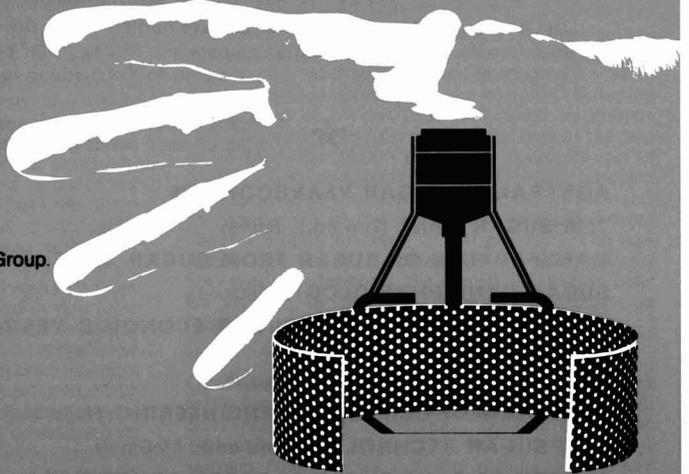
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mined as well as temperature of solution, tube wall and reheat steam, and steam pressure. The effect of steam injection on heat transfer was evaluated statistically and a regression equation developed which was found to describe the relationship sufficiently accurately.

* * *

Split separation of crystals with low-grade massecuite working—trials in the 1975 campaign. F. AMDING. *Zucker*, 1976, 29, 317–319.—The effect of crystal content on low-grade massecuite viscosity is discussed, wherein it is shown that an increase from 40% to 45% in crystal content at 50°C causes the same rise in viscosity as does a reduction in the temperature from 75° to 50°C. Since the aim is to reduce viscosity and increase sugar recovery, tests were conducted at Munzel in 1975 in which the contents of four low-grade pans were discharged to the first of a series of six crystallizers. The massecuite from the last crystallizer was transferred to four continuous centrifugals. About 35% of the total massecuite was withdrawn from the first crystallizer and spun in a separate centrifugal. The sugar was then mixed with that from the other four centrifugals and dissolved in thin juice for boiling together with thick juice; the molasses from the four continuous machines was transferred to a storage tank, while that from the separate machine was pumped via a feed tank to the second crystallizer in the series. The process, which has reduced massecuite viscosity considerably and thus contributed to improved molasses exhaustion, was incorporated in the normal factory scheme during the second half of the campaign.

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The development of the Greek sugar industry in the last 15 years. D. HADJANTONIOU. *Zucker*, 1976, 29, 325–330.—A survey is presented of the Greek sugar industry, including beet and sugar production data from 1961 to 1975, descriptions of the factories (with mention of equipment and products), average performance data from the five campaigns up to and including 1975/76, and future prospects.

* * *

Scaling of sugar factory evaporators during the 1975–76 campaign. P. DEVILLERS, R. DETAVERNIER and M. GROULT. *Sucr. Franç.*, 1976, 117, 245–249.—Weekly measurements were made by atomic absorption spectrometry of the calcium and silicon contents of juice before and after evaporation at 18 factories. Results are tabulated, showing that in only 4 cases was there no calcium deposit on the tubes and in only 1 case was there no silicon deposit. The effects of scale inhibitors at selected factories were also determined, but it is stressed that the effectiveness of these will vary according to conditions. The silicon content can be reduced by careful attention to 1st carbonation juice filtration and by maintenance of as high a pH as possible during 1st carbonation.

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Reverse osmosis in the sugar industry. A. BALOH. *Sugar J.*, 1976, 38, (12), 19–25.—See *I.S.J.*, 1976, 78, 122.

* * *

Iodophores for beet disinfection. F. X. KAMMERER. *Zeitsch. Zuckerind.*, 1976, 101, 409–411.—Reasons for increased usage of formalin in beet diffusion are discussed, and disadvantages and limitations of this

and other disinfectants indicated. The use of iodophores is explained; these contain complexes of iodine with a surface-active agent, so that the active ingredient is made water-soluble and does not have the corrosive effect that iodine has on its own. A list is presented of commercial brands manufactured by firms in a number of countries, and a typical composition is given. The concentration recommended for most purposes lies in the range 15–300 ppm a.i. For beet treatment after washing, 40 kg of iodophore per 10,000 tons of beet is adequate for disinfection. Although at 5–35°C the iodophore is independent of temperature, above 35°C volatilization takes place with rapid decomposition of the complex. Addition of 1.5 litres of “Webco” (manufactured by Biesterfeld-Chemietechnik KG) per hour to beet at the rate of 36 litres per 10,000 tons (at a concentration of 50–100 ppm) plus 1000 litres of formalin, coupled with spraying of the beets with 30 m³ condenser water per hour, reduced the thermophile population from about 4 million to about 27,000 per cm³. The economics are briefly discussed; despite the relatively high cost of iodophores, the overall disinfection costs are reduced by one-third through the decrease in formalin consumption.

* * *

Qualitative classification of 14 limestones of Greek origin for their use in the Greek sugar industry. K. M. SIFTANOU and D. S. MITKA. *Hellenic Sugar Ind. Quarterly Bull.*, 1976, (25), 67–101.—Limestone samples from the six different regions of northern Greece from which the sugar factories draw their supplies were analysed for settling rate, available CaO and thermal reactivity of the lime produced. Results are given in graph form, and photomicrographs showing the surface structure of each type are reproduced.

* * *

The (Greek) sugar industry and the energy crisis. P. HRISTODOULOU. *Hellenic Sugar Ind. Quarterly Bull.*, 1976, (25), 119–127.—Details are given of the boilers, turbo-generators and evaporators at the five Greek sugar factories (Larissa, Platy, Serrai, Xanthi and Orestias); oil consumption for steam generation and pulp drying, and coke consumption for lime kiln operation at the factories in 1975 and at all but Orestias in 1972–74 are also tabulated, showing a progressive improvement with each campaign. Best performance has been achieved at Platy, where average fuel consumption in 1975 was 3% on beet, compared with a rated consumption of 4.2% on beet guaranteed by the factory suppliers. A heat flow scheme for Platy factory is presented.

* * *

Reduce beet handling losses. J. B. FITTS. *Sugar Beet J.*, 1976, 39, (3), 2–4.—Comparison between the sugar recovery from beet at the Monitor Sugar Co. in 1975 and 1973 shows that the results were better for the earlier years, whereas the 1975 figures should have been better, judged on the basis of average beet sugar content as delivered to the factory. The resultant loss in 1975 was calculated to be over \$800,000. The losses were mainly attributed to injury caused to the beet by mechanical handling from harvesting to piling, and to increased respiration rates during storage when temperatures rose to 20°C or higher. The company has introduced means of cushioning the fall of beet into road trucks and pilers.

Sugar factory quantities. M. FRIML. *Listy Cukr.*, 1976, **92**, 102–106.—Formulae are given for calculation of chemical control parameters under the SI system.

* * *

Sugar beet and sugar cane in Spain. ANON. *Die Zuckerrübe*, 1976, **25**, (4), 23.—A short survey is given of beet and cane agriculture in Spain, with brief mention of factory processing.

* * *

Experience in operation of Zhabinka sugar factory. G. I. BEL'KO, N. A. SHUT, N. B. SHESTAK and L. G. BELOSTOTSKII. *Sakhar. Prom.*, 1976, (6), 23–27. Information is given on equipment and processes at this Soviet factory, performance of which in October–December of the 1975/76 campaign was better than rated.

* * *

More about biological treatment of sugar factory waste waters. B. M. SHAKHNOVICH. *Sakhar. Prom.*, 1976, (6), 28–30.—The chief reason for failure to introduce biological treatment of effluent in factory schemes in the USSR is considered to be the large land requirements, which have been put at 100–150 ha for a factory of 3000 tons daily slice. However, there are a number of factors which need examination, and these are discussed. The question of mechanical treatment and subsequent use of the treated water for irrigation of crops is also examined.

* * *

Treatment of sugar factory waste waters for irrigation of agricultural crops. V. T. DODOLINA. *Sakhar. Prom.*, 1976, (6), 30–33.—The use of Class III effluent as irrigation water, after suitable treatment to reduce the contents of bicarbonates, suspended matter and organic matter, is discussed and the contents of valuable nutrients in effluent from a number of Soviet factories are indicated.

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Provision of beet pilers with sprayers for treatment of beet roots with liquid preparations during piling. N. M. IGNATOV and M. F. KINYAKIN. *Sakhar. Prom.*, 1976, (6), 48–52.—Full details are given of the layout and operation of a spray system for application of e.g. milk-of-lime to beets as they are being piled.

* * *

Control of calcined lime and wash water feed to the slaker. A. A. VIL'SHANSKII, K. F. GERBUT and B. A. EREMENKO. *Sakhar. Prom.*, 1976, (6), 52–56.—A description is given of an automatic control scheme for maintenance of desired quantity and density of milk-of-lime according to factory requirements.

* * *

The level of modern slicer technology—design and features, economics and trends in development. H. KOETHKE. *Zucker*, 1976, **29**, 368–377.—The history of beet slicer development is surveyed, starting from the three basic types from which present-day machines have evolved. Slicer arrangements for factories of given daily slice are discussed, as are the capital, running and repair costs of modern slicers. Types of drive as used in slicers manufactured by H. Putsch & Comp. are examined, and slicer performance evaluation is explained.

The centrifugal in the sugar industry and its development. P. H. PITHOIS and A. MERCIER. *Ind. Alim. Agric.*, 1976, **93**, 535–541.—After a résumé of the role of the centrifugal in crystal sugar recovery, the authors examine the development of the batch and continuous machine. While the batch centrifugal has reached its zenith in the form of the fully-automatic machine, the continuous centrifugal, having appeared much later, is still undergoing development. Advantages and disadvantages of continuous machines are considered, and operational conditions under which optimum performance can be achieved are explained. While little progress was made in improvement of continuous centrifugal performance for some time after the machines were first introduced in the sugar industry, more recently major developments have been brought about, e.g. increase in basket diameter, steam treatment of massecuite before it is fed into the centrifugal, and means of maintaining desired crystal size by reducing the fines content.

* * *

Recent progress in electro dialysis. P. PIERRARD. *Ind. Alim. Agric.*, 1976, **93**, 569–581.—The principle of electro dialysis, its use on an industrial scale and its fields of application are discussed. Among the processes described is demineralization of B-masse-cuite run-off and beet molasses to recover sugar. Tests by Raffinerie Tirlemontoise S.A. have shown that up to 38 kg of sugar per m³ can be recovered at a daily throughput of 1000 m³ and a demineralization efficiency of only 25.6%. The 20–30°Bx molasses is treated at a temperature of 40–50°C, which gives the best compromise between conductivity and viscosity.

* * *

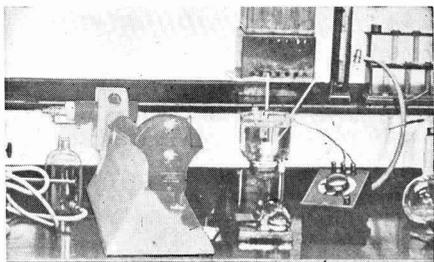
Flocculation processes for clarifier underflow in beet sugar factories. V. M. JESIC. *Zeitsch. Zuckerind.*, 1976, **101**, 457–459.—Experiments were conducted on a modification of the "Rapi-Floc" process for use in beet sugar factories, in which clarifier mud was adjusted to the pH of 1st carbonatation juice and 5–6 ppm flocculant added before the vacuum filter. Lime salts content, colour content, filter cake sugar losses and sweet-water purity were determined. The filtrate was clear and of sufficient purity to be sent direct to 2nd carbonatation. Advantages of the process are indicated.

* * *

The effect of limestone and coke particle size on the quality of lime and carbon dioxide produced. F. SOBEK. *Zeitsch. Zuckerind.*, 1976, **101**, 463–464.—The author discusses the effect of limestone and coke grain size on lime and CO₂ quality, and recommends the following for uniform calcination and optimum waste gas CO₂ concentration: a limestone size within narrow tolerances of 60–80 or 80–120 mm (but not 60–120 mm), and a slow-reacting coke in the size ratio coke:limestone of 0.5–0.76:1. Such coke can be smaller than high-reacting coke.

* * *

Protection of extraction juices in beet sugar factories by bacteriostat "I 32". M. VELINGS. *Zeitsch. Zuckerind.*, 1976, **101**, 464–465.—The author, representing Sopura S.A., gives information on "I 32", a bacteriostat containing 35% iodoacetone, which is stable as a 0.1% solution for 24 hours and has proved effective in reducing inversion in beet diffusion.



Laboratory methods & Chemical reports

Dextranase. I. Characterization of the enzyme for use in sugar mills. R. P. FULCHER and P. A. INKERMANN. *Proc. 43rd Conf. Queensland Soc. Sugar Cane Tech.*, 1976, 295-305.—The effects of dextran, dextranase and sucrose concentration, temperature and pH on the hydrolysis of dextrans by two commercial enzymes were investigated with dextran 2000, as were the hydrolysis rates, substrate specificities and choice of enzyme addition point. Results, in the form of graphs, showed: that the percentage of dextran hydrolysed fell with rise in dextran concentration above 4000 ppm; that for each enzyme there is a temperature at which activity is maximum; that the amount of dextran hydrolysed was directly proportional to enzyme concentration and to time of incubation; that maximum activity occurred at a specific pH or within a narrow pH band; that dextranases had maximum activity in the absence of sucrose, while low concentrations had only limited effect on the hydrolysis rate, although high concentrations caused a considerable fall in activity; that the hydrolysis rate for cane dextran is lower than for dextran 2000; that the catalytic action of the enzyme was of a specific nature; and that the enzyme is best added to mixed juice. Of the two enzymes, "Glucanase D-1" is more suitable, since it may be added to the juice without major modifications to normal processing, while "Talozyme D" is unsuitable because of the low temperature (45°C) at which activity is maximum. The specificity of the enzymes is considered to limit their usefulness.

* * *

Study on the influence of sucrose and other constituents of molasses on the extraction of its free acids by organic solvents. O. I. BELOVA and T. BEGALIEV. *Trudy Frunzensk. Politekhnik. Inst.*, 1973, 63, 157-160; through *S.I.A.*, 1976, 38, Abs. 76-613.—Tests on multiple extraction of lower fatty acids from 50°Bx solutions of (beet) molasses or sucrose are reported with tabulated results. Extraction with acetone: ether (1:1) was eventually more complete than extraction with acetone, although acetone gave higher initial extraction. Removals of acetic and formic acids were 98 and 95.2%, respectively, when 50 g model solution was extracted with three 100-ml portions of mixed solvent; similar extraction removed only 91.5% of added formic acid from previously extracted molasses solution. Thus, while the sucrose in molasses does not impair extraction, the non-sucrose does.

* * *

Chemical composition of vinasses from alcohol and yeast manufacture. V. G. KOVAL', A. A. MALASHKEVICH and O. I. SYCH. *Trudy Ukr. Nauch.-Issled. Inst. Spirt. Likero-Vodoch. Prom.*, 1973, 15, 156-159; through *S.I.A.*, 1976, 38, Abs. 76-619.—Ranges of contents of the major organic and inorganic components (% on dry solids) and 14 trace elements (mg per 100 g dry

solids) in vinasses from 7 alcohol-fodder yeast combines are tabulated and compared. Growth of *Candida* or *Trichosporon* on vinasses used up mainly carboxylic acids, glycerol and added N compounds; the main trace elements present were B, Ba, Mn, Cu, Ti and Ni.

* * *

Trace elements in dried pulp. D. HIBBERT, R. T. PHILLIPSON and W. WOODWARK. *Papers presented at 23rd Tech. Conf., British Sugar Corporation Ltd.*, 1976, 23 pp.—Maximum levels of certain elements in animal fodder permitted under UK and EEC legislation are indicated, and the nature of the toxic effects of some of them is indicated. Details are given of the quantities of arsenic, lead, mercury, copper, fluorine, cobalt, manganese and vanadium in composite samples of molassed dried pulp from BSC factories. Although the molassed pulp conformed to the regulations, arsenic caused some concern. As with the other elements (with exception of vanadium), its average content was greater when coal firing was used than when gas or oil was used as fuel. Vanadium was increased by use of oil firing, while the contents of the other elements with gas and oil firing were about the same. The arsenic content of hard coal was greater than that of brown coal. Higher arsenic and mercury concentrations occurred in the pulp dust fractions, while disproportionately high levels of arsenic, copper and mercury were found in fly-ash taken from the dryer inlet; the relatively high volatility of arsenic and mercury is also considered to be of great importance. While the copper content was increased to a certain extent when coal was used, most of the element was introduced with the beet, while contact with copper or brass in the factory also contributed. The copper content of the molasses, and hence of the molassed pulp, was markedly influenced by the incidence of copper alloys in the 1st and 2nd evaporator effects.

* * *

Reaction partners in the carbonyl-amino reaction in technical sugar juices. E. REINEFELD, K. M. BLIESNER and A. REINEFELD. *Zucker*, 1976, 29, 287-292.—Six different carbonyl components were reacted, individually, with each of four amino-acids at a 1:1 molar ratio. The reactants were heated in a phosphate buffer solution of pH 8 for 24 hours to 95°C, after which the yield, extinction coefficient and C, H and N contents of the high-molecular browning product were determined. Highest yields were obtained from glyceraldehyde, dihydroxyacetone and invert sugar, while lowest yield occurred with hydroxyacetone; glycolaldehyde and acetaldehyde gave intermediate yields. In all cases, γ -aminobutyric acid gave the highest yield of the four amino-acids, followed by lysine; sometimes glutamic acid was next as regards yield, sometimes alanine. The pattern of the extinction coefficients was similar to that of the yields. Infra-

red spectra for dihydroxyacetone and acetaldehyde with each of two amino-acids were identical. Gas chromatography revealed differences between the various reactants as regards amino-acid liberation after acid hydrolysis. Further investigations in which 2-deoxyglucose and 2-O-methyl glucose were reacted, individually, with butyric acid showed that browning products were formed under the severe test conditions despite the unavailability of a free hydroxyl in α position, although the reactivity of the carbonyl components was much lower than of the previous group, so that colour formation was slower. Possible methods of obtaining Maillard reaction intermediates as a contribution to further study of their structures are discussed.

* * *

Some aspects of the theory and practice of sugar crystallization. D. SCHLIEPHAKE and K. AUSTMEYER. *Zucker*, 1976, 29, 293-301.—The effect of hydrodynamic conditions on crystal growth in boiling is discussed from the viewpoint of mass transfer and resistance to this. The theory of mass transfer resistance is examined in detail, mathematical expressions being derived to define various relationships and reference being made to earlier experiments involving both sucrose and potassium alum crystallization, results of which are compared. For Reynolds' numbers greater than 10^{-2} , a Frössling equation for calculation of the rate coefficient of mass transfer for given supersaturated solution parameters was found to give values in close agreement with experimental data. This permits a relationship between Reynolds' number and crystallization resistance to be established, as demonstrated graphically. Limitations imposed on white sugar crystallization by reduced flow conditions were demonstrated by comparing simulated processes in a bubble tube and a suspended bed vessel. While use of a circulator in a batch pan has been found to improve performance, inadequate mass transfer rates result from the unsuitability of the heating surface area which is too great for the first stage of boiling (because of a high evaporation rate) but is insufficient for optimization of the second main stage. These problems can only be resolved, it is stated, by use of continuous boiling in which the heating surface area can be adjusted to the process requirements and the massecuite level maintained constantly at an optimum value. By contrast, in the batch pan the crystal sedimentation path continues to increase during the main boiling stage, while the circulation rate is reduced by the pressure exerted by the column of massecuite. Hence, the chief aim in improving boiling is to reduce the hydrostatic head of the massecuite column, reduce the superheat zones in the calandria and thus restrict massecuite consistency.

* * *

Investigations of diffusion in pure and technical sucrose solutions. II. Diffusion of sucrose and non-sucrose compounds in multi-component systems. A. EMMERICH, D. FINKE, N. PANITZ and H. RIECK. *Zucker*, 1976, 29, 302-307.—The earlier described capillary method¹ was used in an investigation of the auto-diffusion of sucrose and three non-sugars obtained from molasses: lactic acid (representing organic hydroxy acids), glutamic acid (representing amino-acids) and pyrrolidone carboxylic acid (as main component of nitrogenous acids in purified sugar solutions). Results showed that sucrose diffused at a faster rate in the

molasses solution than in pure solution of the same dry solids content, while each of the non-sugars in highly diluted pure solutions had almost the same diffusion rates as did sucrose, whereas in technical solutions the rates were considerably higher. Reasons for the findings are suggested. As regards the factory diffusion process, the non-sugars would not be expected to exert much influence because of their low concentration in the cell juice, nor do they accumulate on the surface of the growing sucrose crystal, since their back-diffusion is more rapid than is the forward diffusion of the sucrose.

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The determination of invert sugar in technical sugar juices. I. New photometric method with 4-amino-3-hydrazino-5-mercapto-1,2,4-triazole as colour reagent. E. REINEFELD, K. M. BLIESENER, H. VAN MALLAND and C. REICHEL. *Zucker*, 1976, 29, 308-316.—Details are given of a method for determination of invert sugar in juices in which the fructose moiety is split into trioses at 80°C in highly alkaline medium; the title reagent reacts only with the glyceraldehyde to form a reddish-violet colour which is measured spectrophotometrically at 535 nm against a blank or is compared visually with one of three named colour solutions. The method was applied in tests to beet factory juices (including thick juice) and to press juice after clarification with lead acetate. Comparison with results obtained for thick juice by SPENGLER *et al.* using Müller's solution showed close agreement. Two variants of the new method are described: in one, the reagent is dissolved in NaOH, while in the other it is dissolved in basic lead acetate solution. At an invert sugar concentration up to 200 μg , the relative error was 1.5-10% (a standard deviation of $\pm 2.4 \mu\text{g}\cdot\text{cm}^{-3}$). The method can be adapted to measurement of glucose separately.

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Problems of the sugar laboratory. Performance of the disintegrator element adapted for the Brazilian digester for cane analysis. J. P. STUPIELLO, E. R. DE OLIVEIRA and L. U. SILVA. *Brasil Açuc.*, 1976, 87, 342-346. The standard disintegrator used for direct analysis of cane in Brazil employs a goblet of 4.5 litres capacity and a blade as disintegrator element. Experiments were made using a bar of 10 mm square steel, 75 mm long and with tips chamfered to 3 mm. Disintegration was equally efficient and the new element should be adopted, since it will last much longer than the blade, so reducing maintenance requirements.

* * *

Determination of lead, cadmium and zinc in sugar. N. M. MORRIS, M. A. CLARKE, V. W. TRIPP and F. G. CARPENTER. *J. Agric. Food Chem.*, 1976, 24, (1), 45-47; through *Anal. Abs.*, 1976, 31, (1), Abs. 1F5.—A graphite furnace was used for flameless atomic absorption spectrophotometry on samples that had previously been fermented with yeast at pH 4.5-5.0 to eliminate matrix interference by the sugar. After fermentation, the solutions were centrifuged to remove yeast, then evaporated, and the residues were charred at <500°C and atomized in the furnace. Recoveries of Pb, Cd and Zn added before fermentation were $97 \pm 7\%$.

¹ SCHNEIDER *et al.*: *I.S.J.*, 1976, 78, 347.

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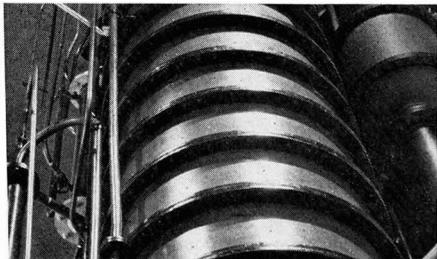
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By-products

Pelletizing offers new options for food waste recovery profits. L. E. SLATER. *Food Eng.*, 1975, 47, (10), 58, 61; through *S.I.A.*, 1976, 38, Abs. 76-353.—The manufacture of bagasse pellets at Clewiston factory, Florida, is described. Bagasse is dried to a moisture content of 5% in two rotary drum dryers, passed through a hammer mill, and pneumatically conveyed to the supply bin for the pellet mills; the extruded pellets are cooled and screened to remove fines. Output was 10 tons.hr⁻¹ during the 1974/75 grinding season. When fed to dairy cattle, the pellets provide valuable roughage.

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Utilization of sugar factory filter cake. G. VERNOIS. *Die Lebensmittelind.*, 1976, 23, 133-134.—Possible uses of filter cake which are briefly discussed include its application as fodder, as a soil conditioner and as a raw material for cement manufacture. Recovery of the lime for re-use in the factory is also considered, and suitable drying means for scattering on soil are described.

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Pilot plant scale trials on the treatment of distillery effluents. S. C. GUPTA and K. A. PRABHU. *Sharkara*, 1974, 13, 7-10.—Large-scale trials were conducted on distillery effluent treatment with an acclimatized culture of ammonifying bacteria¹. The COD of a 3.5°Bx diluted spent wash was reduced by 86.8% (from 50,237 ppm) in 96 hours; BOD reduction was about 80%, although a 92-93% decrease is considered possible, and the pH was raised from 5.2 to 7.3-7.5. Daily treatment of 12,000-15,000 gal of spent wash of 30,000-40,000 ppm initial COD proved possible. Urea added with superphosphate every other day as N source could be replaced with yeast sludge (dried or as slurry), it was found.

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A new potential product from sucrose: microbial gum. W. P. CHEN and C. H. TSOU. *Taiwan Sugar*, 1976, 23, 14-16.—See *I.S.J.*, 1975, 77, 158.

* * *

Plant for the production of fine alcohol and potable spirits in Thailand. ANON. *BMA Information*, 1975, (14), 24-25.—Information is given on the Mahaguna distillery in Bangkok which produces alcohol from cane molasses and rice.

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Possibilities and limits of use of sugar-containing cattle fodder. E. PEEFFER. *Die Zuckerrübe*, 1976, 25, (3), 31-34.—See *I.S.J.*, 1974, 76, 382.

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Alcohol from molasses as a possible fuel and the economics of distillery effluent treatment. P. KUJALA, R. HULL, F. ENGSTRÖM and E. JACKMAN. *Sugar y Azúcar*, 1976, 71, (3), 28-39.—The economics of molasses alcohol production are discussed and the

possible use of ethanol as a motor fuel examined. While the Melle-Boinet method of fermentation is rapid but gives a relatively high alcohol yield, the molasses must first be pasteurized and pre-treated to remove Ca salts, gums and sludges which tend to have an adverse effect on yeast clarification. However, since the pasteurization permits a cleaner alcohol to be produced, the purifying column needs fewer stoppages for descaling, while there is reduced sludge accumulation in the boiling column, and the effluent from the stills is cleaner. The question of distillery waste disposal is discussed at some length, and indications are given of the high BOD₅ values occurring in various countries. The molasses distillery waste is wholly liquid, so that its treatment for use as animal fodder is restricted. However, various methods of treatment are described whereby the BOD₅ can be reduced to an acceptable level. While evaporation to a syrup for use as animal fodder is one possibility discussed, it is pointed out that the product has a high ash content, particularly K, Mg and Na salts (which have a laxative effect on animals), so that dilution with molasses is recommended, thus reducing the feed value of the syrup. An alternative is to recover the potash by incineration. Methods which have been used for crude potash recovery on a commercial scale are described, and details are given of a process for refined K salt recovery. Torula yeast manufacture from distillery waste as used in Taiwan is also discussed. Finally, it is stressed that economics of distillery waste treatment must first be worked out, since the capital and operating costs are high; refined K salt (KCl and K₂SO₄) manufacture appears to be the most profitable of the systems described, although this will be governed by price movements in these chemicals. Local market conditions and the suitability of a given system of waste treatment for the individual distillery should be assessed before any process is introduced.

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A thought on sugar by-product, molasses. A. C. CHATTERJEE and B. M. DUTT. *Sugar News (India)*, 1976, 7, (10), 5-6.—The potential for production of alcohol from cane molasses in India is discussed, including possible markets, molasses quality and transport, and distillery capacity, fuel (preferably coal and bagasse rather than oil) and power consumption.

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Storage of dried and pelleted sugar beet pulp in silos. H. SCHNELLE. *Zucker*, 1976, 29, 238-240.—The tendency towards storage of pelleted pulp in cylindrical silos of 20,000 tons capacity and a maximum discharge height of 40 m is accompanied by the need for greater care to prevent fires resulting from spontaneous combustion. Tests in the US have shown that pellets of only 7% moisture content but containing 30-40% fines decompose rapidly at 50°C and 100%

¹ PRABHU & PRAKASH: *I.S.J.*, 1974, 76, 90.

R.H. and quickly reach a temperature at which spontaneous combustion occurs; similar results occur where there are no fines but the moisture content is at least 15%. On the other hand, a pulp having a moisture content of 7% but very little fines content will not readily decompose, even at an ambient temperature of 70°C. Hence, there is need for removal of fines before storage and for adequate air conditioning; continuous checking of pulp temperature by means of distance thermometers linked to the conditioning controls ensures rapid increase in the cold air feed should the temperature rise. However, it is pointed out that such a system is not always proof against local hot spots which could be shielded because of the heat insulation properties of the pulp, so that there would be a time lag before the thermometer actuated the conditioning system. Should this break down, the silo would have to be emptied as quickly as possible. The question of discharge rate is discussed, and mention made of an emergency entrance provided in the wall of modern silos for use of a front-end loader to supplement the conventional discharge conveyors.

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New sucrose epoxy resins. H. JACQUES and L. LEBLANC. *Sucr. Belge*, 1976, **95**, 179-187.—Experiments are reported in which an attempt was made to use oxyalkylated sucrose derivatives as internal plasticizers of epoxy resins. Tricomponent systems (epoxy resin-oxyalkylated sucrose-curing agent) were tested in order to obtain improved curing; with water-free materials, hard products having no tackiness were obtained in yields up to 55% (by weight) on oxyalkylated sucrose. Suppleness of the product was found to increase with increase in sucrose derivative quantity. With the aim of increasing the compatibility of the sucrose derivatives with resins, oxyalkylated sucrose was reacted with epichlorohydrin in the presence of KOH as catalyst. Infra-red spectroscopic investigations revealed that the resultant resins had absorption bands of the oxirane cycle. Hardening tests on the resins mixed with bisphenol-A epoxy resin yielded well-cured, supple, transparent products having excellent compatibility with epoxy resins.

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Use of sulphonol as antiseptic for molasses in alcohol manufacture. E. R. ALIEVA-VITUKEVICH. *Trudy Ukr. Nauch.-Issled. Inst. Spirt. Likero-Vodoch. Prom.*, 1973, **15**, 67-72; through *S.I.A.*, 1976, **38**, Abs. 76-617. Molasses containing 375 million bacterial cells per g was treated with 17-113 g Na dodecylbenzenesulphonate per metric ton (as 20-150 g crude powder, paste or liquid of various origins), and kept for 15 days at 20°C; acidity increase was usually delayed 10 days by doses greater than 50 g.ton⁻¹. Such doses had beneficial effects on alcohol yield and residual sugars content in fermentation by yeast.

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Energy conservation in beet pulp dryers. B. HUTCHINSON *et al.* *Papers presented at 23rd Tech. Conf., British Sugar Corporation Ltd.*, 1976, 48 pp.—Tests are reported for determining the effect of a number of factors, including savings in energy resulting from recirculation of exhaust gases from the dryer outlet to the combustion end for dilution of fresh incoming gas; other effects determined were those of recirculation on emissions to the atmosphere, on dried pulp combustion and throughput, and the effects of modi-

fications to the outfall equipment on product and dust carry-over to the cyclones. Results indicated a 5-6% saving in fuel; while the potential saving increased with increase in the gas outlet temperature, there is a simultaneous reduction in the chances of achieving the savings in practice. There was negligible effect on emissions and on pulp combustion and throughput, although it is emphasized that the effects on throughput and fuel consumption would depend on the heat transfer capacity of the individual dryer. Grit and dust carry-over to the cyclones varied directly as the flue gas volume and inversely as the moisture content of the dried pulp, the flue gas volume being the more significant factor. Removal of the centre sections of alternate volutes had little or no effect on retention time or pulp drying; it is important that the volutes should overlap, although their length is not necessarily significant. A number of other factors which could be evaluated in further tests are listed.

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Studies on the fermentative production of citric acid. II. Screening of the yeasts producing citric acid from cane molasses. Y. T. LIU. *Rpt. Taiwan Sugar Research Inst.*, 1975, (68), 55-66.—Details are given of tests on citric acid production from molasses and glucose, respectively, using various yeast strains. Yields of the anhydrous product ranged from 20 to 70% where three particular strains were applied. An increase in yield is thought to be possible. The isolated yeasts appeared to be *Candida* species.

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Economy in sugar industry by-products. A. CHATTERJEE and B. M. DUTT. *Sugar y Azúcar*, 1976, **71**, (4), 18-19.—The economic aspects of cane by-products utilization are discussed and potential availability of each by-product as a percentage of processed cane is indicated. The value of molasses alcohol fermentation is discussed, among other things, in relation to world petrol shortage; production of bagasse paper in a central mill supplied with the raw material from a number of sugar factories is recommended, since it is stressed that only the surplus bagasse should be used; as regards furfural manufacture, the plant cost is so high that the process would be economically viable only if there were an adjacent sugar factory and distillery to utilize the surplus steam, the fermentable sugar-containing liquor and the residual products (recommended as boiler fuel). Mention is also made of particle board manufacture from bagasse, wax recovery from filter cake, and use of boiler ash as fertilizer and, in the building industry, together with cement.

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Studies on industrial gum production by fermentation. II. Cultivation conditions in the laboratory. W. P. CHEN, S. L. CHENG and C. L. LAI. *Rpt. Taiwan Sugar Research Inst.*, 1975, (69), 45-52.—Investigations of gum production by *Xanthomonas manihotis* (obtained from the cassava tree) showed that the best medium contained 4% sucrose, 0.2% KCl and 2% defatted soybean powder extract with 0.45% K₂HPO₄ solution. Inoculation of 100 ml of this medium and cultivation on a rotary shaker for 3 days at 28°C yielded 51% industrial gum (on initial sucrose concentration) of 2.17% concentration. The broth culture viscosity was 34,000 cP.

World sugar production estimates 1976/77¹

BEET SUGAR	1976/77	1975/76	1974/75	St. Kitts Trinidad	37,000	37,000	26,000
EUROPE	<i>(metric tons, raw value)</i>				225,000	205,000	163,000
Belgium/Luxembourg..	652,000	711,000	607,000				
Denmark	440,000	423,000	415,000				
France	2,800,000	3,230,000	2,947,000				
Germany, West	2,600,000	2,534,000	2,439,000				
Holland	924,000	914,000	778,000				
Ireland	203,000	203,000	145,000				
Italy	1,650,000	1,442,000	1,012,000				
United Kingdom	790,000	697,000	601,000				
Total EEC.....	10,059,000	10,154,000	8,944,000				
Austria	400,000	512,000	394,000				
Finland	95,000	88,000	82,000				
Greece	315,000	307,000	187,000				
Spain	1,300,000	917,000	572,000				
Sweden	308,000	277,000	305,000				
Switzerland	71,000	65,000	72,000				
Turkey	1,149,000	986,000	834,000				
Yugoslavia	156,000	483,000	556,000				
Total West Europe ..	14,257,000	13,789,000	11,946,000				
Albania	20,000	18,000	16,000				
Bulgaria	240,000	157,000	200,000				
Czechoslovakia	700,000	800,000	750,000				
Germany, East	595,000	665,000	655,000				
Hungary	410,000	331,000	338,000				
Poland	1,960,000	1,840,000	1,589,000				
Rumania	760,000	600,000	620,000				
USSR	9,400,000	7,700,000	7,800,000				
Total East Europe ..	14,085,000	12,111,000	11,968,000				
Total Europe	28,342,000	25,900,000	23,914,000				
OTHER CONTINENTS							
Afghanistan	15,000	15,000	9,000				
Algeria	20,000	18,000	14,000				
Azores	7,000	7,000	7,000				
Canada	140,000	133,000	101,000				
Chile	326,000	320,000	219,000				
China	980,000	980,000	950,000				
Iran	625,000	615,000	565,000				
Iraq	80,000	75,000	50,000				
Israel	40,000	38,000	31,000				
Japan	224,000	244,000	280,000				
Lebanon	5,000	18,000	9,000				
Morocco	270,000	257,000	264,000				
Pakistan	24,000	22,000	24,000				
Syria	30,000	25,000	18,000				
Tunisia	11,000	9,000	7,000				
United States	3,400,000	3,719,000	2,726,000				
Uruguay	110,000	116,000	85,000				
Total Other Continents	6,307,000	6,611,000	5,359,000				
TOTAL BEET SUGAR ..	34,649,000	32,511,000	29,273,000				
CANE SUGAR							
EUROPE							
Spain	20,000	19,000	26,000				
NORTH & CENTRAL AMERICA							
Belize	92,000	63,000	85,000				
Costa Rica	200,000	191,000	179,000				
Cuba	6,000,000	5,700,000	6,432,000				
Dominican Republic ..	1,200,000	1,250,000	1,234,000				
Guadeloupe	95,000	96,000	88,000				
Guatemala	530,000	515,000	381,000				
Haiti	55,000	56,000	58,000				
Honduras	103,000	88,000	77,000				
Martinique	15,000	14,000	16,000				
Mexico	2,750,000	2,725,000	2,707,000				
Nicaragua	265,000	247,000	196,000				
Panama	196,000	164,000	134,000				
Puerto Rico	307,000	279,000	271,000				
El Salvador	290,000	256,000	273,000				
USA—Mainland	1,640,000	1,657,000	1,334,000				
Hawaii	1,001,000	969,000	1,004,000				
West Indies—Barbados	104,000	101,000	107,000				
Jamaica	365,000	368,000	366,000				
Total N. & C. America	15,470,000	14,981,000	15,131,000				
SOUTH AMERICA							
Argentina	1,592,000	1,353,000	1,532,000				
Bolivia	263,000	210,000	165,000				
Brazil	7,400,000	6,180,000	6,985,000				
Colombia	1,036,000	959,000	970,000				
Ecuador	328,000	305,000	273,000				
Guyana	362,000	371,000	311,000				
Paraguay	65,000	55,000	77,000				
Peru	984,000	950,000	990,000				
Surinam	11,000	11,000	10,000				
Uruguay	32,000	29,000	23,000				
Venezuela	544,000	478,000	527,000				
Total South America	12,617,000	10,901,000	11,863,000				
AFRICA							
Angola	50,000	40,000	49,000				
Cameroun	32,000	30,000	29,000				
Congo (Brazzaville)....	46,000	32,000	29,000				
Egypt	680,000	626,000	550,000				
Ethiopia	156,000	134,000	140,000				
Ghana	18,000	18,000	12,000				
Ivory Coast	38,000	23,000	5,000				
Kenya	185,000	177,000	174,000				
Madeira	3,000	2,000	3,000				
Malagasy Republic	119,000	127,000	123,000				
Malawi	95,000	68,000	68,000				
Mali	15,000	14,000	15,000				
Mauritius	725,000	496,000	738,000				
Morocco	5,000	4,000	0				
Mozambique	270,000	233,000	272,000				
Nigeria	39,000	34,000	38,000				
Réunion	240,000	226,000	228,000				
Rhodesia	250,000	260,000	250,000				
Somalia	39,000	30,000	36,000				
South Africa	2,150,000	1,928,000	2,033,000				
Sudan	170,000	154,000	140,000				
Swaziland	222,000	224,000	207,000				
Tanzania	120,000	112,000	110,000				
Uganda	25,000	22,000	34,000				
Zaire	70,000	69,000	68,000				
Zambia	100,000	85,000	64,000				
Total Africa	5,862,000	5,168,000	5,415,000				
ASIA							
Bangladesh	115,000	95,000	108,000				
Burma	85,000	75,000	72,000				
China	2,800,000	2,700,000	2,600,000				
India, excl. khandsari ..	4,900,000	4,630,000	5,212,000				
Indonesia	1,300,000	1,258,000	1,137,000				
Iran	90,000	85,000	83,000				
Iraq	75,000	75,000	50,000				
Japan	213,000	223,000	192,000				
Malaysia	80,000	70,000	50,000				
Nepal	15,000	12,000	0				
Pakistan	500,000	565,000	514,000				
Philippines	2,850,000	2,735,000	2,471,000				
Sri Lanka	28,000	24,000	20,000				
Taiwan	860,000	817,000	751,000				
Thailand	1,714,000	1,665,000	1,216,000				
Total Asia	15,625,000	15,029,000	14,476,000				
OCEANIA							
Australia	3,400,000	2,933,000	2,921,000				
Fiji	318,000	281,000	273,000				
Total Oceania	3,718,000	3,214,000	3,194,000				
TOTAL CANE SUGAR ..	53,312,000	49,312,000	50,105,000				
TOTAL BEET SUGAR ..	34,649,000	32,511,000	29,273,000				
TOTAL SUGAR PRODUCTION	87,961,000	81,823,000	79,378,000				

¹ F. O. Licht, *International Sugar Rpt.*, 1976, 108, (29), 1-4.

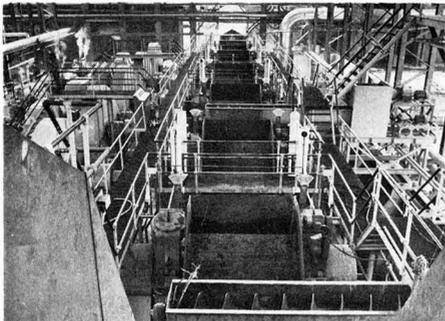
Philippines sugar exports

	1975	1974	1973
	(metric tons, raw value)		
China	11,016	0	0
Finland	0	32,315	0
France	0	23,817	0
Iran	57,031	0	0
Japan	377,039	214,846	29,063
Korea, South ..	0	0	13,630
Malaysia	0	0	12,391
Morocco	27,909	0	0
Portugal	11,376	0	0
Switzerland	0	5,613	0
UK	182,882	32,315	0
USA	339,411	1,347,686	1,389,186
Vietnam, South ..	0	0	10,754
	<u>1,005,664</u>	<u>1,635,637</u>	<u>1,455,024</u>

A/S De Danske Sukkerfabrikker 1975/76 report.—With revision of the EEC sugar policy the 1975/76 Danish A-sugar quota was increased from 290,000 to 328,000 metric tons of which the DDS share was 282,491 tons. New acreage was contracted and a production target of 410,000 tons was set for the campaign. However, cold and windy weather in early June damaged the young beet plants and growth was severely hampered during the rest of the summer by drought. Rain came in September so that the roots started to develop new tops instead of the normal increasing of root volume and sugar content. As a result the beet crop reached only 2,580,000 tons to give 336,000 tons of sugar. The factories operated satisfactorily and Saxkjöbing also refined about 27,000 tons of cane raws for export to Norway. Assens factory has been expanded, a similar project has been under way for the Nakskov factory for the 1976 campaign, and Stege will be expanded for the 1977 campaign. The company is investing heavily in measures against environmental pollution, particularly for recycling of beet transport and wash water. The 1976 target sugar production has been set at 381,000 tons. Sales of beet seed have increased, particularly in Italy and Spain, while sugar production machinery sales have been a record, with outlets in the USSR, France and Yugoslavia, as well as the first DDS cane diffuser in Argentina.

* * *

Brazil's largest cane mill tandem.—On 24th September 1976 the largest milling tandem to be built and installed in Brazil was inaugurated at Usina da Barra, Barra Bonita, São Paulo. Designed and manufactured by M. Dedini S.A. Metalúrgica, the tandem has rollers measuring 42 in × 84 in and a crushing capacity of 12,000 tons per day. Each mill uses four rollers with separate drives to the inlet roller and discharge roller. The two lower rollers are close, requiring only a narrow turn-



plate, while the hydraulic head acts on the top roller at an angle of 15° corresponding to the angle of the resultant of forces exerted on the roller. The mill bearings are of solid bronze, water-cooled. Each mill is individually driven by a 1000 hp steam turbine operating at up to 4600 rpm with gear reducers and a final spur and pinion gearing, all built by Dedini. The new mill represents the latest achievement by the Dedini Group which built its first small mill in 1929.

Trinidad sugar exports²

	1975	1974	1973
	(metric tons, raw value)		
Canada	0	2,458	0
France	0	14,567	0
Holland	0	1,528	0
Japan	0	11,004	0
Tunisia	0	7,888	0
UK	74,022	69,142	133,180
USA	22,313	27,596	8,603
Venezuela	14,013	0	0
	<u>110,348</u>	<u>138,783</u>	<u>141,783</u>

South American beet sugar technologists meeting.—The beet sugar technologists of Uruguay have formed an organization (Asociación Nacional de Técnicos en Remolacha Azucarera) which is cooperating with the technologists of Chile to form a Latin American Association of Beet Sugar Technologists (ALTER) which is holding its inaugural Congress at Bella Vista, 90 km east of Montevideo during the 28th November—5th December 1976. A number of papers on agricultural subjects are to be presented and visits have been arranged to sugar factories and experimental field sites. Both the Chilean and Uruguay associations are non-Governmental institutions and are under the patronage of the Uruguay Ministry of Agriculture and Fisheries, the F.A.O. and the Interamerican Institute of Agricultural Sciences.

* * *

Corrigendum.—In a recent item³ we referred to Fives-Cail Babcock sugar factories for Yugoslavia. We have now been advised by ABR Engineering of Brussels, Belgium, that they are responsible for the whole contract as leaders of a Belgian-French group associated with a Yugoslav company in the undertaking. ABR Engineering will provide complete design engineering and detailed designs, delivery of machinery and equipment (some to be obtained from Fives-Cail Babcock), and technical assistance for erection and commissioning. The factories are to be built at Bac, Zabalj, Kovacica, Pecinci and Nova Crnja and are scheduled for commissioning for the 1978 campaign.

* * *

EEC import quota reductions for three ACP countries⁴. Article 25 of the Lomé covers the procedure followed when a supplier fails to provide his full quota of sugar to the EEC. For the period 1st July 1975 to 30th June 1976 this applied in the case of Mauritius, Uganda, the Congo Republic and Fiji who all claimed that the deficiency was caused by *force majeure*. In the case of Mauritius the EEC Commission agreed the validity of this claim since the island had had its sugar crop badly damaged by a cyclone which reduced exports to the EEC from the forecast 487,200 metric tons to 421,200 tons. Uganda had supplied only 3000 tons against its 5000-ton quota but the Commission rejected the claims that this was due to difficulties of reorganization and transport, noting that production had fallen continually since 1968 so that it could not be expected that Uganda would meet its higher commitment; the quota was consequently reduced to 3200 tons. The reasons put forward by the Congo for non-delivery of its 10,000-ton quota (incendiarism, interruption of fuel and supplies for one enterprise) were also rejected and the quota cancelled completely. In the case of Fiji, which had delivered 137,000 tons against a 163,000-ton quota, the Commission did not consider that the floods which had affected the cane fields were sufficient reasons since Fiji had suffered continually falling crops since 1968 and, in addition, had signed long-term contracts with other customers; as a consequence the quota was reduced to 142,900 tons.

* * *

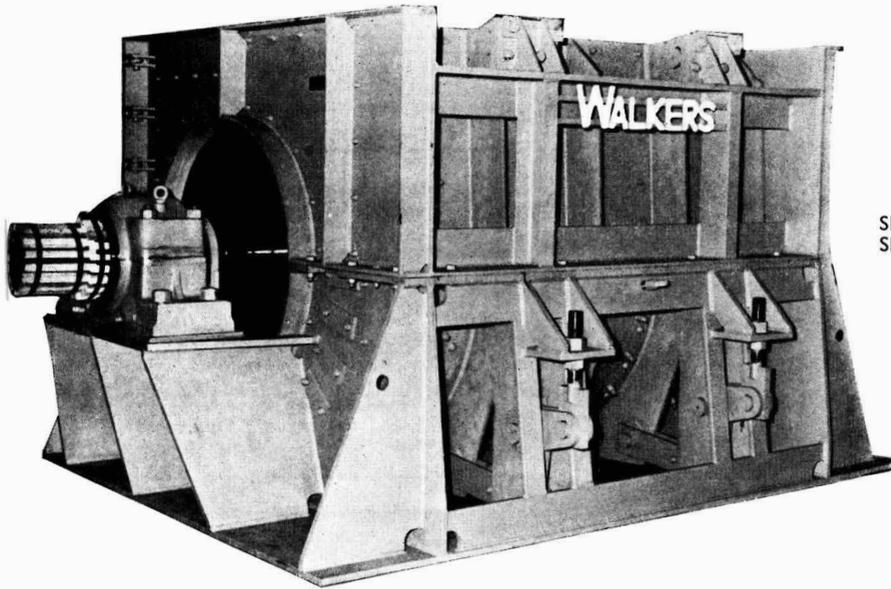
Bagasse paper in South Africa.—The September 1976 issue of the *South African Sugar Journal* was a special issue in that it was printed for the first time on coated paper made by Stanger Pulp & Paper (Pty.) Ltd. at Gledhow, Natal. This new R60m project came on stream recently and is the first paper mill in the world to use bagasse for the making of coated paper of the glossy art type. The mill will eventually produce 34,000 metric tons of fine paper a year and an extension by the end of 1976 will make it possible to produce 17,000 tons of tissue paper annually as well. At present it uses 160,000 tons per annum of bagasse from the Gledhow sugar factory.

¹ I.S.O. Stat. Bull., 1976, 35, (5), 84.

² *Ibid.*, (4), 105.

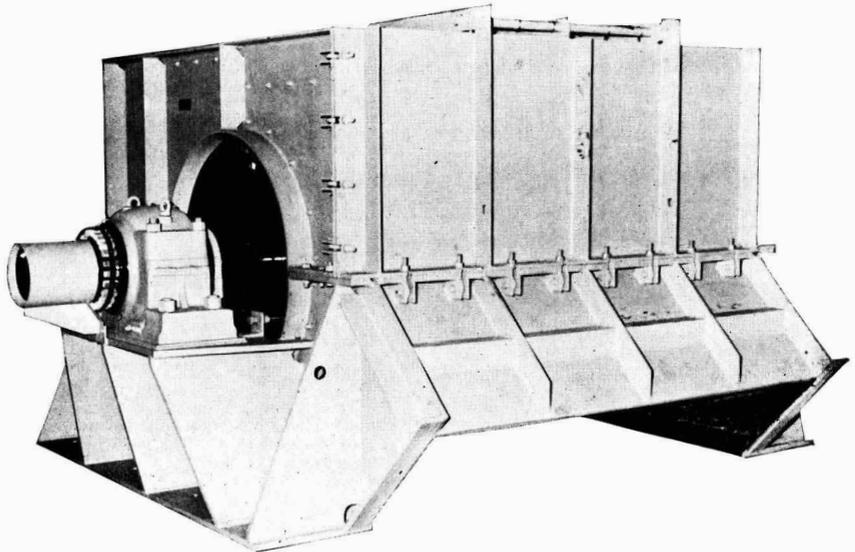
³ I.S.J., 1976, 78, 286.

⁴ *Le Betteravier*, October 1976, 13, 19.



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Index to Advertisers

	PAGE
ABR Engineering	vi
W. H. Allen, Sons & Co. Ltd.	ix
Edward L. Bateman Ltd.	xxi
Bosco Industrie S.p.A.	viii
Brasil Açucareiro	xxiii
Braunschweigische Maschinenbauanstalt	vii
Brill Equipment Co.	xxvi
Thomas Broadbent & Sons Ltd.	i
Peter Brotherhood Ltd.	xiii
Dorr-Oliver Inc.	ii
Fives-Cail Babcock	xii
Fletcher and Stewart Ltd. Inside Front Cover, Inside Back Cover	
Fontaine & Co. GmbH	xxiii
Hitachi Zosen	xviii
Dr. Wolfgang Kernchen Optik-Elektronik-Automation	iv
May & Baker Ltd.	xi
Optical Activity Ltd.	xx
P & S Textiles Ltd.	xvii
F. C. Schaffer & Associates Inc.	xxii
Stork-Werkspoor Sugar B.V.	x
Sucatlán Engineering	v
Sugar Manufacturers' Supply Co. Ltd.	Outside Back Cover
Sugar News	xxiii
Tate & Lyle Engineering Ltd.	xiv, xx
Veco Zeeplatenfabriek B.V.	xix
Wabash Power Equipment Co.	xxvi
Walkers Ltd.	xxv
Western States Machine Co.	iii

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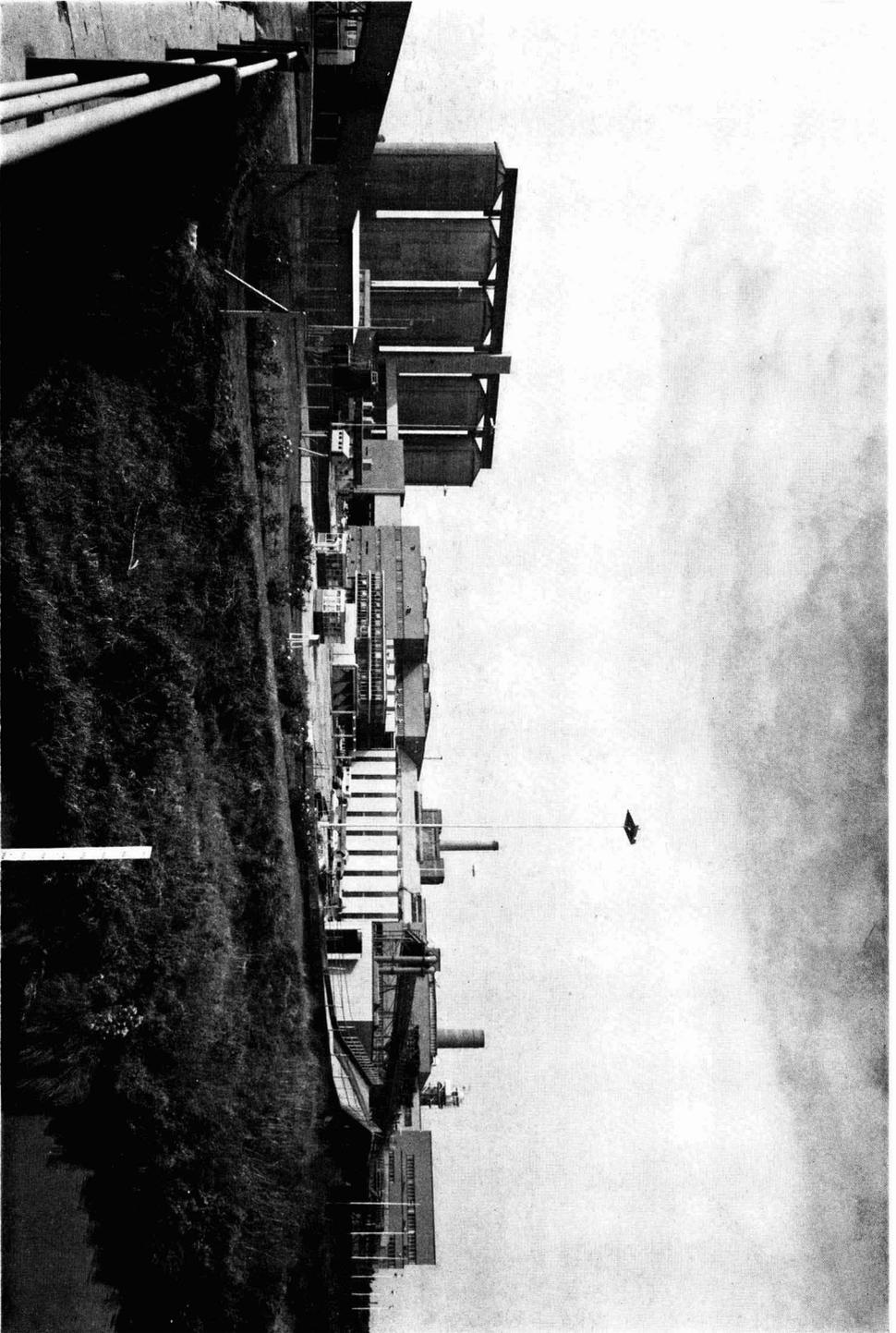
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(Photo: British Sugar Corporation Ltd.)

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ERRATA AND CORRIGENDA

Page 27.	Line 27 of Column 1.	Read "СВОБОДОВА" for "СВОБОДА".
Page 56.	Line 13 of Column 2.	Read "(5), 16-21; (6), 10-15" for "(6), 10-15, 16-21".
Page 76.	Line 35 of Column 2.	Read "wilt" for "red rot".
Page 119.	Line 35 of Column 2.	Read "118-120" for "118-119".
Page 124.	Line 4 of Column 1.	Read "60" for "29".
Page 125.	Line 42 of Column 1.	Read "I.S.J., 1973, 75, 3-6, 44-46" for "I.S.J., 1973, 75, 44-46".
Page 128.	Line 40 of Column 1.	Read "L. GONRY" for "I. GONRY".
Page 150.	Line 37 of Column 1.	Read "1973, 75, 110" for "1974, 76, 84".
Page 182.	Line 2 of Column 1.	Read "MCMASTER" for "MCMASTEY".
Page 183.	Lines 36 and 37 of Column 1.	Read "Proc. 1973 Meetings Amer. Soc. Sugar Cane Tech." for "Proc. 49th Congr. S. African Sugar Tech. Assoc.".
Page 218.	Line 4 of Column 1.	Read "factory" for "vapour".
Page 247.	Line 57 of Column 1.	Read "26" for "27".
Page 248.	Line 2 of Column 2.	Read "217" for "215".
Page 285.	Line 35 of Column 2.	Read "KRASNOPOL'SKII" for "KRASNOPOL'SKII".
Page 286.	Line 47 of Column 2.	Read "ABR" for "Fives-Cail Babcock".
Page 306.	Line 12 of Column 2.	Read "J.F." for "F.J".
Page 308.	Line 13 of Column 1.	Read "KALASWAD" for "KALSWAD".
Page 315.	Line 49 of Column 1.	Read "V. S." for "H. S.".

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INDEX TO VOLUME LXXVIII

SOME REMARKS ON ITS USE

In using this Index it should be noted that the principal entries cover the several stages of production: CULTIVATION (see Beet; Cane; Diseases; Fertilizers; Irrigation; Mechanization; Pests; Soils; Transport; Varieties; Weeds, etc.); SUGAR PROCESSING (see Bagasse; Boilers; Boiling; Carbonation; Centrifugals; Clarification; Crystallization; Diffusion; Evaporators; Filters; Massecuite; Milling; Mills; Molasses; Pans, Vacuum; Scale; Sucrose; Sugar; Sulphitation; Water, etc.); REFINING (see Bone Char; Carbon; Refining; etc.); and BY-PRODUCTS (see Alcohol; Animal Fodder; By-Products; Fermentation; Paper; Pulp; Yeast, etc.).

Subjects covered separately include Ash; Bulk handling and storage; Colour; Control, Automatic and Chemical; Countries; Ion exchange; Juice; Micro-organisms; pH; Polarization; Transport; Weighing, etc. Glucose and Fructose are to be found under Dextrose and Levulose. Obituaries, Statistics and Trade Notices are collected together under those headings. "Sucrose" implies the pure chemical; "Sugar" the commercial product; and "Sugars" the chemical family, rather than grades of sugar. When looking under the author's name, it should be remembered that the surname may be the penultimate in Spanish. Names starting with "Mc" are treated as if they start with "MAC", and the next letter in the name after the "c" will determine the position in the author index. Where a name includes the prefix "AL", "EL", "D", "DA", "DE", "DEL", "EL", "LA", "VAN" or "VON" it is indexed under A, E, D, L or V, respectively. Where a name begins with the abbreviation "St." or "Sto." it is indexed as if this were spelt in full.

(Abs.) indicates Abstract; (Brev.), Brevity; (Corr.), Correspondence; (N.B.), New Books; (N.C.), Note and Comment; (Stat.), Statistics; (T.N.), Trade Notice.

SUBJECT MATTER

	PAGE		PAGE		PAGE
Attenuation: S. A. Brennan <i>et al.</i> (Abs.) control by chloride ion-selective electrodes. C. R. Brown and P. Pommezi (Abs.).....	314 283	Animal fodder:		heavy metals determination in raw sugar. P. Pomez and B. Cormier - - - - - sugar. N. M. Morris <i>et al.</i>	283 380
Air pollution: boiler and beet pulp dryer emission reduction. H. Smid reduction. A. Szabó. (Abs.).....	184 90	cane stalk and top yield and composition. J. Deville and Y. Wong You Cheong. (Abs.).....	158 309	mercury determination in beet pulp and molasses. F. M. Pate and S. W. Coleman. (Abs.).....	189 220 100
Alcohol: in concrete, effect of cane deterioration. J. D. Blake.....	131	- and molasses. F. M. Pate and S. W. Coleman. (Abs.).....	221	- formation. V. A. Golybin <i>et al.</i>	92
manufacture. J. C. Hudson. (Abs.).....	208, 273	filter cake. G. Vernois. (Abs.).....	381	phosphorus determination. N. Morfi <i>et al.</i> (Abs.).....	124
- ammonia removal. Anon. (Abs.).....	94	saccharate process waste water. L. Gonry. (Abs.).....	126, 190	potassium, calcium and chloride contents in cane varieties. R. P. DeStefano. (Abs.).....	178
- beverage from cane. Anon. in Brazil. Anon. (N.B.).....	58	<i>see also</i> Bagasse; Molasses; Pulp, Beet and Yeast		- removal from cane juice. S. Mukherjee and S. K. Srivastava.....	119
- from molasses. Anon. (Abs.).....	381	Argentina: bagasse paper factory. Pérez A. (Abs.).....	302	- and sodium in beet, effect of topping. P. J. Last <i>et al.</i>	167, 195
- A. C. Chatterjee and B. M. Dutt (Abs.) 252, 349, 381, 381	382	- damage by frost. E. Kula <i>et al.</i>	32	- - - - - varieties. E. Borchsueher.....	21
- P. Kujala <i>et al.</i> (Abs.).....	381	- mechanical harvesting study - - - - - research. Anon. (Abs.).....	288 51	- and molasses. P. Devillers <i>et al.</i> (Abs.).....	60, 189
- A. Ramalingam and R. K. Finn	61	sugar statistics. (Stat.).....	160	- and chloride in beet, effect of harvest date and nitrogen. R. C. Zlotke and F. W. Snyder	125
- D. Sridharan. (Abs.).....	61	weeds. R. A. Arevalo. (Abs.).....	367	- determination in beet. J. Hobbs and L. Batterman. (Abs.).....	92
- V. P. Sukhodol <i>et al.</i> (Abs.).....	158	Ascorbic acid: cane growth regulation. G. Singh and K. Sareen. (Abs.)	368	- - - - - W. Kerchen. (Abs.).....	316
- W. P. Trevelyan. (Abs.).....	190	- set. germination. J. R. Kakde <i>et al.</i> (Abs.).....	16	- - - - - M. Burba <i>et al.</i> (Abs.).....	60
- L. Vanossi. (Abs.).....	126	Ash: in beet juice and evaporator scale - thick juice storage. T. P. Khvalkovskii <i>et al.</i> (Abs.).....	246	- salts effect on sucrose solubility. S. Z. Ivanov <i>et al.</i> (Abs.).....	93
- and cane juice. (Brev.).....	191	calcium addition and beet juice pH. P. Peschner and R. Krämer. (Abs.)	28	- - - - - silina. (Abs.).....	91
- effect of antiseptic. E. R. Alieva-Vitukuevich. (Abs.).....	382	- and potassium melassigenic coefficients. V. A. Golybin <i>et al.</i>	27	ratio to glucose as molasses exhaustibility criterion. A. J. Wehre - - - - - reducing sugars and molasses exhaustion. G. Fundora. (Abs.)	151
- - - - - colorants on yeast zeta-potential. V. N. Shvets <i>et al.</i>	252	- effect on beet sugar discharge. J. Guern. (Abs.).....	139	removal by electro dialysis. J. Houssiau and R. Pieck. (Abs.).....	313
- - - - - lactic acid bacteria. V. N. Shvets <i>et al.</i> (Abs.).....	285	- effect on beet sugar discharge. J. Guern. (Abs.).....	139	- - - - - P. Pierrard. (Abs.).....	378
- synthetic alcohol additive determination. J. Guérain and S. Tourlière. (Abs.).....	221	- salts in beet juice and syrup. L. G. Kalimenko. (Abs.).....	356	- efficiency determination. L. D. Bolobronik <i>et al.</i> (Abs.).....	313
- waste water properties. C. E. Monteiro. (Abs.).....	308	cane molasses exhaustibility. M. A. Mohaned <i>et al.</i> (Abs.).....	318	silicon in cane juice, effect on processing. M. A. Clarke. (Abs.).....	283
removal from condensates. J. D. Blake <i>et al.</i>	291	carbonate, sulphite and nitrite in beet juice, effect of ion exchange treatment. H. D. Wallenstein and H. Egler. (Abs.).....	27	- and phosphate effect on raw sugar filtrability. M. Shaqf and R. Samaniego. (Abs.).....	27
<i>see also</i> Distillery and Fermentation		chloride determination in cane molasses. Anon. (Abs.).....	213	- sugar floc formation. E. J. Roberts <i>et al.</i>	326
Algeria sugar imports. (Brev.).....	32	chromium determination. W. Wolf <i>et al.</i> (Abs.).....	27	trace elements in molassed beet pulp. D. Hibbert <i>et al.</i> (Abs.).....	379
Amino-acids: in beet, effect of harvest date and nitrogen. R. C. Zielke and F. W. Snyder. (Abs.).....	125	content in beet, effect of ecology. V. Stehlik and L. Schmidt. (Abs.).....	242	<i>see also</i> Boilers; Bone char; Clarification; Furnaces; Bagasse; Ion exchange; Ion exclusion and Pulp, Beet	
- leaf blades, petioles and root. V. Svachula and P. Vrátný. (Abs.)	27	- - - - - fertilizer uptake. U. Beiss and C. Winner. (Abs.).....	148	Australia: Bureau of Sugar Experiment Stations. Anon. (N.B.).....	58
- molasses. M. Munir.....	100	- - - - - irrigation. I. al-Windi and L. Schmidt. (Abs.).....	148	bulk storage expansion. (Brev.).....	64
behaviour in carbonation. N. Kuladivno and W. Hampel. (Abs.).....	60, 220	- - - - - root, crown and collar. K. Fábán and J. Kollár. (Abs.)	188	cane disease and pest control research. Anon. (Abs.).....	47
beverage floc composition. E. J. Roberts and F. G. Carpenter. (Abs.)	283	cane juice, sugar and molasses. L. K. Kirby. (Abs.).....	92	- mills and factories. C. A. C. Chatterjee. (Abs.).....	22
determination. M. Burba and B. Georgi. (Abs.).....	348	- molasses. E. M. Burba and P. O. Osuji. (Abs.).....	349	- planting in Southern Queensland. C. L. Pooley. (Abs.).....	17
Maillard reaction colour formation. E. Reinefeld <i>et al.</i> (Abs.).....	379	- gur. B. Singh <i>et al.</i> (Abs.).....	92	- varieties. C. A. Rehbein and M. J. Braithwaite. (Abs.).....	47
- reactivities. E. Reinefeld <i>et al.</i> 28, 157	346	- J. Zdárský and A. Svoboda.....	245	- T. G. Wilcox. (Abs.).....	209
molasses formation. G. P. Voloshanenko <i>et al.</i> (Abs.).....	346	- winases. V. G. Koval' <i>et al.</i> (Abs.)	379	irrigation water supplies. D. W. Beattie. (Abs.).....	49
<i>see also</i> Betaine; Glutamic acid and Nitrogen		- white sugar and moisture absorption. V. Maurandi and G. Mantovan. (Abs.).....	55	Isis Land Use Scheme. C. D. Jones nitrogen trials. I. T. Freshwater.....	47
Animal fodder: bagasse and bageacello. A. Cabello and P. C. Martin. (Abs.)	253	- aluminium salt. P. M. Burba and W. Puszcz. (Abs.).....	346	private cane and disease risk. C. Chardon. (Abs.).....	271
- cane molasses. H. L. Chapman.....	221	- juice and evaporator scale and corrosion. P. Devillers <i>et al.</i>	120	River Improvement Trusts. E. F. Copley. (Abs.).....	78
- C. H. Liu. (Abs.).....	258	- cane molasses. A. G. Morris and W. M. Nicoll. (Abs.).....	251	soil monitoring stations. A. Ford.....	271
- pelletizing. L. E. Slater. (Abs.)	381	- sugar and syrup. R. Lees. (N.B.)	282	- properties. N. R. Maclean. (Abs.)	51
beet. E. Pfeffer. (Abs.).....	381	- temperature corrections. E. R. de Oliveira and J. P. Stuppiello.....	249		
- tops. (T.N.).....	61	effect on cane molasses viscosity. Carrazana R. <i>et al.</i> (Abs.).....	251		
- D. Charlesworth. (Abs.).....	252				
- G. H. Francis. (Abs.).....	126				
- E. W. Hart. (Abs.).....	252				
- W. D. Knowles. (Abs.).....	126				
- F. Onian. (Abs.).....	258				
- A. Vignonreux. (Abs.).....	149				
cane. D. Fielding. (Abs.).....	221				
- by-products. M. J. Kort. (N.B.)	58				
- S. C. Mai and P. H. Wu. (Abs.)	61				
- consultancy firm in Barbados	159				

INDEX

	PAGE		PAGE		PAGE
Australia:		Beet:		Beet:	
sugar exports. (Stat.).....	288	breeding. W. Oltmann and T. Sedlmayr. (Abs.).....	275	seed coating. Anon. (Abs.).....	305
- to Japan..... 34, 159, 224		- hybridization. G. H. Cooper. (Abs.).....	307	- dressing and germination. R. Vanstallen. (Abs.).....	115
- industry expansion and sugar production 1976. (N.C.).....	65	- - R. K. Oldemeyer. (Abs.).....	242	- drilling. J. Pichenez. (Abs.).....	244
- production. G. B. Hageberg.....	155	- - polyloid monogerm seed production. J. Christmann. (Abs.).....	181	- effect of soil preparation. M. T. Amaducci <i>et al.</i> (Abs.).....	243
- 1975/76. (N.C.).....	162	- seed isolation chambers. R. J. Hecker and J. O. Gaskill. (Abs.).....	242	- and plant population. S. Machajewski. (Abs.).....	274
- Research Institute computer. Anon. (Abs.).....	213	- selection and nematode resistance. D. L. Doney and E. D. Whitney	241	- - speed. A. S. Kennedy and J. V. Topper. (Abs.).....	243
- year book 1976. W. P. Kerr. (N.B.)	345	- for stalk blight resistance. J. D. MacDonald <i>et al.</i> (Abs.).....	337	- germination, effect of water. F. W. Snyder and R. C. Zielke. (Abs.)	20
Tully experiment station. C. R. Nalder. (Abs.).....	78	- brei clarification with aluminum salt. M. Burba and W. Puszc. (Abs.)..	346	- production in US. R. C. Zielke	83
weather and irrigation. K. C. Leverington and D. R. Ridge. (Abs.)..	49	- freezing, storage and preparation. M. Burba <i>et al.</i> (Abs.).....	60, 124	- yield, effect of plant spacing. S. S. Saini <i>et al.</i> (Abs.).....	83
Western Australia pilot cane farm. Austria: beet varietal trials. A. Graf	288	- nitrate and sugar content. D. G. Westfall and M. Barnes. (Abs.)..	19	seedbed preparation. J. D. Burne	148
sugar production 1975/76.....	256	- sugar determination. I. A. Prikhod'ko. (Abs.).....	156	- J. E. Hull. (Abs.).....	18
Bag: counting automatic control. K. A. Nekrasov. (Abs.).....	90	campaign length and thick juice viscosity and sucrose diffusion coefficient. M. N. Dadenkova <i>et al.</i>	156	- L. S. Robertson and D. M. van P. Doren. (Abs.).....	107, 306
handling equipment. (T.N.).....	62	characteristics. R. C. Zielke. (Abs.)	18	- W. C. von Kessel. (Abs.).....	275
Bagacillo: animal fodder. A. Cabello and P. C. Martin. (Abs.).....	253	composition, effect of harvest date and nitrogen. R. C. Zielke and F. W. Snyder. (Abs.).....	125	- and drilling. J. Crow. (Abs.).....	304
cane juice colour and turbidity. N. L. C. Suzor. (Abs.).....	309	- and juice purity and sugar yield predictions. P. Devillers <i>et al.</i> , 60, 180		- - P. H. Verstraete. (Abs.).....	276
clarification method. J. J. Seip and P. L. Gayle. (Abs.).....	150	crown yield, sugar content and quality. R. C. Zielke. (Abs.).....	20	- by rotary fillers. S. R. Simmons and A. D. Dotzato. (Abs.).....	337
pressing. E. del Valle. (Abs.).....	150	damage by falling. V. I. Vasil'ev and N. M. Kichigin. (Abs.).....	121	slicers. H. Koethke. (Abs.).....	378
separator. P. C. Ivin and R. N. Cullen	373	- by herbicides. R. Vanstallen	339	- hopper level control. I. Ergün.	310
Bagasse: active carbon manufacture. G. Ocampo <i>et al.</i> (Abs.).....	190	- and losses. R. C. Schaefer and W. van Gils. (Abs.).....	281	- knife treatment. A. D. Baglyuk	89
animal fodder. Anon. (Abs.).....	222	- - F. Kapol. (Abs.).....	122	- R. Hies. (Abs.).....	90
- A. Cabello and P. C. Martin.....	253	- W. G. von Kessel. (Abs.).....	149	- I. M. Spiridonov. (Abs.).....	343
- H. L. Chapman. (Abs.).....	221	- E. Reinefeld. (Abs.).....	120	- wear reduction. Y. F. Tsyukalo	90
- Y. Chen <i>et al.</i> (Abs.).....	61	emergence, effect of excessive fertilizer. I. Gutmański. (Abs.).....	181	slicing. V. N. Shehegov <i>et al.</i> (Abs.)	87
- C. H. Liu. (Abs.).....	158	- - pesticides. R. R. Schaefer and C. Winner. (Abs.).....	19	sugar content, effect of topping. P. J. Last <i>et al.</i> (Abs.).....	185
- S. C. Mai and T. H. Wu. (Abs.)	61	- soil salinity and temperature. K. D. Beatty and C. F. Ehlig	69	- and juice purity. W. C. McGuffee.	19
board factory in Malaysia. (Brev.)	320	enzymes and factory colour formation. D. Gross and J. Coombs.....	124	- determination. K. Malce <i>et al.</i> , 188, 347	
- manufacture. Anon. (Abs.).....	126	extraneous matter. Anon. (Abs.)..	217, 248	- K. W. R. Schoenrock and D. Costesso. (Abs.).....	347
- H. Perez. (Abs.).....	253	- pressing. (T.N.).....	350	- Development Ltd. (Abs.).....	237
- properties. R. Hesch. (Abs.).....	94	field headlands. Anon. (Abs.).....	275	- differentiation from cane sugar. J. Bricout and J. C. Fontes.....	28
cellulose manufacture. G. Ocampo	126	flume accidents prevention. R. Krücher. (Abs.).....	342	- yield, effect of irrigation. I. al-Windi and L. Schmidt. (Abs.)..	148
- in Paraguay. (Brev.).....	256	- cleaning. V. Lochman. (Abs.)..	88	- quality, reception and storage. Y. D. Golovnyak <i>et al.</i> (Abs.)	87
conveying. I. Guidry. (Abs.).....	61	- equipment operation, effect of extraneous material. O. Böhm	184	- tarehouse laboratory. W. Kerchen	316
drying. E. W. Kerr. (Abs.).....	86	- parameters calculations. V. N. Shehegov and A. P. Parkhometts. (Abs.).....	121	- temperature measurement. N. A. Arkhipovich <i>et al.</i> (Abs.).....	281
fire in Taiwan. (Brev.).....	64	- sand trap. M. I. Yanitskii. (Abs.)	185	- unloader. S. Dusiak. (Abs.).....	278
furfural and board manufacture. A. C. Chatterjee and B. M. Dutt	382	- galacturonic acid determination. F. Perschak. (Abs.).....	60, 124	- volatile acids and anions, effect of flume water liming. H. Schwiwek	185
factory in Mexico. (Brev.).....	288	- growth and quality. M. G. Frakes	371	washers. J. N. Doucerain. (Abs.)..	215
- and levulinic acid manufacture. C. I. Nee and W. F. Yse. (Abs.)	158	- regulators. Anon. (Abs.).....	306	- A. M. Flagin and B. I. Likhachev	186
humus. R. P. Humbert. (Abs.) 94, 190, 253		- J. Christmann. (Abs.).....	211	- R. Sebastian. (Abs.).....	248
hydrolysis. H. Kollmer and R. Lopez	222	- A. H. Fryer. (Abs.).....	19	- water content and factory fresh water requirements. F. Kastner. (Abs.)	217
- G. Triana <i>et al.</i> (Abs.).....	253	- and storage properties. J. Hobbis and L. Batterman.....	92	- separator. Z. Birczyński and R. Wisniewski. (Abs.).....	186
levulinic and formic acids manufacture. R. A. Schraufnagel and R. K. Finn. (Abs.).....	61	- and sugar content, effect of inorganic constituents. G. K. Ryser	212	- E. T. Koval <i>et al.</i> (Abs.).....	242
lignins. O. Y. Mansour and M. S. el-Dien. (Abs.).....	222	- temperature and drought. H. Krzywon. (Abs.).....	212	- effect of drought. J. Hobohm and J. H. Tiedge. (Abs.).....	244
moisture determination. B. Partridge	92	intercropping with cane. J. S. Garg	211	- late weeds. W. C. von Kessel..	18
and S. H. Reichart. (Abs.).....	92	- and M. P. Azad. (Abs.).....	215	- plant population. H. Strubbe..	176
pelletizing. L. E. Slater. (Abs.).....	381	- P. P. Singh. (Abs.).....	11	- A. von Müller and C. Winner	338
pressing. J. Engolio and J. G. Spinoso	119	leaf blade, petiole and root amino acids. V. Svachula and P. Vrátný	27	- seed spacing. J. M. Nelson.....	215
- and inhibition. M. Beauvais.....	183	- catcher water level control. F. Hruška. (Abs.).....	310	- harvesting and processing, effect of weeds. H. Neutrier. (Abs.)	306
soil mulching and cane quality. C. P. Chen and R. W. Fleun	150	- incorporation in soil. W. Czeratzki and E. Ruhm. (Abs.).....	116	- and quality, effect of agronomic factors. H. D. Fuehring and R. E. Finkner. (Abs.).....	21
- Johnson grass control. J. F. Parr <i>et al.</i> (Abs.).....	144	- injury by ozone. H. A. Menser	115	- I. Gutmański. (Abs.).....	276
storage. Anon. (Abs.).....	158	- yield, effect of late planting and nitrogen application. L. Schmidt. (Abs.).....	274	- drilling date. H. Felz. (Abs.)..	214
sugar content, effect of cane burning. S. el-N. A. Hemaïda <i>et al.</i> (Abs.)	302	mechanical properties and slicing. K. Vukov. (Abs.).....	187	- growth retardants. P. R. Hepler. (Abs.).....	20
tramp iron removal. (T.N.).....	62	nitrogen determination. N. Kubadinov. (Abs.).....	284	- harvest date and irrigation interval. Y. Singh and S. P. Singh. (Abs.).....	338
utilization. (T.N.).....	350	plant population, effect of inter-row spacing. E. Bornscheuer and H. Meinecke. (Abs.).....	276	- inter-row spacing and nitrogen. J. N. Carter <i>et al.</i> (Abs.)..	242
- as fuel. J. C. Hudson. (Abs.).....	208, 273	- - G. Táray. (Abs.).....	211	- nitrogen. W. A. Dickinson.....	180
weighing. B. D. Ravný <i>et al.</i> (Abs.)	150	- - and seed spacing. S. Machajewski. (Abs.).....	274	- plant population. L. Schmidt <i>et al.</i> (Abs.).....	181
see also By-products; Furnaces; Paper and Pulp		- optimization. J. E. Hull. (Abs.)	305	- C. Winner and R. Merkes.....	243
Barbados: cane varieties. Anon. (Abs.)	239	- quality. M. Z. Khelemskii <i>et al.</i>	82	- rotation. D. R. Christenson	212
- trials. Anon. (Abs.).....	238	- effect of agronomic factors. M. Martens. (Abs.).....	53	- vs. monoculture. N. A. Alek'ov and N. F. Kostin	371
Sugar Cane Consultants. (Brev.)..	159	- evaluation. M. Burba. (Abs.)	347	- seed spacing. F. J. Hills	19
- production. (Brev.).....	96	reception. N. M. Kichigin <i>et al.</i> ..	375	- temperature. G. K. Ryser	307
- statistics. (Stat.).....	287	- I. B. Somorov. (Abs.).....	88	- evaluation. Anon. (Abs.).....	215
Bearings: cane mill. U. J. Ackeus.....	54	riponing with chemical. J. Christmann. (Abs.).....	211	- prediction. J. O. Reus <i>et al.</i>	115
- torque requirements. D. Macey	54	root, crown and collar composition. K. Fábán and J. Kollár. (Abs.)	188	see also Animal fodder; Diffusers; Diffusion; Diseases; Factory; Fertilizers; Juice; Mechanization; Molasses; Payment; Peeling; Pests; Pulp; Soil; Storage; Transport; Varieties; Water, Waste and Weather	
and J. A. McEinn. (Abs.).....	54	- K. Fábán and J. Kollár. (Abs.)	188	Belgium: beet agriculture. L. van Steyvoort. (Abs.).....	18, 243
roller. S. E. Carver. (Abs.).....	309	- sugar accumulation. J. Guern.....	339	- varietal trials. N. Roussel <i>et al.</i>	82, 244, 339
Beet: agriculture in Belgium. L. van Steyvoort. (Abs.).....	18, 243	- quality. M. Z. Khelemskii <i>et al.</i>	82	sugar factory closures. (Brev.).....	287
- vs. cane in Morocco. G. Schmidt	82	- effect of agronomic factors. M. Martens. (Abs.).....	53	Belgium/Luxembourg: sugar imports and exports. (Stat.).....	255
- crop rotation. J. Baldwin. (Abs.)	276	- evaluation. M. Burba. (Abs.)	347	see also Europe, EEC	
- demonstrations in UK. (Brev.).....	254	reception. N. M. Kichigin <i>et al.</i> ..	375	Belize sugar production 1975. (Brev.)	320
- in Finland. W. C. von Kessel.....	149	- I. B. Somorov. (Abs.).....	88		
- India. R. S. Kanwar <i>et al.</i> (Abs.)	83	riponing with chemical. J. Christmann. (Abs.).....	211		
- D. S. Oberoi and R. Singh. (Abs.)	83	root, crown and collar composition. K. Fábán and J. Kollár. (Abs.)	188		
- Morocco. Anon. (Abs.).....	83	- sugar accumulation. J. Guern.....	339		
- research in France. Anon. (Abs.)	116	- quality. M. Z. Khelemskii <i>et al.</i>	82		
- station open day in UK. (Brev.)	265	- effect of agronomic factors. M. Martens. (Abs.).....	53		
- in Rumania. Anon. (Abs.).....	149	- evaluation. M. Burba. (Abs.)	347		
- Spain. Anon. (Abs.).....	378	reception. N. M. Kichigin <i>et al.</i> ..	375		
- USSR. (Brev.).....	287	- I. B. Somorov. (Abs.).....	88		
alcohol manufacture in France. Anon. (Abs.).....	285	riponing with chemical. J. Christmann. (Abs.).....	211		
amino-acids determination. M. Burba and B. Georgi. (Abs.).....	348	root, crown and collar composition. K. Fábán and J. Kollár. (Abs.)	188		
analysis. J. Hobbis and L. Batterman. (Abs.).....	92	- sugar accumulation. J. Guern.....	339		
ash content, effect of drilling date. V. Stehlik and L. Schmidt. (Abs.)	242	- quality. M. Z. Khelemskii <i>et al.</i>	82		
- - nutrient uptake. U. Beiss and C. W. Hunter. (Abs.).....	148	- effect of agronomic factors. M. Martens. (Abs.).....	53		
biochemistry. L. László. (Abs.)..	274	- evaluation. M. Burba. (Abs.)	347		

INDEX

	PAGE		PAGE
Betaine: content in beet, effect of harvest date and nitrogen. R. C. Zelik and F. W. Snyder. (Abs.)	125	Bolivia: sugar exports. (Brev.)	269
Bollers. (T.N.)	62	Bone-char: kiln in Colombia. (Brev.)	286
K. J. Nix. (Abs.)	85	refinery liquor colour removal. D. F. Charles. (Abs.)	283
computer simulation. J. M. Steward and W. B. Crawford. (Abs.)	85	seed preparation. E. Corona and J. Castañeda. (Abs.)	277
emission. H. Smith. (Abs.)	184	seedling, seed slurry purity. P. Marinmullu. (Abs.)	309
order from Philippines. (T.N.)	286	steam injection and heat transfer. S. M. Konstantinov and N. N. Bezpal'ko. (Abs.)	376
see also Furnaces, Bagasse; Power; Scale; Steam and Water		syrup purity and molasses yield optimization. V. A. Pugachev <i>et al.</i>	278
Boiling. J. J. Balardi. (Abs.)	119	temperature periodical alteration and crystal size. V. O. Shtangeev <i>et al.</i>	185
V. R. E. Bhnasale. (Abs.)	183	two- vs. three-masseuite system. H. Reyes. (Abs.)	203
K. Hangyal. (Kabs.)	186	white sugar scheme. C. R. Sriramulu <i>et al.</i> (Abs.)	308
V. M. Kharin. (Abs.)	193	see also Crystallization, Masseuite and Pans, Vacuum	
W. Lekawski and A. Bober. (Abs.)	120	Brazil: Abraham Lincoln sugar factory, alcohol manufacture from cane juice and molasses. (Brev.)	213
V. Maurandi. (Abs.)	25	bulk handling terminal. (Brev.)	256
D. Schlepshake and K. Austmeyer. (Abs.)	380	P. Tavares. (Abs.)	210
J. G. Ziegler. (Abs.)	56	cane agriculture. N. Coutinho. (Abs.)	208
automatic control. Anon. (Abs.)	312	— J. A. G. C. Sousa. (Abs.)	210
— R. J. Bass and J. Donovan. (Abs.)	375	— mill. (Brev.)	384
— L. Bates <i>et al.</i> (Abs.)	54	— research. G. M. Azhar. (Abs.)	210
— P. W. Collins. (Abs.)	85	varieties. A. J. Bassinello. (Abs.)	210
— E. Gierada and A. Tobola. (Abs.)	280	— trials. M. M. de Melo and J. A. C. M. de Souza. (Abs.)	270
— H. Kemter. (Abs.)	311	fertilizer recommendations. J. O. Filho. (Abs.)	270
— C. J. Lu. (Abs.)	277	— trials. M. L. Marinho <i>et al.</i> (Abs.)	270
— J. P. Merle. (Abs.)	86	new sugar factory. (Brev.)	32, 63
— H. Thiele and A. Langen. (Abs.)	246	sugar exports. (N.C.)	130, 159
— V. I. Tuzhilkin <i>et al.</i> (Abs.)	344	— industry. Anon. (N.B.)	289
— conductivity electrode. S. R. Reichard and T. L. Vidler. (Abs.)	85	British Sugar Corporation Ltd.: factory expansion and modernization. (23rd Technical Conference)	354, 230
— masseuite Brix. P. J. Fernandez. (Abs.)	214	Brix: automatic control. T. Diaz and P. Friedman. (Abs.)	214
— rheological properties. D. Schlepshake and K. Austmeyer. (Abs.)	55, 187	— P. J. Fernandez. (Abs.)	245
capacity, effect of low juice purity. R. D. Archibald and I. A. Smith. (Abs.)	182	— evaporation. C. D. Clarke and M. Webber. (Abs.)	84
— L. Wieninger and N. Kubadinov. (Abs.)	91, 93	— refinery liquor. A. O. Maylotti and J. W. de Celis. (Abs.)	315
computer application. J. A. Frew and P. G. Wright. (Abs.)	372	— syrup. S. Bouček and V. Valter. (Abs.)	87
continuous. R. Broadfoot <i>et al.</i>	341	beet juice, measurement. M. Friml and B. Tichá. (Abs.)	124
I. S. Gulyi <i>et al.</i> (Abs.)	153	cane juice, effect of burning. S. el-N. A. Hemaïda <i>et al.</i> (Abs.)	302
— H. G. Köppen. (Abs.)	312	— deterioration after harvesting. Anon. (Abs.)	238
— R. J. Steindl <i>et al.</i> (Abs.)	84	— J. E. Irvine and B. L. Legendre. (Abs.)	146
— classified crystal recycling. A. D. Randolph and E. F. White. (Abs.)	372	— N. Ramamoorthy <i>et al.</i> (Abs.)	220
— mathematical simulation. I. S. Gulyi <i>et al.</i> (Abs.)	376	— extraneous matter. S. el-N. A. Hemaïda <i>et al.</i> (Abs.)	308
— performance prediction. R. Broadfoot and E. T. White. (Abs.)	84	— frost. J. D. Miller and G. J. Gascho. (Abs.)	92
crystallization rate calculation. L. Carrazana R. and A. P. Kozlavin. (Abs.)	124	— measurement. A. L. Fors. (Abs.)	188
— effect of juice liming. V. A. Golybin and S. Z. Ivanov. (Abs.)	120	— mud separation by polyelectrolyte. W. Stewart. (Abs.)	145
effect of clarification with magnesium oxide. J. J. Zwardomaker. (Abs.)	118	— selection criterion. C. A. Richard and M. T. Henderson. (Abs.)	145
— pineapple disease. S. K. Manzo. (Abs.)	143	— molasses measurement. P. Mellet <i>et al.</i> (Abs.)	123
— steam pressure and masseuite temperature fluctuations. V. O. Shtangeev <i>et al.</i> (Abs.)	217	— carbonation juice, effect of magnesium oxide. J. Studnický <i>et al.</i>	342
heat surface utilization, effect of relative initial charge and masseuite level. V. P. Troino <i>et al.</i>	153	effect on cane molasses viscosity. L. Carrazana R. <i>et al.</i> (Abs.)	251
— transfer. V. T. Garyazha and B. G. Didushko. (Abs.)	152	— dextran reduction by enzyme. E. Hidl and R. Staker. (Abs.)	85
isohydric conditions. I. G. Bazhal <i>et al.</i> (Abs.)	122	— sugar analysis by gas-liquid chromatography. M. A. Godshall and E. F. Roberts. (Abs.)	283
losses, effect of pH and temperature. S. A. Brenna <i>et al.</i> (Abs.)	249	— solution viscosity, etc. D. E. Sinat-Radchenko and V. D. Popov. (Abs.)	157
low grade sugar recovery. R. J. Batterham. (Abs.)	85	masseuite and heat transfer in boiling. V. T. Garyazha and B. G. Didushko. (Abs.)	152
— head pan performance. D. Gotthardt <i>et al.</i> (Abs.)	341	measurement. I. A. Prikhod'ko and K. V. Ukrainets. (Abs.)	220
— mass balance. J. Uherak and V. Valter. (Abs.)	343	— sugar factory products. A. Y. Zagorut'ko <i>et al.</i> (Abs.)	316
— masseuite circulation. G. Aleman. (Abs.)	214	— temperature control. M. Randabøl melder automatic control. Anon.	251
— increase by air/steam injection. V. T. Garyazha <i>et al.</i> (Abs.)	185	meter. S. Bouček and V. Valter. (Abs.)	218
— forced circulation. J. P. Abbott and J. E. A. Rich. (Abs.)	87	stored beet thick juice. T. P. Khvalkovskii <i>et al.</i> (Abs.)	120, 246
— P. W. Goodenough and M. R. Player. (Abs.)	84	— M. Moore and J. Karr. (Abs.)	56
— layer thickness and flow rate measurement. B. G. Didushko. (Abs.)	313	see also Control, Chemical; Density and Evaporators	
— supersaturation coefficient calculation. V. I. Tuzhilkin and L. M. Bochkov. (Abs.)	280	Bulgaria: factory equipment. D. Babev	313
— measurement. P. Metzging and K. F. Schlag. (Abs.)	218	sugar expansion plants. (Brev.)	192
— surface-active additives. K. Ciz <i>et al.</i> (Abs.)	218	bulk handling. N. A. Emel'yanov and N. M. Kichigin <i>et al.</i> (Abs.)	375
— Y. G. Ropotenko <i>et al.</i> (Abs.)	88	sugar weigher. Anon. (Abs.)	117
— and raw sugar yield and colour. N. L. C. Suzor. (Abs.)	309	see also Conveyors	
— viscosity. G. Aleman. (Abs.)	150	Bulk storage: micro-organisms and sugar deterioration. M. T. Hernández and N. Herrera. (Abs.)	22
— K. Wagnerowksi. (Abs.)	216	sugar. E. Cardet <i>et al.</i> (Abs.)	245
— yield, effect of molasses raffinose hydrolysis. R. A. McGinnis. (Abs.)	121	— silo. A. Baudelocque. (Abs.)	25
mathematical model. T. Diaz and P. Friedman. (Abs.)	245	— M. Braeckman. (Abs.)	311
molasses exhaustion. G. F. Fundora. (Abs.)	151	— M. H. Caplin. (Abs.)	119
— A. L. Webre. (Abs.)	374	terminal in Australia. (Brev.)	64
— purity prediction. Anon. (Abs.)	213	— Brazil. (N.B.)	236
nucleation. R. J. Batterham <i>et al.</i>	84	— Anon. (N.B.)	58
— R. Bretschneider and M. Svobodová. (Abs.)	27	— P. Tavares. (Abs.)	22
parameters calculation. V. I. Pavleiko and V. T. Garyazha. (Abs.)	313	— Cuba. (Brev.)	64
— effect of circulation ratio. V. P. Troino <i>et al.</i> (Abs.)	153	— Taiwan. H. Y. Chen. (Abs.)	23
		very high pol sugar. Z. J. Kimmerring	182
		white sugar conditioning. V. Maurandi and G. Mantovani. (Brev.)	55, 217, 342
		Burma sugar industry. (Brev.)	32
		By-products: utilization. G. K. Khetty	309
		— M. J. Kort. (N.B.)	58
		see also individual by-products	
		Calcium, see Ash; Lime; Carbonation and Clarification	
		Cameron sugar industry finance from France. (Brev.)	287
		Canada: Sugar Industry Technologists Inst. meeting 1976. (Brev.)	127, 235
		— production 1975. (Brev.)	191
		Vancouver refinery. K. M. Foo. (Brev.)	57
		Cane: age and juice clarification. P. M. Fabregat and L. Gomez R. (Abs.)	86
		agriculture. P. H. Nelson and E. Zillch. (Abs.)	302
		— vs. beet in Morocco. G. Schmidt	82
		— in Brazil. N. Coutinho. (Abs.)	110
		— J. A. G. C. Sousa. (Abs.)	210
		— consultancy firm in Barbados. (Brev.)	159
		— crop data utilization. A. B. Tucker	175
		— effect of drip irrigation. C. T. Fisher. (Abs.)	369
		— J. B. Thomson. (Abs.)	369
		— on flat land. M. O. Isherwood. (Brev.)	80
		— in Hawaii. W. S. Robinson. (Abs.)	369
		— M. Uehara. (Abs.)	369
		— for increased sugar yield. E. L. del Rosario. (Abs.)	15
		— in India. Anon. (Abs.)	81, 272
		— S. Thangavelu and K. Sundarasan. (Abs.)	365
		— Japan. G. C. Thompson and P. G. C. Brett. (Abs.)	301
		— Malaysia. K. Y. Li. (Abs.)	77
		— Mexico. Anon. (Abs.)	176
		— S. Flores C. (Abs.)	48
		— C. Passos. (Abs.)	48
		— Philippines. A. Balcells. (Abs.)	111
		— research in Argentina. Anon.	51
		— Australia. Anon. (N.B.)	58
		— R. N. Nalder. (Abs.)	78
		— Brazil. G. M. Azzi. (N.B.)	252
		— India. Anon. (Abs.)	81
		— T. R. Srinivasan and Y. B. Moracan. (Abs.)	301
		— Taiwan. S. J. Yang. (Abs.)	367
		— Réunion. Anon. (Abs.)	365
		— Spain. Anon. (Abs.)	378
		alpha-amylase activity. G. el-K. Sayed <i>et al.</i> (Abs.)	157
		analysis, disintegrator. J. P. Stupliello <i>et al.</i> (Abs.)	380
		animal fodder. D. Fielding. (Abs.)	221
		breeding in Argentina. O. Giménez	48
		L. and E. Pérez A. (Abs.)	302
		— for borer and disease resistance. G. M. Azzi. (Abs.)	303
		— in Brazil. Anon. (N.B.)	58
		— eye spot resistance. J. L. Desan and J. D. Miller. (Abs.)	179
		— in Jamaica. Anon. (Abs.)	240
		— for mosaic resistance. R. D. Breaux. (Abs.)	178
		— R. D. Breaux and P. H. Dunkelmann. (Abs.)	145
		— programme area requirement. R. Cesnik. (Abs.)	241
		— programming calculator application. J. D. Miller and N. I. James	112
		— in Réunion. Anon. (Abs.)	76
		— selection. R. D. Breaux. (Abs.)	113
		— N. I. James and B. L. Mather. (Abs.)	178
		— in South Africa. Anon. (N.B.)	59
		— R. S. Bond. (Abs.)	175
		— G. D. Thompson. (Abs.)	15
		— Taiwan. P. S. Shen. (Abs.)	367
		— U.S. (Brev.)	320, 364
		— P. H. Dunkelmann. (Abs.)	145
		— P. H. Dunkelmann and M. A. Blanchard. (Abs.)	207
		— C. E. Freese and B. L. Walker	114
		— I. L. Laidler. (Abs.)	365
		— West Indies. Anon. (Abs.)	238
		— for yellow wilt resistance. (Brev.)	364
		burning, effect on harvesting, loading and transport. J. Orsenigo. (Abs.)	179
		cleaner. C. J. Daigle. (Abs.)	151
		clone enzyme and morphology variations. A. M. Frias de F. <i>et al.</i>	367

INDEX

	PAGE
Cane: crops effect on soil nutrients. H. J. Andreis. (Abs.)	91
- - - F. A. Fogliata. (Abs.)	79
- - - failure probability evaluation. J. F. Willis. (Abs.)	81
damage by aleurodid feeding. R. A. Agarwal.	109
- - - deterioration after frost, effect on processing. H. A. Naqvi and S. M. Alam.	202
- - - and juice acidity. J. C. P. Chen et al. (Abs.)	188
- - - harvesting. G. J. Gascho et al.	150
- - - R. G. Hoekstra. (Abs.)	151
- - - J. E. Irvine and B. L. Legendre	146
- - - G. et K. Sayed et al. (Abs.)	157
- - - T. R. Srinivasan et al. (Abs.)	210
- - - C. R. Toca. (Abs.)	119
- - - and condensate ethanol. J. D. Blake.	131
- - - effect of burning. Anon. (Abs.)	213
- - - reduction. Anon. (Abs.)	110
- - - S. Bose et al. (Abs.)	302
drying-off. J. E. Lonsdale. (Abs.)	174
enzymes and juice colour formation. D. Gross and J. Coombs	69
extraneous matter and boiler induced draught fan wear. Y. H. Kuo	277
- - - causes. F. N. Bolton. (Abs.)	147
- - - D. P. Viator. (Abs.)	146
- - - fibre properties. M. D. González F. and M. A. Vázquez G.	253
- - - and field losses, manual vs. mechanical harvesting. J. E. Clayton et al. (Abs.)	146
- - - as fuel. J. C. Hudson. (Abs.)	208
- - - and losses. S. el-N. A. Hemaida et al. (Abs.)	308
- - - E. L. Legendre. (Abs.)	177
- - - mill feeding. A. Vigli. (Abs.)	53
- - - processing quality. B. L. Legendre and J. E. Irvine. (Abs.)	183
fibre and moisture determination. A. L. Fors. (Abs.)	92, 220
- - - pith separation. J. C. Hudson.	208, 273
- - - field measurement. E. M. Pointing	333
- - - flowering control. Anon. (Abs.)	206, 239
- - - induction. P. S. Singh. (Abs.)	175, 302
- - - P. H. Dunkelmann and M. A. Blanchard. (Abs.)	178
- - - E. D. Palitaisas. (Abs.)	113, 145
- - - in Egypt. S. D. Dobs. (Abs.)	272
- - - and quality. F. A. Fogliata and D. M. Morin. (Abs.)	303
growth, effect of soil structure. P. R. Downs. (Abs.)	78
- - - weather. P. S. Singh. (Abs.)	175
- - - simulation by computer. T. A. Bull and D. A. Tovey. (Abs.)	142
harvesting data processing. R. F. Sutherland. (Abs.)	54
- - - effect of burning. Anon. (Abs.)	77
- - - time optimization. L. M. Arceo.	111
- - - with water. A. S. Hall. (Abs.)	363
intercropping. R. S. Kanwar.	176, 207
- - - K. Kar et al. (Abs.)	101
- - - K. S. Rath. (Abs.)	211
- - - with beet. J. S. Garg and M. P. Azad. (Abs.)	300
- - - P. P. Singh. (Abs.)	15
- - - corn. Anon. (Abs.)	238
- - - cotton. N. P. Wankhede and K. S. Parashar. (Abs.)	51
- - - potatoes, effect of blight control. Anon. (Abs.)	206
- - - wheat. B. S. Mathur. (Abs.)	272
- - - pest problem. A. N. Kalra et al.	300
leaf analysis. J. O. Filho and H. de Campos. (Abs.)	77
- - - J. H. Meyer. (Abs.)	147, 239
- - - effect of sample cleaning. J. O. Filho et al. (Abs.)	205
- - - optimum number of leaves. J. O. Filho and H. de Campos	16
- - - desiccant application. J. W. Beardsley. (Abs.)	179
- - - development and yield. J. E. Irvine. (Abs.)	113
- - - dew sugars. P. S. Singh. (Abs.)	177
- - - herbicide and ripener retention. H. W. Hilton et al. (Abs.)	81
- - - nitrogen determination. V. C. Bittencourt et al. (Abs.)	318
- - - phosphorus and potassium contents. R. Brunet and S. P. Maurea. (Abs.)	238
- - - sheaths and axillary bud germination. G. T. A. Benda. (Abs.)	146
- - - zinc critical content. G. D. Thompson. (Abs.)	15
lodging effect on quality. F. A. Fogliata and D. M. Morin. (Abs.)	303
mutation by irradiation. Anon. (Abs.)	259
photosynthesis, effect of weather. A. L. Fors. (Abs.)	49
planting. L. L. Lauden. (Abs.)	175
- - - in Australia. G. L. Tooley. (Abs.)	177
- - - material selection. L. G. W. Tilley	271
- - - single vs. double drills. R. C. Hodson. (Abs.)	205
- - - skip method. J. W. Beardsley.	145
- - - in US, spring vs. autumn. H. P. Fanguy and G. T. A. Benda.	177

Cane: preparation. G. N. Nurick. (Abs.)	214
quality, effect of bagasse mulching. J. C. P. Chen and R. W. Picout.	150
- - - burning. S. el-N. A. Hemaida et al. (Abs.)	302
- - - mechanical harvesting. J. J. Seip and J. A. Salazar. (Abs.)	147
- - - reception. H. T. E. Smith. (Abs.)	79
- - - automatic control. R. E. Hicks and H. E. Childs. (Abs.)	340
- - - G. D. Maclean and D. B. Batstone. (Abs.)	340
- - - and sampling. R. L. Muller. (Abs.)	54
- - - computer application. D. B. Batstone. (Abs.)	119
- - - replanting. F. Y. Hsai. (Abs.)	76
- - - ripening with chemicals. Anon. 206, 240	366
- - - J. J. Chen and C. P. Chen	177
- - - D. Eastwood. (Abs.)	111
- - - A. L. Fors. (Abs.)	49
- - - K. R. Frost. (Abs.)	144
- - - R. Julien. (Abs.)	176
- - - L. L. Lauden. (Abs.)	114, 176
- - - B. L. Legendre. (Abs.)	144
- - - L. G. Nickell and D. T. Takahashi. (Abs.)	79, 81, 144
- - - J. R. Orselugo and S. L. Hooks	144
- - - L. Oudman. (Abs.)	369
- - - K. C. Rao et al. (Abs.)	273, 331
- - - H. Rostron. (Abs.)	174
- - - G. Singh et al. (Abs.)	295
- - - L. G. Vallance. (Abs.)	241
- - - residues. H. W. Hilton et al.	81
- - - effect of age. H. Muñoz et al. (Abs.)	16
- - - root system maintenance. J. F. Usher. (Abs.)	209
- - - yield, effect of soil and fertilizer. L. E. Golden. (Abs.)	145
- - - sampling. H. S. Birkett and J. J. Seip. (Abs.)	188
- - - E. R. de Oliveira et al. (Abs.)	166
- - - J. J. Seip and F. L. Gayle. (Abs.)	150
- - - and analysis. H. S. Birkett and J. J. Seip. (Abs.)	220
- - - R. M. Hebert. (Abs.)	347
- - - scrapable cane determination. L. L. Lauden. (Abs.)	238
seed cane growing. S. Inazu. (Abs.)	81
- - - I. Yonemitsu. (Abs.)	81
- - - and cutting. R. D. Sollars	81
- - - material. M. Lakshminantham.	176
sett germination, effect of chemicals. D. Eastwood. (Abs.)	111
- - - growth regulators. P. R. C. Castro et al. (Abs.)	110
- - - pre-treatment. J. R. Kakde et al. (Abs.)	16
- - - E. K. Mathur et al. (Abs.)	17
- - - size. R. S. Kanwar et al.	16
- - - spacing and fertilizer requirements. E. A. Paniagua U. (Abs.)	49
specific heat. T. B. Dale. (Abs.)	220
standover. J. Stewart. (Abs.)	47
starch components and iodine colour spectra. E. Whayman and A. L. Willersdorf.	67
- - - isolation and iodine affinity. J. C. Stevenson and E. Whayman	44
steam treatment and colour formation in juice and sugar. N. H. Smith.	259
sugar content correlation with stool Brix. C. A. Richard and M. T. Henderson. (Abs.)	145
- - - effect of nitrogen. U. S. Singh	111
- - - temperature. K. Venugopal and T. P. Palaniappan.	144
- - - differentiation from beet sugar. J. Briquet and J. C. Fontes. (Abs.)	28
- - - yield and pol. E. Rodriguez C. et al. (Abs.)	118
- - - topping and recoverable sugar. Anon. tops as animal fodder. S. C. Mai and T. H. Wu. (Abs.)	213
- - - trap iron removal. (T.N.)	61
- - - utilization as fuel. R. W. Graham	62
yield correlation with sugar content and c.e.s. B. K. Sahi and K. A. Patel. (Abs.)	300
- - - effect of contouring. J. D. Veurnman. (Abs.)	179
- - - cultivations. R. J. Matherne et al.	77
- - - environmental factors. J. A. Mariotti et al. (Abs.)	366
- - - filter cake and trash mulch. H. H. Hagihara. (Abs.)	80
- - - growth regulators. G. Singh and K. Sareen. (Abs.)	368
- - - harvest date. L. G. Vallance.	273
- - - inter-row spacing. Anon. (Abs.)	206
- - - R. J. Matherne. (Abs.)	114, 145, 205
- - - B. T. Roach. (Abs.)	335
- - - irrigation and trash mulching. B. K. Mathur. (Abs.)	239
- - - leaf canopy. R. P. Humbert.	208
- - - pesticide. R. S. Kanwar. (Abs.)	272
- - - soil erosion. J. D. Veurnman	179
- - - salinity reduction. W. T. Su	112
- - - K. W. Yao. (Abs.)	112
- - - sand content. G. Dodgen.	179
- - - water table. G. E. Carter and J. M. Floyd. (Abs.)	177
- - - stalk height and number. J. A. Mariotti and I. A. Turowski.	366

	PAGE
Cane:	
- - - weed competition. J. A. Mariotti et al. (Abs.)	366
- - - and quality, effect of age and harvest time. J. E. Lonsdale and J. M. Gosnell. (Abs.)	175
- - - drying-off. J. M. Gosnell and J. E. Lonsdale.	7
- - - moisture stress. M. S. Rao and S. H. Rao. (Abs.)	300
- - - as animal fodder; By-products; Diffusers; Diffusion; Diseases; Factory; Fertilizers; Irrigation; Juice; Mechanization; Molasses; Payment; Pests; Soil; Transport; Varieties; Wax and Weather	
Carbon, Active: colour adsorption. G. A. Chikin and V. F. Serebnev	57
granular vs. powdered for refinery liquor treatment. J. N. Forend and C. J. Bernard. (Abs.)	219
manufacture from bagasse. G. Ocampo et al. (Abs.)	190
- - - clarification mud. R. Cetina et al.	221
- - - paddy husk. B. G. Krishnamurti	315
- - - multiple elution. J. Dobrzycki.	139
- - - refinery liquor colour removal. D. F. Charles. (Abs.)	283
- - - M. R. Irimia. (Abs.)	123
- - - regeneration kiln. Y. O. Kravets et al.	123
- - - selection. A. Y. Hyndshaw. (Abs.)	57
- - - sugar recovery improvement in boiling. R. J. Batterham. (Abs.)	85
- - - sweetening-off control. C. R. Brown and P. Pommeze. (Abs.)	283
see also Refining	
Carbonation. J. Caldemaisous. (Abs.)	187
P. Henetton. (Abs.)	187
A. P. Lapin et al. (Abs.)	216
A. S. Okolot and M. S. Kozlo. (Abs.)	88
H. Schwöck. (Abs.)	278
T. Y. Shalimova et al. (Abs.)	185
N. D. Tantsyura and Y. A. Kaufman	248
K. D. Zhura and S. P. Olyanskaya	152
amino-acids behaviour. N. Kubandinov and W. Klamp. (Abs.)	60, 220
automatic control. J. F. T. Oldfield et al. (Abs.)	87
colorants adsorption. S. Z. Ivanov et al. (Abs.)	376
- - - K. Vukov. (Abs.)	26, 246, 316
compared with sulphitation for white sugar manufacture. M. Cordoves et al. (Abs.)	117
correctness. S. Singh et al. (Abs.)	309
effect of starch. J. B. Alexander and M. Matic. (Abs.)	314
- - - E. Whayman and A. L. Willersdorf.	99
gas scrubbing. K. N. Savchuk. (Abs.)	216
juice additive and mud coagulation. J. Burianek et al. (Abs.)	248
- - - colour formation, effect of oxygen. H. Schwöck. (Abs.)	26, 246
- - - and lime salts content, effect of pectin. S. P. Olyanskaya et al.	24
- - - and mud analysis. G. Pollach	284
- - - nitrogen and pectin reduction by pre-carbonation mud removal. K. P. Zakharov et al. (Abs.)	185
- - - optimum alkalinity and evaporation. M. K. Likhtskil and L. P. Reva. (Abs.)	152
- - - pH and silicon content. P. Devillers et al. (Abs.)	377
lime consumption and distribution calculation. R. T. Mishchuk. (Abs.)	121
liming. V. A. Golybin and S. Z. Ivanov. (Abs.)	120
- - - with air injection for colour reduction. E. Reinefeld. (Abs.)	120
- - - magnesium oxide. K. W. R. Schoenrock et al. (Abs.)	56
- - - J. Studnický et al. (Abs.)	50, 342
mass and heat balances. Anon. (Abs.)	312
muld addition to flume water. K. Skalski. (Abs.)	218
- - - soil. J. C. Remy et al. (Abs.)	222
- - - R. Vanstellen. (Abs.)	211
- - - conveying. G. Pal. (Abs.)	216
- - - filtration, effect of decran. J.F.T. Oldfield et al. (Abs.)	26
- - - recirculation calculation. J. Čepelák and R. Osvald. (Abs.)	247
- - - rheological properties. Z. Kębłowski et al. (Abs.)	28
phosphate addition. Anon. (Abs.)	150
refinery liquor. I. Galbán. (Abs.)	314
- - - R. T. Mishchuk and A. Y. Zagor'ko. (Abs.)	219
- - - J. P. Murray and F. M. Rungeas	219
- - - T. Yamane and H. Asai. (Abs.)	154
- - - regenerated lime application. S. Omeri. (Abs.)	154
- - - ces. sulphitation. L. D. Bobrovnik and L. P. Kotelnikova.	152
saccharinic acids formation. L. Skála and M. Friml. (Abs.)	220
vessel. L. P. Reva et al. (Abs.)	247
- - - scale. A. T. Bogorosh et al.	247
see also Clarification and Juice, Beet Cane Ltd. nationalization bid. (Brev.)	255
Centrifugals. P. H. Pithois and A. Mercier. (Abs.)	378

INDEX

PAGE	PAGE	
<p>Centrifugals: automatic control. A. L. Ballard and L. Gandia. (Abs.)..... 150 - A. L. Ballard <i>et al.</i> (Abs.)..... 150 - Western States. A. O. Maylott and J. W. deCelis. (Abs.)..... 315 continuous. D. Ahari and J. Genotelle - blade-type. V. Optil and J. Pridal - masticulate feed control. G. M. Chudakov <i>et al.</i> (Abs.)..... 376 - BMA balancing. D. Macey. (Abs.)..... 341 - capacity increase. M. A. J. McEvoy and R. D. Archibald - water addition. I. N. Akinidinov <i>et al.</i> (Abs.)..... 217 - feeder height and molasses separation. V. F. Kolomiets <i>et al.</i> - FVII-106. N. I. G. M. Chudakov <i>et al.</i> (Abs.)..... 248 - high-speed photography application. Anon. (Abs.)..... 245 - masticulate layer thickness and crystal residence time estimation. R. J. Swindells and E. T. White - performance. L. K. Kirby and P. G. Atherton. (Abs.)..... 213 - screens. Anon. (Abs.)..... 312 - sugar crystal movement. R. J. Swindells and E. T. White. (Abs.) - throughput, effect of screen perforations. D. Haecel. (Abs.)..... 53 - filter cake dewatering. A. B. Ravno and G. R. E. Lionnet. (Abs.)..... 151 - molasses exhaustion. A. L. Webre orders. (T.N.)..... 350 - from Mexico. (Brev.)..... 159 - push-type plus cake milling. M. Sterzinger and J. Zdarsky. (Abs.)..... 323, 361 wash water feed costs. T. Cronewitz <i>et al.</i> (Abs.)..... 342</p> <p>Centrifuge beet juice pulp removal. H. Schiwce. (Abs.)..... 278 clarifier mud treatment. Anon. (Abs.) - S. C. Grimley and R. A. Allaway. (Abs.)..... 86 - P. N. Stewart <i>et al.</i> (Abs.)..... 85, 373 floc formation prevention. E. J. Roberts <i>et al.</i>..... 326 starch removal from cane juice. G. E. K. Sayed <i>et al.</i> (Abs.)..... 286 Chains. (T.N.)..... 214 L. de Jahu. (Abs.)..... 86 R. W. Eibly. (Abs.)..... 182 C. G. Wildsmith. (Abs.)..... 182</p> <p>Chile: joint beet sugar technology association with Uruguay. (Brev.) sugar imports. (Stat.)..... 96 - production expansion. (Brev.) - statistics. (Stat.)..... 46 China: sugar statistics. (Brev.) trade agreement with Guyana - Zaire sugar project aid. (Brev.)..... 191, 287</p> <p>Chromatography, Column: saccharinic acids separation. L. Skála and M. Friml. (Abs.)..... 220 Chromatography, Gas-liquid. M. Kiely and M. O'Sullivan. (Abs.)..... 317 acids determination in beet juice. E. Reinefeld <i>et al.</i> (Abs.)..... 28, 157 - and molasses. E. Reinefeld <i>et al.</i> (Abs.)..... 28, 157 glucuronic acid determination. V. Prey <i>et al.</i> (Abs.)..... 254 nitrogen determination. N. Kubadinov. (Abs.)..... 284 sugar analysis. M. A. Godshall and E. J. Roberts. (Abs.)..... 283 - determination in beet juices. G. W. Maag and G. H. Siler. (Abs.)..... 250 - cane. Anon. (Abs.)..... 365 - molasses. M. Kort <i>et al.</i> (Abs.)..... 189 - Steffen filtrate. J. Karr and J. W. Norman. (Abs.)..... 125 sugars determination. S. E. Kharin <i>et al.</i> (Abs.)..... 125 - D. Nurok and T. J. Reardon. - in molasses. A. Borys and S. J. Kubacki. (Abs.)..... 189</p> <p>Chromatography, Gel: colorants separation. V. Prey and H. Andres..... 318 sugars separation. J. C. Linden. Chromatography, Liquid: molasses sugar extraction. M. Munir..... 100 Chromatography, Paper: juice, molasses and syrup analysis. M. Kiely and M. O'Sullivan. (Abs.)..... 317 organic acids determination. G. P. Voloshanenko and A. M. Shevchenko. (Abs.)..... 156 saccharinic acids separation. L. Skála and M. Friml. (Abs.)..... 220 Chromatography, Thin-layer: lactic acid determination. M. Kiely and M. O'Sullivan. (Abs.)..... 317 pesticide determination in sugar. A. Z. Umetseva <i>et al.</i> (Abs.)..... 93, 347 saccharinic acids separation. L. Skála and M. Friml. (Abs.)..... 220 sugars determination. S. A. Hansen separation. M. Friml. (Abs.)..... 188 - M. Hoton-Dorge. (Abs.)..... 348</p> <p>Citric acid: effect on beet juice pH. F. Teschner and R. Krämer. (Abs.)..... 279 factory in Greece. (Brev.)..... 352</p>	<p>Citric acid: manufacture from cane juice, effect of methanol and groundnut oil. K. Kumar and S. Ethiraj. (Abs.)..... 253 - molasses. H. S. Dhanraj <i>et al.</i> - Kovats and Z. Nieslawski. - L. Vanossi. (Abs.)..... 126 - and dextrose. Y. T. Liu. (Abs.) solution pH, effect of calcium. F. Teschner and R. Krämer. (Abs.)..... 278 Clarification. G. J. Labat. (Abs.)..... 151 calcium phosphate precipitation. F. G. Carpenter and M. A. Clarke - J. Guerra D..... 3, 35, 73 cane juice liming. A. L. Webre..... 118 - micro-organisms and scale formation. R. W. Kuhlmann <i>et al.</i> - viscosity. G. Aleman. (Abs.)..... 150 effect of cane age, fertilization and variety. P. M. Fabregat and L. Gomez R. (Abs.)..... 86 - damage by frost. J. C. P. Chen and J. J. Chen. (Abs.)..... 53 - tops. G. K. Chetty. (Abs.)..... 309 - on raw sugar colour. N. L. C. Suzor. Enviro-Clear clarifier performance. L. Rosenberg <i>et al.</i>..... 263 filtrate. S. Narain. (Abs.)..... 309 with flocculation aid. (T.N.)..... 286 - Anon. (Abs.)..... 213 - M. C. Bennett. (Abs.)..... 315 - K. M. Bhardwaj <i>et al.</i> (Abs.)..... 340 - A. C. Chatterjee <i>et al.</i> (Abs.)..... 309 - J. C. P. Chen. (Abs.)..... 214 - J. A. Duenas. (Abs.)..... 314 - S. Morales and P. M. Flores..... 118 - V. Morris. (Abs.)..... 118 - J. P. Murray and G. S. Shephard. (Abs.)..... 182, 340 - E. Whayman and O. L. Crees..... 215 - effect of calcium chloride addition. J. McClean. (Abs.) - juice/flocculant ratio control. D. J. Hale and B. Partridge inclined surface effect. G. A. Brotherton. (Abs.)..... 373 with magnesium oxide. J. J. Zwart. demaker. (Abs.)..... 118 mud activated carbon manufacture. R. Cetina <i>et al.</i> (Abs.)..... 221 - filtration. Y. Gadjev. (Abs.)..... 150 - effect of polyelectrolytes. J. C. P. Chen and R. W. Pleou. (Abs.) - level automatic control. R. L. Muller. (Abs.)..... 372 - reduction. P. P. Chaturvedi. - pumps. D. R. Paddock and P. B. Quinan. (Abs.)..... 84 sweetening-off. (Brev.)..... 286 - treatment by centrifuge. Anon. - S. C. Grimley and R. A. Allaway. (Abs.)..... 86 - P. N. Stewart <i>et al.</i> (Abs.)..... 85, 373 - with flocculation aid. V. M. Jelic. (Abs.)..... 378 phosphate addition. P. L. Apte and B. R. Math. (Abs.)..... 213 refinery liquor. (T.N.)..... 286 - colour removal. D. F. Charles <i>see also Clarifiers and Juice, Cane</i> Clarifiers. (T.N.)..... 286 Eis Rapids. (Brev.)..... 263 - in Europe. L. Rosenberg <i>et al. see also Clarification</i> Colombia: bone char klin. (Brev.)..... 286 cane damage by flooding. (Brev.)..... 64 new sugar factories. (Brev.)..... 256 sugar exports 1975. (Brev.)..... 191</p> <p>Colour: beet juice, effect of air injection in liming. E. Reinefeld. (Abs.) - diffusion water electrolysis. A. Y. Romanyuk <i>et al.</i> - fine pulp removal. H. Schiwce. (Abs.)..... 278 - liming. V. A. Gornik and S. Z. Ivanov. (Abs.)..... 120 - pectin. S. P. Olyanskaya <i>et al.</i> - and sugar, effect of diffusion water treatment. P. T. Dunas. (Abs.)..... 279 - molasses, effect on citric acid manufacture. J. Kovats and Z. Nieslawski. (Abs.)..... 285 cane molasses exhaustibility evaluation. M. A. Mohamed <i>et al.</i> (Abs.) carbonation juice, effect of magnesium oxide. J. Studnický <i>et al.</i> colorants adsorption by calcium carbonate. S. Z. Ivanov. (Abs.) - K. Vukov. (Abs.)..... 26, 246, 316 - in beet molasses. V. Prey and H. Andres. (Abs.)..... 256 - and yeast spontaneous. V. N. Shvets <i>et al.</i> (Abs.)..... 342 - cane juice, raw and refined sugar. F. G. Carpenter and M. A. Clarke - formation in refining. F. G. Carpenter and E. J. Roberts. (Abs.) - molasses properties. V. N. Shvets <i>et al.</i> (Abs.)..... 317 - separation by gel chromatography. V. Prey and H. Andres. (Abs.)..... 318</p>	<p>Colour: determination, effect of turbidity removal. A. Y. Zagorul'ko and I. A. Korobeinikova. (Abs.)..... 316 - in sugar, effect of membrane filter porosity and pH. J. A. Weber formation in beet and cane juices, effect of enzymes. D. Gross and J. Coombs..... 69, 106 - juice. K. Vukov. (Abs.)..... 278 - effect of flocculation aid. V. Prey <i>et al.</i> (Abs.)..... 55, 90 - saccharate treatment. J. Degeest <i>et al.</i> (Abs.)..... 55 - thick juice and molasses. L. Wieninger and N. Kubadinov. - boiling. V. Prey and H. Wesner. - effect of circulation ratio. V. P. Troino <i>et al.</i> (Abs.)..... 153 - masticulate residence time and feed rate. I. S. Guliy <i>et al.</i> - reduction by air/steam injection. V. T. Garyazha <i>et al.</i> (Abs.)..... 185 - cane juice and raw sugar, effect of cane steam treatment. W. H. Smith..... 259 - carbonation. J. Buriánek <i>et al.</i>..... 248 - N. Kubadinov and W. Hampel - N. D. Tantsyura and N. Kaufman. (Abs.)..... 248 - effect of oxygen. H. Schiwce. - from degraded dextrose. S. Fujii <i>et al.</i> (Abs.)..... 123 - in evaporation. K. N. Paul. (Abs.) - effect of beet juice optimum alkalinity. M. K. Likhitskii and L. E. Kovats. (Abs.)..... 24 - reduction. B. I. Kats. (Abs.) - by Maillard reaction. E. Reinefeld <i>et al.</i> (Abs.)..... 28, 157, 379 - effect of ammonia. P. Devillers <i>et al.</i> (Abs.)..... 24 - and prevention. A. R. Saproinov <i>et al.</i> (Abs.)..... 60 - in stored beet thick juice. T. P. Khvalkovskii <i>et al.</i> (Abs.)..... 88 - raw sugar prevention. J. Bobrovnik <i>et al.</i> (Abs.)..... 245 - in thick juice, effect of sodium sulphite. L. I. Ryzantseva and I. V. Gadjev. (Abs.)..... 278 gur. B. Singh <i>et al.</i> (Abs.)..... 92 measurement. M. Muro M. and C. Silverio R. (Abs.)..... 125 - cane molasses. A. Carranza R. and I. Machado L. (Abs.)..... 125 - sugar and syrup. R. Lees. (N.B.) - white sugar. J. C. P. Chen. (Abs.) melanoidin adsorption by decolorizing resin, effect of pH. G. A. Chikin and V. F. Selmenev. (Abs.) molasses, effect on electrolysis. J. Houssiau and R. Pieck. (Abs.) raw sugar, effect of clarification and non-sugars recirculation. Y. L. C. Suzor. (Abs.)..... 309 reducing sugars colorants formation and properties. J. C. Williams..... 91 refinery liquor effect of pH. G. A. Bugaenko. (Abs.)..... 93 removal with active carbon. R. Cetina <i>et al.</i> (Abs.)..... 221 - G. A. Chikin and V. F. Selmenev. (Brev.)..... 57 - J. N. Foret and C. J. Bernard - A. Y. Kryndshaw. (Abs.)..... 317 - B. G. Krishnamurti. (Abs.) - adsorbent resin. D. Hervé. (Abs.)..... 315 - M. Y. Mazov <i>et al.</i> (Abs.)..... 215 - J. J. Ungar and R. Lumbroso - T. Yamane and H. Asai. (Abs.) - and multiple elution. J. Dobzycki..... 139 - regeneration. K. Číž and V. Čejková. (Abs.)..... 57 - waste water. F. Onda <i>et al.</i> (T.N.)..... 286 - with bone char, effect of pH. G. A. C. C. Chou. (Abs.)..... 314 - by carbonation. L. D. Bobrovnik and L. P. Kotelnikova. (Abs.) - J. Galbán. (Abs.)..... 314 - K. D. Zhura and S. P. Olyanskaya. (Abs.)..... 152 - refinery liquor. (T.N.)..... 286 - D. F. Charles. (Abs.)..... 283 syrup losses. S. A. Brennan <i>et al.</i> stored beet thick juice. T. P. Khvalkovskii <i>et al.</i> (Abs.)..... 120 and sugar desorption from adsorbent resin and bone char. S. Z. Ivanov <i>et al.</i> (Abs.)..... 219 white sugar, reduction by factory modifications. G. S. Jain. (Abs.) <i>see also Bone char; Carbon, Active and Refining</i> Commission Internationale Technique de Suererie 15th General Assembly Proceedings. Anon. (N.B.)..... 155 16th General Assembly..... 287 Computers, applications. D. B. Batstone. (Abs.)..... 119 - boiling. R. J. Bass and J. Donovan - J. Buriánek and M. Kmínek..... 311</p>

INDEX

	PAGE		PAGE
Computers: applications in boiling		Control, Automatic:	
A. Frew and P. G. Wright (Abs.)	372	milk-of-lime feed. M. P. Klepal'-	
I. S. Guliy <i>et al.</i> (Abs.)	376	chenko (Abs.)	311
- A. D. Randolph and E. T. White	372	- quantity and density. A. A.	
- V. I. Tuzhilkin and L. M. Bochk	280	Vil'shanski <i>et al.</i> (Abs.)	378
- V. F. Ushereck and V. Valter (Abs.)	343	power house. R. A. Alloway and	
- V. F. Zubchenko <i>et al.</i> (Abs.)	153	C. R. Graves (Abs.)	340
refining. Anon. (Abs.)	239	raw sugar pol. J. H. King (Abs.)	92
automatic control of factory pro-		rectifier melt house process. J. O.	
cesses and accounting. S. C. Grim-		Maylott and J. W. deCellis (Abs.)	315
ley and R. A. Alloway (Abs.)	86	- melter Brix and temperature.	
bagasse hydrolysis evaluation. H.		Anon. (Abs.)	235
Kollner and R. Lopez P. (Abs.)	222	- processes. Anon. (Abs.)	255
beet analysis. W. Kernchen (Abs.)	316	self-synchronizing motors. R. C.	
- diffusion loss calculation. P. W.		Sharma (Abs.)	245
van der Poel (Abs.)	56	syrup Brix and temperature. S.	
cané data processing. R. M. Hebert	347	Bouček and V. Valter (Abs.)	87
- D. Spooner (Abs.)	214	see also Computers and Instruments	
- R. F. Sutherland (Abs.)	54	Control, Chemical. P. O. Skinner (Abs.)	125
- milling simulation. F. Szklaruk		beet analysis. J. Hobbs and L.	
<i>et al.</i> (Abs.)	22	Batterman (Abs.)	92
- reception automatic control. G. D.		- brix clarification with aluminum	
Maclean and D. B. Batstone.	340	salt. M. Burba and W. Puszc	
- and sampling control. R. L.		346	
Muller (Abs.)	54	- freeczing, storage and prepara-	
- train running simulation. E. B.		tion. M. Burba <i>et al.</i> (Abs.)	60, 124
Shepherd (Abs.)	51	- sugar determination. I. A.	
centrifugal sugar crystal trajectory		Prikhod'ko (Abs.)	156
calculation. R. J. Swindells and		- juice purity determination. M.	
E. T. White (Abs.)	85	Friml and B. Tichá (Abs.)	124
factory data processing. A. Kubasiewicz		- and sugar yield prediction.	
and W. Lekawski (Abs.)	186	- P. Devillers <i>et al.</i> (Abs.)	60
- and accounting. U. Bauern-		- processing quality evaluation. M.	
feind (Abs.)	25	Burba (Abs.)	347
- process simulation. Anon.	213	- sampling and analysis. Anon.	215
- equipment design and construction.		- M. Pietrzak (Abs.)	124
Anon. (Abs.)	312	- A. E. Popov and S. K. Moz-	
- refinery and distillery process		entsev (Abs.)	124
algorithm construction. H. L.		- tarehouse laboratory. W. Kern-	
Fernandes (Abs.)	190	chen (Abs.)	316
molasses yield and sugar content		boiling house balance establishment.	
calculation. A. L. Antonovich and		Ushereck and V. Valter (Abs.)	343
V. S. Petrik (Abs.)	248	cane analysis disintegrator. J. P.	
polarimeter error evaluation. R. S.		Stupiel <i>et al.</i> (Abs.)	380
Watts (Abs.)	348	- juice sampling. L. Kelso and S.	
powerhouse automatic control. R. A.		Reichard (Abs.)	340
Alloway and C. R. Graves (Abs.)	340	- milling performance calculation.	
rainfall probabilities calculation. G.		Arceneaux (Abs.)	86
Kingston (Abs.)	334	- moisture and fibre determination.	
refinery melt house control. A. O.		A. L. Fors (Abs.)	92, 220
Maylott and J. W. deCellis (Abs.)	315	- molasses purity determination.	
Simulation of bagasse boiler. J. M.		J. P. Stupiel <i>et al.</i> (Abs.)	125
Steward and B. Cravford (Abs.)	85	- sampling. H. S. Birkett and J. J.	
- cane growth. T. A. Bull and D. A.		Seip (Abs.)	188
Tovey (Abs.)	142	- R. L. Murar (Abs.)	54
steam utilization optimization. A.		- J. J. Seip and F. L. Gayle (Abs.)	150
Kubasiewicz <i>et al.</i> (Abs.)	122	- J. C. Skinner	227
system for sugar brokers (Brev.)	194	- and analysis. H. S. Birkett and	
Control, Automatic. (T.N.)	286	J. J. Seip (Abs.)	220
G. Aleman <i>et al.</i> (Abs.)	151	- R. M. Hebert (Abs.)	347
C. Sobieszak (Abs.)	186	- computer application. D. B.	
G. Windal (Abs.)	279	Batstone (Abs.)	119
bag counting and level. K. A. Ne-		- sugar yield calculation. B. L.	
krasov (Abs.)	90	Legendre and M. T. Henderson	
boiling. Anon. (Abs.)	312	- varietal yield estimation. J. Payan	
- R. J. Bass and J. Donovan (Abs.)	375	<i>et al.</i> (Abs.)	23
- L. Rates <i>et al.</i> (Abs.)	54	ICUMSA 10th Session Proceedings.	59
- P. W. Collins (Abs.)	287	Anon. (N.B.)	59
- E. Gierada and A. Tobola (Abs.)	280	laboratory apparatus. M. Friml	
- H. Kemter (Abs.)	311	and J. Pucherna (Abs.)	27
- C. J. Lu (Abs.)	277	- molasses exhaustibility determina-	
- J. P. Merie (Abs.)	86	tion. M. Friml and S. Pochylá	151
- H. Thiele and A. Langen (Abs.)	246	- G. F. Fundora (Abs.)	151
- V. I. Tuzhilkin <i>et al.</i> (Abs.)	344	- G. R. E. Lionne and D.	
- Brix. P. J. Fernandez (Abs.)	214	Falconer (Abs.)	189
- conductivity electrode. S. R.		- M. A. Mohamed <i>et al.</i> (Abs.)	318
Reichard and T. L. Vidler (Abs.)	85	- T. Moritsugu <i>et al.</i> (Abs.)	318
- masticule rheological properties		- A. L. Webre (Abs.)	374
determination. D. Schliephake		- standard purity determination.	
and K. Austmeyer (Abs.)	55, 187	I. A. Prikhod'ko and K. V.	
- mathematical model. T. Diaz and		Ukrainets (Abs.)	220
P. Friedman (Abs.)	245	- yield and sugar content calculation.	220
- pan vapour line valves. E. Batule		A. L. Antonovich and V. S.	
and A. Rodriguez (Abs.)	308	Petrik (Abs.)	248
cané carrier speed. A. J. Hussey.	118	parameters calculation. M. Friml.	378
- reception. R. E. Bickle and H. E.		purity determination. J. Ponant and	
Childs (Abs.)	340	G. Windal (Abs.)	375
- G. D. Maclean and D. B. Bat-		- G. Windal (Abs.)	375
stone (Abs.)	340	raw sugar quality evaluation. F. H. C.	
- and sampling. R. L. Muller.		Kelly	199
carbonation. J. F. T. Oldfield <i>et al.</i>	87	refining. A. Rossi (Abs.)	314
Gandia (Abs.)	150	sugar and molasses balance calcula-	
- A. L. Ballard <i>et al.</i> (Abs.)	150	tion. A. Kubasiewicz and W.	
- masticule feed. G. M. Chudakov		Lekawski (Abs.)	186
<i>et al.</i> (Abs.)	376	- yield and pol. calculation. E.	
clarification juice:flocculant ratio.		Rodriguez <i>C. et al.</i> (Abs.)	118
D. J. Hale and B. Partridge (Abs.)	372	see also Ash; Brix; Colour; Filtrability;	
- mud level. R. L. Muller (Abs.)	372	Invert sugar; Losses; Polarization;	
condenser. V. N. Gorokh <i>et al.</i> (Abs.)	89	Reducing sugars; Sucrose; Sugar;	
disc filters. L. S. Taranenko <i>et al.</i>	313	Water and Weighing	
evaporation. C. D. Clarke and M.		Conveyors. N. A. Emel'yanov (Abs.)	375
Webber (Abs.)	84	bagasse. A. I. Guidry (Abs.)	151
- R. Wasmund (Abs.)	343	bagged sugar. V. I. Vasil'ev <i>et al.</i>	376
factory central control room. N. A.		beet elevator operation, effect of	
Nielsen and B. McEachran (Abs.)	54	extraneous matter. Böhm	184
filter mud suspension level. V. I.		- pulp, limestone and sugar. N. M.	
Osokin and A. I. Yamshanov	121	Kichigin <i>et al.</i> (Abs.)	375
filter-thickeners. K. Andersen (Abs.)	215	cane. (T.N.)	350
final actuators. Pietila (Abs.)	372	chains. L. de Jahn (Abs.)	214
Iran sugar factory. (Brev.)	63	- R. W. Eibly (Abs.)	86
		- C. G. Wildsmith (Abs.)	182
		- pin corrosion. J. H. Shuler <i>et al.</i>	119
		magnetic separators. (T.N.)	62
		stored beet bucket wheel. M. Barre	280

INDEX

PAGE		PAGE		PAGE
	Dextrose: adsorption by ion exchange resin. S. Fujii <i>et al.</i> (Abs.).....	123		
	alkaline decomposition products and organics separation. V. Frey and H. Andres. (Abs.).....	318		
	beet and molasses content. P. Devillers <i>et al.</i> (Abs.).....	249		
	citric acid manufacture. G. K. Saproov and R. A. Kolcheva. (Abs.).....	60		
	determination. J. Sagel. (Abs.).....	317		
	- J. P. Sullivan <i>et al.</i> (Abs.).....	317		
	- in beet juice. E. Reinefeld <i>et al.</i> effect on sugar determination by polarization. G. W. Maag and G. H. Sisler. (Abs.).....	390		
	gluconic acid manufacture. L. Vanossi. (Abs.).....	250		
	hydration number. L. P. Zhnyrya <i>et al.</i> (Abs.).....	318		
	melt composition, effect of heat. W. Mauch and S. Assely. (Abs.).....	249		
	ratio to ash as molasses exhaustibility criterion. A. L. Welbre. (Abs.).....	374		
	- levulose in cane, effect of burning. S. el-N. A. Hemaida <i>et al.</i> (Abs.) solubility, effect of sucrose. V. I. Buravleva <i>et al.</i> (Abs.).....	302		
	see also Invert sugar; Reducing sugars and Sugars			
	Diffusers, Beet: AI-PDS-20. A. S. Dorzhavets <i>et al.</i> (Abs.).....	87		
	corrosion prevention. V. F. Rafal'skii <i>et al.</i> (Abs.).....	310		
	cossette transport. D. Schliephake <i>et al.</i> (Abs.).....	25		
	DC-C. H. Dembicki <i>et al.</i> (Abs.).....	120		
	DDNS. A. P. Andersen. (Abs.).....	56		
	- dismantling and reassembling. A. S. Teshev <i>et al.</i> (Abs.).....	247		
	- laboratory models. O. G. Akyar and E. Ozer. (Abs.).....	344		
	KDA-15-58. A. P. Parkhod'ko <i>et al.</i> level measurement. M. E. Furer and V. R. Tsyguzova. (Abs.).....	216		
	RT 4. R. Pleck and W. Loop. (Abs.) see also Diffusion, Beet	215		
	Diffusers, Cane: BMA. Anon. (Abs.).....	309		
	H. J. Delavier. (Abs.).....	277		
	D. Smet, L. Rivas L. and G. I. Stoccol'". R. H. Good. (Abs.).....	23		
	see also Diffusion, Cane.			
	Diffusion, Beet. G. V. Genie. 25, 248, BMA diffuser performance. E. Reinefeld. (Abs.).....	120		
	calcium chloride addition and juice pH. F. Teschner and R. Krämer condensate application. A. I. Shapiro effect of cossette thickness. G. V. Genie. (Abs.).....	343		
	ethylene effect on juice and pulp. A. H. Freytag and J. C. Linden. 218 foam reduction. V. N. Borzalaya <i>et al.</i> heat and mass balances. Anon. 312 - parameters calculation. A. A. Knyazev and V. N. Gorokh. - transfer. A. Kubasiewicz and W. Lekawski. (Abs.).....	286		
	- A. Sokolowski and A. Lamprecht juice draft optimization and loss. J. Biok and P. W. van der Poel 26, 248, KDA-30-66 diffuser performance. A. P. Parkhod'ko. (Abs.).....	313		
	losses determination. A. K. Buryma (Abs.).....	87		
	- J. C. Giorgi and B. Richard. 247 - G. P. Tsyzelova. (Abs.).....	313		
	- effect of weather on invertase. I. Januszewicz <i>et al.</i> (Abs.).....	306		
	magnesium carbonate and phosphoric acid addition. J. Buriánek <i>et al.</i> microbiological control. J. Herfík and V. Dachovský. (Abs.).....	90		
	- F. X. Kammerer. (Abs.).....	377		
	- N. V. Kulnich <i>et al.</i> (Abs.).....	216		
	- B. P. Kur'menok. (Abs.).....	24		
	- M. Vellinga. (Abs.).....	378		
	micro-organisms determination. K. A. Osweiler and G. H. Sisler. (Abs.).....	89		
	- P. W. van der Poel. (Abs.).....	247		
	stroll-type diffuser operation. G. I. Stoccol'". (Abs.).....	513		
	simulation. N. Marinetti <i>et al.</i> 25, 310 variables calculation. V. M. Lysyan'skii <i>et al.</i> (Abs.).....	89		
	water balance calculation. F. Kammerer and Z. Pochylý. (Abs.).....	24		
	- and juice properties. K. Magyar 217 - pH effects. K. Ciz <i>et al.</i> (Abs.).....	90		
	- treatment with aluminum sulphate. (T.N.).....	62		
	- P. T. Dunaev <i>et al.</i> (Abs.).....	279		
	- B. I. Pogorzelski <i>et al.</i>	281		
	- electrolysis. A. Y. Romanyuk <i>et al.</i> (Abs.).....	279		
	- electromagnets. S. I. Tkachenko <i>et al.</i> (Abs.).....	217		
	- and formalin activity. F. 5, 152 - formalin activity. (Abs.).....	246		
	- juice purity. S. Zagrodzki 26, 216, 246 - pulp quantity. H. Zaorska. 26, 218			
	Diffusion, Beet: water treatment and sulphur dioxide. K. Wagnerowski <i>et al.</i> (Abs.).....	90		
	see also Beet; Control Automatie; Diffusers, Beet; Factory and Losses			
	Diffusion, Cane. M. Beauvisage. (Abs.) 183 E. Cardet. (Abs.).....	277		
	J. C. P. Chen. (Abs.).....	53		
	G. V. Genie. (Contr.).....	289		
	S. Gurumurthy and M. S. Sivaswamy BMA diffuser performances. H. J. Delavier. (Abs.).....	277		
	compared with milling. R. Schaer effect of prior milling. J. H. Payne materials balance. J. Palaci. (Abs.) sucrose degradation and lactic acid formation. L. McMaster and A. B. Ravno. (Abs.).....	182, 214		
	see also Diffusers, Cane			
	Diseases, Beet. Anon. (Abs.).....	388		
	- in Belgium. L. van Steyvoort. (Abs.) black leg. Anon. (Abs.).....	275		
	- effect of herbicides. H. Bötger and C. Winner. (Abs.).....	305		
	- root effect on yield, photographic estimation. C. L. Schneider and G. R. Sefir. (Abs.).....	181		
	control. (T.N.).....	62		
	- effect on beet storage and processing quality. M. Martens. (Abs.) 83 - operator protection against chemicals. W. Hartley. (Abs.).....	18		
	- spray equipment. W. Garburg. 307 curly top vector release. D. L. Mumford. (Abs.).....	115		
	effect of rotavirus monoculture. N. A. Al'dekov and N. F. Kostin fungal disease control. C. L. Schneider fungicides. N. B. Davis. (Abs.).....	304		
	- in India. C. Singh <i>et al.</i> (Abs.).....	52		
	leaf spot control. L. Lukács and J. Zana. (Abs.).....	211		
	- J. H. Riesselman and J. L. Weighing. (Abs.).....	20		
	- resistance to fungicides. J. d'Ambrá <i>et al.</i> (Abs.).....	181		
	nutrient deficiencies. R. Vanstallen 82, 337 <i>Phoma betae</i> in stored beet extraneous matter. W. M. Bughee. (Abs.) powdery mildew. E. Ruppel <i>et al.</i> - control. F. J. Hills <i>et al.</i> (Abs.) - J. E. Hull. (Abs.).....	305		
	- A. O. Paulus <i>et al.</i> (Abs.).....	148		
	116 - O. Skovsen <i>et al.</i> (Abs.).....	116		
	resistance. R. C. Zielke. (Abs.).....	18		
	root rot control. C. L. Schneider and H. S. Potter. (Abs.).....	116		
	stalk height in US. J. D. MacDonald <i>et al.</i> (Abs.).....	337		
	stored beet root control. A. M. Elagin <i>et al.</i> (Abs.).....	311		
	in US. C. L. Schneider and L. S. Robertson. (Abs.).....	90		
	virus yellows. G. Becker. (Abs.).....	18		
	- W. B. Schaufele. (Abs.).....	307		
	- in Belgium. Anon. (Abs.).....	149		
	- L. van Steyvoort. (Abs.).....	337		
	control. Anon. (Abs.).....	337		
	- N. B. Davis. (Abs.).....	242		
	- R. A. Dunning and G. H. Winder. (Abs.).....	304		
	- E. Seutin and L. van Steyvoort. (Abs.).....	306		
	- spread by beet tops as animal fodder. G. H. Francis. (Abs.) - tolerance determination. V. Rimsa <i>et al.</i> (Abs.).....	52		
	"whites". Anon. (Abs.).....	149		
	yellow wilt. (Brev.).....	364		
	- C. Urbina-Vidal and H. Hirumi yellowing causes. E. Dalleinne. (Abs.) 244			
	Diseases, Cane: bacterial sun spot. N. Zummo and K. C. Freeman. (Abs.) basal stem and root rot. H. L. Boyle in Brazil. G. M. Azziz (N.B.).....	282		
	chlorosis, effect of soil factors. U. S. Singh and P. D. Bajpai. (Abs.).....	48		
	chlorotic streak spread. A. Matthews control. (T.N.).....	62		
	- K. Blasberg. (Abs.).....	48		
	- in India. T. Somu <i>et al.</i> (Abs.).....	301		
	- research in Australia. Anon. (Abs.) copper deficiency. Anon. (Abs.).....	332		
	eye spot. C. McAleese. (Abs.).....	270		
	- resistance testing. J. L. Dean and J. D. Miller. (Abs.).....	179		
	- susceptibility. G. A. Strobel. 79 - effect of toxin-binding protein. G. A. Strobel and K. D. Hapner. (Abs.).....	77		
	- G. A. Strobel and W. M. Hess 145 - varietal resistance. J. D. Miller Fiji disease. B. T. Egan. (Abs.).....	334		
	- O. W. Sturgess. (Abs.).....	387		
	- control. B. T. Egan. (Abs.).....	78		
	- vector hosts. R. Outridge and D. S. Teakle. (Abs.).....	370		
	fungal rot. Anon. (Abs.).....	48		
	fungi and cane varietal yield decline. S. M. Yang. (Abs.).....	145		
	fungicides and cane yield. J. P. Singh <i>et al.</i> (Abs.).....	273		
	- cane sett germination. (Abs.).....	240		
	- and cane yield. B. K. Mathur <i>et al.</i> (Abs.).....	17		
	Diseases, Cane: grassy shoot control. K. Kar. (Abs.) - virus alternative host. A. Jha <i>et al.</i> (Abs.).....	206		
	239 - physical properties. Jha <i>et al.</i> (Abs.).....	114		
	in India. S. M. P. Khurana and S. Singh. (Abs.).....	143		
	leaf freckle, effect of sucrose. L. G. Vallance. (Abs.).....	111		
	- scald. G. J. Persley. (Abs.).....	47, 144		
	- G. J. Persley and C. C. Ryan. 385 maize dwarf mosaic susceptibility. A. G. Gillaspie and H. Koike. (Abs.) mosaic. H. Koike and A. G. Gillaspie - alternative host. R. D. Joshi and U. P. Gupta. (Abs.).....	370		
	- C. A. K. Singh and K. S. Bhargava. (Abs.).....	143		
	- S. Singh. (Abs.).....	369		
	- effect of planting rate. R. J. Steib and S. J. P. Chilton. (Abs.).....	145		
	- and maize dwarf-mosaic mixtures. H. Koike. (Abs.).....	145		
	- ratoon stunting control. G. T. A. Benda. (Abs.).....	114		
	- resistance induction by irradiation. R. D. Breaux <i>et al.</i> (Abs.).....	178		
	- testing. R. D. Breaux and P. H. Dunkelman. (Abs.).....	145		
	- shoot recovery. G. T. A. Benda - transmission. H. Koike and L. J. Charpentier. (Abs.).....	113		
	- in US. H. Koike. (Abs.).....	370		
	- varietal resistance testing. S. Matsuzaka and A. K. Dodson. - susceptibility. R. D. Breaux <i>et al.</i> orange freckle. W. A. Webb and N. Clarke. (Abs.).....	78		
	pineapple disease. M. A. Hetherington. (Abs.).....	147		
	- S. K. Manooch. (Abs.).....	143		
	- control. Anon. (Abs.).....	273, 365		
	- C. Ricaud <i>et al.</i> (Abs.).....	79		
	- V. V. Suldamath <i>et al.</i> (Abs.) plant source compulsory inspection. B. F. Egan. (Abs.).....	209		
	ratoon stunting and cane bacteria. C. T. Chen <i>et al.</i> (Abs.).....	143		
	- shoot growth. G. T. A. Benda - control. Anon. (Abs.).....	208		
	210 - L. L. Louden. (Abs.).....	16, 366		
	- J. A. G. C. Sousa. (Abs.).....	238		
	- hot water additive and tiller number. G. T. A. Benda. (Abs.).....	144		
	- diagnosis. C. Ricaud. (Abs.).....	273		
	- D. R. L. Steindl. (Abs.).....	332, 334		
	- D. S. Teakle <i>et al.</i> (Abs.).....	50		
	- indicator plant. G. D. Thompson - an mosaic control. G. T. A. Benda. (Abs.).....	178		
	- pathogen. K. E. Damann and K. S. Derriek. (Abs.).....	370		
	- A. G. Gillaspie and J. F. Worley. (Abs.).....	178		
	- A. G. Gillaspie <i>et al.</i> (Abs.) 176, 370 - resistance. D. S. Teakle <i>et al.</i> - screening. (Brev.).....	144		
	red rot. R. N. S. Tyagi and K. N. Goyal. (Abs.).....	272		
	- black rot and pineapple disease control. S. M. Yang and F. Seaberg. (Abs.).....	178		
	- isolate pathogenicity. D. B. Fontenot <i>et al.</i> (Abs.).....	113		
	- pathogen, effect of freezing. R. J. Steib. (Abs.).....	143		
	- and smut pathogens, effect of mosaic. L. N. Dusey and R. D. Joshi. (Abs.).....	370		
	- varietal resistance. L. N. Pandey <i>et al.</i> (Abs.).....	208		
	research in Australia. Anon. (N.B.) - controlled-environment chambers. C. C. Ryan. (Abs.).....	382		
	- Mauritius. Anon. (Abs.).....	206		
	- South Africa. Anon. (N.B.).....	369		
	- Taiwan. Y. S. Pan. (Abs.).....	57		
	- in Réunion. Anon. (Abs.).....	76, 254, 365		
	root fungi. C. C. Chao and M. M. H. Wu. (Abs.).....	386		
	- M. M. Wu <i>et al.</i> (Abs.).....	336		
	- protection. J. P. Fisher. (Abs.) sett heat treatment. M. L. Agarwal and S. C. Gupta. (Abs.).....	239		
	smut. Anon. (Abs.).....	303		
	- K. N. Goyal and R. N. S. Tyagi - I. A. Nasir. (Abs.).....	273		
	- G. Thompson. (Abs.).....	79		
	- control. G. Thompson. (Abs.).....	142		
	- in Guyana. G. Arceneaux. (Abs.) - and Martinique. G. L. James - varietal resistance. S. Muthusamy and S. Sihanantham. (Abs.).....	142		
	- K. J. Sandu. (Abs.).....	175		
	- S. S. Sandhu <i>et al.</i> (Abs.).....	273		
	- and crop profitability. N. W. Simmonds - testing. S. L. Ladd <i>et al.</i> (Abs.) - susceptibility. S. Muthusamy <i>et al.</i> soil fungi and cane growth. S. M. Yang. (Abs.).....	329		
		143		
		207		
		113		

INDEX

PAGE	PAGE	PAGE			
Diseases, Cane: stem and root fungus, K. C. Alexander. (Abs.).....	370	Electrodialysis: organic acids determination. G. P. Voloshanenko and A. M. Shevchenko. (Abs.).....	156	Factory: air compressors. D. C. Hard-ake. (Abs.).....	341
streak. I. A. Nasr. (Abs.).....	143	sugar recovery in boiling. R. J. Batterham. (Abs.)....	85	best processing. L. Rosberg. (Abs.)	290
transmission prevention by equipment cleaning. J. F. Usher. (Abs.)	77	Electrophoresis, Paper: colorant isolation from sugar solution. F. G. Carpenter and E. J. Roberts. (Abs.)	251	cane crushing capacities. A. C. Chatterjee. (Abs.).....	22
- by private cane. C. Chardon. (Abs.)	271	Entrainment: effect on condenser performance. R. V. Koren' <i>et al.</i>	344	concrete and equipment protection. E. Kolmerz. (Abs.).....	312
- volunteer cane. E. A. Pembroke varietal resistance testing. R. Cesnik white leaf. G. T. Chen and M. J. Chen	210	- damage in Thailand. (Brev.).....	328	- protection. F. M. Depke. (Abs.)	310
- yellow spot varietal resistance. B. T. Roach. (Abs.).....	50	Europe: beet area 1976.....	129, 160, 194	construction service. (T.N.).....	350
- wilt. A. G. Hayes. (Abs.).....	143	- sugar production 1976/77. (N.C.)	321	continuous operation. B. G. Ross.....	86
yellowing disease control. G. N. Goyal and R. N. S. Tyagi. (Abs.)	365	EEC, ACP raw sugar price talks. (N.C.) 88, 161, 256	258	data processing. T. Bauerfeind.....	25
Distillery: algorithm construction for computer programmes. H. L. Fernandes. (Abs.).....	190	- beet price recommendations. (N.C.)	33	- A. Kubasiewicz and W. Leikawski. (Abs.).....	186
column scale comparison. L. G. de Souza <i>et al.</i> (Abs.).....	349	- and white sugar prices 1976/77	130	designing. L. I. Nemirovskii. (Abs.)	88
- reduction. J. Navarro and J. Pihol. (Abs.).....	285	- high-fructose corn syrup production. (N.C.).....	257, 321	- V. E. Popov. (Abs.).....	88
- E. Vilamil and J. A. Casey in France. Anon. (Abs.).....	285	- raw sugar import quota restrictions	384	energy consumption. M. Ryckkun.....	57
- fusel oil composition. A. C. Chatterjee and B. M. Dutt. (Abs.).....	221	- refiners fines annulled. (Brev.)....	63	- in Greece. P. Hristodoulou. (Abs.)	377
in Guyana. (Brev.).....	332	- margin. (Brev.).....	63	equipment in Bulgaria. D. Babew	313
Paraguay. (Brev.).....	352	- sugar consumption. (N.C.).....	354	- component strain hardening. B. M. Zinko. (Abs.).....	184
Thailand. Anon. (Abs.).....	381	- industries. K. Dankowski <i>et al.</i>	59	- installation and relocation programme. W. A. Greenwood.....	54
vat corrosion. N. I. Krasnopol'skii and G. A. Preis. (Abs.).....	285	- statistics. (Brev.).....	30	- layout. G. F. Fundora. (Abs.).....	277
waste chemical composition. V. G. Koval' <i>et al.</i> (Abs.).....	379	Evaporators. V. N. Gorokh <i>et al.</i>	103	- metallization. F. Diaz D. (Abs.)	53
- as fertilizer. N. A. da Gloria. (Abs.)	253	automatic control. C. D. Clarke and M. Webber. (Abs.).....	281	- modernization. S.anches A.....	53
- J. C. Remy <i>et al.</i> (Abs.).....	222	- N. A. Nielsen and B. McEachran	84	- noise and vibration. T. Bogumil <i>et al.</i> (Abs.).....	312
- pH and irrigation equipment corrosion. Anon. (Abs.).....	222	- R. Wassund. (Abs.).....	343	expansion. M. Barré and H. Duret	215
- soil phosphate solubilization. N. A. da Gloria and M. E. Mattiazzo	301	- condensate alcohol removal. J. D. Blake <i>et al.</i>	291		
- treatment. A. K. Basu and B. Ledere. (Abs.).....	381	- composition. J. D. Blake.....	131		
- S. C. Gupta and K. A. Prabhu	381	- removal. V. I. Dovgopol' <i>et al.</i>	342		
- W. H. Kampen. (Abs.).....	190	condensers. V. N. Gorokh <i>et al.</i>	89		
- P. Kujala <i>et al.</i> (Abs.).....	381	- E. A. Kutsenko. (Abs.).....	121		
- C. E. Monteiro. (Abs.).....	308	- K. N. Savchuk. (Abs.).....	311		
- vitamin B ₁₂ manufacture. I. L. Luchev <i>et al.</i> (Abs.).....	190	- N. Y. Tobilevich <i>et al.</i> (Abs.).....	311		
- yeast manufacture. Anon. (Abs.)	252	effect arrangement optimization. E. del Valle. (Abs.).....	151		
- J. T. Aguinaldo. (Abs.).....	252	experimental. J. Dornier. (Abs.)....	151		
Zambia order. (Brev.).....	360	heat and mass balances. Anon.....	312		
see also Alcohol and Fermentation		- pump application. A. Fényés.....	246		
Dominican Republic: cane varieties. Anon. (Abs.).....	239	- surfaces. A. A. Knyazev and V. N. Gorokh. (Abs.).....	311		
raw sugar price and sales policy. sugar production 1975. (Brev.).....	193	horizontal thin-film. A. Kubasiewicz and W. Lekawski. (Abs.).....	121		
- statistics. (Stat.).....	287	indensable gas removal. S. Srivastava. (Abs.).....	86		
Drives; belt-slicers. H. Koethke. (Abs.)	378	juice colour formation reduction. B. I. Kats. (Abs.).....	24		
cane mill hydraulic motors. T. R. Bay. (Abs.).....	214	- and lime salts content. M. K. Likhitski and L. E. Reva.....	152		
chains. L. de Jahn. (Abs.).....	214	- deficiency and water supply. F. Nowak. (Abs.).....	90		
fluid couplings. G. E. St. John. (Abs.)	117	- thermal stability, effect of sodium sulphite. L. I. Ryazanseva and A. Y. Gadelov. (Abs.).....	278		
hydrostatic. J. R. Marshall. (Abs.)	81	losses. I. M. Fedotkin <i>et al.</i> (Abs.)	152		
Dryers. (T.N.).....	62	- K. N. Paul. (Abs.).....	308		
- E. W. Kerr. (Abs.).....	86	- determination. Anon. (Abs.).....	213		
- R. Velazquez R. (Abs.).....	53	- evaluation. A. Kubasiewicz and W. Lekawski. (Abs.).....	186		
beet pulp. R. Cronica <i>et al.</i> 130, 158	349	steam requirements and heat transfer calculations. P. G. Wright. (Abs.)	84		
B. Hutchinson <i>et al.</i> (Abs.).....	382	syrup starch elimination. (T.N.)....	286		
- M. Rychkun. (Abs.).....	57	- best processing. L. Rosberg and M. Mathe triple-effect performance. K. Mosich vacuum, effect of condenser incondensable gases. V. N. Gorokh and K. O. Shtangerev. (Abs.).....	342		
- dust emission. H. Smidt. (Abs.)	184	vapour condensation. R. V. Koren' <i>et al.</i> (Abs.).....	344		
- explosion hazard. G. T. Dirckx	310	see also Control, Automatic; Corrosion; Entrainment and Scale			
- oil consumption. P. Hristodoulou. (Abs.).....	377	Explosions: bagasse furnace. T. Ikehara prevention. G. T. Dirckx. (Abs.)....	117		
- trace elements. D. Hibbert <i>et al.</i> cube sugar. F. X. Kammerer. (Abs.)	343	- G. Schneider. (Abs.).....	310		
fluidized bed, white sugar. A. F. Zaborzin <i>et al.</i> (Abs.).....	88		246		
- and refined sugar. L. Neuzil and E. Kostelkova. (Abs.)	218				
Dust; burning in beet pulp dryer. R. Henze. (Abs.).....	349				
emission control. H. Smidt. (Abs.)	184				
explosion prevention. G. Schneider formation in beet pulp drying. T. Cronewitz <i>et al.</i> (Abs.).....	246				
- B. Hutchinson <i>et al.</i> (Abs.).....	349				
- stored sugar. Z. J. Kimmerling.....	182				
measurement. (T.N.).....	62				
separation. A. K. Strautnieks and Y. Y. Lazhev. (Abs.).....	216				
- A. F. Zaborzin <i>et al.</i> (Abs.).....	88				
see also Air; Boilers and Furnaces, Bagasse					
Ecuador sugar expansion. (Brev.).....	351				
Egypt: cane equipment order. (Brev.)	286				
- flowering. K. S. Dobbs. (Abs.).....	272				
sugar physico-chemical properties. M. A. Mohamed <i>et al.</i>	355				
- production 1975. (Brev.).....	64				
- statistics. (Brev.).....	59				
Electrodialysis: beet thick juice treatment. P. P. Zagorodnyi <i>et al.</i> (Abs.)	89				
itaconic acid manufacture from molasses. M. Nakagawa <i>et al.</i> (Abs.)	252				
mathematical model. L. A. Fedorenchenko <i>et al.</i> (Abs.).....	247				
molasses treatment. J. Houssiau and E. Pisco. (Abs.).....	313				
- P. Pierrard. (Abs.).....	378				
- efficiency determination. L. D. Bobrovnik <i>et al.</i> (Abs.).....	313				

INDEX

PAGE		PAGE		PAGE
	Fertilizers: filter cake effect on soil nutrients and cane yield. H. H. Hagihara. (Abs.).....	80		
	-- and farmyard manure. A. Vigoureux and T. Vreven. (Abs.)	337		
	Flt. ash. A. C. Chatterjee and B. M. Dutt. (Abs.).....	382		
	-- and filter cake. N. R. Maclean	335		
	foliar application to beet. Anon.	336		
	-- and soil application. S. C. Yang.	337		
	green manure application and beet pests. W. Renius. (Abs.).....	215		
	-- cultivation. R. Vanstallen.	111		
	-- and soil fungi. C. C. Chao and M. M. H. Wu. (Abs.).....	336		
	gypsum and green manure application on cane. H. S. Ibrahim.	165		
	liquid and farmyard manure effects. L. Truyen et al. (Abs.).....	306		
	magnesium. Anon. (Abs.).....	19		
	micronutrients and cane yield and quality. S. A. Ahmed et al. (Abs.)	270		
	-- deficiency in cane. J. E. Bowen.	212		
	effect on cane yield and quality. B. S. Mathur. (Abs.).....	207		
	nitrogen. Anon. (Abs.).....	18		
	-- M. A. C. dos Santos. (Abs.).....	301		
	-- I. J. Stewart. (Abs.).....	78		
	ammonium sulphate vs. calcium ammonium nitrate. Anon.	206		
	application rate. Anon. (Abs.).....	307		
	-- D. R. Brisbane. (Abs.).....	149		
	-- I. Gutman. (Abs.).....	276		
	aqueous ammonia pump. Anon.	177		
	-- trials. G. Gallarate. (Abs.).....	115		
	and beet ash content. V. Stehlik and L. Schmidt. (Abs.).....	242		
	brei nitrate. D. G. Westfall and M. Barnes. (Abs.).....	19		
	composition. R. C. Zielke and F. W. Snyder. (Abs.).....	125		
	crop yield and quality. R. C. Zielke. (Abs.).....	20		
	-- growth and quality. M. G. Frakes. (Abs.).....	371		
	petrole nitrate content. D. D. Analogos. (Abs.).....	139		
	quality. W. C. McGuffee. (Abs.)	39		
	-- and sugar content. L. W. Wilkely. (Abs.).....	211		
	requirement determination. C. Winner. (Abs.).....	378		
	-- and yield determination. J. N. Carter et al. (Abs.).....	181		
	storage properties. J. Hobbs and I. Beltrami. (Abs.).....	92		
	sugar and N contents. W. A. Dickinson. (Abs.).....	180		
	-- A. von Müller and C. Winner. (Abs.).....	378		
	-- D. R. Christensen. (Abs.).....	331		
	calcium trials in Réunion. C. H. de Fraisse. (Abs.).....	17		
	cane ripening. L. G. Vallance.	21		
	-- sugar content and juice quality. L. S. Singh. (Abs.).....	111		
	-- varietal response. J. A. Mariotti and O. Giménez L. (Abs.).....	302		
	yield. J. A. Mariotti et al. (Abs.)	306		
	-- J. S. Singh. (Abs.).....	114		
	-- and quality. U. S. Singh.	116		
	economics. M. K. Nicholson et al.	301		
	green manure effects on cane. N. Kumarperumal et al. (Abs.).....	337		
	irrigation effects on beet. J. N. Carter et al. (Abs.).....	337		
	-- cane yield. B. K. Mathur and K. B. Tripathi. (Abs.)	272		
	-- G. Singh et al. (Abs.).....	272		
	late application and beet leaf yield. L. Schmidt. (Abs.).....	274		
	nematode development. E. D. Whitney and D. J. Doney.	20		
	phosphorus application in irrigation water. D. W. James. (Abs.)	18		
	plant population effects on beet yield and sugar content. J. N. Carter et al. (Abs.).....	242		
	slow-release urea. R. S. Uchida et al. (Abs.).....	81		
	surface nitrate accumulation. S. R. Winter. (Abs.).....	337		
	trace elements. H. J. Müller.	274		
	trials in Australia. I. T. Freshwater. (Abs.).....	47		
	-- India. D. S. Deol and R. S. Kanwar. (Abs.).....	304		
	-- Réunion. R. Dadant and C. H. de Fraisse. (Abs.).....	17		
	-- G. Loynet and C. de H. Fraisse	17		
	urea application. O. P. Engelstad and R. D. Hogue. (Abs.).....	241		
	-- trials in Argentina. R. Fernández de U. and J. Faade E.	77		
	white fly control. A. N. Kalra and M. C. Gupta. (Abs.).....	300		
	utilization by cane, effect of nitrification inhibitor. Anon. (Abs.)	240		
	weed competition. E. A. Cerzuelza et al. (Abs.).....	79		
	zinc effects on beet yield and quality. H. D. Fuehring and R. E. Finkner. (Abs.).....	21		
	Fertilizers: I. J. Stewart. (Abs.).....	209		
	application rate. A. P. Draycott and M. J. Durrant. (Abs.).....	339		
	beet requirement determination. S. Barker. (Abs.).....	21		
	cane yield. L. E. Goheen.	112		
	fixation. B. P. Sahi et al. (Abs.)	272		
	potassium. A. W. Ford. (Abs.).....	78		
	-- application. N. Roussel. (Abs.)	149		
	potassium. I. J. Stewart. (Abs.).....	300		
	-- G. T. Zeng. (Abs.).....	21		
	beet yield and quality. Y. Bilgin	21		
	calcium and chloride contents in cane. R. P. DeStefano. (Abs.)	178		
	cane leaf composition. S. Sithanatham et al. (Abs.).....	368		
	-- orange freckle. W. A. Webb and N. Clarke. (Abs.).....	78		
	recovery from cane juice. S. Mukherjee and S. K. Srivastava	119		
	trials in Mauritius. Anon. (Abs.)	206		
	programme for beet. Anon. (Abs.)	181		
	recommendations for Brazil. J. O. Filho. (Abs.).....	270		
	-- U.S. Anon. (Abs.).....	16, 302		
	-- West Germany. Anon. (Abs.).....	307		
	requirements and cane response. A. V. Ruedi. (Abs.).....	78		
	research in Brazil. G. M. Azzi et al.	282		
	India. T. R. Srinivasan and Y. B. Morahan. (Abs.).....	301		
	-- South Africa. Anon. (N.B.).....	69		
	and trials in Cuba. J. A. Alomá and I. Cuellar. (Abs.).....	208		
	retention in soil, effect of contouring. J. D. Veerman. (Abs.).....	77		
	sodium. D. Merke. (Abs.).....	275		
	trials in Brazil. M. L. Marinho et al.	270		
	India. S. N. L. Srivastava et al.	305		
	utilization by cane, effect of reduced tillage. N. Rozeff. (Abs.).....	80		
	-- soil erosion. J. D. Veerman	253		
	vinasse. N. A. da Glória. (Abs.).....	253		
	carbonatation mud. J. C. Remy et al. (Abs.).....	222		
	soil phosphate solubilization. N. A. da Glória and E. M. E. Azzolin.	301		
	waste water nutrients. V. T. Dodolina. (Abs.).....	378		
	zinc sulphate. T. C. Juang et al.	335		
	see also Beet; Cane; Lime and Soil			
	Fiji sugar statistics. (Stat.).....	286		
	Filter aid. (T.N.).....	286		
	bagacillo and clarification mud filtration. J. J. Seip and F. L. Humbert. (Abs.).....	150, 253		
	-- and cane nutrients and yield. J. E. Golden. (Abs.).....	114		
	-- orange freckle. W. A. Webb and N. Clarke. (Abs.).....	78		
	-- costs. L. V. Gentil. (N.B.).....	58		
	nutrient uptake and cane yield. H. H. Hagihara. (Abs.).....	80		
	-- salinity. W. T. Su. (Abs.).....	112		
	compressibility. F. Heitz. (Abs.).....	247		
	fertilizer. N. Maclean. (Abs.).....	335		
	-- A. Vigoureux and T. Vreven. (Abs.)	337		
	specific resistance and porosity determination. P. M. Fabregat P. and V. Kharokov. (Abs.).....	23		
	sweetening-off. V. Burov et al.	38		
	-- N. G. Lila et al. (Abs.).....	251		
	control. C. R. Brown and P. Pommeze. (Abs.).....	283		
	utilization. (T.N.).....	350		
	-- G. Vernois. (Abs.).....	381		
	water removal in centrifugal. A. B. Ravnó and G. R. E. Lionnet. (Abs.)	151		
	wax recovery. A. C. Chatterjee and B. M. Dutt. (Abs.).....	382		
	Filters. (T.N.).....	62		
	belt. N. G. Lila and B. I. Eibozhenko	88		
	-- V. Noskova. (Abs.).....	88		
	compared with centrifuges for clarification mud treatment. E. J. Stewart et al. (Abs.).....	85		
	disc, leakage prevention. N. A. Kavun. (Abs.).....	344		
	filter-thickeners. K. Andersen. (Abs.)	215		
	membrane porosity and sugar colour determination. J. A. Weber. (Abs.)	250		
	mud suspension level automatic control. V. I. Osokin and A. I. Yamshanov. (Abs.).....	121		
	scale removal. R. S. Patterson. (Abs.)	123		
	vacuum. P. S. Maksimuk et al. (Abs.)	185		
	see also Filtration; Filtrate			
	Filtrability. F. Heitz. (Abs.).....	247		
	raw sugar, effect of amylopectin. E. Whayman and A. L. Willersdorf.	99		
	-- impurities. M. Shaqf and R. Samaniego. (Abs.).....	27		
	-- phosphate and alcohol insolubles. C. C. Chou. (Abs.).....	314		
	-- silica. M. A. Clarke. (Abs.).....	283		
	refinery liquor, effect of carbonatation. J. P. Murray and F. M. Runggas. (Abs.).....	219		
	Filtration. F. Heitz. (Abs.).....	247		
	automatic control. L. S. Taranenko et al. (Abs.).....	313		
	beet juice, effect of beet dirt tare. E. Reinefeld. (Abs.).....	120		
	-- diffusion water pH. K. Magyar. (Abs.).....	90		
	-- magnesium oxide. V. M. Studnický et al. (Abs.).....	55		
	-- silicon reduction. P. Devillers et al. (Abs.).....	377		
	-- ultrafiltration. T. Balok et al.	122		
	carbonatation juice improvement. A. S. Okolot and M. S. Kozlo.	88		
	-- mud, effect of dextran. J. F. T. Oldfield et al. (Abs.).....	26		
	clarification mud. V. M. Studnický	378		
	-- J. J. Seip and F. L. Gayle. (Abs.)	150		
	-- effect of flocculants. J. P. Murray and G. S. Shephard.	182, 340		
	-- polyelectrolytes. J. C. P. Chen and R. W. Picou.	119		
	filter-thickener performance. Y. V. Anikeev. (Abs.).....	217		
	floc formation prevention. E. J. Roberts et al. (Abs.).....	326		
	press performance. D. P. Goel and V. M. Bhalwar. (Abs.).....	213		
	rotary filter performance. Anon.	213		
	ultrafiltration and sugar recovery improvement in boiling. R. J. Batterham. (Abs.).....	85		
	Finland: beet agriculture. W. C. von Kessel. (Abs.).....	149		
	imports and exports. (Stat.).....	192		
	production 1975/76. (Brev.).....	192		
	Flow: beet thick juice, pipeline loss calculation. E. Manžek and S. Liler. (Abs.).....	279		
	flow: beet thick juice, pipeline loss calculation. E. Manžek and S. Liler. (Abs.).....	279		
	cane juice automatic control. N. A. Nielsen and B. McEachran. (Abs.)	54		
	-- measurement. A. L. Webre.	118		
	-- molasses rheological properties and pumping data calculation. D. V. Boger and C. Tin. (Abs.).....	245		
	carbonatation mud rheological properties. Z. Kmbolowski et al. (Abs.)	28		
	effect on heat transfer. T. Balok et al.	280		
	-- I. M. Fedotkin and I. V. Kosminskii. (Abs.).....	281		
	masseculite friction losses. Y. G. Artyukhov and V. T. Garyazha.	184		
	-- measurement in boiling. V. T. Garyazha	313		
	Didushko and V. T. Garyazha	348		
	-- rheological properties. K. Číž.	348		
	-- determination. D. Schleppehake and K. A. Meyner.	154		
	air flow rate. V. G. Artyukhov and V. T. Garyazha. (Abs.).....	54		
	sugar solution measurement. V. P. Kiochok et al. (Abs.).....	93		
	waste water quality measurement. A. P. Parkhomets et al. (Abs.).....	280		
	Foam: formation, effect of carbonatation temperature. J. P. Murray and F. M. Runggas. (Abs.).....	219		
	-- flume-wash water, effect of sapin. A. G. Kirichenko et al. (Abs.).....	342		
	reduction in beet diffusion. V. N. Borzdava et al. (Abs.).....	87		
	-- surface-active agents. P. Číž et al.	218		
	Food and Agriculture Organization of the United Nations committee review and outlook 1975/76. (N.C.)	321		
	Formic acid production from sucrose. R. A. Schraufnagel and H. F. Rase	61		
	France: beet mechanization exhibition. Anon. (Abs.).....	305		
	-- research. Anon. (Abs.).....	116		
	Commantré sugar factory. Anon.	312		
	distillery. Anon. (Abs.).....	285		
	finances for Ivory Coast and Cameroun sugar developments. (Brev.).....	287		
	new sugar factory. (Brev.).....	96		
	Paris white sugar market. (N.C.)	2, 66		
	weather and beet agriculture. (Brev.)	191		
	see also Europe, EEC			
	French West Indies: Guadeloupe cane varieties. Anon. (Abs.).....	239		
	sugar production 1975. (Brev.).....	63		
	Fructose. see Levulose			
	Furfural: manufacture from bagasse. A. C. Chatterjee and B. M. Dutt	382		
	-- C. I. Nee and W. F. Yse. (Abs.)	158		
	-- in Mexico. (Brev.).....	288		
	Furnaces. Bagasse. B. Lokan. (Abs.)	213		
	air pollution reduction. F. A. Grillo	150		
	-- B. A. Sanford. (Abs.).....	150		
	bagasse burning. V. J. Baillet. (Abs.)	214		
	-- drying and heat utilization. R. Velazquez E. (Abs.).....	53		
	-- moisture content. W. P. Bouvier	214		
	emission particulate analysis. C. G. Watson. (Abs.).....	151		
	explosions. T. Ikehara. (Abs.).....	117		
	fly ash as fertilizer. N. R. Maclean	335		
	-- slurry dewatering. G. M. Sawyer and R. N. Cullen. (Abs.).....	85		
	-- treatment. E. E. McDougall et al. (Abs.).....	341		
	-- utilization. A. C. Chatterjee and B. M. Dutt. (Abs.).....	382		
	induced-draught fan wear prevention. Y. H. Kuo. (Abs.).....	277		

INDEX

	PAGE		PAGE		PAGE
Furnaces, Bagasse:		Heat: insulation of refinery equipment.		International Sugar Journal Panel of Referees (N.C.)	193
pulverized coal firing and bagasse		A. N. Dul'dier and D. K. Dunaev-	123	International Sugar Organization:	
pneumatic firing. A. G. Burter.	183, 372	skil. (Abs.)		council meeting. (N.C.)	225
		liberation in sugar factories. A. A.	89	Malaysia Republic and	
		Chernyi and V. D. Petrash. (Abs.)		South Africa sugar industry survey	159
		losses in condensers. N. Y. Tobilevich	311	year book 1974. Anon. (N.B.)	59
		et al. (Abs.)		International Sugar Research Founda-	
Gears: east mill. (T.N.)	62	pump and evaporator steam heat	246	tion annual meeting 1976. (Brev.)	352
Germany. Cane beet variety. (Brev.)	64	upgrading. A. Péron. (Abs.)	216	International	
sugar industry plans. (Brev.)	127	transfer. I. M. Fedotkin et al. (Abs.)	122	Invert sugar: browning product forma-	
Germany. West: beet production 1975.	244	-- beet diffusion. A. Kubasiewicz and	25	tion. E. Reinefeld et al. (Abs.)	379
J. Hohobin and H. G. Hledge.	120	W. Lekawski. (Abs.)		content in beet, effect of topping.	
campaign 1974/75. E. Reinefeld.	307	-- A. Sokolowski and A. Lam-	156	P. J. Last et al.	167, 185
fertilizer recommendations. Anon.	307	precht. (Abs.)		-- root, crown and collar. K.	
new sugar factory. (Brev.)	352	-- pulp drying. T. Cronewitz et al.	126, 349	Fábán and J. Kollár. (Abs.)	188
sugar production. G. E. Hageberg	155	-- boiling. V. T. Garyazha and B. G.	152	-- cane, effect of frost. J. C. P. Chen	
-- 1975/76. (Brev.)	160	Dudshko. (Abs.)		and J. J. Chen. (Abs.)	53, 188
waste water quantities and pollution		-- V. P. Zubchenko et al. (Abs.)	153	-- carbonation juice, effect of mag-	
loads. E. Reinefeld. (Abs.)	120	-- effect of circulation ratio. V. P.	153	nesium oxide. J. Studnický et al.	342
-- treatment and legislation. H. P.		Troino et al. (Abs.)		decomposition in carbonation,	
Hoffmann-Walbeck and A.		calculation. A. Kubasiewicz and	186	effect of oxygen. H. Schiweck.	26, 246
Pellegri. (Abs.)	186	W. Lekawski. (Abs.)		-- effect of pH and temperature.	
see also Europe, EEC		-- condensate to process water. A. I.	123	A. R. Saprnon and K. A.	
Ghana: sugar factory performance.	277	Khomenko et al. (Abs.)	243	Koleheva. (Abs.)	60
-- production 1974. (N.C.)	34	-- effect of air in steam. R. Wasmund	128	-- occurrence of carbonyl components.	
Verenigde HVA-Mij. N.V. report	288	-- pulsed flow. I. M. Fedotkin and	281	E. Reinefeld et al. (Abs.)	285, 157
1975. (Brev.)		I. V. Kosninskii. (Abs.)		determination in beet. E.	
Gibberellic acid: cane flowering control.	206	-- steam injection. S. M. Konstan-	376	Reinefeld et al. (Abs.)	380
-- growth regulation. G. Singh and	368	tinov and N. N. Bezpal'ko.		effect on sucrose determination. J.	
K. Saren. (Abs.)		evaporators, calculation. P. G.	84	Segel. (Abs.)	317
Gilmore Louisiana-Florida-Texas-		Bright. (Abs.)		melassigenic coefficient. V. A. Goly-	
Hawaii: Puerto Rico sugar manual	155	-- effect of scale. K. Mosich. (Abs.)	343	bin et al. (Abs.)	27
1975. C. M. McKay. (N.B.)		-- ultrasonics. I. M. Fedotkin	88	syrups. M. R. Irimia. (Abs.)	123
Glucuronic acid: determination. V. Prey	250	et al. (Abs.)		-- sugars behaviour. V. S. Velasco	284
et al. (Abs.)		-- massenute heaters. J. P. Macher-	182	and J. P. Dowling. (Abs.)	
Glucose, see Dextrose		-- E. E. A. Rouillard. (Abs.)	182	see also Dextrose; Levulose; Reduc-	
Glutamic acid: auto-diffusion. A.	380	-- through scaled surfaces, effect of	255	sugars; Sucrose inversion and	
Emmerich et al. (Abs.)	379	flow. T. Baloh. (Abs.)		Sugars	
Maillard reaction. E. Reinefeld et al.	379			Ion exchange: D. Hervé. (Abs.)	56
Ratio to glutamine and beet virus	52	Holland: sugar imports and exports.	280	J. J. Ungar and R. Lindbro. (Abs.)	215
yellow tolerance. V. Rimsa et al.	352	see also Europe, EEC		beet juice acids determination. H. D.	
Greece: citric acid factory. (Brev.)	352	Honduras: new sugar factory. (Brev.)	63, 351	Wallenstein and H. Egler. (Abs.)	27
sugar factory fuel consumption. P.	377	sugar expansion. (Brev.)	160	-- separation. E. Reinefeld et al.	250
Hristodoulou. (Abs.)	377	Hong Kong: sugar imports and exports	160	levulinic prevention. E. J.	
imports. (Stat.)	352	Trading and Commodities Exchange	30	Roberts et al. (Abs.)	326
industry. D. Hadjianonion. (Abs.)	120	Hungary: beet varietal trials. L. Lukács	244	-- and H. F. Rose. (Abs.)	61
Xanthi sugar factory. Z. Nitschke	127	and J. Zana. (Abs.)	256	liquid sugar manufacture. N. Mari-	
Guatemala: clarifier pilot plant. (Brev.)	128	new sugar factory. (Brev.)	102, 255	gnetti. (Abs.)	219
earthquake and drought. (Brev.)	128	sugar imports. (Stat.)	127	organic acids determination. G. P.	
new sugar factory. (Brev.)	351			Vloshanenko and A. M. Shev-	
sugar exports. (Stat.)	96	Iceing sugar classification in fluidized	246	chenko. (Abs.)	156
industry. A. Viton. (Abs.)	119	bed. L. Neuzil and L. Brož. (Abs.)	246	resins. (T.N.)	62
Gums: cane deterioration after harvest-	146	India: bagasse paper manufacture.	349	-- description. S. Z. Ivanov et al.	219
ing. J. E. Irvine and B. L. Legendre.	377	P. J. M. Rao. (Abs.)		-- multiple elution. J. Dobrzycki.	139
effect on raw sugar filtrability. M.	27	beet agriculture. J. S. Garg and	211	-- sugar adsorption. G. A. Chiklin	315
Shaňa and R. Samaniego. (Abs.)	27	M. P. Azad. (Abs.)		and V. F. Gerasimov. (Abs.)	85
see also Polysaccharides		-- in Punjab. S. K. Kaur et al.	83	sugar recovery improvement in boil-	
Gur: manufacture. S. K. D. Agarwal	23	-- Rajasthan. D. S. Oberoi and	83	ing. R. J. Batterham. (Abs.)	90
et al. (Abs.)	23	R. Singh. (Abs.)	83	-- treatment of beet diffusion water.	
clarification. K. M. Bhardwaj et al.	340	-- diseases. K. Singh et al. (Abs.)	116	K. Magyar. (Abs.)	187
in India. S. K. Ojha et al. (Abs.)	238	-- varietal trials. K. S. Parashar.	52	-- Juice. P. Caidematis et al. (Abs.)	187
suitable cane varieties. S. N.	271	-- cane agriculture in Kerala. Anon.	81	-- E. Gryllus and H. J. Delavier.	185, 187
Gupta and R. Singh. (Abs.)	271	-- diseases. S. M. P. Khurana and	143	-- V. Gryllus. (Abs.)	278, 281
physico-chemical properties. B.	92	S. Singh. (Abs.)		-- molasses. K. W. R. Schroock	87
Singh et al. (Abs.)	92	-- pests. S. K. Banerjee and D. K.	300	-- cane juice and potassium recovery.	
see also Jaggery		Butani. (Abs.)	301	S. Mukherjee and S. K. Sriva-	
Guayana: Booker interests nationaliza-	98, 226	-- and diseases. T. Somu et al.	301	stava. (Abs.)	119
tion. (N.C.)	98, 226	-- production. S. Thangavelu and K.	305	-- molasses. M. Munir. (Abs.)	100
cane land expansion. (Brev.)	63	Sundaresan. (Abs.)	305	-- refinery liquor. S. Friul et al. (Abs.)	123
varieties. Anon. (Abs.)	239	-- research. Anon. (Abs.)	381	-- water. P. Devillers et al. (Abs.)	24
sugar industry expansion. (Brev.)	32	-- T. R. Srinivasan and Y. B.	301	see also Colour and Juice	
production 1975. (Brev.)	254	Morachan. (Abs.)	333	Ion exclusion: sugar recovery improve-	
trade agreement with China. (Brev.)	63	-- varietal trials. K. S. Parashar.	305	ment in boiling. R. J. Batterham	85
		fertilizer trials. S. N. L. Srivastava	320	treatment of beet molasses. E. Reine-	
		et al. (Abs.)	304	feld. (Abs.)	120
		new sugar factories. (Brev.)	317	Iran: beet sugar industry. J. E. Maudru	152
		nitrogen trials. D. S. Deol and R. S.	254	cane harvester and transporter order	286
		Kanwar. (Abs.)	304	new sugar factory. (Brev.)	288
		refined sugar standard. A. C. Chhat-	317	sugar expansion plans. (Brev.)	352
		erjee. (Abs.)	256	-- factory process controls. (Brev.)	63
		sugar expansion incentives. (Brev.)	256	Iraq: bagasse paper and cellulose factory	320
		-- exports. (Stat.)	98	Mosul sugar complex. J. Molenda	120
		-- industry development incentives	288	and W. Lekawski. (Abs.)	120
		-- machinery manufacture. (Brev.)	352	Irrigation. K. C. Leverington and	
		-- production 1975/76. (Brev.)	352	D. R. Ridge. (Abs.)	49
		-- statistics. (N.C.)	33	-- Australia. D. W. Beattie. (Abs.)	49
		Uttar Pradesh soils, weather and	238	-- E. R. Hoare. (Abs.)	49
		cane varieties. S. K. Ojha et al.	340	-- R. B. Moller and L. S. Chapman	49, 110
		Vuyyuru sugar factory. P. J. M. Rao	127	beet yellowing. E. Dalleinne. (Abs.)	244
		West Bengal sugar industry. (Brev.)	96	benefits and cost factors. G. A. Fer-	
		Indonesia: clarifier pilot plant. (Brev.)	127	guson and R. J. Hampson. (Abs.)	50, 110
		new sugar factories. 63, 64, 192, 350, 352	352	-- cane borer control. A. Schaaf. (Abs.)	110
		"Unigrator" orders. (Brev.)	127	-- drying-off. J. E. Lonsdale. (Abs.)	174
		Instruments: laboratory apparatus	27	-- land planning. A. I. Linedale.	78
		standardization. M. Friml and J.	27	-- water requirements. P. J. Nielsen	209
		Fucherna. (Abs.)		-- determination. G. Kingston	49
		see also Brink; Colour; Contr; Auto-		and G. J. Ham. (Abs.)	
		matic; Flow; Level; pH; Polariza-		-- utilization, effect of drying-off.	
		tion; Viscosity; Water; etc.		J. M. Gosnell and J. E. Lons-	
		International Commission for Uniform		dale. (Brev.)	7
		Methods of Sugar Analysis 16th		In Cuba. (Brev.)	191
		Session Proceedings. (N.B.)	59	-- drip. R. M. Bader. (Abs.)	369
		International Society of Sugar Cane		-- W. Gibson. (Abs.)	80
		Technologists 16th Congress 1977		-- W. S. Haines. (Abs.)	368
		29, 96, 224, 351		-- J. E. Usher. (Abs.)	331
		International Sugar Agreement		-- G. Williams. (Abs.)	369
		1, 128, 225, 290, 353		-- effect on cane agriculture. C. T.	
		US participation	128, 161	Fisher. (Abs.)	369
		International sugar economic yearbook		-- J. B. Thomson. (Abs.)	369
		and directory 1975. H. Ahlfeld.	59	-- equipment. S. M. Tutton. (Abs.)	369

INDEX

	PAGE		PAGE		
Irrigation: drip, flushing valve. W. Gibson and U. Bul. (Abs.)	369	Juice, Beet: acids determination. H. D. Weinstein and H. Eder. (Abs.)	27	Juice, Cane: alcohol beverage manufacture. Anon. (Abs.)	922
- scheduling. J. M. Sakuma. (Abs.)	80	active alkalinity. K. Vukov. (Abs.)	217	- manufacture. (Brev.)	191
- and cane yield. R. Scardua and J. A. G. C. Sousa. (Abs.)	331	amino-acids determination. M. Burba and B. Georgi. (Abs.)	348	ash and reducing sugars contents. L. K. Kirby. (Abs.)	92
- single-no. chamber tubes. U. Bul and W. Gibson. (Abs.)	368	ammonia determination and removal. P. Devillers <i>et al.</i> (Abs.)	24	Brix and level automatic control in evaporation. C. D. Clarke and M. Webber. (Abs.)	54
- soil erosion prevention. M. C. Tulang and J. W. Bedish. (Abs.)	40	analysis. G. Roth. (Abs.)	284	- measurement, mud separation by polyelectrolyte. W. Stewart. (Abs.)	188
- sub-surface. W. Gibson. (Abs.)	80	ash determination as evaporator scale and corrosion guide. P. Devillers <i>et al.</i> (Abs.)	120	chloride and phosphate determination. W. C. Cheng <i>et al.</i> (Abs.)	346
- S. Lanting. (Abs.)	368	calcium and silicon contents and evaporator scale. P. Devillers <i>et al.</i>	377	citric acid manufacture, effect of methanol and groundnut oil. K. Kumar and S. Ethiraj	13
- tube plugging prevention. R. Belew. (Abs.)	369	colour formation. K. Vukov. (Abs.)	278	colorants. P. G. Carpenter and M. A. Clarke. (Abs.)	123
- P. McElhooe and W. Gibson	80	- effect of enzymes. D. Gross and J. Coombs	69, 106	colour formation, effect of cane steam treatment. N. H. Smith	259
effect on beet processing quality. I. al-Windi and L. Schmidt. (Abs.)	148	- flocculation aid. V. Prey <i>et al.</i>	55, 90	- enzymes. D. Gross and J. Coombs	69, 106
- yield and quality. H. D. Fuchring and R. E. Plinkner. (Abs.)	21	- and lime salts, effect of treatment with saccharate. J. Degeest <i>et al.</i> (Abs.)	55	- turbidity, effect of lime, bagacillo and heat. N. L. C. Suzor. (Abs.)	309
- cane yield. B. K. Mathur. (Abs.)	239	- reduction in evaporation. B. I. Kats. (Abs.)	24	dextran determination. A. Borys. (Abs.)	284
- E. Pembroke. (Abs.)	270	effect of diffusion water electrolysis. A. Y. Romanyuk <i>et al.</i> (Abs.)	281	effect of diffusion water electrolysis. A. Y. Romanyuk <i>et al.</i> (Abs.)	281
fertilization. F. A. Fogliata. (Abs.)	111	fine pulp removal by centrifuge. H. Schreck. (Abs.)	278	flow measurement. A. L. Webre	118
- nematode development. E. D. Whitney and D. L. Doney. (Abs.)	20	galacturonic acid determination. F. Perschak. (Abs.)	60, 124	- temperature and pH automatic control. N. A. Nielsen and B. McEachran. (Abs.)	54
- nitrate accumulation in beet fields. S. K. Winter. (Abs.)	337	heater corrosion. H. J. Heppner	218	heater arrangement optimization. E. del Valle. (Abs.)	151
- nitrogen fertilization and beet sugar content. J. N. Carter <i>et al.</i>	337	- and pipeline scale, aragonite effect. A. Bogdanov. (Abs.)	247	ion exchange treatment and potassium recovery. S. Mukherjee and S. K. Srivastava. (Abs.)	119
- topped beet yield. P. J. Last <i>et al.</i>	167, 195	- scale thickness determination. I. V. Kosminskii <i>et al.</i> (Abs.)	311	pH. J. C. P. Chen and R. W. Picou	150
- soil conservation. R. Kane. (Abs.)	18	invert sugar determination. E. Reinefeld <i>et al.</i> (Abs.)	380	- and frost damage. J. C. P. Chen <i>et al.</i> (Abs.)	188
- water utilization. O. W. Sturges	111	ion exchange treatment. F. Galde-maisous. (Abs.)	187	- sugar recovery, effect of cane deterioration. G. J. Gascho <i>et al.</i>	150
large-scale project economic assessment. D. Wesley and R. F. Woolcock. (Abs.)	50	- E. Gryllus and H. J. Delavier. (Abs.)	185, 187	phosphate determination. N. Morfi <i>et al.</i> (Abs.)	124
in Morocco. C. Zehani. (Abs.)	82	- V. Gryllus. (Abs.)	278, 281	properties, effect of cane burning. S. el-N. A. Hemaidda <i>et al.</i> (Abs.)	302
nitrogen effects on cane yield. G. Singh <i>et al.</i> (Abs.)	272	- D. Horvath. (Abs.)	285	- extraneous matter. S. el-N. A. Hemaidda <i>et al.</i> (Abs.)	308
number and beet yield. K. Singh <i>et al.</i>	211	- J. J. Ungar and R. Lumbroso	215	- frost on cane. J. D. Miller and G. J. Gascho. (Abs.)	290
overhead. G. Friescke. (Abs.)	19	lactic and volatile acids determination. M. Kely and M. O'Sullivan	317	- H. A. Naqvi and S. M. Alam	202
- J. A. G. C. Sousa. (Abs.)	301	lime salts determination. L. G. Kalinenko. (Abs.)	156	purity and boiling house capacity. R. D. Archibald and I. A. Smith	182
in Peru. A. Hoekstra. (Abs.)	301	magnetic treatment. S. I. Tkachenko <i>et al.</i> (Abs.)	217	- drop in evaporation. K. N. Paul	308
pump and motor shed. C. D. Jones	331	micro-organisms control. D. Mattuzzi <i>et al.</i> (Abs.)	26, 247	- mulling. D. Smith. (Abs.)	118
rainwater storage dams. P. R. Downs and L. K. Izait. (Abs.)	209	non-sugars and Mallard reaction. E. Reinefeld <i>et al.</i> (Abs.)	28, 157	sampling. L. Keiso and S. Reichard	340
research in Brazil. G. M. Azter <i>et al.</i>	282	organic acids determination. E. Reinefeld <i>et al.</i> (Abs.)	250	silicon effect on processing. M. A. Clarke. (Abs.)	283
- South Africa. Anon. (N.B.)	59	- G. P. Voloshanenko and N. N. Shevchenko. (Abs.)	156	starch elimination measurement. J. B. Alexander and M. Matic	314
- Taiwan. S. J. Yang. (Abs.)	367	- pH. Effect of calcium addition. F. Teschner and R. Kramer. (Abs.)	258	- G. el-K. Sayed <i>et al.</i> (Abs.)	150, 157
restriction and cane ripening. L. G. Vallance. (Abs.)	241	- temperature. L. P. Krava and N. L. Izbinskaya. (Abs.)	126	- measurement. G. el-K. Sayed <i>et al.</i>	157
scheduling. P. Y. Chan and L. Li Pi Shan. (Abs.)	238	phosphoric and organic acids determination. J. F. T. Oldfield <i>et al.</i>	125	trace metals determination. S. L. Sang <i>et al.</i> (Abs.)	346
- G. Kingston and L. S. Chapman	49, 110	properties, effect of diffusion water purification with magnesium carbonate and phosphoric acid. J. Buriánek <i>et al.</i> (Abs.)	90	treatment with flocculation aids. S. Morales and P. M. Flores. (Abs.)	23
- and beet yield and sugar content. V. Singh and P. Singh. (Abs.)	338	purity determination. M. Friml and B. Tichá. (Abs.)	124	see also Clarification and Syrup	
- nitrogen effects on cane and sugar yield. B. K. Mathur and K. B. Tripathi. (Abs.)	272	- and lime salts, effect of diffusion water treatment with aluminum sulphate. B. I. Pogorzelskii <i>et al.</i> (Abs.)	279	Kestose, see Sugars	
- rainfall quality estimation. G. Kingston. (Abs.)	334	- prediction. P. Devillers <i>et al.</i> (Abs.)	92	Lactic acid: auto-diffusion. A. Emmerich <i>et al.</i> (Abs.)	380
self-travelling irrigator. (T.N.)	350	- J. Hobbis and L. Batterman	92	determination in beet juice and molasses. M. Kely and M. O'Sullivan. (Abs.)	317
sewage effluent. E. Y. Hirata. (Abs.)	81	- and sugar content, effect of ethylene in diffusion. A. H. Freytag and J. C. Linden. (Abs.)	218	fermentation suppression. V. N. Shvets <i>et al.</i> (Abs.)	285
solid-set sprinkler system. G. Kingston and E. Heibin. (Abs.)	335	- total anions distribution in beet. K. Fábian and J. Kollár. (Abs.)	188	manufacture from molasses. L. Vanossi. (Abs.)	126
underground water quality. G. J. Ham. (Abs.)	47	reverse osmosis. T. Baloh. (Abs.)	122, 377	as microbial infection criterion in beet diffusion. P. W. van der Poel	56
water distribution, effect of furrow length. Y. T. Fan <i>et al.</i> (Abs.)	76	sugar decomposition in evaporation. I. M. Fedolkin <i>et al.</i> (Abs.)	152	- cane diffusion. L. McMaster and A. P. Ravno. (Abs.)	182, 214
- quality. D. R. Ridge and G. J. Kelly. (Abs.)	50	- determination. P. Devillers <i>et al.</i>	348	Level: bonification measurement. M. E. Furer and V. R. Tsygura.	216
- salinity, effect on cane nutrient uptake and yield. Anon. (Abs.)	301	- G. W. Maag and G. H. Sisler	250	clarification mud automatic control. R. L. Muller. (Abs.)	372
well construction in Taiwan. Y. Chu	367	sulphite determination, effect of nitrite. R. B. Lew. (Abs.)	250	control in beet slicer hoppers. I. Ergün. (Abs.)	310
see also Water		thermal stability, effect of sodium sulphite. L. I. Ryvazova and A. Y. Gadzhiev. (Abs.)	278	- measurement. K. A. Nekrasov	90
Israel sugar industry. J. Rosenberg	90	thick juice colour formation, effect of temperature. L. Wieninger and N. Kubadinov. (Abs.)	55, 217	filter mud suspension automatic control. V. I. Oskin and A. I. Yamshnov. (Abs.)	121
Itaconic acid manufacture from molasses. M. Nakagawa <i>et al.</i> (Abs.)	252	- electrodiolysis. P. Zagrodny <i>et al.</i> (Abs.)	89	juice automatic control in evaporation. C. D. Clarke and M. Webber	84
Italy: sugar factory closure. (Brev.)	352	- nitrogen determination. T. P. Khvalkovskii <i>et al.</i>	88, 120, 246	massecuite and heat surface utilization in boiling. V. P. Troino <i>et al.</i>	153
- imports. (Brev.)	64	- R. Kubadinov. (Abs.)	284	levulinic acid manufacture from bagasse. C. I. Nee and W. F. Yse	158
- industry. G. de Andre. (Abs.)	279	- M. Moore and J. Karr. (Abs.)	56	- sucrose. R. A. Schraunfagel and H. F. Rase. (Abs.)	61
- production 1975/76. (Brev.)	192	- E. Reinefeld. (Abs.)	120	Levulose: content in cane, effect of post-harvest deterioration. G. el-K. Sayed <i>et al.</i> (Abs.)	157
see also Europe, EEC		- M. Rychnik. (Abs.)	57	high-fructose corn syrup production in EEC. (N.C.)	257, 321
Ivory Coast: sugar industry finance from France. (Brev.)	287	- O. I. Shepel'skii <i>et al.</i> (Abs.)	217	moist composition, effect of heat. W. March and S. Assely. (Abs.)	249
- project. (Brev.)	256	- pipeline pressure loss calculation. E. Manzke and S. Lier. (Abs.)	279	see also Invert sugar; Reducing sugars and Sugars	
Jaggery: colour removal with active carbon. B. G. Krishnamurti. (Abs.)	315	- storage tank. Anon. (Abs.)	186	- viscosity and sucrose diffusion coefficient, effect of campaign length. M. N. Dadenkova <i>et al.</i> (Abs.)	156
Jamaica: cane varieties. Anon. (Abs.)	239	see also Carbonation; Filtration and Sulphitation	156		
- trials. Anon. (Abs.)	240				
sugar statistics. (Stat.)	352				
Japan: cane agriculture. G. D. Thompson and P. G. C. Bret. (Abs.)	301				
- production 1975/76. (Brev.)	352				
refinery closure. (Brev.)	127				
sugar company rationalization	64				
- imports 1975. (Brev.)	192				
- from Australia. (Brev.)	159				
- trade agreement with Cuba. (Brev.)	265				
- South Africa. (Abs.)	64				

INDEX

PAGE		PAGE		PAGE
	F. O. Licht's International Sugar Economic Yearbook and Directory 1975. H. Ahlfeld (N.B.).....	59		
	Lime application to soil. L. B. Golden	112		
	- R. Vanstellen. (Abs.).....	82, 211		
	- and beet yield and sugar content.			
	R. Vanstellen. (Abs.).....	83		
	- cane orange. F. Reisse. W. A. Webb and N. Clarke. (Abs.).....	78		
	- fungus development. C. C. Chao and M. M. H. Wu. (Abs.).....	336		
	- micronutrients availability. J. E. Bowen. (Abs.).....	210		
	- nutrient availability. C. von Kessel. (Abs.).....	115		
	free calcium and magnesium oxides determination. N. P. Tabunshchikov and L. D. Shevtsov. (Abs.).....	251		
	kin. R. A. McGinnis. (Abs.).....	121		
	- charging. K. N. Savchuk. (Abs.).....	90		
	- fuel, design and operation. I. Sue 55, 185			
	- oil or gas firing. F. Sobek. (Abs.).....	25		
	limestone handling. N. M. Kichigin <i>et al.</i> (Abs.).....	375		
	- properties. K. M. Sipitanou and D. S. Mitka. (Abs.).....	377		
	- milk-of-lime addition to flume water. K. Skalski. (Abs.).....	25, 90, 186, 218		
	- and beet volatile acids and antons. H. Schwieck. (Abs.).....	278		
	- analysis. G. Pollack. (Abs.).....	254		
	- application to stored beet. N. M. Ignatov and M. F. Kinyakin.....	378		
	- doser. Z. Somora. (Abs.).....	87		
	- feed control valve. M. P. Klepalchenko. (Abs.).....	311		
	- screening. L. Palfalvai. (Abs.).....	246		
	- sprayer for beet. A. M. Elagin <i>et al.</i> quality, effect of limestone and coke size. F. Sobek. (Abs.).....	378		
	- regeneration in refinery. S. Omori.....	154		
	<i>see also</i> Carbonation and Clarification			
	Liquid sugar: manufacture. D. Hervé	56		
	- M. R. Irimia. (Abs.).....	123		
	- N. Marignetti. (Abs.).....	219		
	pesticide residue determination. T. Mikl. (Abs.).....	156		
	US exports to Canada. (N.B.).....	98		
	Losses: bagasse and molasses sugar. A. L. Webre. (Abs.).....	374		
	beet briel sugar and nitrate content. D. G. Westfall and M. Barnes.....	19		
	- damage. R. de Vletter and W. van Gils. (Abs.).....	281		
	- W. C. von Kessel. (Abs.).....	149		
	- and humming. F. Kapol. (Abs.).....	122		
	- loading, unloading and binning. V. Vasiliev and N. M. Kichigin. (Abs.).....	121		
	- diffusion. A. K. Buryma <i>et al.</i>	87		
	- G. S. Derzhavets. (Abs.).....	87		
	- G. G. Giorgi and B. Richard.....	247		
	- G. F. Tyazheleva. (Abs.).....	313		
	- effect of weather on beet invertase. I. Januszewicz <i>et al.</i>	306		
	- infection determination. F. W. van der Poel. (Abs.).....	56		
	- reduction. J. Blok and P. W. van der Poel. (Abs.).....	26, 248, 313		
	- N. V. Kulinich <i>et al.</i> (Abs.).....	216		
	- P. P. Panchodko <i>et al.</i> (Abs.).....	344		
	- handling and storage. J. B. Pitts	377		
	- sugar manufacture. J. Genotelle.....	121		
	- washing and conveying. J. N. Doucraim. (Abs.).....	215		
	- water separation. E. T. Koval' <i>et al.</i> (Abs.).....	56		
	boiling, reduction. G. Aleman. (Abs.)	214		
	cane burning effect. S. el-N. A. Hemaida <i>et al.</i> (Abs.).....	302		
	- determination after frost. J. D. Miller and G. J. Gascho. (Abs.).....	220		
	- harvesting. Anon. (Abs.).....	238, 365		
	- G. J. Gascho <i>et al.</i> (Abs.).....	150		
	- J. E. Irvine and B. L. Legendre.....	146		
	- R. S. Kanwar and J. K. Kapur.....	358		
	- N. Ramamoorthy <i>et al.</i> (Abs.).....	220		
	- T. R. Srinivasan <i>et al.</i> (Abs.).....	210		
	- E. E. A. Rouillard. (Abs.).....	374		
	- alpha-amylase activity. G. el-K. Sayed <i>et al.</i> (Abs.).....	157		
	- and condensate ethanol. J. D. Blake.....	131		
	- dextran reduction. P. A. Inkerman and G. P. James.....	374		
	- effect of burning. Anon.....	213		
	- R. G. Hoekstra. (Abs.).....	151		
	- frost. E. M. Chen and A. J. J. Chen. (Abs.).....	53, 188		
	- juice composition. G. el-K. Sayed <i>et al.</i> (Abs.).....	157		
	- processing and molasses exhaustion. C. R. Toea. (Abs.).....	119		
	- reduction. Anon. (Abs.).....	110		
	- S. Bose <i>et al.</i> (Abs.).....	302		
	- H. T. E. Smith. (Abs.).....	79		
	- diffusion. J. C. McMaster and A. B. Ravno. (Abs.).....	182, 214		
	- harvesting. J. E. Clayton <i>et al.</i>	146		
	- L. L. Louden. (Abs.).....	238		
	clarification mud. P. N. Stewart <i>et al.</i> determination. P. Devillers <i>et al.</i> 91, 93, 48			
	- in molasses. V. A. Golybin <i>et al.</i>	92		
	Losses:			
	effect of cane extraneous matter. S. el-N. A. Hemaida <i>et al.</i> (Abs.).....	308		
	- B. L. Legendre. (Abs.).....	177		
	- in evaporation. I. M. Fedotkin <i>et al.</i>	152		
	- K. N. Paul. (Abs.).....	203		
	- determination. Anon. (Abs.).....	318		
	- effect of sodium sulphite. J. I. Ryazantseva and A. Y. Andzhiev. (Abs.).....	278		
	filter cake. N. G. Lila <i>et al.</i> (Abs.).....	281		
	- pol and filtration evaluation. P. M. Fabregat P. and V. Kharakoz. (Abs.).....	23		
	frost effect on cane processing. H. A. Naqvi and S. M. Alam.....	202		
	rafinose effect on polarization. P. Devillers <i>et al.</i> (Abs.).....	249		
	reduction by microbiological control. B. P. Kuz'menko. (Abs.).....	24		
	- D. Matteucci <i>et al.</i> (Abs.).....	26		
	- in refinery by equipment modifications. Technical Staff, CSR Ltd. (Abs.).....	57		
	- in refining. A. Rossi. (Abs.).....	314		
	stored beet. N. A. Emel'yanov <i>et al.</i>	312		
	- W. Trznicki and E. Bakowska.....	239		
	- effect of extraneous matter. Anon. (Abs.).....	217, 248		
	- rotation vs. monoculture. N. A. A. B. Akeson <i>et al.</i> (Abs.).....	212		
	- topping. W. R. Akeson <i>et al.</i>	180		
	- prediction. M. G. Barnes <i>et al.</i>	181		
	- reduction. W. R. Akeson and S. D. Fox. (Abs.).....	180		
	- W. R. Akeson <i>et al.</i> (Abs.).....	180		
	- A. M. Elagin <i>et al.</i> (Abs.).....	311		
	- A. H. Freytag. (Abs.).....	19		
	- M. Z. Khelmskii <i>et al.</i> (Abs.).....	87, 311		
	- thick juice. (Abs.).....	88		
	- O. I. Shepel'skii <i>et al.</i> (Abs.).....	217		
	- M. Moore and J. Karr. (Abs.).....	56		
	- O. I. Shepel'skii <i>et al.</i> (Abs.).....	217		
	sugar deterioration. M. T. Hernandez and N. Herrera.....	22		
	sugar adsorption by ion exchange resin. G. A. Chikin and V. F. Selemenev. (Abs.).....	315		
	- calculation. A. R. Sazonov and B. A. Kolcheva. (Abs.).....	60		
	- decomposition of silicon. M. A. Clarke. (Abs.).....	283		
	in syrup decolorization and boiling, effect of pH and temperature. S. A. Brennan <i>et al.</i> (Abs.).....	249		
	white sugar manufacture. S. Ortega <i>see also</i> Bagasse; Diseases; Filter cake; Molasses; Pests; Pulp; Beet and Weather	150		
	Lubrication: cane mill roller bearings. U. J. Akeus. (Abs.).....	54		
	- G. D. Jackim <i>et al.</i> (Abs.).....	54		
	centralized. A. Y. Volokhov. (Abs.).....	344		
	Maintenance of beet drills. W. Hartley	18		
	Malaysia Republic sugar industry.....	159		
	Malawi sugar development. (N.C.).....	2		
	Malaysia: bagasse board factory. (Brev.)	320		
	refining. T. Yamane and H. Asai.....	150		
	sugar industry. K. Y. Li. (Abs.).....	77		
	Massecurite: Brix and sugar determination. A. Y. Zagorouk <i>et al.</i> (Abs.)	316		
	colour measurement. M. Muro M. and C. Silverio R. (Abs.).....	125		
	crystal size analysis. D. Toningerová and K. Hamplová. (Abs.).....	157		
	distribution in centrifugals and sugar quality. D. Ahari and J. Genotelle. (Abs.).....	215		
	properties and molasses separation in centrifugals. Y. Y. Kolornets <i>et al.</i> (Abs.).....	248		
	reheater. L. K. Kirby <i>et al.</i> (Abs.).....	373		
	- heat transfer and friction loss. E. E. A. Rouillard. (Abs.).....	182		
	- reheating with evaporator vapour. J. P. Mukherji <i>et al.</i> (Abs.).....	183		
	- rheological properties. K. Ciz. (Abs.)	348		
	stream friction losses. Y. G. Artukhovich and T. Garyshina.....	184		
	viscosity, effect of crystal and mother-liquor properties. M. Awang and E. T. White. (Abs.).....	373		
	- reduction by re-centrifugalling. F. Amnding. (Abs.).....	377		
	<i>see also</i> Boiling; Centrifugals; Crystallization and Pans, Vacuum			
	Mauritius: cane diseases. Anon. (Abs.)	206		
	sugar factories performance. J. T. d'Espagnet. (Abs.).....	183		
	- industry. (Brev.).....	159		
	- production. G. B. Hagelberg.....	159		
	- 1975. (N.C.).....	66		
	- statistics. (Stat.).....	26		
	Mechanization, Beet: cleaner-loader operation and field clamp siting. M. Mawby. (Abs.).....	82		
	equipment. W. C. von Kessel. (Abs.)	302		
	- exhibition. Anon. (Abs.).....	305		
	Mechanization, Beet:			
	harvesters. Anon. (Abs.).....	149		
	- D. R. Brisbane and H. T. Breyer.....	243		
	- G. Heller. (Abs.).....	21		
	- A. Vigoureux. (Abs.).....	211		
	- W. C. von Kessel. (Abs.).....	212		
	- accidents. Anon. (Abs.).....	149		
	- and loaders. Anon. (Abs.).....	243		
	- performance. W. Stigter <i>et al.</i>	244		
	harvesting and beet damage minimization. F. B. Russell. (Abs.).....	212		
	- groups. D. Charlesworth. (Abs.).....	379		
	- losses. W. C. von Kessel. (Abs.).....	149		
	- hoeing. A. Vigoureux. (Abs.).....	21		
	loaders. Anon. (Abs.).....	338		
	- A. Vigoureux. (Abs.).....	274		
	seed drills. K. J. Thompson. (Abs.)	304		
	- maintenance. W. Hartley.....	35		
	- drilling. G. L. Maughan. (Abs.).....	243		
	- effect of soil profile. C. de Zanche and G. Baraldi. (Abs.).....	305		
	- speed and emergence. A. S. Kennedy and J. V. Topper.....	243		
	- and stand quality. H. Draher.....	18		
	storage hoe knives and beet field stones. Anon. (Abs.).....	19		
	top harvesting trials. Anon. (Abs.).....	244		
	- top harvesting. Vigoureux. (Abs.).....	149		
	topping. Anon. (Abs.).....	180		
	- A. Vigoureux. (Abs.).....	181		
	- J. A. Wayman <i>et al.</i> (Abs.).....	148		
	- and beet yield and quality. P. J. Last <i>et al.</i>	167, 195		
	- effect on beet storage and processing quality. W. R. Akeson <i>et al.</i>	180		
	- harvesting. J. Pichenez. (Abs.).....	244		
	- height and beet processing quality. M. Z. Khelmskii <i>et al.</i> (Abs.).....	52		
	- M. Martens. (Abs.).....	83		
	tractor tyre size and beet row spacing. (Abs.).....	211		
	Tátray. (Abs.).....	211		
	UK demonstrations. (Brev.).....	254		
	weed cutting. D. Charlesworth.....	82		
	Mechanization, Cane: cleaner. C. W. Hart. (Abs.).....	79		
	- D. L. Roberts. (Abs.).....	114		
	cleaning. J. E. Clayton and D. B. Churchill. (Abs.).....	113		
	costs. L. V. Gentil. (N.B.).....	58		
	cutters. E. Meyer <i>et al.</i>	174, 302		
	Beer. (Abs.).....	174, 302		
	equipment order from Egypt. (Brev.)	286		
	- purchasing vs. contracting. P. J. Nielsen. (Abs.).....	332		
	extraneous matter and cane damage. B. J. Cochran and W. A. Hadden. field layout requirements. O. P. Landrey <i>et al.</i> (Abs.).....	174, 303		
	harvesters. (N.C.).....	350		
	- Anon. (Abs.).....	177		
	- R. Panjuli and I. Schexnayder.....	114		
	- R. F. Spargo and S. W. D. Baxter.....	210		
	- base-foster. V. Ablikov and G. B. Rivas. (Abs.).....	300		
	- and loaders. Anon. (Abs.).....	365		
	- order from Iran. (Brev.).....	286		
	- topper performance. J. Brito M. and J. Albas. (Abs.).....	48		
	harvesting. L. G. Fowler. (Abs.).....	114		
	- L. V. Gentil. (Abs.).....	336		
	- A. S. Hall. (Abs.).....	368		
	- R. C. Hodson and B. Legendre.....	368		
	- C. C. Montgomery. (Abs.).....	308		
	- J. J. Seip and J. A. Salazar. (Abs.)	147		
	- H. T. E. Smith. (Abs.).....	79		
	- G. Thomas. (Abs.).....	179		
	- R. B. V. Toledo. (Abs.).....	80		
	- cane deterioration reduction. Anon	110		
	- D. H. Foster. (Abs.).....	333		
	- extraneous matter. F. N. Bolton.....	147		
	- J. E. Clayton <i>et al.</i> (Abs.).....	146		
	- removal. J. E. Clayton <i>et al.</i>	369		
	- properties. J. A. Silveira. (Abs.).....	16		
	- costs. R. L. Walker. (Abs.).....	114		
	- G. A. Zapp and J. E. Clayton.....	146		
	- in Cuba. (Brev.).....	191		
	- cut-chop whole-stalk cane. J. J. Seip <i>et al.</i> (Abs.).....	205		
	- effect of cane burning. Anon.....	77		
	- double drilling. H. Willett.....	205		
	- rain. R. L. Walker. (Abs.).....	333		
	- factory processing. J. Castro and J. J. Balardi. (Abs.).....	144		
	- C. K. Lu. (Abs.).....	277		
	- green cane. J. C. Hudson <i>et al.</i>	206		
	- photographic analysis. J. E. Clayton. (Abs.).....	142, 179		
	- scheduling. L. S. Chapman and K. C. Leverington. (Abs.).....	333		
	- rational quantity estimation. G. Kingston. (Abs.).....	334		
	- seed cane. S. Inazu. (Abs.).....	81		
	- in South Africa. S. W. D. Baxter.....	240		
	- G. Thompson. (Abs.).....	79		
	- study in Argentina. (Brev.).....	288		
	- transport vehicle number. T. C. Ripoli and L. A. Balastreire.....	368		
	- in US. J. E. Clayton and B. R. Eiland. (Abs.).....	369		
	- J. E. Clayton and W. C. Hedick.....	144		
	hydrostatic drive equipment. J. R. Marshall. (Abs.).....	81		
	land levelling and forming machinery. Anon. (Abs.).....	332		

INDEX

	PAGE		PAGE		PAGE
Mechanization, Cane:		Milling, Cane:		Molasses, Beet:	
loader, A. G. de Beer. (Abs.)...	302	imbibition water addition, S. Vlogo	53	fatty acid extraction, O. I. Belova	
— capacity, effect of green cane.		— juice purity drop, P. D. Smith. (Abs.)	118	— and T. Bogaliev. (Abs.)...	379
— J. R. Orsenigo. (Abs.)...	179	— materials balance calculation, L.	216	— formation, G. Yavinecz. (Abs.)...	188
— and dirt tare, J. G. van Groenigen	111	— Hernandez C. et al. (Abs.)...	187	— effect of amino-acids and peptides,	
— soil compaction, N. R. Maclean...	335	— micro-organisms reduction, (T.N.)...	216	— G. P. Voloshanenko et al. (Abs.)	346
— planter, Anon. (Abs.)...	48, 273	— plus centrifuging, M. Sterzinger and	323, 361	— — salts, N. P. Silina. (Abs.)...	91
— W. S. Boots. (Abs.)...	179	— J. Zlarsky et al. (Abs.)...	22	— galactinol determination, I. Housiau	284
— T. E. Clayton. (Abs.)...	271	— simulation, F. Szklaruk et al. (Abs.)	22	— ion exchange treatment, K. W. R.	
— L. G. Fowler. (Abs.)...	113	— see also Milling, Cane		— Schoenrock. (Abs.)...	87
— L. G. Fowler and F. Stein. (Abs.)	205	Mills, Cane: In Brazil. (Brev.)...	384	— — J. J. Ungar and R. Lumbroso	215
— N. S. L. Srivastava. (Abs.)...	17	— feeding, A. Vigil. (Abs.)...	53	— lactic acid determination, M. Kieley	317
— and harvesters, Anon. (Abs.)...	303	— — automatic control, A. J. Hussey...	118	— and M. O'Sullivan. (Abs.)...	
— time control, D. Thompson. (Abs.)	81	— gears, (T.N.)...	62	— — citric acid, J. Kovats and Z.	285
— planting and harvesting, Anon....	367	— hydraulic motors, T. B. Ray. (Abs.)	214	— — Niestrawski. (Abs.)...	285
— research in South Africa, Anon....	59	— Mozambique order, (T.N.)...	350	— — fodder yeast, P. S. Matvenko	285
— — Taiwan, S. J. Yang. (Abs.)...	307	— roller bearings, J. U. Acker. (Abs.)	54	— and P. A. Semets. (Abs.)...	
— in Réunion, Anon. (Abs.)...	77	— — G. D. Jacklin et al. (Abs.)...	54	— mercury determination, P. B.	189, 220
— stalk chopper, G. Dodgin. (Abs.)...	144	— — and torque requirements, D.	54	— Koster et al. (Abs.)...	220
— tillage reduction, N. Kozoff. (Abs.)	80	— Macey and J. A. McGinn. (Abs.)	54	— non-sugars and Maillard reaction, E.	
— tractor, (T.N.)...	350	— — float indicators and speed restric-	374	— Reinefeld et al. (Abs.)...	28
— J. Lyons. (Abs.)...	369	— — tion, A. L. Webre. (Abs.)...	213	— pH, effect of temperature, L. P. Reva	156
— four-wheel-drive eqs. tracks, L. M.		— — setting calculation, G. R. Swamy	374	— phosphate determination, T. P.	250
— Hummel. (Abs.)...	81	— — shredder, (T.N.)...	62, 350	— Khvalkovskii and T. V. Zakharova	
— sound reduction and safety devices,		— — balancing, D. Macey. (Abs.)...	341	— pulp mixture briquetting, coefficients	
— R. L. Krolak. (Abs.)...	80	— — hammer failure, S. G. Clarke and	341	— of friction, M. G. Parfenov and	
— three-point linkage, C. B. Henkel	78	— — G. H. Matthews. (Abs.)...	127	— — N. E. Karaulov. (Abs.)...	252
— two-drill planting, S. Rodrigue...	179	— — orders, (Brev.)...	341	— purity, effect of massecuite heating	
— US company changes. (Brev.)...	191	— — size, A. C. Chatterjee. (Abs.)...	22	— with steam, D. Ahari and J.	215
— wet harvesting and ratoon crop yield,		— — turnplates, A. H. Chancellor and	340	— Genelle. (Abs.)...	
— R. P. Vickers et al. (Abs.)...	334	— — J. Glass. (Abs.)...	22	— — reduction, effect of magnesium	
Mexico: bagasse paper factory. (Brev.)	64	— — R. van Wijk. (Abs.)...	86	— oxide, K. W. R. Schoenrock	56
— — Anon. (Abs.)...	221	Molasses: alcohol manufacture. P.	381	— raffinose hydrolysis, D. Staszewicz	347
— — P. J. M. Rao. (Abs.)...	349	— — Kujala et al. (Abs.)...	161	— silage preservative, Anon. (Abs.)...	222
— cane agriculture, Anon. (Abs.)...	176	— — A. Ramalingam and R. K. Finn	61	— sterilization and degradation in	
— centrifugal order. (Brev.)...	159	— — V. F. Suk et al. (Abs.)...	158	— storage, A. D. Kovalenko. (Abs.)	190
— new sugar factories. (Brev.)...	287	— — colorants effect on yeast zeta-	252	— sugar content, effect of diffusion	
— raw sugar manufacture from crude		— — potential, V. N. Shvets et al.	385	— water treatment with aminium	
— sugar, B. A. Smith et al. (Abs.)	277	— — effect of antiseptic, E. R.	282	— sulphate, B. I. Pogorzelski et al.	279
— sugar commission. (Brev.)...	159	— — lactic acid bacteria, V. N.	385	— — determination, P. Devillers et al.	348
— — exports. (Brev.)...	96	— — Shvets et al. (Abs.)...	282	— — G. W. Maag and G. H. Sisler	250
— — industry. (Abs.)...	224	— — calcium, potassium and invert sugar	27	— — extraction, J. Degeest et al. (Abs.)	52, 121
— — S. Flores C. (Abs.)...	48	— — formation, V. A. Golybin et al.	27	— — M. Munir. (Abs.)...	100
— — C. Passos. (Abs.)...	48	— — colorants, V. Prey and H. Andres	318	— — P. Pierrard. (Abs.)...	378
Micro-organisms: best biochemical pro-		— — separation, V. Prey and H. Andres	318	— — E. Reinefeld. (Abs.)...	120
— cesses, L. Laszity. (Abs.)...	274	— — components mass and molar concen-	346	— — I. Salanki. (Abs.)...	216
— — diffusion, A. G. G. G. G. G. G. G.		— — trations, D. E. Sinat-Radchenko	346	— — effect of raffinose hydrolysis,	
— — Osweller and G. H. Sisler. (Abs.)	89	— — yeast, L. Vanoss. (Abs.)...	125	— — R. A. McGinnis. (Abs.)...	121
— — effect of aluminium sulphate,		— — composition, properties and use-	156	— — Steffen filtrate sugar determi-	
— — P. T. Dunne et al. (Abs.)...	279	— — B. P. Baker. (N.B.)...	125	— — Norman. (Abs.)...	125
— — water treatment on raffinose		— — fermentation, L. Vanossi. (Abs.)...	156	— — waste water as animal odor	
— — activity, F. Hollaus. (Abs.)	55, 152	— — carotene, E. V. Stabnikova et al.	91	— — additive, L. Gonry. (Abs.)...	126
— — infection determination, P. W.		— — yeast, L. Vanoss. (Abs.)...	94	— — ratio to metals, P. Devillers et al.	60, 189
— — van der Poel. (Abs.)...	56	— — phosphate determination, T. P.	250	— — trace elements, D. Hibbert et al.	379
— — flume-wash water, V. A. Lagoda		— — Khvalkovskii and T. V. Zakharova	250	— — yield, effect of beet as monoculture,	
— — et al. (Abs.)...	124	— — reducing sugars determination, J.	250	— — N. A. Al'dekov and N. P. Kostin	212
— — disaccharide formation, W. Mauch		— — Lenczewski. (Abs.)...	249	— — optimization, effect of syrup purity,	
— — and F. de Aama. (Abs.)...	284	— — formation, V. A. Golybin et al.	249	— — V. A. Pugachev et al. (Abs.)...	278
— — juice clarification and scale formation,		— — separation in centrifugals, effect of	248	Molasses, Cane: addition and raw sugar	92
— — R. W. Kuhlmann et al. (Abs.)...	350	— — feeder height, V. F. Kolomiets et	248	— — pol control, J. H. King. (Abs.)...	
— — molasses sterilization, E. R. Alieva-		— — standard purity determination, I. A.	220	— — to vinasse for yeast manufacture,	
— — Vitukevich. (Abs.)...	382	— — Prikhod'ko and K. V. Ukrainets.	220	— — J. T. Aginaldo. (Abs.)...	252
— — A. M. Ostapenko and V. A.		— — sterilization by electromagnetic field,	349	— — analysis, L. Carrazana R. and I.	125
— — Matison. (Abs.)...	349	— — A. M. Ostapenko and V. A. Matison	349	— — Machado L. (Abs.)...	94
— — in ratoon containing infected cane,		— — sucrose and non-sugars auto-diffusion,	380	— — animal fodder, B. M. Bakstad. (Abs.)	94
— — C. T. Chen et al. (Abs.)...	143	— — Emermerci et al. (Abs.)...	317	— — G. L. Chuprov et al. (Abs.)...	61
— — A. G. Gillaspie and J. F.		— — sugars determination, A. Borys and	157	— — Y. Chen et al. (Abs.)...	190
— — Worley. (Abs.)...	378	— — S. J. Kubacki. (Abs.)...	157	— — J. Freivalds. (Abs.)...	190
— — reduction, (T.N.)...	158	— — utilization, (T.N.)...	100	— — A. R. Frontera et al. (Abs.)...	158
— — in beet diffusion, F. X. Kammer...	377	Molasses, Beet: amino-acids, M. Munir	350	— — C. H. Liu. (Abs.)...	158
— — N. V. Kulnich et al. (Abs.)...	216	— — determination, M. Burba and B.	348	— — S. C. Mai and T. H. Wu. (Abs.)	61
— — B. P. Kuzmenko. (Abs.)...	24	— — Georgi. (Abs.)...	222	— — F. M. Pate and S. W. Coleman	221
— — D. Matteuzzi et al. (Abs.)...	26, 247	— — animal fodder, Anon. (Abs.)...	348	— — E. F. Unsworth and P. O. Osuji	349
— — M. Velings. (Abs.)...	378	— — — T. K. Alimov. (Abs.)...	94	— — ash and reducing sugars contents,	
— — and press water, J. Herdik		— — — L. E. Dolgoruchenko. (Abs.)...	61	— — L. K. Kirby. (Abs.)...	92
— — and V. Dachovský. (Abs.)...	90	— — — E. Pfeffer. (Abs.)...	381	— — determination of Brix, P. Mellet...	93
— — cane milling, (T.N.)...	286	— — — L. Thompson. (Abs.)...	61	— — chloride, Anon. (Abs.)...	213
— — soil, effect on nitrification inhibitor,		— — balance calculation, A. Kubasiewicz	186	— — and phosphate, W. C. Cheng et	346
— — Anon. (Abs.)...	240	— — and W. Lekawski. (Abs.)...	186	— — al. (Abs.)...	27
— — in stored beet thick juice, T. P.		— — Brix and sugar determination, A. Y.	312	— — purity, J. P. Stuppiello et al. (Abs.)	125
— — Khvalkovskii et al. (Abs.)...	88, 120	— — Zagorul'ko. (Abs.)...	356	— — starch, G. el-E. Sayed et al. (Abs.)	157
— — sugar deterioration, M. T. Her-		— — citric acid manufacture in Greece...	312	— — dextran reduction, P. Hidi and R.	85
— — nandez and N. Herrera. (Abs.)	22	— — colorants and properties, V. N.	317	— — Staker. (Abs.)...	
— — sucrose degradation in cane diffusion,		— — colour, L. Wieninger and N. Kubad-	55, 217	— — electro dialysis, J. Houssiau and R.	313
— — L. McMaster and A. B. Ravnö...	182	— — inow. (Abs.)...	55, 217	— — Pieck. (Abs.)...	313
— — determination with <i>B. stearotherm-</i>		— — components mass and molar concen-	346	— — exhaustibility determination, Anon.	213
— — ophilus, G. Pollach. (Abs.)...	60	— — trations, D. E. Sinat-Rad-	346	— — G. B. Bonnet and D. Fal-	
— — see also Diseases: Fermentation;		— — chenko et al. (Abs.)...	250	— — comer. (Abs.)...	189
— — Losses; Water, Waste and individual		— — composition in USSR, A. Y. Zagor-	125	— — — T. Moritsugu et al. (Abs.)...	318
— — fermentation products		— — ul'ko et al. (Abs.)...	250	— — effect of clarification with mag-	
Milling, Cane, M. Beauvillage. (Abs.)	183	— — determination of galacturonic acid,	60, 124	— — nesium oxide, J. J. Zvarada	118
— — G. Ramschandra. (Abs.)...	308	— — F. Perschak. (Abs.)...	60, 124	— — — colour and ash, M. A. Mohamed	318
— — automatic control, N. Nielsen and		— — organic acids, G. P. Voloshanenko	156	— — et al. (Abs.)...	318
— — B. McEachran. (Abs.)...	54	— — and A. M. Shevchenko. (Abs.)...	156	— — exhaustion, A. L. Webre. (Abs.)...	374
— — cane extraneous matter, B. L.		— — phosphoric and organic acids,	125	— — calculation, G. F. Fundora. (Abs.)	151
— — Legendre. (Abs.)...	177	— — J. F. T. Oldfield et al. (Abs.)...	60	— — effect of continuous crystallization,	
— — quality determination, L. P.		— — — sucrose, G. Pollach. (Abs.)...	60	— — V. R. R. Bhonsale. (Abs.)...	183
— — Hebert. (Abs.)...	112	— — dextrose, raffinose and sugar con-	249	— — — raffinose and cane quality, C. R.	119
— — comparison with diffusion, R. Schaar		— — contents, P. Devillers et al. (Abs.)...	249	— — — Toca. (Abs.)...	188
— — dextran reduction, P. Hidi and R.		— — electro dialysis, J. Houssiau and R.	313	— — — evaluation, A. Acosta. (Abs.)...	188
— — Staker. (Abs.)...	85	— — — efficiency determination, L. D.	313	— — — Bobrovnik et al. (Abs.)...	23
— — effect on subsoil diffusion, J. H.		— — — exhaustibility determination, M.	247	— — — Friid and S. Pochyla. (Abs.)...	308
— — Payne. (Abs.)...	170	— — — exhaustion, effect of massecuite	378	— — — manufacture of alcohol. (Brev.)...	191
— — extraction calculation, P. F. Jain...	309	— — — cooling time, A. Y. Zagorul'ko	278	— — — Anon. (Abs.)...	381
— — — B. L. Legendre and M. T.		— — — pre-centrifugalling, F. Amding	377	— — — A. C. Chatterjee and B. M. Dutt.	382
— — — Henderson. (Abs.)...	119				
— — — M. J. H. (Abs.)...	117				
— — — P. W. Rein. (Abs.)...	189, 249				
— — — P. O. Skinner. (Abs.)...	125				
— — — adjustment for varietal differ-					
— — — ences, E. Arnesen. (Abs.)...	86				
— — — L. Payan et al. (Abs.)...	23				
— — — effect of extraneous matter, J.					
— — — Castro and J. J. Balerdi. (Abs.)	144				
— — — S. el-N. A. Hemaida et al.	308				

INDEX

	PAGE		PAGE		PAGE
Molasses, Cane: manufacture of alcohol		Fans, Vacuum:		Pests, Beet:	
- D. Sridharan. (Abs.).....	61	tube length and tube plate angle		pygmy mangold beetle control. M.	
- W. E. Trevelyan. (Abs.).....	190	effects on boiling. V. P. Troino	217	Kubacka-Szmigdal. (Abs.).....	212
- citric acid. H. S. Dhankhar <i>et al.</i>	253	vacuum creation. E. I. Vaisman.	374	root maggot. A. Keller and J. D.	305
- J. Kovats and Z. Nestravski	382	vapour condensation. B. V. Koren'	278	Stallings. (Abs.).....	
- Y. T. Liu. (Abs.).....	252	<i>et al.</i> (Abs.).....	343	Pests, Cane: aleurodid feeding and cane	
- itaconic acid. M. Nakagawa <i>et al.</i>	190	- consumption fluctuation reduction.		damage. R. A. Agarwal.....	109
- rum. W. H. Kampen. (Abs.).....	251	K. Mosich. (Abs.).....	343	aphid control. C. R. Diaz. (Abs.)...	48
pesticide and trace constituents		- line valve automatic control. E.	308	in Australia. C. R. Nalder. (Abs.)...	271
determination. A. C. Morris and		Batule and A. Rodriguez. (Abs.)...	217	borers. S. Kumar. (Abs.).....	174
W. M. Nicol. (Abs.).....	251	- re-utilization. M. L. Vaisman <i>et al.</i>	217	G. Thompson. (Abs.).....	142
reducing sugars determination. S.		<i>see also</i> Boiling; Crystallization;		- and army worm, effect of inter-	
Bose <i>et al.</i> (Abs.).....	92	Entrainment; Heat; Mousseite		cropping with wheat. A. N.	300
rheological properties and pumping		and Scale.		Kafra <i>et al.</i> (Abs.).....	300
data calculation. D. V. Boger and		Paper, Bagasse: factory in Argentina	351	- in Brazil. H. D. de Souza and	
C. Tu. (Abs.).....	245	- Iraq. (Brev.).....	320	M. F. da Silva. (Abs.).....	303
spontaneous destruction. P. F. Jain	22	- Mexico. (Brev.).....	84	- control. Anon. (Abs.).....	206, 240
sugar determination. M. Kort <i>et al.</i>	159	- Anon. (Abs.).....	221	- G. M. Azzi. (Abs.).....	303
- E. C. Vignes. (Abs.).....	220	- Paraguay. (Brev.).....	256	- M. D. Padmanabhan <i>et al.</i> (Abs.)...	300
- extraction. M. Munir.....	100	- Peru. (Brev.).....	256	- A. Schaaf. (Abs.).....	110
trace metals determination. S. L.		- possibility in Pakistan. (Brev.)...	192	- H. N. Yadav and S. P. Sharma	301
Sang <i>et al.</i> (Abs.).....	346	- Venezuela. (Brev.).....	256	- by topping. S. Kumar. (Abs.)...	239
viscosity, effect of non-sugars. L.		manufacture. A. C. Chatterjee and		- damage and parasites. A. J. M.	208
Carrazana <i>et al.</i> (Abs.).....	251	B. M. Dutt. (Abs.).....	382	- incidence, effect of planting time.	
yield, effect of filtrate clarification.		- R. A. Odlot. (Abs.).....	222	S. Sithanathan <i>et al.</i> (Abs.)...	48
S. Narain. (Abs.).....	300	- P. J. M. Rao. (Abs.).....	349	- set treatment. B. K. Mathur	17
<i>see also</i> By-products		- South Africa. (Brev.).....	32, 384	<i>et al.</i> (Abs.).....	48
Molasses, Refinery: colorants fractionation		<i>see also</i> Pulp, Bagasse		- in India. E. S. Kooner <i>et al.</i> (Abs.)...	16
- F. Bugaenko. (Abs.).....	93	Paraguay: bagasse paper and cellulose	256	- parasites. Anon. (Abs.).....	241
pesticide residue determination T.		factory. (Brev.).....	256	- P. J. Etienne. (Abs.).....	17
Miki. (Abs.).....	156	distillery. (Brev.).....	352	- C. E. F. Pereira <i>et al.</i> (Abs.)...	331
Morocco: beet agriculture. Anon.....	83	sugar production 1975. (Brev.)...	160	- P. S. Das <i>et al.</i> (Abs.).....	239
- campaign 197. (Abs.).....	80	Payment, Beet: computerized system.	25	- T. E. Summers and R. D. Jack-	
- vs. cane agriculture. G. Schmidt	82	- U. Beaucaudin <i>et al.</i> (Abs.).....	25	son. (Abs.).....	112
- sugar production 1975. (Brev.)...	30	- EEC 1976/77. (N.C.).....	130	- H. T. Tseng. (Abs.).....	207
- cane production 1974. Anon. (Abs.)...	79	- recommendations. (N.C.).....	33	- N. C. Tuhani and O. S. Andira	207
- new sugar factory. (Brev.).....	127	- UK. (N.C.).....	65, 322	and predators. W. Y. Cheng.	207
- sugar production 1975/76. (Brev.)...	352	USSR. (Brev.).....	52	- rearing. R. D. Jackson. (Abs.)...	146
Mozambique cane mill order. (T.N.)	350	- M. S. Bariko and F. I. Khamat	52	- N. Macedo <i>et al.</i> (Abs.).....	302
		<i>see also</i> Beet analysis; Beet sampling		- A. Varma <i>et al.</i> (Abs.).....	207
		and Polarization		- sex attractant. W. Y. Cheng	74
		Payment, Cane: computer application.	119	- in South Africa. Anon. (Abs.)...	17
		D. B. Batstone. (Abs.).....	214	- U. S. S. Viator. (Abs.).....	179
		- D. D. Sponner. (Abs.).....	54	- varietal susceptibility and control.	333
		- R. F. Sutherland. (Abs.).....	54	B. S. Kooner <i>et al.</i> (Abs.)...	81
		- frost and juice acidity penalties.		- effect of potassium. G. K.	300
		F. A. Martin <i>et al.</i> (Abs.).....	189	Zende. (Abs.).....	282
		- in U.S. H. S. Birkett and J. T. Seip	188	- in Brazil. G. M. Azzi. (N.B.)...	62
		<i>see also</i> Cane analysis; Cane sampling		- and cane root protection. J. F.	48
		and Polarization		Usher. (Abs.).....	209
		Pectin, Beet: in beet juice, effect of		- in India. T. Somu <i>et al.</i> (Abs.)...	301
		pre-carbonation mud removal.	185	- research in Australia. Anon. (Abs.)...	47
		K. P. Zakharov <i>et al.</i> (Abs.).....	285	- froggipor varietal resistance testing.	210
		- colour and lime salts content.	24	E. J. Marques. (Abs.).....	113
		S. P. Olyanskaya <i>et al.</i> (Abs.)...	256	fulgorid and mosaic transmission.	113
		- beet pulp. V. V. Parfenenko <i>et al.</i>	301	H. Koike and L. J. Charpentier.	208
		- manufacture. G. V. Buzina and V. V.	96	- and cane root protection. J. F.	47
		- Parfenenko. (Abs.).....	338	grub damage. J. F. Reimers. (Abs.)...	146
		- beet pulp. V. V. Parfenenko <i>et al.</i>	338	- T. E. Summers. (Abs.).....	49
		- Peru: bagasse paper factory. (Brev.)	256	Guatemala. V. Sanchez-Riesca. G.	301
		- irrigation. A. Hoekstra. (Abs.)...	301	<i>Teera pilosa</i> control. R. A. Singh	301
		- sugar exports. (Brev.).....	96	- insecticide applicator. G. Dodgen.	144
		Pests, Beet, Anon. (Abs.).....	338	- insects in India. S. N. Banerjee and	374
		aphids and beet fly control. Anon.	338	D. K. Butani. (Abs.).....	300
		- in Belgium. L. van Steyvoort.	242	leatherpiper. Anon. (Abs.).....	331
		- control. Anon. (Abs.).....	275, 337, 339	- control. J. S. Sandhu <i>et al.</i> (Abs.)...	331
		- N. B. Davis. (Abs.).....	242	- Fiji disease vector. B. T. Egan.	334
		- R. A. Dunning and G. H. Winder	304	- hosts. R. Outridge and D. S.	370
		- E. Seutin and L. van Steyvoort.	18	Teakle. (Abs.).....	334
		- as virus yellows vectors. G. Becker	191	locusts. P. J. Amiet. (Abs.).....	334
		- beet damage in France. (Brev.)...	18	- C. W. Chardon. (Abs.).....	79
		- in Belgium. L. van Steyvoort. (Abs.)	338	- B. E. Hitchcock. (Abs.).....	208
		- bird damage. Anon. (Abs.).....	274	- control. D. J. Williams. (Abs.)...	334
		- O. Schrier. (Abs.).....	52	- nematodes. Anon. (Abs.).....	332
		- black fly control. L. van Steyvoort	62	- J. Dick and R. H. G. Harris. (Abs.)...	142
		- control. (T.N.).....	19	- A. A. Rajzivin <i>et al.</i> (Abs.).....	114
		- W. R. Schaufele and C. Winner.	243	- L. G. Vallance. (Abs.).....	238
		- E. Seutin and L. van Steyvoort.	275	- in Barbados. C. W. D. Brathwaite	367
		- W. C. von Kessel. (Abs.).....	83	- control. S. Rau and P. K. Moberly.	174, 241
		- effect on beet storage and process-	274	- G. D. Thompson. (Abs.).....	15
		- ing quality. M. Martens. (Abs.)	276	- distribution in soil. R. H. G.	174
		- micro-regulators. Anon. (Abs.)	274	- Harris. (Abs.).....	81
		- W. R. Schaufele and H. Schaf-	18	- parasites and hosts. J. R. Williams	181
		- mayer. (Abs.).....	83	- pesticide determination in raw sugar	156
		- feed rates. R. Vanstallen. (Abs.)	276	and refinery molasses. T. Miki.	368
		- operator protection against chem-	20	- effect on cane leaf composition.	272
		- icals. W. Hartley. (Abs.).....	115	- S. Sithanathan <i>et al.</i> (Abs.)...	272
		- spray equipment. W. (Abs.).....	52	- yield. R. S. Kanwar. (Abs.)...	300
		- insects. R. F. Ruppel. (Abs.).....	116	- hazards. C. Ricard. (Abs.).....	300
		- leaf miner. M. Kubacka-Szmigdal	276	- residues in molasses. A. C. Morris	58
		- leatherpiper control. D. L. Mumford	20	- and W. M. Nicol. (Abs.).....	272
		- and D. L. Griffin. (Abs.).....	115	- pig control, electric fence costs. R. E.	332
		- release for curly top induction.	116	- Kerkywk. (Abs.).....	272
		- D. L. Mumford. (Abs.).....	244	- damage. R. McLennan. (Abs.)...	273
		- mangold fly and black bean aphid.	275	- control. L. M. Blaisor. (Abs.)...	50
		- H. Bernarova <i>et al.</i> (Abs.).....	20	- B. E. Hitchcock and R. E.	241
		- nematodes. Anon. (Abs.).....	116	- Kerkywk. (Abs.).....	78
		- G. D. Griffin. (Abs.).....	244	- R. E. Kerkywk. (Abs.).....	207
		- and beet yellowing. E. Dalleinne	275	- research in Australia. Anon. (Abs.)...	207
		- control. Anon. (Abs.).....	20	- Mauritius. Anon. (Abs.).....	57
		- development, effect of agronomic	21	- South Africa. Anon. (N.B.)...	367
		- factors. E. D. Whitney and	115	- Taiwan. Y. S. Pan. (Abs.).....	59
		- D. L. Doney. (Abs.).....	20	- scale insect. C. S. Rao. (Abs.)...	208
		- beet resistance determination.	21	- and bud and stem scale. (Abs.)...	209
		- D. L. Doney and E. D. Whitney	115	- O. W. D. Myatt. (Abs.).....	271
		- and spring-tans. (Abs.).....	304	- soldier fly. D. Bull. (Abs.).....	47
		- manuring. W. Renius. (Abs.)...	156	- damage. J. Wright. (Abs.)...	271
		- pesticides. N. B. Davis. (Abs.)...	317		
		- determination in raw sugar and	93, 347		
		- refinery molasses. T. M. Moberly			
		- sugar. M. Kieley and M. O'Sulli-			
		- van. (Abs.).....			
		- A. Z. Usmentseva <i>et al.</i> (Abs.)...			

INDEX

PAGE		PAGE
<p>Pests, Cane: termite control. Anon. transmission prevention by equipment cleaning. J. F. Usher. (Abs.) 78 varietal resistance testing. R. Cusnik walaby damage. B. E. Arkway. white fly control with urea. A. A. Kalra and M. C. Gupta. (Abs.) 300 wireworm control. H. H. Samol and S. R. Johnson. (Abs.) 112 pH: beet diffusion water. K. Číž <i>et al.</i> juice, effect of ammonia. P. Devillers <i>et al.</i> (Abs.) 24 -- of calcium addition. F. Teschner and R. Krämer 28, 279 -- optimization and evaporation. M. K. Likhitskii and L. P. Reva. (Abs.) 152 -- sugar factory products, effect of temperature. L. P. Reva and N. L. Izbinskaya. (Abs.) 156 cane juice automatic control. N. A. Nielsen and B. McEachran 54 -- behaviour in evaporation. K. N. Paul. (Abs.) 308 -- effect of cane deterioration. J. C. P. Chen and J. J. Chen. (Abs.) 53, 188 -- G. J. Gascho <i>et al.</i> (Abs.) 220 -- J. D. Miller and G. J. Gascho -- H. A. Naqvi and S. L. Alam -- soil structure. J. C. P. Chen and R. W. Pilon. (Abs.) 150 citric acid manufacture, molasses. J. Kovats and Z. Niestrawski. (Abs.) 285 clarification mud filtration. J. J. Seip and F. L. Gayle. (Abs.) 308 -- level reduction. P. Chaturvedi colour sensitivity and measurement. D. F. Charles. (Abs.) 283 dextran hydrolysis. R. P. Fulcher and P. A. Inkerman. (Abs.) 379 -- reduction by enzyme. P. Hidi and R. Staker. (Abs.) 85 distillery waste and irrigation equipment corrosion. Anon. (Abs.) effect on beet sugar discharge. J. Guern. (Abs.) 339 -- colorants adsorption in carbonation. S. Z. Ivanov <i>et al.</i> (Abs.) 376 -- melanoidin adsorption by decolorizing resin. A. Chikhin and V. F. Seleznev. (Abs.) 27 -- organic acids determination in sugar. M. A. Godshall and E. J. Roberts. (Abs.) 283 ion exchange resin regeneration water decolorization. F. Onda <i>et al.</i> irrigation water quality. I. Risseew measurement of sugar and syrup. R. Lees. (N.B.) 282 -- reduction in clarification of juice quality. V. Morris. (Abs.) 118 refinery liquor carbonation. J. P. Murray and F. M. Runnagas. (Abs.) 219 -- decolorization. C. C. Chou. (Abs.) 314 soil and beet yield and sugar content. R. Vanstallen. (Abs.) 83 -- effect of lime and phosphate. L. E. Golden. (Abs.) 112 -- trace element effect on beet yield and quality. H. J. Müller. (Abs.) 274 stored beet thick juice. T. P. Kivalovskii <i>et al.</i> (Abs.) 120 sugar colour determination. J. A. Weber. (Abs.) 250 sugars behaviour in invert syrup. V. S. Velasco and J. F. Dowling. 284 -- decomposition. A. R. Saprnon and B. A. Kolcheva. (Abs.) 60 syrup decolorization and boiling losses. S. A. Brennan <i>et al.</i> (Abs.) 249 waste water. E. Reinefeld. (Abs.) 120 -- K. Skalski. (Abs.) 90 water and diffusion juice supervision. B. P. Kuz'menko. (Abs.) 24 see also Carbonation; Clarification and Sulphitation</p>	<p>Poland: new sugar factory. (Brev.) 352 sugar exports. (Stat.) 22 -- factory exports. (Brev.) 192, 254, 256 -- industry. W. Goralezky. (Abs.) 286 Polarization: automatic polarimeters. -- P. C. Ivin <i>et al.</i> (Abs.) 92 -- evaluation. C. C. Chou and K. R. Hanson. (Abs.) 318 beet juice sugar determination. M. Friml and B. Tichá. (Abs.) 124 -- sugar determination. K. Malec <i>et al.</i> (Abs.) 347 calcium and invert sugar melassogenic coefficients. V. A. Golynin <i>et al.</i> cane molasses sugar determination. J. P. Stuppiello <i>et al.</i> (Abs.) 125 -- sugar yield. E. Rodriguez C. <i>et al.</i> comparison with gas-liquid chromatography for sucrose determination. G. W. Maag and G. H. Sisler polarimeter errors. R. S. Watts 250 -- sample tubes. (T.N.) 350 sugar determination. P. Devillers <i>et al.</i> (Abs.) 249, 348 -- errors. M. Roche. (Abs.) 189 -- mixtures. J. Sagel. (Abs.) 317 temperature control. M. Randabel. see also Control, Chemical Polyelectrolyte: cane juice mud separation for Brix measurement. W. Stewart. (Abs.) 188 Polysaccharides: acid beverage flocc. B. J. Roberts <i>et al.</i> 326 -- composition. E. J. Roberts and F. G. Carpenter. (Abs.) 283 cane arabinogalactan isolation and composition. E. J. Roberts <i>et al.</i> see also Dextran; Gums and Starch Powdered sugar, see Icing sugar Power: auxiliary supplies. R. J. McIntyre. (Abs.) 340 -- consumption by cranes, calculation. A. I. Gromkovskii <i>et al.</i> 89 -- factory and refinery. M. Rychkun vacuum pans, use of priming pumps. M. Vaisman. (Abs.) 278 factor. R. S. Arnold. (Abs.) 309 flow control in tie-lines. R. J. McIntyre. (Abs.) 509 -- generation efficiency. E. G. Clarke by excess bagasse burning. A. M. Hain. (Abs.) 221 -- steam turbines. S. V. Wildman and T. J. Goldsmith. (Abs.) 86 -- turbo-generators in Greece. P. Hristodoulou. (Abs.) 377 house automatic control. R. A. Allaway and C. R. Graves. (Abs.) 340 -- N. A. Nielsen and B. McEachran. (Abs.) 54 pump requirements calculation for cane molasses transfer. D. V. Bogner and C. Thi. (Abs.) 245 transmission chains. C. G. Wildsmith. (Abs.) 182 utilization in refinery. J. D. Ryan 57 Prices: raw sugar and Dominican Republic selling policy. (N.C.P.) 193 -- EEC negotiations with ACP countries. (N.C.) 98, 161, 226, 258 -- exporters' meetings. (N.C.) 130, 268, 354 tablet sugar in Nigeria. (N.C.) 66 world raw sugar chart. (Brev.) 127 -- sugar. (N.C.) 2, 98, 130, 194, 226, 258, 289, 322, 353 -- stabilization. (N.C.) 321 -- and US raw sugar chart. (Brev.) 224 Puerto Rico: sugar factory re-erection in Costa Rica. (Brev.) 288 -- industry. C. M. McKay. (N.B.) 155 Pulp, Bagasse: bagasse and cane trash fibre properties. M. D. González P. and M. A. Vázquez G. (Abs.) 253 lignin removal. Y. Fahmy <i>et al.</i> manufacture. L. Gutiérrez <i>et al.</i> see also Paper, Bagasse Pulp, Beet: animal fodder. Anon. 92 -- I. E. Dolgoruchenko. (Abs.) 61 -- J. Freivalds. (Abs.) 190 -- L. Gonry. (Abs.) 126, 190 -- M. Journet <i>et al.</i> (Abs.) 221 -- F. Onalan. (Abs.) 253 -- E. Pfeffer. (Abs.) 281 -- E. Thier. (Abs.) 221 -- L. Thompson. (Abs.) 61 briquetting, coefficients of friction. M. G. Parfenopulo and N. E. Karaulov. (Abs.) 252 dryer. R. Henze. (Abs.) 349 -- emission. H. Smidt. (Abs.) 184 driving. P. Gronewitz <i>et al.</i> 126, 158, 349 -- B. Hutchinson <i>et al.</i> (Abs.) 382 -- M. Rychkun. (Abs.) 57 -- oil consumption. P. Hristodoulou storage fire hazards. G. T. Dixx handling. N. M. Kichigin <i>et al.</i> 375 mercury determination. P. B. Koster <i>et al.</i> (Abs.) 189, 220 moisture content, effect of ethylene in diffusion. A. H. Freytag and J. C. Linden. (Abs.) 218 molasses feed supplement. T. K. Alimov. (Abs.) 94</p>	<p>Pulp, Beet: pectin preparation. V. V. Parfenenko <i>et al.</i> (Abs.) 285 press. (T.N.) 350 pressing. (T.N.) 256 -- Y. D. Golovnyak <i>et al.</i> (Abs.) 87 -- and storage. N. M. Tkachenko. 158 storage. H. Schnell. (Abs.) 381 trace elements. D. Hibbert <i>et al.</i> vibration effects. M. G. Parfenopulo and N. E. Karaulov. (Abs.) 61 yield calculation. F. Kastner and Z. Pochlyl. (Abs.) 24 Pumps. (T.N.) 350 aqueous ammonia. Anon. (Abs.) 177 beet. S. F. Timoshenko and G. I. Podvorchanyi. (Abs.) 121 -- effect of extraneous matter. O. Böhm. (Abs.) 184 centrifugal, erosion and corrosion. A. I. Slyn'ko <i>et al.</i> (Abs.) 153 clarifier mud transfer. D. K. Paddock and P. B. Quinn. (Abs.) 84 priming for pan vacuum creation. M. L. Vaisman. (Abs.) 278 Pyrrolidone carboxylic acid auto-diffusion. A. Emmerich <i>et al.</i> (Abs.) 380</p> <p>Raffinose: in beet, effect of harvest date and nitrogen. R. C. Zielke and P. W. Snyder. (Abs.) 125 determination. H. Schweick and L. Büsching. (Abs.) 28 effect on beet sugar determination. K. W. B. Schenrock and D. Costello. (Abs.) 347 -- cane processing and molasses exhaustion. C. R. Toca. (Abs.) 119 -- molasses sugar extraction. J. Degeest <i>et al.</i> (Abs.) 55, 121 -- sugar determination by polarization. P. Devillers <i>et al.</i> (Abs.) 249 -- G. W. Maag and G. H. Sisler hydrolysis. D. Ostaszewicz. (Abs.) 347 -- and molasses sugar extraction. R. A. McGinnis. (Abs.) 121 see also Sugars Raw sugar: analysis. R. Lees. (N.B.) ash determination. G. Pli B. and M. Muro M. (Abs.) 124 chromium determination. W. Wolf <i>et al.</i> (Abs.) 27 colorants. F. G. Carpenter and M. A. Clarke. (Abs.) 123 colour, effect of clarification and non-sugars recirculation. N. L. C. Suzor. (Abs.) 309 -- formation, effect of cane steam treatment. N. H. Smith. 259 -- prevention. L. Bobrovnik <i>et al.</i> 245 -- measurement. M. Muro M. and C. Silverio R. (Abs.) 125 EEC imports from (N.C.) 98, 161, 226, 258 -- quota reductions. (Brev.) 384 filtrability, effect of impurities. M. Shaqiq and B. Samanogo. (Abs.) 27 -- phosphate and alcohol insolubles. C. C. Chou. (Abs.) 314 heavy metals determination. P. Pommeze and R. Gormier. (Abs.) 283 itaconic acid manufacture. M. Nakagawa <i>et al.</i> (Abs.) 252 pesticides residue. T. Miki. (Abs.) 156 production from crude sugar. Mexico. B. A. Smith <i>et al.</i> (Abs.) 277 -- es. while sugar. A. C. Chattergee refining quality. J. Brujin. (Abs.) 23 -- F. H. C. Kelly. 199 -- effect of cane damage by frost. J. C. P. Chen and J. J. Chen. (Abs.) 53, 188 -- in UK es. beet sugar production. 194 reflectance measurement and pol control. J. H. King. (Abs.) 92 starch content. J. B. Alexander and M. Matic. (Abs.) 314 -- determination. G. el-K. Sayed <i>et al.</i> (Abs.) 157 UK imports. (N.C.) 98, 161, 226, 258 US import duty. (N.C.) 322, 354 white sugar colour prediction. D. F. Charles. (Abs.) 283 world prices. (N.C.) 2, 98, 130, 194, 226, 258, 289, 322, 353 -- chart. (Brev.) 127 -- and Dominican Republic selling policy. (N.C.) 193 -- and US prices chart. (Brev.) 224 see also Affination; Boiling; Bulk handling; Bulk storage; Colour; Control; Chemical; Crystallization; Dryers; Factory; Masscon; Polarization; Refinery and Sugar Reducing sugars: cane deterioration after harvesting. Anon. (Abs.) 238 -- N. Ramamoorthy <i>et al.</i> (Abs.) 220 -- G. el-K. Sayed <i>et al.</i> (Abs.) 157 -- T. R. Srivivasan <i>et al.</i> (Abs.) 210 colorants formation and properties. J. C. Williams. (Abs.) 91</p>

INDEX

	PAGE		PAGE		PAGE
Reducing sugars:		Refining: liquor clarification with		Soil: cane chlorosis. U. S. Singh and	
content and beet, effect of harvest		floculation aid. M. G. Bennett,	315	F. D. Bajpai. (Abs.).....	48
date and nitrogen. R. C. Zielke		— colour determination. A. Y. Zag-		— land levelling. J. F. Reimers.	78
and F. W. Snyder. (Abs.).....	125	— and fluorescence reduction. D. F.	316	— — — and forming machinery.	
— — — juice, effect of liming. V. A.		Charles. (Abs.).....	283	— — — Anon. (Abs.).....	332
Golybin and S. Z. Ivanov. (Abs.)	120	— — — removal. M. Y. Mazlov et al.	315	— — — planning. A. I. Linedale. (Abs.)	78
— cane, effect of lodging. F. A.		— — — ion exchange treatment. S. Fujii		— — — for mechanical and drain-	
Fogliata and D. M. Morin. (Abs.)	303	et al. (Abs.).....	123	— — — O. Landreau et al. (Abs.)	74, 303
— — — juice, sugar and molasses. L. K.		— treatment. M. R. Trinia. (Abs.)	123	— — — preparation. L. L. Lauden.	175
Kirby. (Abs.).....	92	— losses in syrup decolorization and		— — — R. Oviانو. (Abs.).....	51
— — — molasses. A. Acosta. (Abs.).....	188	boiling, effect of pH and tempera-		— — — root and stubble yields. L. E.	145
— — — B. F. Unsworth and P. O.		ture. S. A. Brenman et al. (Abs.)	249	— — — compaction, effect of cane loaders	
Osuji. (Abs.).....	349	— melt house process control. A. O.		and cultivation. N. R. Maclean.	335
— — — reduction. S. Bose et al. (Abs.)	302	Maylott and J. W. deCellis. (Abs.)	315	— — — conditions and beet growth. W.	
— — — gur. B. Singh et al. (Abs.).....	92	— phosphate effect and removal. C. C.		— — — for mechanical and drain-	
— — — stored beets thick juice. T. P.		Chou. (Abs.).....	314	— — — quality. M. G. Frakes. (Abs.)	371
Khvalkovskii et al. (Abs.).....	85, 120	— starch occurrence, effect and elim-		— — — conservation, structure and drain	
degradation and colour formation.		ination. J. B. Alexander and M.		— — — maintenance. C. R. Henkel. (Abs.)	332
I. F. Bugaenko. (Abs.).....	93	Matic. (Abs.).....	314	— — — in Cuba. J. Alomá and J. Cuellar.	208
— — — in evaporation. K. N. Paul. (Abs.)	308	— sugar melting. V. Urban. (Abs.)	219	— — — cultivation. C. Kester and P. Kirk.	83, 305
— — — determination. S. Honda et al. (Abs.)	157	— technology book. (Brev.).....	320	— — — E. Meyer and A. G. de Beer.	174, 302
— — — R. Lees. (N.B.).....	282	— in U.K. F. Lewis. (N.B.).....	345	— — — costs. L. V. Gentil. (N.B.).....	58
— — — in molasses. S. Bose et al. (Abs.)	92	— — — rationalization. (N.C.).....	257, 322	— — — number and cane yield. R. J.	
— — — J. Lenczewski. (Abs.).....	124	— — — in U.S.R. Y. Y. Mazlov et al.	323	— — — M. Athernie. (Abs.).....	179
— — — effect on carbonation juice purity.		— — — see also Affination; Bone char; Carbon,		— — — and properties. A. A. G. van der	
P. Henneton. (Abs.).....	187	Active; Ion exchange; Raw sugar		— — — et al. (Abs.).....	77
— — — molasses formation. V. A. Golybin		and Syrup		— — — deep ripening and gypsum effects on	
et al. (Abs.).....	92, 249	Réunion: cane agriculture. Anon.....	365	— — — cane. H. S. Ibrahim. (Abs.).....	165
— — — viscosity. L. Carrazana R. et al.	251	— — — breeding. Anon. (Abs.).....	76	— — — drainage. H. H. Belcher. (Abs.).....	176
— — — ratio to ash and molasses exhaustion.		— — — diseases. Anon. (Abs.).....	76, 254	— — — C. R. Camp and C. E. Carter. (Abs.)	177
G. F. Fudora. (Abs.).....	151	— — — mechanical harvesting. Anon.....	77	— — — A. I. Linedale. (Abs.).....	334
see also Dextrose; Invert sugar;		— — — varietal trials. Anon. (Abs.).....	77	— — — A. A. Macal. (Abs.).....	301
Levulose and Sugars		— — — G. Loynet and C. H. de Fraisse		— — — pipes. G. Kingstom. (Abs.).....	270
Refined sugar: analysis. R. Lees. (N.B.)	282	— — — Rhodesia: cane varietal trials. G. L.		— — — sand removal. C. C. Ho. (Abs.)	112
chromium determination. W. Wolf	27	James. (Abs.).....	17	— — — research in Taiwan. S. J. Yang	367
et al. (Abs.).....	27	— — — C. H. de Fraisse. (Abs.).....	17	— — — and salinity reduction. W. T. Su	112
colorants. F. G. Carpenter and M. A.	123	— — — G. Loynet and C. H. de Fraisse	17	— — — K. W. Yao. (Abs.).....	112
Clarke. (Abs.).....	123	— — — Rhodesia: cane varietal trials. G. L.		— — — erosion. D. Jackins. (Abs.).....	49
— — — colour measurement. M. Muro M.		James. (Abs.).....	175	— — — prevention. E. F. Copley. (Abs.)	78
and C. Silverio R. (Abs.).....	125	— — — sugar expansion. (Brev.).....	320	— — — R. P. Humbert. (Abs.).....	300
— — — prediction from raw sugar colour.		— — — weather and irrigation. K. C.		— — — T. Linedale. (Abs.).....	270
D. F. Charles. (Abs.).....	283	Levington and D. R. Ridge.	49	— — — H. S. Pinks. (Abs.).....	50, 272
— — — flocc determination. R. R. Johnson.	249	Rum: distillery column scale reduction.		— — — S. R. Simmons and A. D. Do-	
— — — crystal growth. Malczewski. (Abs.)	249	J. Navarro and J. Piñol. (Abs.).....	285	— — — zenko. (Abs.).....	337
— — — length and width dissolution rates.		— — — manufacture. W. H. Kampen. (Abs.)	190	— — — J. D. Veurman. (Abs.).....	48, 77
L. Carrazana R. et al. (Abs.)	124	— — — Rumania: beet agriculture. Anon.....	149	— — — J. Wright. (Abs.).....	331
— — — size control. R. Esparza. (Abs.)	219	— — — new sugar factories. (Brev.).....	64	— — — effect of defoliation. H. C.	
— — — flocc determination. R. R. Johnson.	249			— — — Tulang and J. W. Bedish.	80
— — — formation. E. J. Roberts et al.	326			— — — with rye. W. J. A. Ascrott-Leigh	242
— — — fluidized bed treatment. L. Neuzil				— — — exchangeable sodium and hydraulic	
and E. Kostelková. (Abs.).....	218			— — — conductivity. M. A. Johnston.	174
— — — pesticide residue determination. T.				— — — factors effect on fertilizer utilization.	
Milč. (Abs.).....	156			— — — H. J. Müller. (Abs.).....	274
— — — physico-chemical properties in Egypt.				— — — filter cake application. G. Vernois	381
M. A. Mohamed et al. (Abs.).....	355			— — — fungl. M. H. Wu et al. (Abs.).....	336
— — — standard in India. A. C. Chatterjee	317			— — — and cane growth. S. M. Yang.	113
— — — uses. M. J. Kott. (Abs.).....	58			— — — effect of lime and green manure.	
see also Icing sugar; Liquid sugar;				— — — C. C. Chao and M. H. Wu.	336
Tablet sugar and White sugar				— — — hardpan. P. Lefevre. (Abs.).....	304
Refinery: bone char kiln in Colombia	286			— — — in India. S. K. Ojha et al. (Abs.)	238
in Canada. Anon. (Brev.).....	235			— — — liming and beet yield. Anon. (Abs.)	83
closure in Japan. (Brev.).....	127			— — — cent. R. Vanstellen. (Abs.).....	83
— — — U.S. (Brev.).....	256			— — — effect on cane. L. E. Golden. (Abs.)	112
— — — continuous melter. S. Bouček and				— — — micronutrients. J. E. Bowen.	210
V. Valter. (Abs.).....	123			— — — micro-organisms and nitrification.	240
— — — energy consumption. M. Ryevkin	57			— — — effect of inhibitor. Anon. (Abs.)	240
equipment history. A. N. Dul'dier	123			— — — monitoring stations in Australia. A.	
and D. K. Dunaevskii. (Abs.).....	123			— — — Ford. (Abs.).....	271
— — — modifications. Technical Staff,				— — — in Morocco. G. Schmidt. (Abs.)	82
CSH Ltd. (Abs.).....	57			— — — mulching with bagasse. Anon. (Abs.)	80
— — — in Iraq. J. Molenda and W. Lekawski	120			— — — quality. J. C. P. Chen and R. W.	
van vacuum crew. M. L. Vaisman	254			— — — Picou. (Abs.).....	150
Philippines. (Brev.).....	254			— — — polyethylene. S. Rau and E. W.	
— — — process algorithm construction for				— — — Millard. (Abs.).....	175
computer programmes. H. L.				— — — trash and cane borer damage.	
Fernandes. (Abs.).....	190			— — — Anon. (Abs.).....	240
— — — processes at Vancouver. K. M. Foo	57			— — — — — incidence. A. Schaaf. (Abs.)	110
raw sugar weighers. W. L. Reed.	57			— — — — — yield. B. K. Mathur. (Abs.)	239
— — — steam and power generation. E. G.				— — — — — and nutrients. H. H. Hagihara	80
Clarke. (Abs.).....	57			— — — nutrient availability and determina-	
— — — utilization. J. D. Ryan. (Abs.)	57			— — — tion. H. Hartl. (Abs.).....	21
— — — strikes in Canada. (N.C.).....	98			— — — effect of filter cake. L. E. Golden	114
— — — Sudan project. (Brev.).....	237			— — — — — lime. C. von Kessel. (Abs.)	115
— — — U.S. Anon. (Abs.).....	123			— — — extraction by cane. H. J. Andreis	91
— — — valves. Anon. (Abs.).....	214			— — — — — F. A. Fogliata. (Abs.).....	79
— — — waste water treatment. K. Kaishi-				— — — particles and drip irrigation tube	
mura and Y. Yoshida. (Abs.).....	154			— — — plugging. B. McElhose and W.	
— — — R. L. Knecht et al. (Abs.).....	57, 123			— — — Gibson. (Abs.).....	80
— — — S. Tanigaki et al. (Abs.).....	154			— — — phosphorus fixation. E. P. Sahn et al.	272
Refining. A. Rossi. (Abs.).....	314			— — — G. D. Thompson. (Abs.).....	15
— — — cane sugar in U.S. beet sugar				— — — and potassium determination. W.	
production. (N.C.).....	194			— — — Köster. (Abs.).....	307
— — — chloride ion-selective electrode applica-				— — — pollution reduction. A. Szalinski. (Abs.)	90
tions. C. R. Brown and P.	283			— — — preparation and cane extraneous	
Pommez. (Abs.).....	93			— — — matter. F. N. Bolton. (Abs.).....	147
— — — colorant formation. I. F. Bugaenko	93			— — — properties and beet yield. I. Gutm-	
— — — F. G. Carpenter and E. J. Rob-	251			— — — anski. (Abs.).....	276
erts. (Abs.).....	251			— — — effect of cane agriculture. N. R.	
— — — defeco-melt phosphotation. A. C.				— — — Maclean. (Abs.).....	51
Chatterjee. (Abs.).....	317			— — — continuous cane cropping. Anon.	206
— — — effect of silicon. M. A. Clarke. (Abs.)	283			— — — herbicide performance. D.	
— — — liquor carbonation. I. Galbán	314			— — — Traveller and J. E. Hull.	305
— — — R. T. Mischeuk and A. Y.				— — — research in Australia. Anon. (N.B.)	58
Zaguriko. (Abs.).....	219			— — — South Africa. Anon. (N.B.).....	59
— — — J. P. Murray and E. M. Rungger				— — — salinity and beet seedling emergence.	
— — — and decolorization. T. Yamane				— — — K. D. Beatty and C. F. Ehlig.	19
and H. Asai. (Abs.).....	154			— — — cane yellow wilt. A. G. Hayes.	143
— — — effect of starch. E. Whayman				— — — sandy land and cane yield. G.	
and A. L. Willersdorf. (Abs.).....	99			— — — Dodgen. (Abs.).....	179
— — — regenerated lime. S. Omori.	154			— — — silicon and beet tops quality. G. H.	
— — — clarification. F. G. Carpenter and				— — — Francis. (Abs.).....	126
M. A. Clarke. (Abs.).....	123			— — — availability determination.	
— — — J. A. Duenas. (Abs.).....	314			— — — Hayson and L. S. Chapman.	50
— — — and decolorization. (T.N.).....	286				
— — — flocculation aid.....	66, 96				

INDEX

	PAGE		PAGE
Soil: straw incorporation. Anon. (Abs.)	371	Steam: air content and heat transfer.	248
— structure and can. growth. P. R. Downs. (Abs.)	78	— cane set treatment for ratoon stunting disease control. L. L. Lauden	16
— potassium, calcium and chloride contents. R. P. DeStefano	178	— treatment and colour formation in juice and sugar. N. H. Smith	252
— and treatment. R. VanStallan	371	condensate entrainment reduction. V. V. Dovygool <i>et al.</i> (Abs.)	349
subsoiling. G. Spoor. (Abs.)	305	consumption in alcohol manufacture. A. C. Chatterjee and B. M. Dutt	57
surface irregularities and beet planting. C. de Zanche and G. Baraldi	336	— in factory and refinery. M. Rychkun. (Abs.)	150
tidal land reclamation in Taiwan. J. F. Williams. (Abs.)	80	— white sugar manufacture. S. Ortega. (Abs.)	84
tillage reduction effects. N. Zozef type and nematode development. E. D. Whitney and D. L. Doney	276	evaporator requirements calculation. P. G. Wright. (Abs.)	217
water and beet leaf miner incidence. M. Kubacka-Smidtgen. (Abs.)	306	factory requirements. M. L. Vaisman <i>et al.</i> (Abs.)	57
— seed germination. P. Kolago	276	generation efficiency. E. G. Clarke	214
— herbicide performance. Anon.	238	— effect of Green's economizer. R. P. Mittal. (Abs.)	377
— holding capacity. P. Y. Chan and L. Li Pi Shan. (Abs.)	300	— oil consumption. P. Hristodoulou	246
— reduction and cane yield and quality. M. V. Rao and S. H. Rao. (Abs.)	177	heat upgrading for evaporation. A. Pénys. (Abs.)	342
— table height and cane yield. C. E. Carter and M. Floyd. (Abs.)	76	incondensable gases and evaporator vacuum. V. N. Gorokh and K. O. Shtangeev. (Abs.)	214
zinc extraction. M. M. Kao and T. C. Juang. (Abs.)	370	injection in boiling and massenauic circulation. G. Aleman. (Abs.)	215
see also Fertilizers; Irrigation and Pests	219	— centrifugals. D. Ahari and J. Genotelle. (Abs.)	376
Sorghum: leafhopper hosts. R. Outridge and D. S. Teakle. (Abs.)	32, 384	— sugar solution heat transfer. S. M. Konstantinov and N. N. Bezpalko. (Abs.)	85
— liquid sugar manufacture. N. Marinetti. (Abs.)	175	output of bagasse boiler. J. M. Stewart and W. B. Crawford	315
South Africa: bagasse paper manufacture. (Bt.)	240	premixer feed automatic control. A. O. Maylott and J. W. deGolis	217
cane breeding. R. S. Bond. (Abs.)	79	pressure effect on crystallization in boiling. V. O. Shtangeev <i>et al.</i>	291
— mechanical harvesting. S. W. D. Baxter. (Abs.)	175	stripping still for condensate alcohol removal. J. D. Blake <i>et al.</i>	247
— and new varieties. G. Thompson. (Abs.)	23	traps. A. I. Khomenko. (Abs.)	119
— varietal trials. D. B. Hellmann	59	turbine failures. S. S. Shukla. (Abs.)	86
— research at SMRI. J. Brujin. (Abs.)	159	— power generation. S. V. Wildman and T. J. Goldsmith. (Abs.)	54
Sugar Association Experiment Station. Anon. (N.B.)	155	turbo-alternator governing and power flow control. R. J. Keltz. (Abs.)	122
— industry. (Ft.)	282	utilization optimization. A. Kubasiewicz <i>et al.</i> (Abs.)	57
— production. G. B. Hagsberg	64	— in refinery. J. D. Ryan. (Abs.)	158
— statistics. (Stat.)	49	see also Boilers; Furnaces; Bagasse; Heat and Power	158
— year book 1974-75. Anon. (N.B.)	282	Storage: bagasse. Anon. (Abs.)	60
Tongaat Group Ltd. Report. (Abs.)	64	beet brei. M. Burba <i>et al.</i> (Abs.)	381
trade agreement with Japan. (Brev.)	378	— pulp. H. Schnelle. (Abs.)	358
weather and irrigation. K. C. Leverington and D. R. Ridge. (Abs.)	258	— N. M. Tkachenko. (Abs.)	181
Spain: beet and cane agriculture. Anon.	192	— bin capacity calculation. M. G. Parfenopulo and N. E. Karulov. (Abs.)	61
sugar production. (N.C.)	67	— and sugar explosion hazards. G. P. Dirks. (Abs.)	316
Sri Lanka sugar development plans	157	— thick juice. Anon. (Abs.)	88
Starch: components and iodine complex spectra. E. Whyman and A. L. Willersdorf. (Abs.)	157	— T. P. Khvalkovskii <i>et al.</i>	56
content and alpha-amylase activity in cane. G. K. Sayed <i>et al.</i> (Abs.)	157	— M. Moore and J. Karr. (Abs.)	120
— in cane. effect of deterioration after harvesting. G. el-K. Sayed <i>et al.</i> (Abs.)	156	— E. Reinefeld. (Abs.)	57
determination in cane sugar factory products. G. K. Sayed <i>et al.</i>	99	— M. Rychkun. (Abs.)	279
— in condensate. Y. Takatori <i>et al.</i>	286	— O. I. Shepel'skii <i>et al.</i> (Abs.)	249
effect on carbonatation. E. Whyman and A. L. Willersdorf.	213	— pipeline pressure loss calculation. E. Manzke and S. Lier. (Abs.)	279
— raw sugar filtrability. C. C. Chou	150	— properties. P. K. Kichigin <i>et al.</i> (Abs.)	93
— M. Shafti and R. Samaniego	44	— cane molasses Brix variation. P. Mellet. (Abs.)	213
elimination. (T.N.)	314	— mechanism. N. A. Emel'yanov	375
— from cane juice. Anon. (Abs.)	160	molasses degradation. A. D. Kovalenko. (Abs.)	285
— G. el-K. Sayed <i>et al.</i> (Abs.)	287	— effect on citric acid manufacture. J. Kovats and Z. Niestrawski.	245
isolation from cane and iodine affinity. J. C. Stevenson and E. Whyman	255	raw sugar, colour formation prevention. L. Bobrovnik <i>et al.</i> (Abs.)	314
occurrence, effect and elimination. J. B. Alexander and M. Matic.	159	refined sugar. A. Rossi. (Abs.)	376
Statistics: Argentina sugar	96	— limestone and beet pulp. N. M. Kichigin <i>et al.</i> (Abs.)	375
Australia sugar exports	254	Storage. Beet. N. M. Kichigin <i>et al.</i>	25
Barbados sugar	287	J. Orłowska. (Abs.)	24
Belgium/Luxembourg sugar imports and exports	288	— beet cooling rate. F. W. Bakker	121
Brazil sugar exports	192	Arkema <i>et al.</i> (Abs.)	24
Chile sugar	352	— damage. V. I. Vasil'ev and N. M. Kichigin. (Abs.)	281
— imports	256	— and losses. R. de Vletter and F. van Gils. (Abs.)	122
Cuba sugar exports	352	— F. Kapol. (Abs.)	281
Dominican Republic sugar	254	— properties determination. J. Hobbs and L. Batterman. (Abs.)	83
Europe beet area 1976	256	— effect of agronomic factors. M. Martens. (Abs.)	280
EUJ sugar	352	— reclamation by bucket wheel. M. Barre. (Abs.)	376
Finland sugar imports and exports	96	— economics. I. B. Romashevich and V. A. Novikov. (Abs.)	376
Greece sugar imports	254	effect on beet sugar yield. Y. D. Golovnyak <i>et al.</i> (Abs.)	217, 248
Guatemala sugar exports	288	— extraneous matter. Anon. (Abs.)	181
Holland sugar imports and exports	192	field clamp cover. D. Charlesworth	82
Hungary sugar imports	32	— protection against frost. A. Vigoureux. (Abs.)	215
India sugar exports	128	— sifting and loading. M. Maszycki	215
Jamaica sugar	256	in France. J. N. Doucraïn. (Abs.)	319
Mauritius sugar	64, 159		383
Norway sugar imports	384		
Philippines sugar exports	32		
Poland sugar exports	128		
Salvador sugar exports	256		
South Africa sugar imports and exports	32		
Taiwan sugar exports	319, 95, 223, 319		
Thailand sugar exports	383		
Trinidad sugar exports	319, 95, 223, 319		
UK sugar imports and exports	383		
Uruguay sugar imports and exports	383		
US sugar imports	383		
USSR sugar imports and exports	383		
world sugar production 1975/76	383		
— 1976/77	383		

INDEX

	PAGE		PAGE		PAGE
Sugar: classification in fluidized bed. L. Neuzil and L. Brož. (Abs.)	246	Sugars: kestose effect on sugar determination by polarization. G. W. Maag and G. H. Sisler. (Abs.)	250	Thailand: sugar exports. (Stat.)	64, 159
colorants. V. Prey and H. Wesner. (Abs.)	91, 93	- preparation and analysis. J. Brujin monosaccharide degradation in bagasse hydrolysis. H. Kollner and R. Lopez P. (Abs.)	222	- industry. P. Abdubhan and K. Suksupha. (Abs.)	266, 297
consumption in EEC. (N.C.)	354	- ratio and acid beverage flocculation. E. J. Roberts <i>et al.</i> (Abs.)	326	- production 1975/76. (Brev.)	226
content in beet root, crown and collar. K. Fábian and J. Kollár. (Abs.)	188	- separation. I. I. Gavriluk. (Abs.)	158	- situation. (Brev.)	96
- cane molasses. E. F. Unsworth and P. O. Ousji. (Abs.)	349	- M. Hoton-Dorge. (Abs.)	348	- white leaf-resistant cane variety. Togo sugar group Ltd. report 1976	64
- condensate. J. D. Blake. (Abs.)	131	- see also Dextrose; Fermentation; Invert sugar; Levulose; Polysaccharides; Raffinose; Reducing sugars and Sucrose		Trade Notices: Alumina Co. Ltd.	62
crystal granulometry determination. L. Carranza H. and A. P. Kozaykin. (Abs.)	251	Sulphitation: compared with carbonatation for white sugar manufacture. L. D. Bobrovnik and L. P. Kotelnikova. (Abs.)	152	Babecock	62
- effect of raffinose. F. Devillers <i>et al.</i> (Abs.)	249	- M. Cordoves <i>et al.</i> (Abs.)	117	David Brown Gear Industries Ltd.	59
- cane molasses. E. C. Vignes. (Abs.)	220	- juice sulphite determination, effect of nitrite. R. B. Lew. (Abs.)	250	Claas Maschinenfabrik GmbH	52
- factory products. A. Y. Zagorul'ko <i>et al.</i> (Abs.)	316	- white sugar manufacture. S. Ortega	150	Ewart Chainbelt Co. Ltd.	286, 350
dryer. W. Stankiewicz <i>et al.</i> (Abs.)	342	Surface-active agents: in boiling. K. Číž <i>et al.</i> (Abs.)	218	Fabcon International Inc.	286
economic policy book 1975/76. (N.C.)	59	- Y. G. Ropotenko <i>et al.</i> (Abs.)	88	J & L/Honlon Engineering Co. Inc.	350
Dankowski <i>et al.</i> (N.B.)	59	- and raw sugar yield and colour. N. L. C. Suzor. (Abs.)	309	May & Baker Ltd.	350
effect on human diet and health. Anon. (N.B.)	282	foam reduction in beet diffusion. V. N. Borzdaya <i>et al.</i> (Abs.)	87	Arthur G. McKee & Co.	350
explosions. G. P. Dirks. (Abs.)	310	manufacture from sugar. (N.C.)	66	Rudolph Research	286, 350
exporters' meetings. N. C. (3)	258	N. L. C. Suzor. (Abs.)	191, 256	Poly Filters Inc.	62
handling. N. M. Kichigin <i>et al.</i> (Abs.)	375	Swaziland sugar project. (N.C.)	162	Sartorius-Membranfilter GmbH	62
heavy metals determination. N. M. Morris <i>et al.</i> (Abs.)	380	Sweden: sugar imports 1975. (Brev.)	98	Serck Water Processing	62
Industry Technologists Inc. meeting 1976.	127, 235	- production 1975/76. (Brev.)	256	Scaleway Tools & Equipment Ltd.	350
international economic yearbook and directory 1975. H. Ahlfeld. (N.B.)	59	tablet sugar manufacture. Anon.	232	Stord Bartz Industri A/S.	350
loss calculation. A. R. Saprnonov and R. A. Kolcheva. (Abs.)	60	A. Birch-Iensen. (Abs.)	311	Shell International Chemical Co. Ltd.	62
market in Hong Kong. (Brev.)	30	Switzerland: sugar imports 1975. (Brev.)	192	Stork-Amsterdam B.V.	350
melter. A. Acosta. (Abs.)	119	- production 1975/76. (Brev.)	192	Tate & Lyle Engineering Ltd.	350
- automatic Brix control. Anon.	25	Syria new sugar factory. (Brev.)	64	Tate & Lyle Enterprises Ltd.	286
melting. V. Urban. (Abs.)	219	Syrup analysis. M. Kiely and M. O'Sullivan. (Abs.)	317	Thames Packaging Equipment Co.	62
minor constituents determination. M. A. Godshall and E. J. Roberts	283	- R. Lees. (N.B.)	282	Unice Machine Co.	62
moisture determination. F. Schneider <i>et al.</i> (Abs.)	93, 249	back-boiling control by chloride ion-selective electrode. C. R. Brown and B. Pomme. (Abs.)	283	Wyssmont Co. Inc.	62
pesticide residues determination. M. Kiely and M. O'Sullivan. (Abs.)	317	Brix and temperature automatic control. S. Bouček and V. Valter.	87	Transport: beet pulp, effect of vibrations. M. G. Parfenopulo and N. E. Karauy. (Abs.)	61
- A. Z. Usmentseva <i>et al.</i> (Abs.)	93, 347	colour measurement. M. Muro M. and C. Silvera. (Abs.)	125	- N. E. Karauy. (Abs.)	61
quick-dissolving sugar manufacture. M. Pietrzak. (Abs.)	280	- removal. D. Hervé. (Abs.)	56	molasses. A. C. Chatterjee and M. B. Dutt. (Abs.)	381
solution colorant extraction. F. G. Carpenter and E. J. Roberts. (Abs.)	251	- J. J. Ungar and R. Lumbroso.	215	- J. Freivalds. (Abs.)	190
- crystal content and crystallization rate. J. Malczewski. (Abs.)	316	- sucrose losses. S. A. Brennan <i>et al.</i> (Abs.)	249	noise reduction. G. Navarre. (Abs.)	117
- fermentation and alcohol manufacture. A. Ramalingam and R. K. Finn. (Abs.)	61	dextran reduction. P. Hill and R. Staker. (Abs.)	85	sugar bulk carriers. N. M. Kichigin <i>et al.</i> (Abs.)	185
- flocciposition. E. J. Roberts and F. G. Carpenter. (Abs.)	283	high-fructose corn syrup production in EEC. (N.C.)	257, 321	- containization. Anon. (Abs.)	277
- flow measurement. V. P. Klochkov <i>et al.</i> (Abs.)	93	invert sugars behaviour. V. S. Velasco and P. Dowling. (Abs.)	284	syrrup. E. E. Belokni' and V. K. Sevryuk. (Abs.)	248
- heat transfer. effect of pulsed flow. I. M. Fedotkin and I. V. Kosminski. (Abs.)	281	lime salts determination. I. G. Kalinenko. (Abs.)	156	white sugar carrier. N. M. Kichigin <i>et al.</i> (Abs.)	376
- molar concentration calculation. D. E. Sinat-Radchenko <i>et al.</i>	346	yield, effect of beet diffusion water - masses yield of pulp. Anon. V. A. Pugachev <i>et al.</i> (Abs.)	278	Transport, Beet. C. Heller. (Abs.)	21
- thermo-physical properties calculation. D. E. Sinat-Radchenko and V. D. Popov. (Abs.)	376	starch determination. G. el-K. Sayed <i>et al.</i> (Abs.)	157	automatic tallage openers. G. A. Sauer. (Abs.)	211
storage. V. I. Vasil'ev <i>et al.</i> (Abs.)	157	storage. F. Cordoves Z. (Abs.)	213	effect on beet storage and processing quality. M. Martens. (Abs.)	83
surface-active agent manufacture. technology consultancy firm in Barbados. (Brev.)	169	transport. E. E. Belokni' and V. K. Sevryuk. (Abs.)	248	groups. D. Charlesworth. (Abs.)	371
trace metals determination. S. L. Sang <i>et al.</i> (Abs.)	346	treatment with calcium saccharate. J. Degeest <i>et al.</i> (Abs.)	55, 121	loading. M. Mawby. (Abs.)	82
world balance 1975/76. (N.C.)	97, 225, 321	see also Invert sugar; Juice, Beet; Liquid sugar and Refining		- unloading and beet damage. V. I. Vasil'ev and N. M. Kichigin.	121
- economy. G. B. Hagebel. (N.B.)	345	Tablet sugar: manufacture. Anon.	232	unloading and beet damage. V. I. Vasil'ev and N. M. Kichigin.	121
- expansion plans. H. Ahlfeld.	282	- A. Birch-Iensen. (Abs.)	311	Unloading and beet damage. V. I. Vasil'ev and N. M. Kichigin.	121
- production. G. B. Hagebel.	155	- F. X. Kammerer. (Abs.)	343	Transport, Cane. H. T. E. Smith. (Abs.)	79
- 1975/76. 1, 31, 65, 95, 194, 223, 289	319	price in Nigeria. (N.C.)	66	R. B. V. Toledo. (Abs.)	80
- 1976/77.	353, 383	Taiwan: bagasse fire. (Brev.)	64	canal planning. A. I. Linedale	78
year book 1974. Anon. (N.B.)	59	bulk handling terminal. H. J. Chen	23	containization. Anon. (Abs.)	111, 336
yield from beet, prediction. P. Devillers <i>et al.</i> (Abs.)	60	Yang. (Abs.)	367	J. Giardina. (Abs.)	177
- and pot calculation. B. Rodriguez C. <i>et al.</i> (Abs.)	118	- breeding. I. S. Shen. (Abs.)	367	in Cuba. J. Vázquez. (Abs.)	114
see also Bulk handling; Bulk storage; Crystallization; Liquid sugar; Polarization; Prices; Raw sugar; Refined sugar; Sucrose and White sugar		- mechanical planting and harvesting. Anon. (Abs.)	367	delays. R. G. Hoekstra. (Abs.)	151
Sugars: behaviour in invert syrup. V. S. Velasco and J. F. Dowling.	284	- pest and disease research. Y. S. Pan. (Abs.)	367	green cane. J. B. Orenigo. (Abs.)	179
cane leaf dew. J. E. Irvine. (Abs.)	177	- transport. Anon. (Abs.)	367	Marshall. (Abs.)	81
determination. S. A. Hansen. (Abs.)	157	clarifier pilot plant (Brev.)	76	infield, order from Iran. (Brev.)	286
- M. A. Jerny. (Abs.)	317	effective rainfall. H. Chu <i>et al.</i> (Abs.)	76	performances and costs. J. L. Gentili	58
- S. E. Kharin <i>et al.</i> (Abs.)	125	irrigation well construction. Y. Chu	256	railway maintenance "sled". G. B. Hansen. (Abs.)	335
- L. C. Linden. (Abs.)	28	sugar exports. (Stat.)	256	- standards. R. N. Cullen and R. A. James. (Abs.)	335
- D. Nurok and J. T. Readon. (Abs.)	189	- factories. Anon. (Abs.)	374	- train handling. W. J. Greenwood and J. B. Hayes. (Abs.)	51
- in beet. J. Hobbs and L. Batterman. (Abs.)	92	- research and development. C. J. Lu. (Abs.)	374	- running simulation. E. E. Shepherd. (Abs.)	51
- condensate. Y. Takatori <i>et al.</i>	156	tidal land reclamation. J. F. Williams	336	simulation and cost analysis. B. J. Cochran and R. W. Whaney.	208
- molasses. A. Borys and S. J. Kubacki. (Abs.)	157	Tanzania: Msolwa sugar factory production 1974/75. (N.C.)	34	in Taiwan. Anon. (Abs.)	367
dextrose isomerization. S. Fujii <i>et al.</i>	123	sugar plants. (Brev.)	351	trailer. A. G. de Beer. (Abs.)	302
disaccharide formation by micro-organism. W. Mauch and P. el Aama. (Abs.)	284	Verenigde HVA-Mij. N.V. report 1975. (Brev.)	288	- brakes. Anon. (Abs.)	366
		Tate & Lyle Ltd.: acquisition of Manbré & Garlon Ltd. (N.C.)	257, 322	- pivot steer unit. Anon. (Abs.)	47
		beet sugar factory and refineries. E. Lewis. (N.B.)	345	in US. J. E. Clayton and B. R. Eiland. (Abs.)	369
		new company formed. (Brev.)	127	vehicle number requirements calculation. T. C. Ripoli and L. A. Balastreire. (Abs.)	368
		report 1975. (N.C.)	66	Trinidad: cane varieties. Anon. (Abs.)	239
		sugar factory order from Venezuela	224	Caroni Ltd. nationalization. (Brev.)	255
		Swaziland sugar project. (N.C.)	162	- report 1975. (Brev.)	30
				sugar exports. (Stat.)	384
				Turbidity: cane juice, effect of surface-active additive. N. L. C. Suzor	309
				- molasses Brix determination. P. Mellet. (Abs.)	93
				dextran determination in beet juice. A. Borys. (Abs.)	284
				removal for colour determination. A. Y. Zagorul'ko and L. A. Korobeynikova. (Abs.)	316
				Turkey: new sugar factories. (Brev.)	63, 351
				sugar expansion. (Brev.)	351
				Union of Soviet Socialist Republics: aid to Cuban sugar industry. (Brev.)	127
				beet agriculture and delivery improvements. (Brev.)	287

INDEX

	PAGE
Union of Soviet Socialist Republics: beet payment M. Bel'ko and F. I. Khamaza. (Abs.).....	52
- production 1974. (N.C.).....	33
- 1975. (N.C.).....	129
- plans. (Brev.).....	191
new sugar factories. (Brev.).....	191
refining. Y. Y. Lazhe. (Abs.).....	123
sugar imports. (N.C.).....	130
- and exports. (Stat.).....	320
industry. J. Moragha. (Stat.).....	320
Zhablinka sugar factory. G. I. Bel'ko et al. (Abs.).....	378
United Kingdom: beet area 1976. (N.C.).....	65
- demonstrations. (Brev.).....	254
- price 1977. (N.C.).....	322
- research station open day. (Brev.).....	255
- sugar producers vs. cane sugar refiners. (N.C.).....	194
- varietal trials. D. S. Kimbor and S. F. H. McCullagh. (Abs.).....	371
- L. A. Willey and S. F. H. McCullagh. (Abs.).....	82
raw sugar imports. (N.C.).....	66
refining rationing. (N.C.).....	257
sucrochemistry seminar. (Brev.).....	63
Sugar Board annual report 1974.....	33
- dissolution. (Brev.).....	32
- payments 1975. (N.C.).....	193
- imports and exports. (Brev.).....	97
- industry. F. Lewis. (N.B.).....	145
- production 1975/76. (Brev.).....	328
- 1976/77. (Brev.).....	352
see also British Sugar Corporation Ltd.; Europe, EEC and Tate & Lyle Ltd.	
United States of America: Association of Official Analytical Chemists meeting 1976. (Brev.).....	127
beet seed production. R. C. Zielke - sugar production. G. B. Hagelberg - varietal trials. R. C. Zielke. (Abs.).....	375
- yellow wilt resistance testing. (Abs.).....	364
cane - mechanical harvesting and transport. J. E. Clayton and B. R. Eiland. (Abs.).....	369
Colorado sugar beet production. (Brev.).....	96
fluoculation for use in refining. (Brev.).....	320
Florida cane breeding. (Brev.).....	320
- C. E. Freeman and R. L. Walker. (Abs.).....	114
- mechanical harvesting. J. E. Clayton and W. C. Hedrick.....	144
- varieties. B. J. Bourne. (Abs.).....	112
- E. H. Todd. (Abs.).....	142
- sugar industry. J. Thielens.....	119
- production 1975/76. (Brev.).....	352
Georgia Savannah refinery. (Abs.).....	123
Gilmore sugar manual. C. M. McKay International Sugar Agreement participation. (N.C.).....	128, 161, 353
Louisiana cane breeding. (Brev.).....	364
- R. D. Breaux. (Abs.).....	113
- P. H. Dunckelman. (Abs.).....	145
- P. H. Dunckelman and M. A. Blanchard. (Abs.).....	207
- L. L. Lauden. (Abs.).....	365
- harvesting. R. C. Hodson and B. Legendre. (Abs.).....	16
- payment. E. S. Birkett and J. J. Scip. (Abs.).....	188
- varieties. Anon. (Abs.).....	176
- L. L. Lauden. (Abs.).....	114
- R. J. Mathere et al. (Abs.).....	208
- testing. H. P. Fungy and M. J. Giamalva. (Abs.).....	113
- C. A. Richard and M. J. Giamalva. (Abs.).....	176
- fertilizer recommendations. Anon. 16, 302 - St. James factory performance. F. A. Graugnard. (Abs.).....	150
- sugar factory closure. (Brev.).....	191
- production 1975. (Brev.).....	191
- research. J. J. Seip and P. L. Gayle. (Abs.).....	150
Maine sugar factory re-opening.....	351
Maryland cane quarantine. A. G. Gillespie and C. M. Krew. (Abs.).....	142
Minnesota new sugar factories.....	56, 127
New York refinery closure. (Brev.).....	256
North Dakota Hillsboro and Wahpeton factories. Anon. (Abs.).....	56, 312
raw sugar imports. (N.C.).....	322
sugar exports. (Brev.).....	154
- imports 1975.....	162, 191
- machinery company. (Brev.).....	191
- situation. (N.C.).....	98
Texas cane damage by frost. K. A. Sund and B. A. Smith. (Abs.).....	146
and world raw sugar prices chart.....	224
see also Hawaii	
Uruguay: beet sugar technologists meeting. (Brev.).....	384
sugar factory plans. (Brev.).....	192
- statistics. (Stat.).....	63
Valves. Anon. (Abs.).....	214
irrigation tube flushing. W. Gibson and U. Bul. (Abs.).....	369
milk-of-lime feed control. M. P. Klepal'chenko. (Abs.).....	311
pan vapour pipe, automatic control. E. Batule and A. Rodriguez. (Abs.).....	308

Varieties, Beet: ash content. V. Stehlik and L. Schmidt. (Abs.).....	242
- blackroot resistance and yield assessment by photography. C. L. Schneider and G. R. Sair. (Abs.).....	181
- East Germany. (Brev.).....	64
- fruit properties, effect of immaturity and moisture adsorption. F. W. Snyder. (Abs.).....	116
- performance assessment. (Brev.).....	276
- processing quality. M. V. Khelenski et al. (Abs.).....	52
- seed germination, effect of moisture. P. Kolago. (Abs.).....	306
- seedling leaf and root growth. F. W. Snyder. (Abs.).....	212
- sodium, potassium and amino-N contents. E. Borscheuer. (Abs.).....	21
- sowing time, irrigation and yield. K. Singh et al. (Abs.).....	211
- storage losses. W. Trzcinski and E. Bakowska. (Abs.).....	279
- trials in Austria. A. Graf. (Abs.).....	274
- Belgium. N. Roussel et al. (Abs.).....	339
- Czechoslovakia. L. Karaman.....	243
- L. Schmidt et al. (Abs.).....	52, 305
- Hungary. L. Lukacs and J. Zana.....	244
- India. K. S. Parasar. (Abs.).....	116
- UK. D. S. Kimbor and S. F. H. McCullagh. (Abs.).....	371
- L. A. Willey and S. F. H. McCullagh. (Abs.).....	82
- US. R. C. Zielke. (Abs.).....	371
- triploid root potassium absorption. G. C. Lucci. (Abs.).....	338
- yellow wilt resistance testing in US yield, effect of sowing and harvesting dates. S. Singh et al. (Abs.).....	181
see also Beet breeding	
Varieties, Cane: assessment from crop data. A. B. Tucker. (Abs.).....	175
- in Australia. J. P. Crocker. (Abs.).....	331
- C. A. Rehbein and M. J. Braithwaite. (Abs.).....	47
- T. G. Willcox. (Abs.).....	209
- borer susceptibility. B. S. Kooner et al. (Abs.).....	333
- C. E. F. Pereira et al. (Abs.).....	331
- Brazil. A. I. Bassinello. (Abs.).....	210, 368
- cane development and yield. J. E. Irvine. (Abs.).....	113
- C. O. 1157. B. K. Mathur. (Abs.).....	219
- Co 6613. B. S. Mathur. (Abs.).....	208
- CoJ 64. R. S. Kanwar and S. Singh CoS 659. B. K. Mathur and H. H. Ram. (Abs.).....	271
- correction factor in milling performance calculation. G. Arceneaux.....	86
- CP 46-357. H. P. Fungy. (Abs.).....	145
- H. Robichaux. (Abs.).....	76
- deterioration after frost. J. D. Miller and G. J. Gascho. (Abs.).....	290
- harvesting. Anon. (Abs.).....	238
- R. S. Kanwar and J. K. Kapur.....	358
- N. Ramamoorthy et al. (Abs.).....	220
- Dominican Republic, Guyana and West Indies. Anon. (Abs.).....	239
- drought resistance. O. Brinholi and O. P. Godoy. (Abs.).....	210
- effects on soil nutrients. H. J. Andreis. (Abs.).....	91
- eye spot resistances. J. D. Miller.....	145
- frogopper resistance testing. E. J. Marques. (Abs.).....	210
- frost damage and resistance. J. C. P. Chen and J. J. S. Chen. (Abs.).....	53
- effects. K. A. Sund and B. A. Smith. (Abs.).....	146
- resistance. O. Brinholi et al. (Abs.).....	241
- F. A. Martin et al. (Abs.).....	189
- J. D. Miller. (Abs.).....	303
- gur manufacture. D. N. Gupta and R. Singh. (Abs.).....	271
- herbicide tolerance testing. S. Y. Peng. (Abs.).....	238
- India. S. K. Ojha et al. (Abs.).....	241
- J. 69/3. Anon. (Abs.).....	303
- juice clarification differences. P. M. Fabregat and L. Gomez R. (Abs.).....	86
- N. V. Moron. (Abs.).....	118
- I. 60-14. M. Goronel et al. (Abs.).....	146
- lodging resistance evaluation. H. P. Viator and M. T. Henderson. (Abs.).....	178
- Louisiana. L. L. Lauden. (Abs.).....	114
- milling quality determination. L. P. Hebert. (Abs.).....	112
- mosaic susceptibility. N. Rishi et al. (Abs.).....	137
- testing. S. Matsunaka and A. K. Dodson. (Abs.).....	77
- N 52/210. Anon. (Abs.).....	17
- NA 56-62. J. G. da Silva. (Abs.).....	110
- NA 63-90. R. Fernandez de U....	238
- nematode resistance. L. G. Vallance nitrogen response. J. Mariotti and O. Gimenez L. (Abs.).....	302
- pest and disease resistance testing. R. Cesnik. (Abs.).....	210
- in Philippines. (Brev.).....	320
- in Puerto Rico. E. M. G. Esquerria potassium, calcium and chloride contents. R. P. DeStefano. (Abs.).....	178

Varieties, Cane:	
Q 80 susceptibility to damage by herbicides. H. L. Boyle. (Abs.).....	209
Q 87. C. L. Tooley. (Abs.).....	209
Q 90. Anon. (Abs.).....	332
Q 101 and eye spot. C. McAlaese.....	270
- raton stunting resistance. D. S. Teakle et al. (Abs.).....	144
- red rot reaction. D. B. Fontenot et al. (Abs.).....	113
- resistance. L. N. Pandey et al. (Abs.).....	208
- ripening differences. E. R. Rice.....	177
- sampling. J. C. Skinner.....	227
- sett germination, effect of chemical treatment. D. Eastwood. (Abs.).....	111
- fungicide and growth regulator. Anon. (Abs.).....	240
- heat treatment. M. L. Agarwal and S. C. Gupta. (Abs.).....	239
- herbicides. W. L. Maddan and E. M. Christie. (Abs.).....	110
- smut resistance. S. Muthusamy and S. Sithanatham. (Abs.).....	142
- S. Muthusamy et al. (Abs.).....	207
- K. J. Nuss. (Abs.).....	175
- S. S. Sandhu et al. (Abs.).....	273
- and crop profitability. N. W. Simmonds.....	329
- testing. S. J. Ladd et al. (Abs.).....	143
- in South Africa. G. Thompson. (Abs.).....	79
- stalk and top yield and composition. J. Deville and Y. Wong You Cheong. (Abs.).....	158
- sugar accumulation. Anon. (Abs.).....	239
- B. J. Mathere. (Abs.).....	113
- calculation. B. L. Legendre and M. T. Henderson. (Abs.).....	119
- L. Payan et al. (Abs.).....	23
- total leaf area estimation. J. E. Irvine. (Abs.).....	146
- trials in Barbados. Anon. (Abs.).....	238
- Brazil. M. M. de Melo and J. A. C. M. de Sa.....	270
- India. K. S. Parashar. (Abs.).....	333
- Réunion. Anon. (Abs.).....	77, 365
- C. H. de Fraise. (Abs.).....	167
- Rhodesia. G. L. James and M. J. South Africa. G. P. Heilmann.....	175
- US. H. P. Fungy and M. J. Giamalva. (Abs.).....	113
- C. A. Richard and M. J. Giamalva. (Abs.).....	176
- alva. (Abs.).....	112
- in US. E. J. Bourne. (Abs.).....	176
- Anon. (Abs.).....	208
- R. J. Mathere et al. (Abs.).....	142
- E. H. Todd. (Abs.).....	142
- white leaf resistance. (Brev.).....	64
- yellow spot resistance. B. T. Roach yield decline, effect of fungi. S. M. Yang. (Abs.).....	145
- effect of age and harvest.....	175
- J. E. Lonsdale and T. M. Gosnell.....	273
- fungicides. J. P. Singh et al.....	236
- stalk height and number. J. A. Mariotti and I. A. Turowski.....	341
- and nutrient uptake, effect of irrigation water salinity. Anon.....	266
- sugar content, effect of age, harvest time and climate. R. Julien et al.....	79
- harvest date. L. S. Chapman and C. Leverington. (Abs.).....	333
see also Cane breeding	
Venezuela: bagasse paper factory.....	256
new sugar factory. (Brev.).....	32
sugar factory order. (Brev.).....	224
- purchases. (Brev.).....	160
Verenigde HVA Mij. N.V.: report 1974 - 1975. (Brev.).....	288
Vinasse, see Distillery waste	
Viscosity: beet thick juice, effect of campaign length. M. N. Dadenkova et al. (Abs.).....	156
- pipeline pressure loss calculation. E. Manzke and S. Ller.....	279
- storage. T. P. Khvalkovskii et al. (Abs.).....	246
- cane molasses. L. Carrazana et al.....	251
- measurement. L. Carrazana and I. Machado L. (Abs.).....	125
- rheological properties and pumping date calculation. D. V. Bogen and G. Tur. (Abs.).....	245
carbonation mud rheological properties. Z. Kembrowski et al. (Abs.).....	88
effect on crystallizer power consumption. A. I. Gromkovskii et al. (Abs.).....	29
increase causes. G. Aleman. (Abs.).....	150
mascuite. K. Ciz. (Abs.).....	348
- in boiling. H. Thiele and A. Langen.....	246
- K. Wagnerowski. (Abs.).....	216
- determination. J. Schliepke and K. Austmeyer. (Abs.).....	55
- effect of clarification with magnetum oxide. J. J. Zwaardemaker. (Abs.).....	118
- crystals and mother-liquor properties. M. Awang and E. T. White. (Abs.).....	373
- reduction by pre-centrifuging. F. Amding. (Abs.).....	377
- sugar solution calculation. D. E. Sinat-Radchenko and V. D. Popov VMF-Stork annual report 1975. (Brev.).....	157

INDEX

	PAGE
Water: absorption by white sugar, effect of ash content. V. Mairand and G. Mantovani. (Abs.).....	55
ammonia determination and removal. P. Devillers <i>et al.</i> (Abs.).....	24
beet diffusion balance calculation. F. Kastner and Z. Pochlyly. (Abs.).....	24
condensate. A. I. Shapiro. (Abs.).....	246
disinfection. J. Herčík and V. Dachovsky. (Abs.).....	90
effect on juice. K. Magy. (Abs.).....	217
pH adjustment. K. Číž <i>et al.</i>	279
treatment. P. T. Dunsev <i>et al.</i>	216
N. V. Kulinič <i>et al.</i> (Abs.).....	279
B. I. Pogorzelski <i>et al.</i>	281
A. Y. Romsanyuk <i>et al.</i> (Abs.).....	217
S. I. Tkachenko <i>et al.</i> (Abs.).....	90
K. Wagnerowski <i>et al.</i> (Abs.).....	55, 152
and formalin activity. F. Holtau. (Abs.).....	26, 216, 246
juice purity. S. Zagrodzki (Abs.).....	20, 216, 246
pulp quantity. H. Zaorska. 26, 218	184
boiler feed treatment. G. Pohle. 247	247
condensate complexing properties. E. D. Yarnall. (Abs.).....	49
conservation in Australia. D. W. Beattie. (Abs.).....	214
content in bagasse and fuel efficiency. W. F. Boulton and R. C. Varma. 381	210
and beet pulp decomposition in storage. H. Schnelle. (Abs.).....	92
cane, effect of deterioration after harvesting. T. B. Srinivasan <i>et al.</i> (Abs.).....	92
gur. B. Singh <i>et al.</i> (Abs.).....	92
determination in bagasse. B. Partridge and S. R. Reichard. (Abs.).....	92, 220
cane. A. L. Fors. (Abs.).....	282
sugar. F. Schneider. (Abs.).....	306
and syrup. R. Lees. (N.B.).....	220
effect on beet seed germination. P. Kolago. (Abs.).....	90
F. W. Snyder and B. C. Kecke	90
cane specific heat. T. B. Dale. 217	217
evaporator supply. F. Nowak. (Abs.).....	89
factory consumption reduction. V. R. R. Phonsale. (Abs.).....	22
I. G. Chuganov. (Abs.).....	22
F. Kastner. (Abs.).....	22
P. S. Maksimuk. (Abs.).....	22
by condensate use. V. G. Bahulekar. (Abs.).....	24
M. Singh and R. K. Varma. 342	342
recycling. G. D. Agarwal. 278	278
wall deterioration reduction. V. I. Ovcharov. (Abs.).....	123
flume water foam formation. A. G. Kirichenko <i>et al.</i> (Abs.).....	310
liming effect on beet volatile acids and anions. H. Schieweck heating. A. I. Khomenko <i>et al.</i> (Abs.).....	144
level maintenance in beet leaf catcher. F. Hruska. (Abs.).....	24
movement in cane and ratoon stunting resistance. D. S. Teakle <i>et al.</i> pH as indication of bacterial activity. B. P. Kuz'menok. (Abs.).....	90
pollution reduction. A. Szabo. (Abs.).....	60, 124
press water gaseotropic acid determination. F. Perschak. (Abs.).....	301
quality. L. Risseuwer. (Abs.).....	47
protection. J. H. W. (Abs.).....	151
ratio to impurities and molasses exhaustion. G. F. Fundora. (Abs.).....	309
removal from condensers. J. G. Ziegler. (Abs.).....	186
separator for beets. Z. Burozynski and R. Wisniowski. (Abs.).....	56
E. T. Koval' <i>et al.</i> (Abs.).....	209
in soil and cane root growth. J. F. Usher. (Abs.).....	238
holding capacity. P. Y. Chan and L. Li Pi Shan. (Abs.).....	182
sugar bulk storage, effect of relative humidity. Z. J. Kimmerring. 62, 275	62, 275
treatment. (T.N.).....	275
utilization by beet leaves. H. Strube see also Brix; Centrifugals; Drying; Irrigation; Milling; Cane; Soli; Water; Waste and Weather	153
Water, Waste, adsorbent resin regeneration, colour removal. F. Onda <i>et al.</i> (Abs.).....	126, 190
beet pulp mix as animal fodder. L. Gonry. (Abs.).....	308
composition and treatment. A. C. Chatterjee <i>et al.</i> (Abs.).....	131
condensate composition. J. D. Blake economy. V. I. Dogvopoli <i>et al.</i> sugars determination. Y. Takatori <i>et al.</i> (Abs.).....	156
treatment for ethanol removal. J. D. Blake <i>et al.</i> (Abs.).....	291
flume-wash water mud particle size. A. P. Parkhomets <i>et al.</i> (Abs.).....	185
foam formation. A. G. Kirichenko <i>et al.</i> (Abs.).....	342
hot water cooling and recycling. K. A. Stuart. (Abs.).....	374
lactic and volatile acids determination. M. Kiely and M. O'Sullivan	317

	PAGE
Water, Waste: micro-organisms determination. V. A. Lagoda <i>et al.</i> (Abs.).....	124
pollution reduction. F. A. Grillot. quantity measurement. A. P. Parkhomets <i>et al.</i> (Abs.).....	280
reduction. P. S. Maksimuk <i>et al.</i> treatment. (T.N.).....	62
G. Bertolani and E. Gavioli. (Abs.).....	122
N. I. Besedovskii and I. D. Kovalenko. (Abs.).....	344
J. Bocko <i>et al.</i> (Abs.).....	280
J. F. Bond and K. E. McNeill. 23, 157	374
J. Brujin. (Abs.).....	23, 157
V. A. Burov <i>et al.</i> (Abs.).....	88
B. G. Camurungan. (Abs.).....	22
V. T. Dodolina. (Abs.).....	378
E. Greulich. (Abs.).....	187
H. P. Hoffmann-Walbeck and A. Pellegri. (Abs.).....	186
K. Kashimura and Y. Yoshida. 154	154
R. L. Knecht <i>et al.</i> (Abs.).....	57, 123
A. N. Krivchun <i>et al.</i> (Abs.).....	89
J. P. Merie. (Abs.).....	117
J. Metz. (Abs.).....	187
C. E. Monteiro. (Abs.).....	308
N. E. Parakhin. (Abs.).....	246
J. P. Rideau <i>et al.</i> (Abs.).....	280
A. Sakun. (Abs.).....	246, 280, 310
J. J. Seip and P. J. Gayle. (Abs.).....	378
B. M. Shakhovich. (Abs.).....	25, 90, 186, 218
K. Skalski. (Abs.).....	154
S. Tanigaki <i>et al.</i> (Abs.).....	245
E. Wellner. (Abs.).....	154
and COD determination. R. de Vletter and E. Wind. (Abs.).....	55, 280
with condensate. A. Simonart <i>et al.</i> (Abs.).....	56, 310, 311
effect of beet dirt taxa. E. Reinhold. (Abs.).....	120
in Sweden. N. Akermark. (Abs.).....	248
USSR. B. K. Kubrak and N. A. Ronskaya. (Abs.).....	344
utilization for irrigation. W. F. Dodolina <i>et al.</i> (Abs.).....	343
K. Z. Piven'. (Abs.).....	344
Wax. Cane: effect on raw sugar filtrability. M. Shaif and R. Samanigoo extraction from filter cake. C. Chatterjee and B. M. Dutt. (Abs.).....	382
Weather: in Australia, Hawaii, Rhodesia and South Africa. K. C. Leverington and D. R. Ridge. 49	49
beet agriculture in France. (Brev.).....	191
in Belgium. L. van Steyvoort. 18, 244	18, 244
Cuba cane harvest. (Brev.).....	226
cyclone damage to cane in Mauritius drought and beet ash content. V. Stehlik and I. Schmidt. (Abs.).....	242
yield. J. Hohobm and H. G. Tiedge. (Abs.).....	244
cane fallow probability evaluation. J. F. Willis. (Abs.).....	210
varietal resistance. O. Brinholi and O. P. Godoy. (Abs.).....	210
effects on beet agriculture. W. C. von Kessel. (Abs.).....	194
nutrient indices. Anon. 249	249
processing quality. M. Z. Khelmskii <i>et al.</i> (Abs.).....	52
varietal performance. A. Graf. 274	274
assessment. C. Winne. 276	276
yield. E. Bornscheuer. (Abs.).....	276
I. Gutmański. (Abs.).....	276
and quality. M. Mortazavi <i>et al.</i> (Abs.).....	21
cane borer incidence. S. Sithanatham <i>et al.</i> (Abs.).....	48
dextran content. D. H. Foster growth. U. S. Singh. (Abs.).....	373
photosynthesis. A. L. Fors. 49	49
potassium, calcium and chloride content. R. P. DeStefano. 178	178
yield. R. Julien <i>et al.</i> (Abs.).....	79
herbicide performance. E. G. Spry invertase and beet diffusion losses. 306	306
J. Januszewicz <i>et al.</i> (Abs.).....	335
leaf scald spread. G. J. Persley and C. C. Ryan. (Abs.).....	335
mangold fly and black bean aphid. H. Bernardová <i>et al.</i> (Abs.).....	54
flooding and cane damage in Colombia. (Brev.).....	62
frost and cane deterioration. J. C. P. Chen and J. J. Chen. (Abs.).....	53, 188
J. C. P. Chen <i>et al.</i> (Abs.).....	188
J. E. Irvine and B. L. Legendre. (Abs.).....	146
F. A. Martin <i>et al.</i> (Abs.).....	189
J. D. Miller and G. J. Gascho. 76	76
H. Robichaux. (Abs.).....	146
K. A. Sund and B. A. Smith in Argentina. (Brev.).....	32
processing. H. A. Naqvi and S. M. Alam. 202	202
varietal resistance. O. Brinholi <i>et al.</i> (Abs.).....	241
J. D. Miller. (Abs.).....	303
protection of beet clamps. A. Vigoureaux. (Abs.).....	181
rot pathogen survival. R. J. Steib. (Abs.).....	143

	PAGE
Weather: in India. Anon. (Abs.).....	81
S. K. Ojha <i>et al.</i> (Abs.).....	238
meteorological service in Taiwan. S. J. Yang. (Abs.).....	367
in Morocco. G. Schmidt. (Abs.).....	82
rain and beet leaf growth and plant population. H. Strube. (Abs.).....	275
cane chemical ripener effect. L. Oudman. (Abs.).....	309
crop failure. Anon. (Abs.).....	148
extraneous matter. R. P. Vickers. 146	146
harvesting. R. P. Vickers <i>et al.</i> herbicide performance. Anon. 276	276
quantity estimation. G. Kingston soil erosion. R. P. Humbert. (Abs.).....	304
in Taiwan. H. Chu <i>et al.</i> (Abs.).....	76
temperature effects on beet yield and quality. H. Laby. (Abs.).....	243
research in Brazil. G. M. Azzi. (N.B.) temperature and beet seedling emergence. K. D. Beatty and C. P. Ehlig. (Abs.).....	19
yield and sugar content. G. K. Ryser. (Abs.).....	307
cane sugar content. K. Palaniappan and T. P. Palaniappan. (Abs.).....	144
drought effects on beet growth and sugar content. H. Krzywon effect on fertilizer efficiency. F. A. Fogliata. (Abs.).....	111
herbicide performance. D. Traveller and J. E. Hull. (Abs.).....	305
moisture effects on beet leaf miner incidence. M. Kubacka-Szmidtgal. (Abs.).....	276
and trace elements effect on beet yield and quality. H. J. Müller. wind and soil erosion. S. R. Simmons and A. D. Dotzonko. (Abs.).....	337
Weeds: in Argentina. R. A. Arevalo <i>Borreria</i> sp. control. W. A. C. Webb bolted beet elimination. Anon. 338, 371	338, 371
E. Kesten. (Abs.).....	19
J. Krzywon. (Abs.).....	307
E. Vanstallen and A. Vigoureaux. (Abs.).....	339
chemical control. (T.N.).....	62
Anon. (Abs.) 16, 76, 176, 207, 240, 274, 275, 276, 306, 307, 366	275, 276, 306, 307, 366
J. M. Belien and J. P. Salembier. (Abs.).....	274, 306
J. M. Belien <i>et al.</i> (Abs.).....	148, 243
K. Blasberg. (Abs.).....	48
N. B. Davis. (Abs.).....	304
E. Ebers <i>et al.</i> (Abs.).....	275
M. Eddowes. (Abs.).....	304
L. W. Hendrick <i>et al.</i> (Abs.).....	149
G. A. Iggo. (Abs.).....	147
A. S. Kennedy. (Abs.).....	82
E. Lonsdale. (Abs.).....	147
D. T. Loupe and L. M. McCormick. (Abs.).....	366
V. F. Megitt. (Abs.).....	83
R. W. Mitchell. (Abs.).....	112
G. Peters. (Abs.).....	211, 276
A. Rudd. (Abs.).....	270
D. J. C. Singh and K. M. Gupta 301	301
E. R. Stauffer. (Abs.).....	20
F. Sullivan. (Abs.).....	209
L. G. W. Tiley. (Abs.).....	304
N. V. Turner. (Abs.).....	331
W. A. C. Webb. (Abs.).....	331
economics. E. P. Weller. (Abs.).....	110
effect of weather. E. G. Spry equipment. W. Garburg. (Abs.).....	307
herbicides. (T.N.).....	286, 309
effects on beet. L. László. 274	274
Vanstallen. (Abs.).....	339
W. C. von Kessel. (Abs.).....	275
storage and processing quality. M. Martens. (Abs.).....	83
cane. H. L. Boyle. (Abs.).....	209
W. L. Madden and E. M. Christie. (Abs.).....	110
S. Peng. (Abs.).....	241
fertilizer efficiency. B. Debreczer and R. Kovács. 83	83
F. A. Fogliata. (Abs.).....	111
hazards. C. Ricaud. (Abs.).....	300
mixing and application. M. R. Boast. (Abs.).....	147
operator protection. W. Hartley. (Abs.).....	18
order from Cuba. (Brev.).....	159
performance. D. Traveller and J. E. Hull. (Abs.).....	305
residues. H. W. Hilton <i>et al.</i> wetting compound. Anon. 21	21
and hoeing. A. Vigoureaux. (Abs.).....	21
planning. G. Kester. (Abs.).....	306
research and field operations. B. B. Fischer <i>et al.</i> (Abs.).....	180
in UK. W. E. Bray. (Abs.).....	243
underleaf spraying. Anon. 275	275
in US. P. B. Brinholi and R. C. Bond. (Abs.).....	212
D. T. Loupe. (Abs.).....	241
competition and cane yield. J. A. Mariotti <i>et al.</i> (Abs.).....	366
effect of nitrogen. E. A. Cerrizuela <i>et al.</i> (Abs.).....	79

INDEX

	PAGE
Weeds: control. A. Fleury, (Abs.).....	82
- R. P. Humbert, (Abs.).....	117
- A. Vigoureux, (Abs.).....	149
- by cultivation. C. Kester and F. Kirk, (Abs.).....	83, 305
- R. J. Matherne, (Abs.).....	179
- E. Meyer and G. de Boer, (Abs.).....	174, 302
- effect of reduced tillage. N. Rozoff 80	
- machine. D. Charlesworth, (Abs.) 82	
- methods comparison. R. P. Cossio and J. M. Hinoj, (Abs.).....	302
- R. P. Cossio <i>et al.</i> (Abs.).....	303
- research in Taiwan. S. J. Yang, couch grass control. J. M. Belien and W. Haquenne, (Abs.).....	115
- dodder control. K. Doba, (Abs.).....	18
- effects on beet yield, harvesting and processing. H. Neururer, (Abs.).....	306
- grasses control. Anon., (Abs.).....	303
- S. Y. Peng <i>et al.</i> (Abs.).....	241
- Johnson grass control. J. F. Parr <i>et al.</i> (Abs.).....	144
- E. R. Stamper, (Abs.).....	144
- late weeds and beet yield. W. C. von Kessel, (Abs.).....	18
- Napier grass control. H. H. Samoi para grass control. J. A. Currie, (Abs.).....	205
- research in South Africa. Anon., rice grass control. Anon., (Abs.).....	309
- transmission prevention by cane equipment cleaning. J. F. Usher in U.S. L. L. Louden, (Abs.).....	78
- volunteer cane. E. A. Pembroke, wild beet. J. S. McFarlane, (Abs.).....	333
- A. Vigoureux, (Abs.).....	242
- A. Vigoureux and R. Van-stallen, (Abs.).....	18, 82, 337
Weighers: raw sugar. W. L. Reed, sugar. Anon., (Abs.).....	57
Weighing bagasse. B. D. Ravno <i>et al.</i> West Indies: Antigua and St. Vincent sugar industry revival plans.....	192
- cane breeding. Anon., (Abs.).....	238
- smut varietal resistance and crop profitability. N. W. Simmonds St. Kitts sugar production 1975.....	329
- St. Vincent sugar plan. (Brev.).....	254
- see also Barbados; Guyana; Jamaica and Trinidad	351

White sugar: ash determination. G. P. R. and M. Juro, (Abs.).....	124
- boiling. D. Schliephake and K. Austmeyer, (Abs.).....	380
- C. R. Sriramulu <i>et al.</i> (Abs.).....	308
- bulk carrier. N. M. Kichigin <i>et al.</i> colour determination. J. C. P. Chen - effect of renet liquid carbonation. L. D. Bobrovnik and L. P. Kotelnikova, (Abs.).....	376
- conditioning. V. Maurandi and G. Mantovani, (Abs.).....	152
- 55, 217, 352	
- cooler. E. A. Orlov and N. A. Buzynkin dryer dust separator. A. F. Zaborin <i>et al.</i> (Abs.).....	251
- 88	
- EEC price 1976/77. (N.C.).....	130
- effect of heat. W. Mauch and S. Asselt, (Abs.).....	249
- fluidized bed treatment. L. Neuzil and E. Kostelkova, (Abs.).....	218
- improvement by factory modifications. G. S. Jain, (Abs.).....	308
- manufacture. A. Galban, (Abs.).....	314
- J. J. Ungar and R. Lumbroso.....	215
- carbonation <i>vs.</i> sulphitation. M. Cordoves <i>et al.</i> (Abs.).....	117
- continuous carbonation. S. L. Sang <i>et al.</i> (Abs.).....	309
- in Cuba. S. Ortega, (Abs.).....	150
- <i>vs.</i> raw sugar. A. C. Chatterjee, melting for transport. E. E. Belokon' and V. K. Sevryuk, (Abs.).....	308
- moisture determination. F. Schneider <i>et al.</i> (Abs.).....	248
- Paris market. (N.C.).....	2, 66
- physico-chemical properties in Egypt. M. Mohamud <i>et al.</i> (Abs.).....	375
- pneumatic conveying. T. K. Vasil'eva, (Abs.).....	356
- T. K. Vasil'eva <i>et al.</i> (Abs.).....	376
- A. F. Zaborin and T. K. Vasil'eva, (Abs.).....	344
- quality, effect of thick juice heating and colour formation. L. Wieninger and N. Kubandinov, (Abs.).....	55
- storage. T. P. Khvalkovskii <i>et al.</i> (Abs.).....	88
- silo. M. Braeckman, (Abs.).....	311

White sugar: solution colour determination. A. Y. Zagorul'ko and L. A. Korobeinikova, (Abs.).....	316
- standards. A. C. Chatterjee, (Abs.) 317	
- world prices. (N.C.).....	2, 98, 130, 194, 225
- yield, effect of beet as monoculture. N. A. Al'dekov and N. F. Kostin 212	
- prediction. M. Burba, (Abs.).....	347
- see also icing sugar; Refined sugar; Sugar and table sugar	
World: raw sugar price chart. (Brev.) 127	
- sugar balance 1975/76. (N.C.) 97, 225, 290	
- demand. (N.C.).....	321
- economy. G. B. Hagelberg, (N.B.) 345	
- expansion plans. H. Ahlfeld 282	
- prices. (N.C.).....	2, 98, 130, 194, 225, 258, 289, 322, 353
- production. G. B. Hagelberg 155	
- 1975/76 1, 31, 65, 95, 194, 223, 239, 319	
- 1976/77.....	353, 383
- and US raw sugar prices chart 224	
- see also International	
Yeast: animal fodder. Anon., (Abs.).....	222
- P. S. Matveenko and P. A. Semenovs, (Abs.).....	285
- composition and nutritional value. L. Vassosi, (Abs.).....	94
- growth on vinasse and chemical composition changes. V. G. Kovai' ATIAKH, M. S., see KANWAR, R. S.	379
- manufacture from vinasse. Anon., - J. T. Aguinaldo, (Abs.).....	126
- P. Kujala <i>et al.</i> (Abs.).....	252
- molasses colorant effects. V. N. Shvets <i>et al.</i> (Abs.).....	381
- see also Alcohol and Micro-organisms	252
Yugoslavia: new sugar factories. (Brev.) 64, 286, 384	
- sugar production 1975. (Brev.).....	96

Zaire sugar project. (Brev.).....	191, 287
Zambia: sugar factory expansion - and distillery orders. (Brev.) 30	
- production 1975.....	127

NAMES

	PAGE
ALEXANDER, J. B. and MATIC, M. Cane starch. (Abs.).....	314
ALEXANDER, K. C. Cane stem and root fungus. (Abs.).....	370
ALIERI, V. T. Uric acid. Anticropic effect on alcohol manufacture from molasses. (Abs.).....	382
ALIMOV, T. K. Molasses as animal fodder. (Abs.).....	94
ALLAWAY, R. and GRAVES, C. B. Automatic power house control... see also GRIMLEY, S. C.	340
ALONIA, J. and CUELLAR, I. Soils and fertilization research in Cuba. (Abs.)	208
AL-WINDI, I. and SCHMIDT, L. Irrigation effect on beet. (Abs.).....	148
AMADUCCI, M. T. <i>et al.</i> Soil preparation and beet planting uniformity.....	243
AMIDING, F. Massesite preservative fugging. (Abs.).....	377
AMJET, P. J. Locusts. (Abs.).....	334
AMORIM, A. DE L. C., see MARINHO, M. L.	
ANALOGIDE, D. D. Nitrogen and beet petiole nitrate-N. (Abs.).....	339
ANDERSEN, A. F. DDS beet diffuser	256
ANDERSEN, K. Filter-thickeners. (Abs.)	515
ANDREY, V. G., see KOLOMETS, V. F.	
ANDREIS, H. J. Cane effect on soil nutrients. (Abs.).....	91
ANDRES, H., see PREY, V.	
ANDUX, M. Vacuum pan design. (Abs.)	53
ANKREEV, Y. V. Filter-thickener performance. (Abs.).....	217
ANTONI, H. J., see FRIAS DE F., A. M.	
ANTONOVICH, A. L. and PETRIK, V. S. Molasses yield and sugar content calculation by computer. (Abs.).....	248
APASOV, V. E., see GROMKOVSKII, A. I.	
APPE, P. L. and MATH, B. R. Phosphatation. (Abs.).....	213
ARCEBIAUX, G. Cane smut in Guyana	176
Cane varietal correction factor and milling performance calculation.....	86
ARCO, L. M. Cane harvesting time optimization. (Abs.).....	111
ARCHIBALD, R. D. and SMITH, I. A. Cane juice purity drop and boiling house capacity. (Abs.).....	182
- see also MEROV, M. A. J.	
ARCEVALO, R. A. Weeds in Argentina see also CERRIZUELA, E. A.	367
ARKHIPOVICH, N. A. E. Beet temperature measurement. (Abs.)... see also LAGOD, V. A.	381
ARNOLD, K. S. Power factor. (Abs.).....	209
ARTYUKHOV, Y. G. and GARYAZHA, V. T. Air flow rate in massesuite stream. (Abs.).....	184
- Massesuite flow friction losses.....	184
ARVESU, A., see ALEMAN, G.	
ASAI, H., see YAMANE, T.	

ASCROFT-LEIGH, W. J. A. Soil erosion prevention with rye. (Abs.).....	242
ASSEILI, S., see MAUCH, W.	
ATHERTON, P. G., see KIRBY, L. K.	
ATIAKH, M. S., see KANWAR, R. S.	
AUTMEYER, K., see SCHLIEPHAKE, D.	
AUTREY, J. C., see RICAUD, C.	
AVASTHY, P. N., see VARMA, A.	
AVELLANEDA, R. A., see MAROTTI, J. A.	
AWANG, M. and WHITE, E. T. Crystall and mother-liquor properties and massesuite viscosity. (Abs.).....	373
AYATS, J. D., see FAYAN, L.	
AYATI, M. P., see FAYAN, L.	
AZZI, G. M. Cane agricultural research in Brazil. (N.B.).....	282
Cane borer control. (Abs.).....	303
BABEV, D. Bulgarian factory equipment. (Abs.).....	313
BABU, C. N., see SINGH, J. P. and SINGH, S.	
BADER, R. M. Drip irrigation. (Abs.) 369	
BABYNA, H., see KUELMANN, R. W.	
BAGLYUK, A. D. Beet knife treatment	89
BAHULEKAR, V. G. Water consumption reduction by condensate use. (Abs.) 22	
BALLET, V. J. Bagasse burning as fuel	214
BALJAI, P. D., see SINGH, U. S.	
BAKER, B. P. Molasses composition, properties and use. (N.B.).....	155
BAKER-ARKEMA, F. W. <i>et al.</i> Beet cooling tests. (Abs.).....	24
BAKOWSKA, E., see TRZCINSKI, W.	
BALAKAN, A. V., see KICHIGN, N. M.	
BALASTREIRE, L. A., see RIPOLI, T. C.	
BALASUBRAMAN, N. <i>et al.</i> Co 449 cane variety. (Abs.).....	365
BALCELS, A. Cane agriculture in Philippines. (Abs.).....	111
BALDWIN, J. Beet and crop rotation	276
BALDERM, J. J. Boiling schemes. (Abs.)	119
- see also CASTRO, J.	
BALLARD, A. L. and GANDIA, L. Automatic centrifugal control. (Abs.) 150	
- <i>et al.</i> Automatic centrifugal control	150
BALOH, T. Beet juice reverse osmosis 122, 377	
- Flow effect on heat transfer through scaled surfaces. (Abs.).....	280

INDEX

PAGE		PAGE		PAGE
	BAMBANASTE, R., see GUTIÉRREZ, L.		BICKERT, W. G., see BAKKER-ARKEMA, F. W.	
	BANAS, V. F., see POGORZHEL'SKI, B. I.		BICKLE, R. E. and CHILDS, H. E. Automatic cane reception control	340
	BANEJRJE, S. N. and BUTANI, D. K. Cane insect pests in India. (Abs.)	300	BIESKE, E., see STANKIEWICZ, W.	
	BARALDI, G., see AMADUCIO, M. T. and DE ZARHIE, C.		BILGIN, Y. Potassium effect on beet yield and quality. (Abs.)	21
	BARCUDI, R., see COSSIO, R. P.		BINDRA, O. S., see TUHAN, N. C.	
	BARKER, S. Beet phosphorus requirement determination. (Abs.)	21	BIRCH-ENSEN, A. Cube sugar manufacture. (Abs.)	311
	BARKO, M. N. and KHAMAZA, F. I. Beet payment in USSR. (Abs.)	52	BIRKETT, H. S. and SEIF, J. J. Cane sampling and analysis. (Abs.)	188, 220
	BARNES, M. G. et al. Beet storage losses prediction. (Abs.)	181	BIRYUKOV, I. V., see GULYI, I. S.	
	see also WESTFALL, D. G.		BISHNOI, L. K., see SINGH, S. and SRIVASTAVA, S. N. L.	
	BARRÉ, M. Bucket wheel for piled beet reclamation. (Abs.)	280	BISSINGER, B., see CRONEWITZ, T.	
	and DURET, H. Beet sugar factory expansion. (Abs.)	215	BITTENCOURT, V. C. et al. Cane leaf nitrogen determination. (Abs.)	318
	BARTH, R., see DANKOWSKI, K.		BLAKE, J. D. Evaporator condensate composition. (Abs.)	131
	BASKARAN, T. L., see MUTHUSAMY, S.		et al. Ethanol removal from condensates	291
	BASKER, D. Sucrose solution refractive index adjustments. (Abs.)	359	BLANCHARD, G. T., see CHEN, J. C. P.	
	BASS, R. J. and DONOVAN, J. Automatic boiling control. (Abs.)	375	BLANCHARD, M. A., see DUNCKELMAN, P. H.	
	BASSINELLO, A. L. Cane varieties in Brazil. (Abs.)	210, 368	BLAQUIER, L. M. Rat control. (Abs.)	241
	BASU, A. K. and LECLERO, E. Distillery waste treatment. (Abs.)	285	BLASBERG, K. Cane pests, diseases and weed control. (Abs.)	48
	BATAGLIA, O. G., see FIBRO, J. O.		BLUESNER, K. M., see REINEFELD, E.	
	BATALOV, K. K., see ARKHIPOVICH, N. A.		BLOK, J. and VAN DER POEL, P. W. Beet diffusion juice draft and loss optimization. (Abs.)	26, 248, 313
	BATES, L. A. Automatic boiling control. (Abs.)	54	BOAS, A. M. V. see PEREIRA, C. E.	
	BATSTONE, D. B. Computer applications. (Abs.)	119	BOAST, M. R. Herbicide mixing and application. (Abs.)	147
	see also MACLEAN, G. D.		BOBER, A., see LEKAWSKI, W.	
	BATTERHAM, R. J. Sugar recovery in low-grade boiling. (Abs.)	85	BOBOVNIK, L. D. and KOTY, P. NIKOVA, L. P. Remelt liquor decolorization by carbonation vs. sulphitation et al. Molasses electrolysis efficiency determination. (Abs.)	152
	et al. Nucleation in boiling. (Abs.)	84	et al. Raw sugar colour formation prevention. (Abs.)	313
	BATTERMAN, L., see HOBBS, J.		see also FIDORENCHENKO, L. A., SAPRONOV, A. R. and ZAGORODNYI, P.	
	BATULE, B. and RODRIGUEZ, A. Automatic pan vapour line valve control. (Abs.)	308	BOCHKO, L. M., see TUZHILKIN, V. I.	
	BAUDELOQUE, A. Sugar silo. (Abs.)	25	BOCKO, J. et al. Flume water treatment	280
	BAUERMEIND, U. Computerized data processing and accounting. (Abs.)	25	BOEGER, D. V. and TIU, C. Cane molasses pumping data calculation. (Abs.)	245
	BAUSTAPF, B. M. Molasses as animal fodder. (Abs.)	94	BOGOROSH, A. T. et al. Aragonite and scum formation. (Abs.)	247
	BAXTER, S. W. D. Mechanical cane harvesting in South Africa. (Abs.)	240	BOGUMIL, T. et al. Equipment noise and vibration. (Abs.)	312
	see also SPARGO, R. F.		BOHM, O. Beet handling losses. (Abs.)	184
	BAZHAL, G. et al. Crystal size effect on growth and dissolution rate. - Isohydrate conditions in boiling. - see also SHTANGAEV, V. O.	251, 122	BOLDYREV, A. T., see IVANOV, S. Z.	
	BAZILOV, V. N., see BUIROV, V. A.		BOLLEN, O. Straw incorporation in soil	147
	BRADSHAW, J. W. Cane skip planting "Paraquat" as cane leaf desiccant	179	BOLTON, F. N. Cane trash content. - see also F. F. and McNEIL, K. E. Waste water treatment. (Abs.)	374
	BEATTIE, D. W. Irrigation in Australia	49	BOND, R. G., see BIRNHAU, P. B.	
	BEATTY, K. D. and EHLIG, C. F. Soil salinity and temperature effects on beet. (Abs.)	19	BOND, R. S. Cane selection in South Africa. (Abs.)	175
	BEAUFILS, E. R., see SUMNER, M. E.		BOON, V. Y., see SHTANGAEV, V. O.	
	BEAUVISAGE, M. Cane sugar extraction	183	BORNSCHUEER, E. Weather and beet varietal differences. (Abs.)	21
	BECKER, G. Beet virus yellows. (Abs.)	18	and MEINKE, H. Beet seed spacing and plant population. (Abs.)	276
	BECHIS, J. W., see C. C.		BORRATO, M., see CARRAZZA R. L.	
	BEGALIEV, T., see BELOVA, O. I.		BORYS, A. Dextran determination in beet juice. (Abs.)	284
	BEISS, U. and WINNER, C. Fertilizer effect on beet. (Abs.)	148	and KUBACKI, J. Beet sugars determination. (Abs.)	157
	BELEHR, R. Beet leaf drainage	176	BORZDAYA, V. N. et al. Foam reduction in beet diffusion. (Abs.)	87
	BELEW, W. Irrigation tube plugging prevention. (Abs.)	369	BOSB, S. et al. Cane deterioration reduction. (Abs.)	302
	BELLEN, J. M. and HAQUENNE, W. Conch grass control. (Abs.)	115	- Reducing sugars determination in molasses. (Abs.)	92
	and SALEMBER, H. P. Chemical weed control. (Abs.)	274, 306	BOSMA, S. M., see CARTER, J. N.	
	et al. Chemical weed control. (Abs.)	148, 243	BOTELEO, P. S. M., see MACEDO, N.	
	BEL'KO, G. I. et al. Zhabinka sugar factory. (Abs.)	378	BÖTNER, H. and WINNER, C. Herbicides and soil fungi. (Abs.)	305
	BELONK' O. E. and SEVRYUK, V. K. Transport of white sugar melt.	248	BOUČEK, S. and VALTER, V. Automatic syrup Brix and temperature control - Brix meter. (Abs.)	87, 123
	BELOLIPETSKII, B. I., see IVANOV, S. Z.		Continuous melter. (Abs.)	215
	BELOSTOYSKII, L. G., see BEL'KO, G. I. and GOLOVYAK, Y. D.		BOULET, W. P. Bagasse moisture content and fuel efficiency. (Abs.)	214
	BELOVA, O. I. and BEGALIEV, T. Beet molasses fatty acids extraction.	379	BOURLLET, P., see DEVILLERS, P.	
	BENDA, G. T. A. Cane leaf sheaths and axillary bud germination. (Abs.)	146	BOURNE, B. J. Cane varieties in US	110
	Cane mosaic and refoam stunting control. (Abs.)	114, 178	BOWEN, J. E. Cane micronutrient deficiency. (Abs.)	212
	Cane recovery from mosaic. (Abs.)	145	BOYCOTT, C. A., see HUDSON, J. C.	
	Ratoon stunting disease and cane shoot growth. (Abs.)	113	BOYLE, H. L. Cane basal stem and root rot. (Abs.)	47
	see also FANGUY, H. P.		Cane susceptibility to herbicide damage. (Abs.)	209
	BENNETT, M. C. Clarification with polymer flocculants. (Abs.)	315	BRAECKMAN, M. White sugar silo. (Abs.)	311
	BERSHENEV, I. P., see KULOV, V. A.		BRAITHWAITE, M. J., see REHBEIN, C. A.	
	BERNARD, C. J., see FORET, J. N.		BRANDT, M. and MATEC, J. Beet storage in USSR. (Abs.)	186
	BERNARDOVA, H. et al. Mangold fly and black bean aphid. (Abs.)	52	BRAITHWAITE, C. W. D. Nematodes in Barbados. (Abs.)	367
	BERTOLANI, G. and GAVIOLI, E. Waste water treatment. (Abs.)	122	BRAY, W. E. Chemical weed control in UK. (Abs.)	243
	BESBODYSKII, N. I. and KOVALENKO, I. D. Waste water treatment.	344	BREAU, R. D. Cane varietal selection Irradiation and cane mosaic resistance. (Abs.)	113, 178
	BEZPAL'KO, N. N., see KONSTANTINOV, S. M.		and DUNCKELMAN, P. H. Cane breeding for mosaic resistance.	145
	BHADANI, V. S., see MATHUR, B. K.			
	BHADWAR, V. M., see GOEL, D. B.			
	BHARDWAJ, K. M. et al. Clarification with flocculation aids. (Abs.)	340		
	BHARGAVA, K. S., see RISHI, N. and SINGH, C. K.			
	BHONSALE, V. R. R. Continuous vs. batch crystallization. (Abs.)	183		
	Factory water consumption. (Abs.)	22		
			BREAY, H. T., see BRISBOURNE, D. R.	
			BRENMAN, S. A. et al. Affination - Syrup decolorization and boiling losses. (Abs.)	314, 249
			BRETSCHNEIDER, R. and SYROD, M. Nucleation in boiling. (Abs.)	27
			BRETT, P. G. C. et al. Cane flowering induction. (Abs.)	175, 302
			see also THOMPSON, G. D.	
			BRICOUT, J. and POSTES, J. C. Beet and cane sugar differentiation. (Abs.)	28
			BRIMHALL, P. B. and BOND, R. C. Chemical weed control in U.S.	212
			BRINOLI, O. and GODOY, O. P. Cane varietal drought resistance. (Abs.)	210
			et al. Cane varietal frost resistance.	241
			BRISBOURNE, D. R. Nitrogen fertilizer rate optimization. (Abs.)	149
			and BREAY, H. T. Beet harvesters	243
			BRITO M., J. and ABREU C. J. Cane harvester topper performance.	48
			BROADFOOT, R. and WHITE, E. T. Continuous pulp performance prediction. (Abs.)	84
			et al. Continuous boiling. (Abs.)	341
			see also BLAKE, J. D. and STEINDL, R. J.	
			BROTHERTON, G. A. Clarification between inclined surfaces. (Abs.)	373
			see also STEWART, P. N.	
			BROUGHTON, N. W., see OLDFIELD, J. F. T.	
			BROWN, C. R. and POMMEZ, P. Chloride ion-selective electrode applications	283
			BRÖZ, L., see NEUZIL, I.	
			BRUNIS, G., see DANKOWSKI, K.	
			BRUIJN, J. Research at SMRI. (Abs.)	23
			Waste water treatment. (Abs.)	151
			BRUNET, R. and MAUREE, S. P. Cane leaf phosphorus and potassium contents. (Abs.)	238
			BRUSLOVSKAYA, E. M., see FEDOTKIN, I. M. and GULYI, I. S.	
			BUGANKO, I. F. Refinery molasses colorants fractionation. (Abs.)	93
			BUGBE, W. M. Phoma betae in the storage extraneous matter. (Abs.)	82
			BUI, U. and GIBSON, W. Drip irrigation tubes. (Abs.)	368
			see also GIBSON, W.	
			BULACIO, A. R., see MARIOTTI, J. A.	
			BULL, D. Soldier fly. (Abs.)	271
			BULL, T. A. and GIBNEY, D. A. Cane growth stimulation. (Abs.)	142
			BUKAVLEVA, V. I. et al. Sucrose and dextrose solubilities. (Abs.)	316
			BURBA, M. Beet processing quality evaluation. (Abs.)	347
			and GEORGI, B. Amino-acids determination. (Abs.)	348
			and PUSCZ, W. Beet brei clarification, with aluminum salt. (Abs.)	346
			et al. Beet brei freezing, storage and preparation. (Abs.)	60, 124
			BURZYNSKI, Z. and WISNIOWSKI, R. Beet water separator. (Abs.)	186
			BURDA, V. S., see CHUDAROV, E. M.	
			BURDEKOVA, R. S., see DADKOVA, M. N. and ZHMYRVA, L. P.	
			BURES, R., see SCHMIDT, L.	
			BURIANEK, J. and KMINER, M. Factory process evaluation by computer. (Abs.)	311
			et al. Carbonation with magnesium carbonate and phosphoric acid - Carbonation with mud coagulant	278, 248
			BURNE, J. D. Beet seed bed preparation. (Abs.)	148
			BURNS, R. R., see BALLARD, A. L.	
			BUIROV, V. A. et al. Waste water treatment and filter cake sweetening-off. (Abs.)	88
			BURCH, L. M., see FISCHER, B. B.	
			BURYMA, A. K. et al. Beet diffusion loss determination. (Abs.)	87
			see also BORZDAYA, V. N.	
			BÜSCHING, L., see SCHWIECK, H.	
			BUTANI, D. K., see BANERJEE, S. N.	
			BUZINA, G. V. and PARENENKO, V. V. Beet pectin manufacture. (Abs.)	285
			see also PARENENKO, V. V.	
			BUZYKIN, N. A., see ORLOV, L. A.	
			BYTHER, R. S., see LADD, S. L.	
			BYL'EV, L. Y., see KHOMENKO, A. I.	
			BYVALTSKY, A. B., see ZHURAVENKO, M. V. Dextrin effect on sucrose nucleation. (Abs.)	250
			CABELLO, A. and MARTÍN, P. C. Bagasse and bagacillo as animal fodder. (Abs.)	253
			CALDESAISOU, T. Juice purification	187
			CAMP, C. R. and CARTER, C. E. Soil drainage. (Abs.)	177
			see also PAER, J. F.	
			CAMURUNGAN, R. G. Waste water treatment. (Abs.)	22
			CADLIN, M. H. Bulk sugar silo. (Abs.)	119
			CARDET, E. Cane diffusion. (Abs.)	277
			et al. Bulk sugar storage. (Abs.)	245
			CARNEGIE, A. J. M. Cane borer damage and parasites. (Abs.)	208

INDEX

PAGE		PAGE		PAGE
	CARPENTER, F. G. and CLARKE, M. A. Colorants and calcium phosphate precipitation in clarification. (Abs.)	123		
	and ROBERTS, E. J. Colorant formation in sugar solution. (Abs.)	251		
	<i>see also</i> MORRIS, N. M. and ROBERTS, E. J.			
	CARRAZANA R. L. and KOZYAVKIN, A. P. Laboratory vacuum pan and crystallization rate calculation..	124		
	- Sugar crystal granulometry determination. (Abs.)	251		
	and MACHADO L., I. Cane molasses analysis. (Abs.)	125		
	<i>et al.</i> Cane molasses viscosity. (Abs.)	251		
	- Sugar crystal length and width dissolution rates. (Abs.)	124		
	CARROLL, B. R., <i>see</i> PARR, J. F.			
	CARTER, C. E. and FLOYD, J. M. Water table height and cane yield. (Abs.)	177		
	<i>see also</i> CAMP, C. R.			
	CARTER, J. N. <i>et al.</i> Beet nitrogen requirements and yield determination	242		
	- Inter-row spacing and nitrogen effects on beet yield and sugar content. (Abs.)	242		
	- Irrigation and nitrogen effects on beet. (Abs.)	337		
	CARUBA, G., <i>see</i> D'AMBRA, V.			
	CARVER, S. E. Roller bearings. (Abs.)	309		
	CASAGRANDE, F. A. <i>et al.</i> Fertilizers and cultivation effects on soil.	77		
	CASEY, J. A., <i>see</i> VILLAMIL, E.			
	CASTANEDA, J., <i>see</i> CORONA, E.			
	CASTRO, J. and BALDI, G. Mechanical cane harvesting and factory operations. (Abs.)	144		
	CASTRO, P. R. C. <i>et al.</i> Growth regulators and cane germination. (Abs.)	110		
	CATROUX, G., <i>see</i> RIDRET, J. P.			
	CAVALCANTI, A., <i>see</i> MARSHO, M. L.			
	ČEKROVÁ, Y., <i>see</i> ČÍŽ, K.			
	ČEPELÁK, J. and OSVALD, R. Carbonation mud recirculation calculations. (Abs.)	247		
	CEPERO, I., <i>see</i> GUTIERREZ, L.			
	CERRIZUELA, E. A. <i>et al.</i> Nitrogen and weed competition. (Abs.)	79		
	CESAR, M. A. A., <i>see</i> DE OLIVEIRA, E. R.			
	CESNIK, R. Cane breeding programme area requirement. (Abs.)	241		
	Cane varietal pest and disease resistance testing. (Abs.)	210		
	CETINA, R. <i>et al.</i> Active carbon manufacture from clarification mud..	221		
	CHAN, P. Y. and LI PI SHAN, L. Soil water-holding capacity and irrigation scheduling. (Abs.)	238		
	CHANCELLOR, A. H. and GRASS, J. S. Cane mill turpallates. (Abs.)	340		
	CHANG, C. H., <i>see</i> JUANG, T. C.			
	CHANG, Y. C., <i>see</i> CHEN, Y.			
	CHANG, Y. H., <i>see</i> FANG, Y. T.			
	CHAO, C. C. and WU, M. H. Lime and green manure effects on soil fungi. (Abs.)	336		
	<i>see also</i> WU, M. H.			
	CHAO, O., <i>see</i> CETINA, R.			
	CHAPMAN, H. L. Bagasse and cane molasses as animal fodder. (Abs.)	221		
	CHAPMAN, L. S. and LEVERINGTON, K. C. Cane harvesting scheduling	333		
	<i>see also</i> HAYSON, M. B. C., KINGSTON, G. and MOLLER, R. B.			
	CHARDON, C. W. Private cane and disease risk in Australia. (Abs.)	271		
	- Spur-throated locust. (Abs.)	79		
	CHARLES, D. F. Refinery liquor colour and fluorescence. (Abs.)	293		
	CHARLESWORTH, D. Beet clamp cover	148		
	Beet tops as animal fodder. (Abs.)	252		
	Group beet harvesting and transportation. (Abs.)	371		
	Weed cutting. (Abs.)	82		
	CHARPENTIER, L. J., <i>see</i> KOIKE, K.			
	CHATTERGEE, A. C. Raw sugar vs. white sugar production. (Abs.)	308		
	CHATTERGEE, A. C. Sugar factory capacity. (Abs.)	202		
	White and refined sugar standards.	317		
	and DUTT, B. M. Alcohol manufacture from molasses. (Abs.)	331		
	- Cane by-products utilization	382		
	- Fuel oil composition from molasses. (Abs.)	221		
	<i>et al.</i> Clarification with flocculant..	309		
	- Waste water composition and treatment. (Abs.)	308		
	<i>see also</i> MUKHERJI, J. P.			
	CHATURVEDI, P. P. Clarification mud level reduction. (Abs.)	308		
	CHEN, C. H., <i>see</i> SANO, S. I.			
	CHEN, C. T. and CHEN, M. J. Cane white leaf. (Abs.)	208		
	<i>et al.</i> Ratoon stunting disease and cane bacteria. (Abs.)	143		
	CHEN, H. Y. Taiwan bulk handling terminal. (Abs.)	23		
	CHEN, J. C. P. Cane diffusion. (Abs.)	53		
	Clarification with flocculants. (Abs.)	214		
	White sugar colour determination	318		
	and CHEN, J. J. Frost and cane deterioration. (Abs.)	53, 188		
	CHEN, J. C. P.			
	and PICOU, R. W. Bagasse application to soil and cane quality. (Abs.)	150		
	- Flocculants and clarification mud filtration. (Abs.)	119		
	<i>et al.</i> Determination of cane damage by frost. (Abs.)	188		
	<i>see also</i> CHEN, J. J.			
	CHEN, J. J. and CHEN, J. C. P. Cane ripening with chemicals. (Abs.)	177		
	<i>see also</i> CHEN, J. C. P.			
	CHEN, M. J., <i>see</i> CHEN, C. T.			
	CHEN, W. P. and TSOU, C. H. Gum manufacture from sucrose. (Abs.)	381		
	<i>et al.</i> Gum manufacture from sucrose	382		
	<i>et al.</i> Determination of bagasse and molasses as animal fodder. (Abs.)	61		
	CHENG, H. T., <i>see</i> CHENG, W. C. and SANG, S. L.			
	CHENG, S. L., <i>see</i> CHEN, W. P.			
	CHENG, W. C. <i>et al.</i> Chloride and phosphate determination. (Abs.)	346		
	<i>see also</i> SANG, S. L.			
	CHENG, W. Y. Cane borer parasites and predators. (Abs.)	207		
	- Cane borer sex attractant. (Abs.)	76		
	CHENG, Y., <i>see</i> CHEN, Y.			
	CHEKAS, I. S., <i>see</i> KRIVCHUN, A. N.			
	CHERENKO, V. F., <i>see</i> BAZHAL, I. G.			
	CHERNINKA, V. G., <i>see</i> GOLYBIN, V. A.			
	CHERNY, A. A. and ZEPPEL, V. D. Factory temperatures and heat liberation. (Abs.)	89		
	CHETTY, G. K. By-products utilization	309		
	CHIASSON, D. J., <i>see</i> FORTNOR, D. B.			
	CHIKIN, G. A. and SELEMEYEV, V. F. Colour adsorption by active carbon	57		
	- pH and melanoidin adsorption by decolorizing resins. (Abs.)	27		
	- Sugar adsorption by ion exchange resin. (Abs.)	315		
	CHILDS, H. E., <i>see</i> BICKLE, R. E.			
	CHILTON, S. J. P., <i>see</i> GORONEL, M. and STEBB, R. J.			
	CHOD, J. C., <i>see</i> RÍMSA, V.			
	CHOU, C. C. Phosphates in refining..	314		
	and HANSON, K. R. Automatic polarimeter evaluation. (Abs.)	318		
	CHRISTENSON, D. R. Inter-row spacing, rotation and nitrogen effects on beet yield. (Abs.)	371		
	CHRISTIE, E. M., <i>see</i> MADDAN, W. L.			
	CHRISTMANN, J. Beet growth regulators and chemical insecticides. (Abs.)	211		
	- Polyploid monogerm beet seed production. (Abs.)	181		
	CHU, F., <i>see</i> GORONEL, M.			
	CHU, H. <i>et al.</i> Effective rainfall in Taiwan. (Abs.)	76		
	CHU, Y. Irrigation well construction in Taiwan. (Abs.)	367		
	CHUDAKOV, G. M. <i>et al.</i> Centrifugal masscuite feed control. (Abs.)	376		
	- FV1-106.1N-1 continuous centrifugal. (Abs.)	121		
	CHUGUNOV, I. G. Factory water consumption reduction. (Abs.)	310		
	CHURCHILL, D. B., <i>see</i> CLAYTON, J. E.			
	CHYOT, M. S., <i>see</i> CHU, H.			
	CIFUENTES, O. M., <i>see</i> COCHRAN, B. J.			
	CHIALIK, J., <i>see</i> MORFPI, N.			
	CHIVERRA, G. L., <i>see</i> MATTEUZZI, D.			
	ČÍŽ, K. Masscuite rheological properties. (Abs.)	348		
	- Sucrose solution wetting angle. (Abs.)	220		
	and ČEKROVÁ, V. Decolorizing resin regeneration. (Abs.)	57		
	<i>et al.</i> Beet diffusion water pH effects	217		
	- Boiling with masscuite surface-active additives. (Abs.)	218		
	CLARKE, C. D. and WEBBER, M. Automatic evaporation control. (Abs.)	84		
	CLARKE, E. G. Steam and power generation efficiency. (Abs.)	57		
	CLARKE, M. A. Silicon effect on sugar manufacture and refining. (Abs.)	283		
	<i>see also</i> CARPENTIER, F. G., MORRIS, N. M. and WEBB, W. A. C.			
	CLARKE, S. G. and MATTHEWS, B. C. H. Shredder hammer failure. (Abs.)	341		
	CLAYTON, J. E. Cane harvesting photographic analysis. (Abs.)	142, 179		
	Cane planter. (Abs.)	271		
	and CHURCHILL, D. B. Cane cleaning and ELLAND, B. R. Mechanical cane harvesting and transport in U.S.	113		
	and HEDDICK, W. C. Mechanical cane harvesting in Florida. (Abs.)	369		
	<i>et al.</i> Mechanical cane harvesting and trash removal. (Abs.)	369		
	- Mechanical vs. manual harvesting and cane field losses and trash content. (Abs.)	146		
	<i>see also</i> GASCHO, G. J. and ZEPF, G. A.			
	COCCIOLO, F. and VERDOMI, M. Sucrose dissociation constants.	249		
	COCHRAN, B. J. and HADDEN, W. A. Mechanical cane harvesting and extraneous matter. (Abs.)	51		
	and WHEATLEY, R. W. Cane transport cost analysis. (Abs.)	208		
	and CHEN, J. J. Frost and cane deterioration. (Abs.)	53, 188		
	COLEMAN, S. W., <i>see</i> PATE, F. M.			
	COLLIER, P. W. Automatic boiling control. (Abs.)	85		
	COMSTOCK, J. C., <i>see</i> LADD, S. L.			
	CONTIN, M., <i>see</i> PAVAN, L.			
	COOMBS, J., <i>see</i> GROSS, D.			
	COONS, G. H. Beet hybridization. (Abs.)	307		
	COPELY, E. F. River Improvement Trusts. (Abs.)	78		
	CORDOVEZ, M. <i>et al.</i> Carbonation vs. sulphitation for white sugar manufacture. (Abs.)	117		
	CORDOVEZ Z., F. Cane syrup storage	213		
	CORMIER, R., <i>see</i> POMMEZ, P.			
	CORONA, E. and CASTANEDA, J. Seed preparation for boiling. (Abs.)	277		
	CORSINI, P. C., <i>see</i> CASAGRANDE, A. A.			
	COSSIO, R. P. and HINOJO, J. M. Weed control methods comparison. (Abs.)	302		
	<i>et al.</i> Weed control methods comparison. (Abs.)	303		
	COSTESSO, D., <i>see</i> SCHOENROCK, K. W. R.			
	COUTINHO, N. Cane development in Brazil. (Abs.)	286, 158,		
	CRAWFORD, W. B., <i>see</i> STEWARD, J. M.			
	CRESO, O. L., <i>see</i> WHAYMAN, E.			
	CROENWITZ, T. <i>et al.</i> Beet pulp drying.	349		
	- Centrifugal wash water feed costs	342		
	Crow, J. Beet seedbed preparation and drilling. (Abs.)	304		
	CUBELAR, J., <i>see</i> ALOMA, J.			
	CUBELAR, R. C., <i>see</i> HERNÁNDEZ C., L.			
	CURRO, L., <i>see</i> CETINA, R.			
	CULLEN, R. N. and JAMES, R. A. Cane railway standards. (Abs.)	335		
	<i>see also</i> IVIN, P. C. and SAWYER, G. M.			
	CURRIE, J. A. Para grass control. (Abs.)	78		
	CZERZATKI, W. and RUHM, E. Soil conditions and beet growth. (Abs.)	115		
	DABROWSKI, C., <i>see</i> WAGNEROWSKI, K.			
	DACANAY, J. C. Philippine sugar industry. (Abs.)	86		
	DACHOVSKÝ, V., <i>see</i> FERNÝ, V.			
	DADANT, R. and DE FRAISSE, C. H. Nitrogen trials in Réunion. (Abs.)	17		
	DADENKOVA, M. N. <i>et al.</i> Campaign length effect on thick juice viscosity and sucrose diffusion. (Abs.)	156		
	- Sucrose diffusion coefficient. (Abs.)	318		
	<i>see also</i> ZHMYRYA, L. P.			
	DA GLORIA, N. A. Distillery waste as fertilizer. (Abs.)	253		
	and MATTIAZZO, M. E. Vinasse and soil phosphate solubilization. (Abs.)	301		
	DAIGLE, C. J. Cane cleaner. (Abs.)	151		
	DAISHEW, M. L. and OHLOVA, N., KCl effect on sucrose solution density and refractive index. (Abs.)	316		
	- Sucrose solution free water specific volume and refractive index.	125		
	DALF, T. B. Cane specific heat. (Abs.)	220		
	DALLBRINNE, E. Beet yellowing. (Abs.)	244		
	DAMANN, K. E. and DERRICK, K. S. Ratoon stunting disease pathogen	370		
	D'AMBRA, V. <i>et al.</i> <i>Cercospora beticola</i> resistance to "Bromy" (Abs.)	181		
	DANDAR, A., <i>see</i> STUDNICKÝ, J.			
	DANIELSON, R. E., <i>see</i> NICHOLSON, M. K.			
	DANILEKO, V. M., <i>see</i> DADENKOVA, M. N. and ZHMYRYA, L. P.			
	DANKOWSKI, K. <i>et al.</i> Sugar economic pocket book, 1975/76. (N.B.)	59		
	DA SILVA, J. M. Na 56-62 cane variety	110		
	DA SILVA, M. E., <i>see</i> DE SOUZA, H. D.			
	DATSENKO, N. G., <i>see</i> KOVAL, E. T.			
	DAVIS, N. B. Aphid control. (Abs.)	242		
	Approved fungicides, herbicides and pesticides. (Abs.)	304		
	DAVIS, R. E., <i>see</i> GILLASPIE, A. G.			
	DEAN, J. L. and MILLER, J. D. Cane spot resistance testing. (Abs.)	179		
	DE ANDRE, G. Italian sugar industry	279		
	DE BEER, A. G. Cane loader and trailer	302		
	<i>see also</i> MEYER, E.			
	DEBRECZENI, B. and KOVÁCS, K. Chemical weed control and fertilizer effects on cane. (Abs.)	83		
	DE CAMPOS, H., <i>see</i> DE OLIVEIRA, E. R. and FILHO, J. O.			
	DE CASTRO, L., <i>see</i> MORFFI, N.			
	DECEJIS, J. W., <i>see</i> MAYLOTT, A. O.			
	DE CLIPPEL, R. Fertilizer rate optimization. (Abs.)	149		
	DE FRAISSE, C. H. Cane varietal trials in Réunion. (Abs.)	17		
	Nitrogen and calcium trials in Réunion. (Abs.)	17		
	<i>see also</i> DADANT, R. and LOYNET, G.			
	DEGEEST, J. <i>et al.</i> Molasses sugar extraction. (Abs.)	55, 121		
	DE JAIN, L. Chassis. (Abs.)	214		
	DELAIVER, H. J. BMA cane diffusers	277		
	<i>see also</i> GRYLUS, E.			
	DELAVOUET, G., <i>see</i> JULIEN, R.			
	DE LIMA, R. O. R., <i>see</i> PEREIRA, E. F.			
	DEL GOSIARO, E. L. Cane agriculture for increased sugar yield. (Abs.)	15		

INDEX

PAGE		PAGE		PAGE
150	DEL VALLE, E. Bagacillo pressing... Evaporator and juice heater arrangement optimization. (Abs.)	151	DEMAUX, M. Beet pulp pressing. (Abs.)	253
120	DEMICKI, H. et al. DC-6 beet diffuser	270	DE MORAES, R. S. and DE SOUZA, J. A. C. M. Cane varietal trials in Brazil. (Abs.)	304
304	DE MORAES, R. S., see STUPIELLO, J. P.	249	DE OLIVEIRA, E. R. and STUPIELLO, J. P. Temperature corrections for ash determination. (Abs.)	16
310	DE MORAES, R. S., see STUPIELLO, J. P.	310	DEPKE, F. M. Concrete protection... DERBYNCHENKO, V. T., see FEDOR-ENCHENKO, L. A. and FEDOTKIN, I. M.	87
87	DERRICK, K. S., see DAMANN, K. E.	303	DE SOUZA, H. D. and DA SILVA, M. F. Cane borers in Brazil. (Abs.)	349
253	DEMAUX, M. Beet pulp pressing. (Abs.)	183	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	183
120	DEMICKI, H. et al. DC-6 beet diffuser	178	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	183
270	DE MORAES, R. S. and DE SOUZA, J. A. C. M. Cane borers in Brazil. (Abs.)	249	DESPRADES, O., see PAYAN, L.	178
304	DE MORAES, R. S., see STUPIELLO, J. P.	349	DESTEFANO, P. Potassium, calcium and chloride in cane. (Abs.)	178
249	DE MORAES, R. S., see STUPIELLO, J. P.	178	DETAVERNIER, R., see DEVILLERS, P.	158
16	DEPKE, F. M. Concrete protection... DERBYNCHENKO, V. T., see FEDOR-ENCHENKO, L. A. and FEDOTKIN, I. M.	158	DETRoux, L., see BELLEN, J. M.	281
310	DEPKE, F. M. Concrete protection... DERBYNCHENKO, V. T., see FEDOR-ENCHENKO, L. A. and FEDOTKIN, I. M.	281	DEVILLE, J. and WONG YU CHEONG, Y. Cane stalks and top yield and composition. (Abs.)	158
87	DERRICK, K. S., see DAMANN, K. E.	158	DEVILLERS, P. et al. Ammonia in beet sugar manufacture. (Abs.)	24
303	DE SOUZA, H. D. and DA SILVA, M. F. Cane borers in Brazil. (Abs.)	24	- Beet composition and juice purity and sugar yield predictions.	60, 189
349	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	60, 189	- Evaporator scale formation. (Abs.)	377
183	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	377	- Juice ash components and evaporator scale and corrosion.	56, 120
178	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	56, 120	- Raffinose effect on beet sugar determination. (Abs.)	249
183	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	249	- Sucrose determination. (Abs.)	91, 93, 348
178	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	91, 93, 348	DE VLETER, R. and VAN GILS, W. Sugar losses in damaged beet and wind. E. Waste water treatment and COD determination. (Abs.)	251, 280
178	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	251, 280	DE ZANOCHE, C. and BARALDI, G. Soil profile and beet planting. (Abs.)	305
251, 280	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	305	see also AMADEUCCI, M. T.	
305	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	253	DHANKHAR, H. S. Citric acid manufacture from molasses. (Abs.)	48
253	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	48	DIAZ, B. R. Yellow aphid control. (Abs.)	245
48	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	245	DIAZ, G., see CARRAZANA R., L.	53
245	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	53	DIAZ, T. and FREDMAN, P. Boiling mathematical model. (Abs.)	22
245	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	22	DIAZ, F. "Rototec" metallization	142
22	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	142	DIAZ, G. E. P. et al. Evaporator tube corrosion. (Abs.)	180
142	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	180	DICK, J. and KARIS, R. H. G. Nitrogen effect on beet sugar and N contents. (Abs.)	54
180	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	54	DICKS, H. G. Factory equipment vibrations. (Abs.)	313
54	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	313	DIDUSIKO, B. G. and GARYAZHA, V. T. Massecuite layer thickness and flow rate measurement in boiling. (Abs.)	310
313	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	310	see also GARYAZHA, V. T.	
310	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	375	DIGO H., G., see FERNANDEZ C., L.	18
375	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	18	DITMAIER, T., see PREY, V.	272
18	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	272	DIRKX, G. T. Explosion hazards and prevention. (Abs.)	139
272	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	139	DIVIZIA, M. T., see MARIOTTI, J. A.	144
139	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	144	DIXIT, H. N., see BHARDWAJ, K. M. and OJHA, S. K.	179
144	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	179	DIXON, P. M. S. Factory work patterns	375
179	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	375	DIXON, P. M. S. Factory work patterns	18
375	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	18	DOBA, K. Dodder control. (Abs.)	272
18	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	272	DOBBS, K. S. Cane flowering in Egypt	139
272	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	139	DOBRECKY, J. Multiple elution with partial recycle	144
139	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	144	DODGEN, G. Cane stalk chopper. (Abs.)	179
144	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	179	DOEGLI, V. P. Waste water treatment. (Abs.)	378
179	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	378	DODOLINA, V. P. Waste water treatment. (Abs.)	343
378	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	343	DODSON, A. K., see MATSUOKA, S.	61
343	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	61	DOLGORUCHENKO, L. E. Beet molasses and pulp as animal fodder. (Abs.)	21
61	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	21	DONBY, D. L. and WHITNEY, E. D. Beet nematode resistance determination. (Abs.)	21
21	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	21	see also WHITNEY, E. D.	
21	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	151	DONOVAN, J., see BASS, R. J.	301
151	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	301	DOOLAN, B. J., see JACKLIN, G. D.	215
301	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	215	DORCHENKO, G. P., see PARKHOMETS, A. P.	151
215	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	151	DORNIER, J. Experimental evaporator dos Santos, M. A. C. Nitrogen fertilization. (Abs.)	301
151	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	301	DORZENKO, A. D., see SIMONS, S. R.	215
301	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	215	DOUCERAIN, J. N. Beet storage and washing. (Abs.)	215
215	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	215	DOUVAL, C., see CARRAZANA R., L.	158
215	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	158	DOVGOPOI, V. I. et al. Condensate removal and utilization. (Abs.)	316
158	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	316	- Vacuum pan condenser. (Abs.)	242
316	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	242	see also VAISMAN, M. L.	
242	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	78	DOWLING, J. F., see VALASCO, V. S.	209
78	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	209	DOWNS, P. H. Soil structure and cane growth. (Abs.)	148
209	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	148	DRABEK, K. Beet seed drilling and stand quality. (Abs.)	339
148	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	339	DRAYCOTT, A. P. Autumn vs. spring fertilizer application. (Abs.)	339
339	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	339	and DURRANT, M. J. Optimum phosphorus application to beet.	339
339	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	339	see also LAST, P. J.	
339	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	339	DREVAL, A. A., see SINAT-RADCHENKO, D. B.	370
339	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	370	DRUGHAK, N. D., see LAPIN, A. P.	314
370	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	314	DRUZHLYAKOV, V. P., see DUNAËV, P. T.	123
314	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	123	DUBRY, L. N. and JOSHI, R. D. Cane mosaic effect on red rot and smut	279
314	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	279	DUBOIS, J. P., see SIMONART, A.	145
279	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	145	DUEÑAS, J. A. Refinery liquor clarification with polymer flocculants.	207
145	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	207	DUIRER, M. S., see SANDHU, J. S.	178
207	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	178	DUIRER, A. N. and DUNAËVSKII, D. K. Refinery equipment heat insulation. (Abs.)	370
178	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	370	DUNAËV, P. T. et al. Beet diffusion water treatment with aluminium sulphate. (Abs.)	123
370	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	123	DUNAËVSKII, D. K., see DUIRER, A. N.	145
123	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	145	DUNCKELMAN, P. H. Cane breeding in Louisiana. (Abs.)	207
145	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	207	and BLANCHARD, M. A. Cane breeding in U.S. (Abs.)	178
207	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	178	- Cane flowering induction. (Abs.)	304
178	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	304	see also BREAUUX, R. D.	
178	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	304	DUNNING, R. A. and WINDER, G. H. Aphids and virus yellows control	185
304	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	185	DURAL, R., see SITHANANTHAM, S.	207
185	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	207	DURANT, M. J., see DRAYCOTT, A. P.	207
207	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	207	DURANT, M. J., see DRAYCOTT, A. P.	185
207	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	185	DUSEK, S. Beet unloader. (Abs.)	185
185	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	185	DUTCHAK, V. V., see BOBROVNIK, L. D.	304
185	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	304	DUTT, B. M., see CHATTERJEE, A. C.	207
304	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	207	DUTTON, J. V., see OLDFIELD, J. F. T.	207
207	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	207	DVOINYKH, V. I., see TRINO, V. P.	111
207	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	111	DYCHENKO, M. V., see KRAVETS, I. M.	111
111	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	111	DZIUBINSKI, M., see KEMBLOWSKI, Z.	111
111	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	111	EASTWOOD, D. Chemical cane ripening	111
111	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	111	Chemical treatment and cane sett germination. (Abs.)	275
111	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	275	EBERS, G. et al. Chemical weed control	86
275	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	86	EBLY, R. W. Conveyor chains. (Abs.)	204
86	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	204	EEDOWES, M. Chemical weed control	78, 334
204	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	78, 334	Eggs, B. T. Compulsory plant cane source inspection for disease. (Abs.)	78, 334
204	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	78, 334	Piji disease. (Abs.)	78, 334
78, 334	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	78, 334	Egiservian, E. E., see KOLOMETS, V. F.	186
78, 334	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	186	EIGLER, H., see WALLENSTEIN, H. D.	311
186	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	EHLIS, C. P., see BRATTY, K. D.	186
311	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	186	EIBERZHOEK, B. I., see LILA, N. G.	186
186	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	186	ELLAND, B. R., see CLAYTON, J. E.	186
186	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	186	EL AMA, F., see MAUCH, W.	186
186	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	186	ELAGIN, A. A. and LUKACHEV, B. I. Impurities removal in beet washing	311
186	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	et al. Beet pile lime sprayer. (Abs.)	311
311	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	EL-BADAWI, A. A., see HEMAIDA, S.	311
311	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	EL-GHANI, A. and SAYED, G. EL-K.	311
311	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	EL-DIEN, M. S., see MANSOUR, O. Y.	311
311	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	EMEL'YANOV, N. A. Loading, unloading, conveying and storage mechanization. (Abs.)	311
311	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	et al. Beet storage in USSR. (Abs.)	311
311	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	see also KICHIGIN, N. M.	
311	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	311	EMMERICH, A. et al. Sucrose and non-sugars auto-diffusion. (Abs.)	380
380	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	380	see also SCHNEIDER, F.	
380	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	380	EMPIO, P. and ESCUERRA, M. C. Cane varieties in the Philippines. (Abs.)	111
111	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	111	ENGELSTAD, O. P. and HAUCK, R. D. Urea as fertilizer. (Abs.)	241
111	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	241	ENGSTAD, O. P. and SPINOSO, J. G. Bagasse press performance. (Abs.)	119
241	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	119	ENOSTROM, F., see KUJALA, P.	310
119	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	310	EREMENKO, L. Beet slicer hopper level control. (Abs.)	219
310	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	219	ESPARZA, R. Refined sugar crystal size control. (Abs.)	219
219	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	219	ESPINOSA, R., see EMPIO, P.	219
219	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)	219	ESQUERRA, M. C., see EMPIO, P.	219
219	DE SOUZA, L. G. et al. Distillation column scale composition. (Abs.)			

INDEX

	PAGE
FOX, S. D., <i>see</i> AKESON, W. R.	
FRANKS, M. G. Beet growth and quality. (Abs.)	371
FRANCIS, G. H. Beet tops as animal fodder. (Abs.)	126
FRANKS, G. N., <i>see</i> CLAYTON, R. E.	
FREEMAN, C. E. and WALKER, R. L. Cane breeding in U.S. (Abs.)	114
FREEMAN, K. C., <i>see</i> ZUMMO, N.	
FREIVALDS, J. Molasses and beet pulp as animal fodder. (Abs.)	190
FREES, H. Bagasse board manufacture	253
FRESHWATER, I. T. Cane varieties in Australia. (Abs.)	331
Nitrogen trials in Australia. (Abs.)	47
FREW, J. A. and WRIGHT, P. G. Boiling	372
FREYTAG, A. H. Beet growth regulators and LINDEN, J. C. Ethylene in beet diffusion. (Abs.)	19
FRIAS DE F., A. M. <i>et al.</i> Enzyme and morphology variations in cane clones. (Abs.)	218
FRIEDMAN, F., <i>see</i> DIAZ, T.	
FRIESECKE, G. Overhead irrigation	307
FRIML, M. Chemical control parameters calculation. (Abs.)	378
and POCHYLÁ, S. Molasses exhaustibility determination. (Abs.)	247
and PUCHERNA, J. Laboratory apparatus standardization. (Abs.)	27
and STENOL, R. Continuous crystallization. (Abs.)	215, 218
and TICHÁ, B. Beet juice purity determination. (Abs.)	124
<i>see also</i> SKALA, L.	
FRONTERA, A. R. <i>et al.</i> Cane molasses as animal fodder. (Abs.)	158
FROST, K. R. Chemical cane ripening	144
FUEHRING, H. D. and FINKNER, R. E. Agronomic factors and beet yield and quality. (Abs.)	21
FUJII, S. <i>et al.</i> Heavy liquor ion exchange treatment. (Abs.)	123
FULCHER, R. P. and INKERMAN, P. A. Dextran hydrolysis. (Abs.)	379
FUNDORA, G. F. Cane molasses exhaustion calculation. (Abs.)	151
Sugar factory layout. (Abs.)	277
FURBER, M. E. and TSYGURA, V. R. Level measurement in beet diffuser	216
FURSOV, V. M., <i>see</i> GROMKOVSKI, A. I.	
GADZHIEV, A. Y., <i>see</i> RYAZANTSEVA, L. I.	
GALBÁN, I. White sugar manufacture	314
GALLARATE, G. Aqueous ammonia fertilizer trials. (Abs.)	115
GANDIA, L., <i>see</i> ALARI, D.	
GANGAVATI, S. S., <i>see</i> MUKHERJI, J. P.	
GARGUR, W. Field spray equipment	307
GARCIA, M. A., <i>see</i> SEIP, J. J.	
GARGO, J. S. and AZAD, M. P. Beet growing in Uttar Pradesh. (Abs.)	211
GARYAZHA, V. T. and DIPUSKO, B. G. Heat transfer in boiling. (Abs.)	152
<i>et al.</i> Masscuite circulation increase in boiling by steam injection	185
<i>see also</i> ARTUKHOV, Y. G., DIDUSHIKO, B. G. and PAVELKO, V. I.	
GASCHO, G. J. <i>et al.</i> Cane deterioration after harvesting. (Abs.)	150
<i>see also</i> MILLER, J. D.	
GASKILL, J. O., <i>see</i> HECKER, R. J.	
GATLEY, T. W., <i>see</i> JACKLIN, G. D.	
GAVIOLI, E., <i>see</i> BERTOLANI, G.	
GAVRIUTSK, I. I. Sugars separation by thin-layer chromatography. (Abs.)	188
GAYLE, F. L., <i>see</i> SEIP, J. J.	
GEBLER, J., <i>see</i> CÍZ, K.	
GELABERT, O., <i>see</i> TRIANA, G.	
GENIE, G. V. Beet diffusion. (Abs.)	25, 248, 312, 343
Cane diffusion. (Cont.)	269
GENOTELLE, J. Losses in beet sugar manufacture. (Abs.)	121
Masscuite crystallization. (Abs.)	90
<i>see also</i> AHARI, D.	
GENTIL, L. V. Cane mechanization and transport costs and performance. Mechanical cane harvesting. (Abs.)	58
336	
GENTRY, J. P., <i>see</i> GASCHO, G. J.	
GEORGI, B., <i>see</i> BURBA, M.	
GEPEKE, S. T., <i>see</i> TROINO, V. P.	
GERASIMOVA, R. Y., <i>see</i> SHALIMOVA, T.	
GERBUT, K. F., <i>see</i> VIL'SHANSKI, A. A.	
GIAMALVA, M. J., <i>see</i> FANGUY, H. P.	
FONTENOT, D. B., MARTIN, F. A. and RICHARD, B. Beet diffusion loss calculation. (Abs.)	247
GIARDINA, J. Cane containerization.	177
GIBSON, W. Drip irrigation. (Abs.)	80
Subsurface and drip irrigation. (Abs.)	40, 111
and BUT, U. Irrigation tube flushing with water. (Abs.)	369
<i>see also</i> BUT, U. and McELHOE, B.	
GIERADA, E. and TOBOLA, A. Automatic boiling control. (Abs.)	280

GILES, J. F., <i>see</i> REUSS, J. O.	
GILLESPIE, A. G. and KOIKE, H. Cane susceptibility to maize dwarf mosaic virus. (Abs.)	113
and MCKNEW, C. C. Cane quarantine in U.S. (Abs.)	142
and WOBBLEY, J. F. Brown stunting disease pathogen. (Abs.)	178
<i>et al.</i> Ratoon stunting disease pathogen. (Abs.)	176, 370
<i>see also</i> KOIKE, H.	
GIMÉNEZ L., O. and PÉREZ A., E. Cane breeding in Argentina. (Abs.)	302
<i>see also</i> MARIOTTI, J. A.	
GIORGIO, J. C. Beet sugar factory processes and equipment. (Abs.)	56
and RICHARD, B. Beet diffusion loss calculation. (Abs.)	247
GLADKII, V. N., <i>see</i> TROINO, V. P.	
GLASS, J. S., <i>see</i> CHANCELLOR, A. H.	
GODDY, O. P., <i>see</i> BRINHOLI, O. and CASAGRANDE, A. A.	
GODSHALL, M. A. and ROBERTS, E. J. Sugar analysis by gas-liquid chromatography. (Abs.)	283
<i>see also</i> ROBERTS, E. J.	
GOEL, D. P. and BHALWAR, V. M. Filter press plate type and performance. (Abs.)	213
GOLYN, L. E. Fertilizer analyses on same root and stubble yields	145
Filter cake effect on cane. (Abs.)	114
Lime and phosphate effects on cane	112
GOLDSMITH, T. J., <i>see</i> WILDMAN, S. V.	
GOLDENYAR, Y. D. <i>et al.</i> Beet quality, reception and storage effects on sugar yield. (Abs.)	87
<i>see also</i> KRAVETS, Y. O.	
GOLDYIN, V. A. and IVANOV, S. Z. Beet juice reducing matter and Hmin. (Abs.)	120
<i>et al.</i> Calcium, potassium and invert sugar melleissic coefficients	27
reducing sugars and molasses formation. (Abs.)	92, 249
<i>see also</i> IVANOV, S. Z.	
GOMAND, N., <i>see</i> BELIEN, J. M.	
GOMANYUK, D. G., <i>see</i> KHELEMSKII, M. Z.	
GOMER, R. L., <i>see</i> FABREGAT P., P. M.	
GONCHARENKO, B. I., <i>see</i> KIRICHENKO, A. G.	
GONCHARUK, M. V., <i>see</i> IVANOV, S. Z.	
GONBY, I. Saccharate process waste water as animal fodder additive 126,	190
GONZÁLEZ, M., <i>see</i> TRIANA, G.	
GONZÁLEZ E., M. D. and VÁZQUEZ G., M. A. Bagasse and cane trash fibre properties. (Abs.)	253
GOOD, R. E., <i>see</i> RODRÍGUEZ G., E.	
GOOD, R. H. "Rotocel" cane diffuser	23
GOODENOUGH, P. W. and PLAYER, M. R. Boiling with masscuite forced circulation. (Abs.)	84
GOOS, R. J. M., <i>see</i> ROSENBERG, L.	
GORALCZYK, W. Polish sugar industry	88
GOROKH, V. N. and SHTANGEBY, K. O. Condenser in condenser gases and evaporator vacuum. (Abs.)	342
<i>et al.</i> Condenser. (Abs.)	89
Evaporator. (Abs.)	281
<i>see also</i> KNYAZEV, A. A., KOSMINSKII, V. V. and VAKHIN, L. I.	
GORONEL, M. <i>et al.</i> L 60-14 cane variety	146
GORTZ, K., <i>see</i> EBERS, G.	
GORY, P., <i>see</i> DEVILLERS, P.	
GOSNELL, J. M. and LONSDALE, J. E. Drying-off effect on cane yield and quality	7
<i>see also</i> LONSDALE, J. E.	
GOTTHARD, D. <i>et al.</i> Low head vacuum pan performance. (Abs.)	86
GOYAL, K. N. and TYAGI, R. N. S. Cane ovariolicous smut. (Abs.)	273
Cane yellowing disease control.	365
<i>see also</i> TYAGI, R. N. S.	
GRAB, A. Beet varietal trials in Austria	274
GRAHAM, B. W. Cane utilization as fuel	51
GRAHAM, F. A. St. James factory performance. (Abs.)	150
GRAVES, C. R., <i>see</i> ALLAWAY, R. A.	
GREENWOOD, W. A. Factors equipment installation and re-location programme. (Abs.)	54
and HAYES, J. B. Cane train handling and process control. (Abs.)	51
GREULICH, E. Waste water treatment	187
GRIFFIN, G. D. Beet nematodes. (Abs.)	116
<i>see also</i> MUMFORD, D. L.	
GRILLON, F. A. Air and water pollution reduction. (Abs.)	150
GRIMLEY, S. C. and ALLAWAY, R. A. Clarification mud treatment by centrifuge. (Abs.)	86
Computerized process control.	86
GRIMM, T. Beet seed X-ray analysis	211
GRINBERG, T. A., <i>see</i> STARNIKOVA, E. V.	
GROISMAN, A. M., <i>see</i> DERZHAVETS, A. S.	
GROMKOVSKI, A. I. <i>et al.</i> Crystallizer power consumption calculation.	89
GROSS, D. and COOMBS, J. Beet and cane juice enzymes and colour formation	69, 106

	PAGE
GROULT, M., <i>see</i> DEVILLERS, P.	
GRUBER, H., <i>see</i> FREY, V.	
GRUSHCHENKO, V. I., <i>see</i> KICHIGIN, N. M.	
GRYLUS, E. and DELAVIER, H. J. Beet juice ion exchange treatment	185, 187
GRYLUS, V. Beet juice ion exchange treatment. (Abs.)	278, 281
GUBÉRAIN, J. and FOURLIÈRE, S. Synthetic alcohol determination in synthetic-fermentation alcohol mixture. (Abs.)	221
GUBERN, J. Beet sugar accumulation.	339
GUBERRA D., J. Calcium phosphate precipitation in clarification	35, 73
GUILDAY, A. Bagasse conveying	151
GUILLOTTE, P., <i>see</i> SHULER, J. H.	
GULYI, I. S. <i>et al.</i> Continuous boiling and masscuite colour. (Abs.)	153
Continuous vacuum pan. (Abs.)	153
Mathematical simulation of continuous boiling. (Abs.)	376
Temperature change frequency and success crystallization	153
<i>see also</i> BAZHAL, G. G., BOGOROSH, A. T., SHTANGEBY, V. O. and ZUBCHENKO, V. P.	
GUPTA, D. N., and SINGH, R. Cane varieties for gut manufacture	271
GUPTA, K. C., <i>see</i> ROSE, S.	
GUPTA, K. M., <i>see</i> SINGH, D. J. C.	
GUPTA, M. C., <i>see</i> KALRA, A. N.	
GUPTA, R. C., <i>see</i> AGARWAL, S. K. D.	
GUPTA, S. C. and PRABHU, K. A. Distillery waste treatment. (Abs.)	381
<i>see also</i> AGARWAL, M. L.	
GUPTA, U. P., <i>see</i> JOSHI, R. D.	
GUTHA, S. N., <i>see</i> SRIRAMULU, C. R.	
GURUMURTHY, S. and SIVASWAMY, M. S. Cane milling-cum-diffusion	118
GUTIÉRREZ, L. <i>et al.</i> Bagasse pulp manufacture. (Abs.)	94
GUTMANSKI, I. Beet planting and yield. (Abs.)	276
Excessive fertilizer application rates	181
HADDEN, W. A., <i>see</i> COCHRAN, B. J.	
HADDOCK, J. L., <i>see</i> RYSER, G. K.	
HADJIANTONIOU, D. Greek sugar industry	377
HAECKEL, D. Screen perforations and centrifugal throughput. (Abs.)	53
HAGELBERG, G. B. World sugar economy. (N.B.)	345
World sugar production. (N.B.)	155
HAGIHARA, H. H. Filter cake and trash mulch effect on soil nutrients and water yield. (Abs.)	80
HADY, J. Excess bagasse burning for power production. (Abs.)	221
HAINES, W. S. Drip irrigation. (Abs.)	368
HALE, D. J. and PARTRIDGE, B. Clarification interfacial-tension control. (Abs.)	372
HALL, A. S. Cane harvesting. (Abs.)	368
HALL, D. H., <i>see</i> HILLS, F. J.	
HAM, G. J. Underground water quality	47
<i>see also</i> KINGSTON, G.	
HAMMADI, K. A., <i>see</i> MOHAMED, M. A.	
HAMPEL, W., <i>see</i> KUBADINOW, N.	
HAMPELOVÁ, K., <i>see</i> TONINGEROVÁ, D.	
HAMPSON, R. J., <i>see</i> FERGUSON, G. A.	
HANGYAI, K. Magna boiling. (Abs.)	186
HANSEN, G. B. Cane railway "sled"	335
HANSEN, S. A. Sugars determination by thin-layer chromatography	157
HANSON, K. R., <i>see</i> CHOU, C. C.	
HANUS, H., <i>see</i> MORTAZAVI, M.	
HAPNER, K. D., <i>see</i> STROBEL, G. A.	
HÄUBNER, W., <i>see</i> BELIEN, J. M.	
HARAKADA, D. C. Air compressors	341
HARDING, R., <i>see</i> BRETT, P. G. C.	
HARPER, R., <i>see</i> SHULER, J. H.	
HARRIS, R. H. G. Soil nematode vertical distribution. (Abs.)	174
<i>see also</i> DICK, J.	
HART, C. W. Cane harvester-cleaner	79
HART, E. W. Beet tops as animal fodder. (Abs.)	252
HART, H. Fertilizers and beet juice quality. (Abs.)	21
HARTLEY, W. Beet seed drill maintenance and operator protection from chemicals. (Abs.)	18
HARVEY, A. C., <i>see</i> PAULUS, A. O.	
HAUCK, R. D., <i>see</i> ENGELSTADT, O. P.	
HAUFE, W., <i>see</i> BURBA, M.	
HAYES, A. G. Cane yellow wilt. (Abs.)	143
HAYES, J. B., <i>see</i> GREENWOOD, W. A.	
HAYSON, M. B. C. and CHAPMAN, L. S. Available silicon determination in soil and calcium silicate application. (Abs.)	50
HAYWOOD, A. C., <i>see</i> TRABELLA, D. S.	
HEBER, L. P. Cane milling quality assessment. (Abs.)	112
HEBERT, R. M. Cane sampling and analysis. (Abs.)	347
HECKER, R. J. and GASKILL, J. O. Isolation chambers for beet seed production. (Abs.)	242

INDEX

PAGE		PAGE		PAGE
	HEDICK, W. C., see CLAYTON, J. E.		HUSSEIN, M. A., see HEMAIDA, S. EL-N. A.	
	HEGDE, R. K., see SULLADMATH, V. V.		HUSSEY, A. J. Automatic cane carrier	
	HEINZ, D. J., see LADD, S. L.	247	speed control. (Abs.)	118
	HEITZ, F. Filtration. (Abs.)	28	HUTCHINSON, B. <i>et al.</i> Beet pulp drying	382
	HEWZ, S. Sucrose solution properties. (Abs.)	28	HWANG, D. Z., see FANG, Y. T.	
	HELLER, C. Beet harvesters and transport. (Abs.)	21	HYNDSHAW, A. Y. Active carbon selection. (Abs.)	57
	HELLMANN, D. B. Cane varietal trials in South Africa. (Abs.)	175		
	HEMAIDA, S. EL-N. A. <i>et al.</i> Cane burning effect on juice quality and sugar yield. (Abs.)	302		
	- Cane trash and sugar losses. (Abs.)	308		
	HENDERSON, M. T., see LEGENDRE, B. L., RICHARD, C. A. and VIATOR, H. P.			
	HENDRICK, L. W. <i>et al.</i> Chemical weed control. (Abs.)	149		
	HENKEL, C. R. Soil conservation structure and drain maintenance. (Abs.)	332		
	Tractor three-point linkage. (Abs.)	78		
	HENNINGTON, P. Carbonation. (Abs.)	157		
	HENZE, R. Beet pulp dryer. (Abs.)	349		
	HEPLER, P. R. Beet growth retardant effects on sugar content and yield	20		
	HEPPNER, H. J. Juice heater and evaporator tube corrosion. (Abs.)	218		
	HERCIN, J. and DACHOVSKÝ, V. Disinfectant. (Abs.)	90		
	HERNÁNDEZ, M. T. and HERRERA, N. Micro-organisms and stored sugar deterioration. (Abs.)	22		
	HERNÁNDEZ C. L. <i>et al.</i> Cane milling materials balance calculation	117		
	HERRERA, N., see HERNÁNDEZ, M. T.			
	HERVE, D. Ion exchange. (Abs.)	56		
	HESCH, R. Bagasse board properties	94		
	HESS, W. M., see STROBEL, G. A.			
	HETHERINGTON, M. A. Pineapple disease. (Abs.)	47		
	HIBBERT, D. <i>et al.</i> Molasses beet pulp trace elements. (Abs.)	379		
	see also KOSTER, P. B.			
	HIDI, P. and STAKEB, R. Dextran reduction. (Abs.)	85		
	HIES, K. Beet knife treatment. (Abs.)	90		
	HILLS, F. J. Beet spacing effect on sugar content and yield. (Abs.)	19		
	<i>et al.</i> Beet powdery mildew control	148		
	see also RUIZ, G. G.			
	HILTON, H. W. <i>et al.</i> Cane ripener and herbicide residues. (Abs.)	81		
	HINOJO, J. M., see COSSIO, R. P.			
	HIRATA, E. Y. Irrigation with sewage effluent. (Abs.)	81		
	HIRUMI, H., see URBINA-VIDAL, C.			
	HITCHCOCK, B. E. Locusts. (Abs.)	208		
	and KERKWR, R. E. Rat control	50		
	Ho, C. C. Soil drainage pipe sand removal. (Abs.)	112		
	HOARE, E. R. Irrigation in Australia	49		
	HOBBIS, J. and BATTERMAN, L. Beet analysis and storage properties.	92		
	HOBKOVÁ, V., see ČÍŽ, K.			
	HOBHUM, J. and TIEDGE, H. G. Drought and beet crop in West Germany	244		
	HODEN, A., see JOURNET, M.			
	HODSON, R. C. Single or double cane drills. (Abs.)	205		
	and LEGENDRE, B. Mechanical cane harvesting. (Abs.)	16		
	HOEKSTRA, A. Irrigation in Peru	301		
	HOEKSTRA, R. G. Cane harvesting-crushing delays. (Abs.)	151		
	HOFFMANN-WALBECK, H. P. and PELLEGRIANI, A. Waste water treatment. (Abs.)	186		
	HOLLATS, F. Beet diffusion water treatment and formalin activity. 55,	152		
	Galactinol determination in beet molasses. (Abs.)	284		
	HONDA, S. <i>et al.</i> Reducing sugars determination. (Abs.)	157		
	HOOKS, S. L., see ORSENGIO, J. R.			
	HOTON-DORGE, M. Sugars separation by thin-layer chromatography	348		
	HOUSIAU, J. and PIECK, R. Molasses electrodialysis. (Abs.)	313		
	see also DEGEST, J.			
	HRISTOPOLDOU, P. Greek sugar factory fuel consumption. (Abs.)	377		
	HRSKA, F. Beet leaf catcher water level maintenance. (Abs.)	310		
	HSTA, F. Y. Cane replanting and yield	76		
	HSEH, E. S., see YANG, T. T.			
	HUANG, Y. Y., see CHEN, Y.			
	HUDSON, J. C. Cane sugar industry energy consumption. (Abs.)	208, 273		
	<i>et al.</i> Green cane harvesting. (Abs.)	208		
	HULL, J. E. Beet seedbed preparation	18		
	Beet stand optimization. (Abs.)	305		
	Powdery mildew control. (Abs.)	305		
	see also TRAVELLER, D.			
	HULL, R., see KUJALA, P. and LAST, P. J.			
	HUMBERT, R. P. Cane leaf canopy and yield. (Abs.)	208		
	Filter cake-bagasse burning. 94, 190	253		
	Soil erosion prevention. (Abs.)	300		
	Weed control. (Abs.)	17		
	HUMMEL, L. M. Four-wheel-drive vs. track-type tractors. (Abs.)	81		
	HURTER, A. Pulverized coal firing and bagasse pneumatic firing of furnace. (Abs.)	183, 372		
	HUSSEIN, M. A., see HEMAIDA, S. EL-N. A.			
	HUSSEY, A. J. Automatic cane carrier speed control. (Abs.)	118		
	HUTCHINSON, B. <i>et al.</i> Beet pulp drying	382		
	HWANG, D. Z., see FANG, Y. T.			
	HYNDSHAW, A. Y. Active carbon selection. (Abs.)	57		
	IBRAHIM, H. S. Deep ripping and gypsum effects on cane yield	165		
	IGGO, G. A. Chemical weed control.	147		
	IGNAT'EV, L. P., see DOVGOPOL, V. I.			
	IGNATOV, N. M. and KINYAKIN, M. F. Lime application to stored beet	378		
	IKIHARA, T. Bagasse furnace explosions. (Abs.)	117		
	IL'CHENKO, N. B., see TSYUKALO, Y. F.			
	INAZU, S. Seed cane growing and cutting. (Abs.)	81		
	INKERMAN, M. R. and JAMES, G. P. Dextran reduction by enzyme.	374		
	see also FULCHER, R. P.			
	IRIMA, M. R. Liquid sugar manufacture. (Abs.)	123		
	Refinery liquor treatment. (Abs.)	123		
	IRUTHAYARAJ, M. R., see SRINIVASAN, T. R.			
	IRVINE, J. E. Cane canopy development and sugar yield. (Abs.)	113		
	Cane leaf dew sugars. (Abs.)	177		
	Cane total leaf area determination and LEGENDRE, B. L. Cane deterioration after harvesting. (Abs.)	146		
	see also LEGENDRE, B. L.			
	ISHERWOOD, M. O. Cane agriculture on flat land. (Abs.)	80		
	ITO, H., see ONDI, M.			
	IVASHENSKO, E. K., see ZAGORUL'KO, A. Y.			
	IVANOV, S. Z. <i>et al.</i> Beet sugar factory plannin. (Abs.)	216		
	- Colorants adsorption in carbonatation. (Abs.)	376		
	- Hydroxy acid salts and sucrose inversion. (Abs.)	250		
	- Ion exchange resin and bone char desorption. (Abs.)	219		
	- Potassium and sodium carbonate and sulphite effects on sucrose solubility. (Abs.)	93		
	see also GOLYBIN, V. A.			
	IVANOV, V. P., see KLOCHKOV, V. P.			
	IVAN, P. C. and CULLEN, R. N. Bagacillo separator. (Abs.)	373		
	<i>et al.</i> Automatic polimerizer. (Abs.)	92		
	IZATT, L. K., see DOWNS, P. R.			
	IZBINSKAYA, N. L., see REVA, L. P.			
	JACKLIN, G. D. Soil erosion. (Abs.)	49		
	<i>et al.</i> Spherical roller bearing cane mill. (Abs.)	54		
	JACKMAN, E., see KUJALA, P.			
	JACKSON, R. D. Muss borer rearing.	146		
	see also SUMMERS, T. E.			
	JACQUES, H. and LEBLANC, L. Sucrose epoxy resin application. (Abs.)	382		
	JAIN, G. S. Factory modifications and white sugar improvements. (Abs.)	308		
	JAIN, P. F. Cane mill performance evaluation. (Abs.)	309		
	Molasses spontaneous destruction.	222		
	JAKEL, W., see CRONWITZ, T.			
	JAMES, D. W. Fertilizer application in irrigation water. (Abs.)	18		
	JAMES, G. L. Cane varietal trials in Rhodesia. (Abs.)	175		
	Effect of nitrogen in hot water for sett treatment on cane tiller population. (Abs.)	144		
	Smut in Guyana and Martinique.	336		
	JAMES, G. P., see INKERMAN, P. A. and WELLS, W. D.			
	JAMEN, N. J. and MILLER, J. D. Cane selection. (Abs.)	178		
	see also MILLER, J. D.			
	JAMES, R. A., see CULLEN, R. N.			
	JANUSZEWICZ, I. <i>et al.</i> Weather effect on invase and beet diffusion losses. (Abs.)	306		
	JAROS, J., see SCHMIDT, L.			
	JENSEN, M. E., see CARTER, J. N.			
	JERMYS, M. Sugars determination	317		
	JESIC, V. M. Clarification mud treatment with flocculant. (Abs.)	378		
	JHA, A. <i>et al.</i> Grassy shoot virus alternative host. (Abs.)	239		
	- Grassy shoot virus physical properties. (Abs.)	114		
	JILKOVA, M., see RIMSA, V.			
	JOHNSTON, J. R. Flocc determination in refined sugar solution. (Abs.)	91		
	JOHNSON, S. R., see SAMOL, H. H.			
	JOHNSTON, M. A. Soil exchangeable sodium and hydraulic conductivity	174		
	JOHNSTON, N. A., see LANDREY, O. P.			
	JONES, D. P. Irrigation pump and motor shed. (Abs.)	331		
	Isis Land Use Scheme. (Abs.)	17		
	JOSHI, D. P., see SINGH, G.			
	JOSHI, R. D. and GUPTA, U. P. Cane mosaic host. (Abs.)	370		
	see also DUBEY, L. N. and RISHI, S. C.			
	JOURNET, M. <i>et al.</i> Beet pulp as animal fodder. (Abs.)	221		
	JOYCE, F. W., see WYMAN, J. A.			
	JUANG, T. C. <i>et al.</i> Zinc sulphate effect on cane and sugar yields. (Abs.)	335		
	see also KAO, M. M.			
	JULIEN, R. Cane ripening with chemicals. (Abs.)	176		
	<i>et al.</i> Harvest time, age and climate effects on cane yield and sugar content. (Abs.)	79		
	KARDE, J. R. <i>et al.</i> Cane sett pre-treatment and germination. (Abs.)	16		
	KARIMOTO, K., see HONDA, S.			
	KALASWAD, S. R., see CHATTERJEE, S. R.			
	KALINA, S. N., see KHELEMSKI, M. Z.			
	KALINENKO, L. G. Beet juice and syrup soluble lime salts determination. (Abs.)	156		
	KALRA, A. N. and GUPTA, M. C. White fly control by area spraying. (Abs.)	300		
	<i>et al.</i> Cane intercropping with wheat and pest problems. (Abs.)	300		
	KAMBUJ, P. D., see MUKHERJEE, S. P.			
	KAMEDA, S. S., see HILTON, H. W.			
	KAMINSKI, T., see DEMBICKI, H.			
	KAMMERER, F. K. Cube sugar manufacture. (Abs.)	343		
	Iodophores and beet diffusion disinfection. (Abs.)	377		
	KAMPEN, W. H. Rum manufacture.	190		
	KANE, R. F. Furrow irrigation and soil conservation. (Abs.)	18		
	KANWAR, R. S. Cane intercropping 176, 207	272		
	Pesticide application and cane yield and KAPUR, J. K. Cane deterioration after harvest. (Abs.)	358		
	and SINGH, S. CoJ 64 cane variety	16		
	<i>et al.</i> Beet agriculture in Punjab.	83		
	Cane sett pre-treatment and piece size effects on germination and yield. (Abs.)	16		
	see also DEOL, D. S. and SINGH, G.			
	KAO, M. M. and JUANG, T. C. Soil zinc extraction. (Abs.)	76		
	see also JUANG, T. C. and WU, M. M. H.			
	KAPOF, F. Beet damage and sugar losses. (Abs.)	122		
	KAPUR, J. K., see KANWAR, R. S.			
	KAR, K. Grassy shoot control. (Abs.)	206		
	<i>et al.</i> Cane intercropping. (Abs.)	111		
	KARAMAN, L. Beet varietal trials in Czechoslovakia. (Abs.)	243		
	KARALOV, N. B., see PARENOPULO, M. G.			
	KAREAN, K., see SINGH, G.			
	KARNASEVICH, E. M., see KRAVETS, Y. O.			
	KAR, Y. O. and NORMAN, L. W. Steffen filtrate sucrose determination	125		
	see also MOORE, M.			
	KASHIMURA, K. and YOSHIDA, Y. Refinery waste water treatment.	154		
	KASTNER, F. Factory fresh water consumption. (Abs.)	217		
	and POCHYLÝ, Z. Beet diffusion water balance calculation. (Abs.)	24		
	KATROHKA, I. M., see PARIKHOMETS, A. P.			
	KATS, B. I. Evaporator juice colour formation reduction. (Abs.)	24		
	KATMAN, Y. A., see TANTSYURA, N. D.			
	KAVUN, N. A. Disc filter leakage prevention. (Abs.)	344		
	KAWASAKI, H., see FUJII, S.			
	KAZIMIROV, R. K., see EMELYANOV, N. A.			
	KEKAR, V. K., see CHATTERJEE, A. C.			
	KELLER, A. and STALLINGS, J. D. Beet root maggot. (Abs.)	305		
	KELLY, P. H. C. Raw sugar quality evaluation. (Abs.)	199		
	KELLY, G. J., see RIDGE, D. R.			
	KEISO, L. and REICHARD, S. Cane sampling. (Abs.)	340		
	KEMBLAWSKI, Z. <i>et al.</i> Carbonatation mud rheological properties. (Abs.)	28		
	KEMTER, H. Automatic boiling control	311		
	KENTRY, J. S., see GOTHARD, D.			
	KENYON, A. S. Chemical weed control and TOPPER, J. V. Beet drilling lateness and speed. (Abs.)	243		
	KERKWR, R. E. Cane damage by wildberries. (Abs.)	47		
	Elavite feeding costs. (Abs.)	332		
	Rat control. (Abs.)	78		
	see also HITCHCOCK, B. E.			
	KERNCHEN, W. Beet tarehouse laboratory. (Abs.)	316		
	KERR, E. W. Bagasse drying. (Abs.)	86		
	KERR, W. P. Australian Sugar Year Book 1976. (N.B.)	345		
	KIRSTEN, E. Bolted beet control. (Abs.)	19		
	KESTER, G. Chemical weed control planning. (Abs.)	306		
	and KIRK, F. Soil cultivation. (Abs.)	83, 305		

INDEX

PAGE		PAGE		PAGE																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KHAMAZA, F. I., see BARKO, M. N.		KONTAXIS, D. G., see HILLS, F. J.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KHARAKOV, V., see FABREGAT, P. M.		KOONER, B. S. <i>et al.</i> Cane borer varietal susceptibility and control. (Abs.)	333																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KHARIN, S. E. <i>et al.</i> Sugars determination. (Abs.)	125	- Stalk borer incidence in Punjab	16																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KHARIN, V. M. Boiling. (Abs.)	93	KOP'EV, M. A., see MAZOV, M. Y.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	and ZHANKOV, A. L. Sucrose crystallization. (Abs.)	251, 317	KÖPFFEN, H. G. Continuous boiling.	312																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KHARTONOVA, R. I., see IVANOV, S. Z.		KOERN, R. V. <i>et al.</i> Vapour condensation. (Abs.)	344																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KHELEMSKII, M. Z. <i>et al.</i> Beet processing quality. (Abs.)	52	KORN, K., see CROWNETZ, T.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	- Loss reduction in stored beet.	87	KORBEINIKOVA, L. A., see ZAGORULKO, A. Y.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	- Stored beet ventilation and moistening. (Abs.)	311	KOROLCZUK, E., see JANUSZEWICZ, I.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	see also GOLOVYNNY, Y. D.		KORT, M. J. By-product utilization <i>et al.</i> Cane molasses sucrose determination. (Abs.)	189																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KHELEMSKII, S. M., see RAFAL'SKII, V. F.		KOSMINSKII, I. V. <i>et al.</i> Heat exchanger scale thickness determination ..	311		KHILINSKAYA, E. Y., see LAPIN, A. P.		KOSOGOR, N. F., see VASIL'eva, T. K.			KHOMENKO, A. I. Steam traps. (Abs.)	247	KOSTELKOVA, E., see NEUŽIL, L.			<i>et al.</i> Water heating with condensate	123	KOSTER, P. P. <i>et al.</i> Mercury determination in beet pulp and molasses	189, 220		see also DOVGOPOLO, V. I. and GOROKH, V. N.		KÖSTER, W. Soil phosphorus and potassium determination. (Abs.)	307		KHOMENKO, N. D., see KOVAL', E. T.		KOSTIN, N. F., see AL'DEKOV, N. A.			KHOMENKO, V. S., see PAKHODKO, A. P.		KOTEL'NIKOVA, L. P., see ROBOVNIK, D. D. and SAFRONOV, S. Z.			KHURANA, S. M. P. and SINGH, S.	143	KOULYAR, L. V. see TSYUKALO, Y. F.			Cane diseases in India. (Abs.)		KOVACS, K., see DEBRECZENI, B.			KHVALKOVSKI, T. P. Beet thick juice storage. (Abs.)	88	KOVAL', E. T. <i>et al.</i> Beet water separators. (Abs.)	56		and ZAKHAROVA, T. V. Phosphate determination in beet molasses.	250	KOVAL', Y. A., see IKHCHENKO, S. I.			<i>et al.</i> Beet thick juice storage	120, 246	KOVAL', V. G. <i>et al.</i> Vinasse chemical composition. (Abs.)	379		KHREBAB, T., see NICHOLSON, M. K.		KOVALSKO, A. D. Molasses storage and degradation. (Abs.)	190		KICHIGIN, N. M. <i>et al.</i> Beet pulp, limestone and sugar handling	375	KOVALENKO, I. D., see BRISODSKII, N. I.			- Bulk sugar carrier. (Abs.)	185, 376	KOVALENOK, I. K., see LILA, N. G.			see also EML'YANOV, N. A. and VASIL'EV, V. I.		KOVAJS, J. and NISZTRAWSKI, Z. Citric acid manufacture from molasses. (Abs.)	285		KIRBY, M. and O'SHELVAN, M. Chromatography applications. (Abs.)	317	KOZEL'TSOVA, N. N. P., see IVANOV, S. Z.			KIMBER, D. S. and MCCULLAGH, S. F. H. Beet varietal trials in U.K. (Abs.)	371	KOZLO, M. S., see OKOLOT, A. S.			KIMMERLING, Z. J. Very high pol sugar bulk storage. (Abs.)	182	KOZYARVICH, A. A., see KICHIGIN, N. M.			KING, J. H. Raw sugar reflectance measurement and pol control	92	KOZYAVKIN, A. P., see CARRAZANA R., L.			KINGSTON, G. Rainfall probabilities calculation. (Abs.)	334	KRAMARENKO, B. I., see GOROKH, V. N.			Soil drainage pipes. (Abs.)	270	KRAMER, R., see TSCHENER, F.			and CHAPMAN, L. S. Irrigation scheduling trials. (Abs.)	49, 110	KRASNOPOL'SKII, N. I. and FRIE, G. A. Distillery vat corrosion. (Abs.)	285		and HAM, G. J. Cane water requirement determination. (Abs.)	49	KRAUSE, W., see RAVNO, B. D.			and REHRBRIN, R. E. Solid-seed sprinker irrigation. (Abs.)	335	KRAVETS, Y. O. <i>et al.</i> Active carbon regeneration kiln. (Abs.)	123		KINYAKIN, M. F., see IGNATOV, N. M.		KRISHNAMURTHAM, P. S., see SRIRAMULU, C. R.			KIRBY, L. K. Cane juice, sugar and molasses acid and reducing sugars contents. (Abs.)	92	KRISHNAMURTHI, B. G. Active carbon manufacture from paddy husk.	315		and AHERTON, P. G. Continuous centrifugal performance. (Abs.)	213	KRIVCHIN, A. N. <i>et al.</i> Waste water treatment. (Abs.)	89		<i>et al.</i> Finned-tube massecuite heater. (Abs.)	373	KROCHER, R. Beet flume accident prevention. (Abs.)	342		KIRICHENKO, A. G. <i>et al.</i> Foam formation in flume-wash water. (Abs.)	342	KROEZY, M. E. and SCHMIDT, W. H. Spring and autumn fertilization of beet. (Abs.)	212		KIRK, F., see KESTER, C.		KROLAK, R. L. Tractor sound reduction and safety devices. (Abs.)	80		KISILEVA, N. I., see USMENTSEVA, A. Z.		KROEGER, W., see BURBA, M.			KLEPAL'CHENKO, M. P. Milk-of-lime feed control valve. (Abs.)	311	KREYBON, H. Temperature and drought effects on beet growth and sugar content. (Abs.)	212		KLESENKO, M. A., see USMENTSEVA, A. Z.		KRYWON, J. Wild beet control. (Abs.)	307		KLOCHKOV, V. P. <i>et al.</i> Sugar solution flow measurement. (Abs.)	93	KRZYC, C. J., see SCHROEDER, W. R.			KMINEK, M., see BURIANEK, J.		KUBACKA-SZMIDTGAJ, M. Beet leaf miner. (Abs.)	276		KNECHT, R. L. <i>et al.</i> Refinery waste water treatment. (Abs.)	57, 123	Pygmy mangold beetle control. (Abs.)	212		KNOGOTKOVA, E. I., see SHVETS, V. N.		KUBANDOV, N. Nitrogen determination in beet and juice. (Abs.)	284		KNOWLES, W. D. Beet tops as animal fodder. (Abs.)	126	and HAMPPEL, W. Amino-acids behaviour in carbonation. (Abs.)	60, 220		KNYZAYEV, A. A. and GOROKH, V. N. Beet diffusion heat parameters calculation. (Abs.)	216	see also WENINGER, I.			- Evaporator heating surfaces and optimum evaporation rate.	311	KUBASIEWICZ, A. and LEKAWSKI, W. Factory data processing by computer. (Abs.)	186		KNYZAYEV, V. A., see ARKHPOVICH, N. Z.		- Heat exchange in beet diffusion.	25		KOBAYASHI, T., see NAKAGAWA, M.		- Horizontal thin-film evaporator.	121		KOFTKHE, H. Beet siclers. (Abs.)	378	<i>et al.</i> Steam utilization optimization	122		KOIKI, H. Cane mosaic in Louisiana	370	KUBRAK, B. K. and RONSKAYA, N. A. Waste water treatment and factory water consumption. (Abs.)	344		Cane mosaic and maize dwarf mosaic mixtures. (Abs.)	145	KUELMANN, R. W. <i>et al.</i> Juice micro-organisms, clarification and scale formation. (Abs.)	53		and CHARPENTIER, L. J. Fulgoroid and cane mosaic transmission	113	KUJALA, P. <i>et al.</i> Alcohol manufacture from molasses. (Abs.)	381		and GILLASPIE, A. G. Cane mosaic see also GILLASPIE, A. G.	272	KULIS, E. D., see FISCHER, R. B.			KOJIMA, T. and NISHIMOTO, S. Sucrose ester synthesis. (Abs.)	190	KULIG, M., see KUBASIEWICZ, A.			KOLAGO, P. Moisture and beet seed germination. (Abs.)	306	KULINICH, N. V. <i>et al.</i> Beet diffusion infection reduction. (Abs.)	216		KOLOBEVA, R. A., see SAFRONOV, A. R.		KULKARNI, B. G. P., see SULLADMATH, V. V.			KOLLAR, J., see FABIAN, K.		KUMAR, K. and ETHERAJ, S. Methanol and groundnut oil effects on citric acid manufacture from cane juice	13		KOLLNER, H. and LOPEZ P., R. Bagasse hydrolysis. (Abs.)	222	KUMAR, S. Cane borer control by scoping. (Abs.)	239		KOLMREER, E. Surface protection in factories. (Abs.)	312	- Cane borers. (Abs.)	174		KOLOMETS, V. F. <i>et al.</i> Continuous centrifugal feeder height and molasses separation. (Abs.)	248	KUMARAPRIMAL, N. <i>et al.</i> Nitrogen and green manure effects on cane	301		KOMOTO, M., see FUJII, S.		KUO, Y. H. Hot induced drought fan wear prevention. (Abs.)	277		KONSTANTINOV, S. M. and BYPALKO, N. N. Steam injection and sugar solution heat transfer. (Abs.)	376						KURBET, T. A., see BOGHEMSKII, M. Z.					KUROWSKI, W., see KUGUMIL, T.					KUTS, A. M., see SUKOPOL, V. F.					KUTSNER, E. Barometric condenser. (Abs.)	121				KUZ'MENKO, B. P. Microbiological control in beet sugar factory. (Abs.)	24				KUZNETSOVA, L. A., see MAROCHKO, I. A.					LABAT, G. J. Clarification at Greenwood. (Abs.)	151				LABY, H. Beet yield and composition	243				LADD, S. L. <i>et al.</i> Cane smut resistance testing. (Abs.)	143				LADOGA, V. A. <i>et al.</i> Beet flume-wash water micro-organisms determination. (Abs.)	124				LAI, C. L., see CHEN, W. P.					LAKSHMIKANTHAM, L. Cane seed material. (Abs.)	176				LAL, R. and SINGH, K.					LALITHA, E., see RAO, K. C.					LALL, S. B., see KARDE, J. R.					LAMPRECHT, A., see SOKOLOWSKI, A.					LANDI, S., see MARGENTI, E.					LANDREY, O. P. <i>et al.</i> Cane field layout and mechanization. (Abs.)	174, 303				LANG, H., see TRIANA, G.					LANGEAN, A., see THEILE, H.					LANTING, S. Sub-surface drip irrigation	368				LAPIN, A. P. <i>et al.</i> Carbonation. (Abs.)	216				see also KOVAL', E. T.					LA SERNA, N., see OCAMPO, G.					LAST, P. J. <i>et al.</i> Beet topping, population and irrigation effects on yield and quality	167, 195				LAESTRA, J., see OCAMPO, G.					LASZITY, L. Beet biochemistry. (Abs.)	274				LAUDEN, L. L. Cane breeding in Louisiana. (Abs.)	365				- Cane land preparation and planting	175				- Cane ripening with "Polaris". (Abs.)	176				- Ratoon stunting disease control.	16, 366				- Scrapable cane determination.	192, 238				- US cane varieties and chemical cane ripening. (Abs.)	114				- Weeds in Louisiana. (Abs.)	76				LAZHE, Y. Refining in USSR. (Abs.)	123				see also STRAUBNERIS, A. K.					LEACH, L. D., see MACDONALD, J. D.					LEBLANC, E., see JACQUES, H.					LECLERC, B., see BASU, A. K.					LEE, S. M., see CHEN, C. T.					LEES, R. Food analysis. (N.B.)	282				LEFEVRE, P. Hardpan. (Abs.)	304				LEGBREND, B. L. Cane mud and sugar yield. (Abs.)	177				Chemical cane ripening. (Abs.)	144				and HENDERSON, M. T. Cane sugar yield calculation. (Abs.)	119				and IRVINE, J. E. Cane trash and processing quality. (Abs.)	183				see also HODSON, R. C. and IRVINE, J. E.					LEKAWSKI, W. and BOBER, A. Boiling scheme. (Abs.)	120				see also KUBASIEWICZ, A. and MOJENDA, J.					LENCZEWSKI, J. Reducing sugars determination in molasses. (Abs.)	124				LENTS, P. I., see POGORZEL'SKII, B. I.					LESCURE, J. P., see DEVILLERS, P.					LET, L. S., see WANG, Z. N.					LEVEIRINGTON, K. C. and RIDGE, D. R. Irrigation. (Abs.)	49				see also CHAPMAN, L. S.					LEW, R. B. Sulphite determination in beet juice. (Abs.)	250				LEWANDOWSKI, W., see STANKIEWICZ, W.					LEWELLEN, R. T., see SKOTEN, I. O.					LEWIS, F. Essex and sugar. (N.B.)	345				LI, K. Y. Malaysian sugar industry.	77				LIER, S., see MANZKE, E.					LIKHACHEV, B. I., see ELAGIN, A. M.					LIKHITSKII, M. K. and REVA, L. P. Carbonation juice optimum alkalinity and evaporation. (Abs.)	152				LIL, N. G. and EBERZ, E. B. L. Beet filter. (Abs.)	88				<i>et al.</i> Filter cake sweetening-off	281				LIM, M. J. H. Cane mill extraction calculation. (Abs.)	117				LIMA, U. DE A., see DE SOUZA, L. G.					LIN, C. N., see CHU, H.					LINDEN, J. C. Sugars determination.	28				see also FRETZAG, A. H.					LINDALE, A. I. Cane land planning.	78				Drainage in Australia. (Abs.)	334				Soil erosion prevention. (Abs.)	270				LIONNET, G. R. E. and FALCONER, D. Nutsch bomb. (Abs.)	189				see also RAYNS, A. B.					LIPETS, A., see LYSYANSKII, V. M.					POGORZEL'SKII, B. I. and ROMANYUK, A. Y.					LI PI SHAN, L., see CHAN, P. Y.					LIPSMAN, V. S., see KOSMINSKII, I. V.					LITOSTAD, G. I., see KOREN', R. V.					LITVINOV, A. M., see TESHEV, A. S.					LITVINOV, E. V., see SHCHEGOV, V. N.					LIU, C. H. Bagasse and cane molasses as animal fodder. (Abs.)	158
	KHILINSKAYA, E. Y., see LAPIN, A. P.		KOSOGOR, N. F., see VASIL'eva, T. K.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KHOMENKO, A. I. Steam traps. (Abs.)	247	KOSTELKOVA, E., see NEUŽIL, L.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	<i>et al.</i> Water heating with condensate	123	KOSTER, P. P. <i>et al.</i> Mercury determination in beet pulp and molasses	189, 220																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	see also DOVGOPOLO, V. I. and GOROKH, V. N.		KÖSTER, W. Soil phosphorus and potassium determination. (Abs.)	307																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KHOMENKO, N. D., see KOVAL', E. T.		KOSTIN, N. F., see AL'DEKOV, N. A.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KHOMENKO, V. S., see PAKHODKO, A. P.		KOTEL'NIKOVA, L. P., see ROBOVNIK, D. D. and SAFRONOV, S. Z.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KHURANA, S. M. P. and SINGH, S.	143	KOULYAR, L. V. see TSYUKALO, Y. F.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	Cane diseases in India. (Abs.)		KOVACS, K., see DEBRECZENI, B.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KHVALKOVSKI, T. P. Beet thick juice storage. (Abs.)	88	KOVAL', E. T. <i>et al.</i> Beet water separators. (Abs.)	56																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	and ZAKHAROVA, T. V. Phosphate determination in beet molasses.	250	KOVAL', Y. A., see IKHCHENKO, S. I.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	<i>et al.</i> Beet thick juice storage	120, 246	KOVAL', V. G. <i>et al.</i> Vinasse chemical composition. (Abs.)	379																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KHREBAB, T., see NICHOLSON, M. K.		KOVALSKO, A. D. Molasses storage and degradation. (Abs.)	190																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KICHIGIN, N. M. <i>et al.</i> Beet pulp, limestone and sugar handling	375	KOVALENKO, I. D., see BRISODSKII, N. I.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	- Bulk sugar carrier. (Abs.)	185, 376	KOVALENOK, I. K., see LILA, N. G.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	see also EML'YANOV, N. A. and VASIL'EV, V. I.		KOVAJS, J. and NISZTRAWSKI, Z. Citric acid manufacture from molasses. (Abs.)	285																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KIRBY, M. and O'SHELVAN, M. Chromatography applications. (Abs.)	317	KOZEL'TSOVA, N. N. P., see IVANOV, S. Z.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KIMBER, D. S. and MCCULLAGH, S. F. H. Beet varietal trials in U.K. (Abs.)	371	KOZLO, M. S., see OKOLOT, A. S.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KIMMERLING, Z. J. Very high pol sugar bulk storage. (Abs.)	182	KOZYARVICH, A. A., see KICHIGIN, N. M.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KING, J. H. Raw sugar reflectance measurement and pol control	92	KOZYAVKIN, A. P., see CARRAZANA R., L.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KINGSTON, G. Rainfall probabilities calculation. (Abs.)	334	KRAMARENKO, B. I., see GOROKH, V. N.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	Soil drainage pipes. (Abs.)	270	KRAMER, R., see TSCHENER, F.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	and CHAPMAN, L. S. Irrigation scheduling trials. (Abs.)	49, 110	KRASNOPOL'SKII, N. I. and FRIE, G. A. Distillery vat corrosion. (Abs.)	285																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	and HAM, G. J. Cane water requirement determination. (Abs.)	49	KRAUSE, W., see RAVNO, B. D.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	and REHRBRIN, R. E. Solid-seed sprinker irrigation. (Abs.)	335	KRAVETS, Y. O. <i>et al.</i> Active carbon regeneration kiln. (Abs.)	123																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KINYAKIN, M. F., see IGNATOV, N. M.		KRISHNAMURTHAM, P. S., see SRIRAMULU, C. R.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KIRBY, L. K. Cane juice, sugar and molasses acid and reducing sugars contents. (Abs.)	92	KRISHNAMURTHI, B. G. Active carbon manufacture from paddy husk.	315																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	and AHERTON, P. G. Continuous centrifugal performance. (Abs.)	213	KRIVCHIN, A. N. <i>et al.</i> Waste water treatment. (Abs.)	89																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	<i>et al.</i> Finned-tube massecuite heater. (Abs.)	373	KROCHER, R. Beet flume accident prevention. (Abs.)	342																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KIRICHENKO, A. G. <i>et al.</i> Foam formation in flume-wash water. (Abs.)	342	KROEZY, M. E. and SCHMIDT, W. H. Spring and autumn fertilization of beet. (Abs.)	212																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KIRK, F., see KESTER, C.		KROLAK, R. L. Tractor sound reduction and safety devices. (Abs.)	80																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KISILEVA, N. I., see USMENTSEVA, A. Z.		KROEGER, W., see BURBA, M.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KLEPAL'CHENKO, M. P. Milk-of-lime feed control valve. (Abs.)	311	KREYBON, H. Temperature and drought effects on beet growth and sugar content. (Abs.)	212																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KLESENKO, M. A., see USMENTSEVA, A. Z.		KRYWON, J. Wild beet control. (Abs.)	307																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KLOCHKOV, V. P. <i>et al.</i> Sugar solution flow measurement. (Abs.)	93	KRZYC, C. J., see SCHROEDER, W. R.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KMINEK, M., see BURIANEK, J.		KUBACKA-SZMIDTGAJ, M. Beet leaf miner. (Abs.)	276																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KNECHT, R. L. <i>et al.</i> Refinery waste water treatment. (Abs.)	57, 123	Pygmy mangold beetle control. (Abs.)	212																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KNOGOTKOVA, E. I., see SHVETS, V. N.		KUBANDOV, N. Nitrogen determination in beet and juice. (Abs.)	284																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KNOWLES, W. D. Beet tops as animal fodder. (Abs.)	126	and HAMPPEL, W. Amino-acids behaviour in carbonation. (Abs.)	60, 220																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KNYZAYEV, A. A. and GOROKH, V. N. Beet diffusion heat parameters calculation. (Abs.)	216	see also WENINGER, I.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	- Evaporator heating surfaces and optimum evaporation rate.	311	KUBASIEWICZ, A. and LEKAWSKI, W. Factory data processing by computer. (Abs.)	186																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KNYZAYEV, V. A., see ARKHPOVICH, N. Z.		- Heat exchange in beet diffusion.	25																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KOBAYASHI, T., see NAKAGAWA, M.		- Horizontal thin-film evaporator.	121																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KOFTKHE, H. Beet siclers. (Abs.)	378	<i>et al.</i> Steam utilization optimization	122																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KOIKI, H. Cane mosaic in Louisiana	370	KUBRAK, B. K. and RONSKAYA, N. A. Waste water treatment and factory water consumption. (Abs.)	344																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	Cane mosaic and maize dwarf mosaic mixtures. (Abs.)	145	KUELMANN, R. W. <i>et al.</i> Juice micro-organisms, clarification and scale formation. (Abs.)	53																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	and CHARPENTIER, L. J. Fulgoroid and cane mosaic transmission	113	KUJALA, P. <i>et al.</i> Alcohol manufacture from molasses. (Abs.)	381																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	and GILLASPIE, A. G. Cane mosaic see also GILLASPIE, A. G.	272	KULIS, E. D., see FISCHER, R. B.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KOJIMA, T. and NISHIMOTO, S. Sucrose ester synthesis. (Abs.)	190	KULIG, M., see KUBASIEWICZ, A.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KOLAGO, P. Moisture and beet seed germination. (Abs.)	306	KULINICH, N. V. <i>et al.</i> Beet diffusion infection reduction. (Abs.)	216																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KOLOBEVA, R. A., see SAFRONOV, A. R.		KULKARNI, B. G. P., see SULLADMATH, V. V.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
	KOLLAR, J., see FABIAN, K.		KUMAR, K. and ETHERAJ, S. Methanol and groundnut oil effects on citric acid manufacture from cane juice	13																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KOLLNER, H. and LOPEZ P., R. Bagasse hydrolysis. (Abs.)	222	KUMAR, S. Cane borer control by scoping. (Abs.)	239																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KOLMREER, E. Surface protection in factories. (Abs.)	312	- Cane borers. (Abs.)	174																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KOLOMETS, V. F. <i>et al.</i> Continuous centrifugal feeder height and molasses separation. (Abs.)	248	KUMARAPRIMAL, N. <i>et al.</i> Nitrogen and green manure effects on cane	301																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KOMOTO, M., see FUJII, S.		KUO, Y. H. Hot induced drought fan wear prevention. (Abs.)	277																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
	KONSTANTINOV, S. M. and BYPALKO, N. N. Steam injection and sugar solution heat transfer. (Abs.)	376																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																									
			KURBET, T. A., see BOGHEMSKII, M. Z.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			KUROWSKI, W., see KUGUMIL, T.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			KUTS, A. M., see SUKOPOL, V. F.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			KUTSNER, E. Barometric condenser. (Abs.)	121																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			KUZ'MENKO, B. P. Microbiological control in beet sugar factory. (Abs.)	24																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			KUZNETSOVA, L. A., see MAROCHKO, I. A.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LABAT, G. J. Clarification at Greenwood. (Abs.)	151																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LABY, H. Beet yield and composition	243																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LADD, S. L. <i>et al.</i> Cane smut resistance testing. (Abs.)	143																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LADOGA, V. A. <i>et al.</i> Beet flume-wash water micro-organisms determination. (Abs.)	124																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LAI, C. L., see CHEN, W. P.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LAKSHMIKANTHAM, L. Cane seed material. (Abs.)	176																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LAL, R. and SINGH, K.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
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			LALL, S. B., see KARDE, J. R.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LAMPRECHT, A., see SOKOLOWSKI, A.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LANDI, S., see MARGENTI, E.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LANDREY, O. P. <i>et al.</i> Cane field layout and mechanization. (Abs.)	174, 303																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
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			LANGEAN, A., see THEILE, H.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LANTING, S. Sub-surface drip irrigation	368																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LAPIN, A. P. <i>et al.</i> Carbonation. (Abs.)	216																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			see also KOVAL', E. T.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LA SERNA, N., see OCAMPO, G.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LAST, P. J. <i>et al.</i> Beet topping, population and irrigation effects on yield and quality	167, 195																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
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			LASZITY, L. Beet biochemistry. (Abs.)	274																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LAUDEN, L. L. Cane breeding in Louisiana. (Abs.)	365																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			- Cane land preparation and planting	175																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			- Cane ripening with "Polaris". (Abs.)	176																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			- Ratoon stunting disease control.	16, 366																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			- Scrapable cane determination.	192, 238																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			- US cane varieties and chemical cane ripening. (Abs.)	114																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			- Weeds in Louisiana. (Abs.)	76																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LAZHE, Y. Refining in USSR. (Abs.)	123																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
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			LEACH, L. D., see MACDONALD, J. D.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
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			LECLERC, B., see BASU, A. K.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
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			LEES, R. Food analysis. (N.B.)	282																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LEFEVRE, P. Hardpan. (Abs.)	304																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LEGBREND, B. L. Cane mud and sugar yield. (Abs.)	177																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			Chemical cane ripening. (Abs.)	144																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			and HENDERSON, M. T. Cane sugar yield calculation. (Abs.)	119																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			and IRVINE, J. E. Cane trash and processing quality. (Abs.)	183																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
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			see also KUBASIEWICZ, A. and MOJENDA, J.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LENCZEWSKI, J. Reducing sugars determination in molasses. (Abs.)	124																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LENTS, P. I., see POGORZEL'SKII, B. I.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LESCURE, J. P., see DEVILLERS, P.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LET, L. S., see WANG, Z. N.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LEVEIRINGTON, K. C. and RIDGE, D. R. Irrigation. (Abs.)	49																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			see also CHAPMAN, L. S.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LEW, R. B. Sulphite determination in beet juice. (Abs.)	250																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LEWANDOWSKI, W., see STANKIEWICZ, W.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LEWELLEN, R. T., see SKOTEN, I. O.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LEWIS, F. Essex and sugar. (N.B.)	345																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LI, K. Y. Malaysian sugar industry.	77																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LIER, S., see MANZKE, E.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LIKHACHEV, B. I., see ELAGIN, A. M.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LIKHITSKII, M. K. and REVA, L. P. Carbonation juice optimum alkalinity and evaporation. (Abs.)	152																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LIL, N. G. and EBERZ, E. B. L. Beet filter. (Abs.)	88																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			<i>et al.</i> Filter cake sweetening-off	281																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LIM, M. J. H. Cane mill extraction calculation. (Abs.)	117																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LIMA, U. DE A., see DE SOUZA, L. G.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LIN, C. N., see CHU, H.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LINDEN, J. C. Sugars determination.	28																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			see also FRETZAG, A. H.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LINDALE, A. I. Cane land planning.	78																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			Drainage in Australia. (Abs.)	334																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			Soil erosion prevention. (Abs.)	270																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			LIONNET, G. R. E. and FALCONER, D. Nutsch bomb. (Abs.)	189																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							
			see also RAYNS, A. B.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LIPETS, A., see LYSYANSKII, V. M.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			POGORZEL'SKII, B. I. and ROMANYUK, A. Y.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LI PI SHAN, L., see CHAN, P. Y.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LIPSMAN, V. S., see KOSMINSKII, I. V.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LITOSTAD, G. I., see KOREN', R. V.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LITVINOV, A. M., see TESHEV, A. S.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LITVINOV, E. V., see SHCHEGOV, V. N.																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																								
			LIU, C. H. Bagasse and cane molasses as animal fodder. (Abs.)	158																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																																							

INDEX

	PAGE		PAGE		PAGE
LIU, C. L., see WU, M. M. H.		MAGYAR, K. Beet diffusion water effect on juice properties. (Abs.).....	90	MAURANDI, V. Boiling (Abs.). and MANTOVANI, G. White sugar and silo conditioning. (Abs.) 55, 217, 342	25
LIU, Y. T. Citric acid manufacture from molasses and dextrose. (Abs.)	382	MAHAMUNI, I., see RAMAMOORTHY, N.		MAURE, S. P., see BRUNET, R.	
LIERENA, G., see OCAMPO, G.		MAI, S. C. and WU, T. H. Cane, bagasse and molasses as animal fodder. (Abs.)	61	MAURBY, M. Beet field clamp siting..	82
LISTRÒ, A. M. S. M., see DE SOUZA, L. G.		MAKSYMUK, P. S. Water consumption and waste water quantity reduction. (Abs.).....	89	MAYANSKI, M. T., see MAKSYMUK, P. S.	
LOCHMAN, V. Beet rume cleaning..	88	MALASHEVICH, A. A., see KOVAL', V. G.	185	MAYEUX, M. E., see COCHRAN, B. J.	
LODOS, J., see CORDOVES, M.		MALCZEWSKI, J. Refined sugar crystal growth. (Abs.).....	249	MAYLOTT, A. O. and DECELES, J. W. Refinery melt house computer..	315
LOHLER, M., see DEVILLERS, P.		Sugar solution crystal content and crystallization rate. (Abs.).....	316	MAZOV, M., et al. Syrup decolorization with adsorbent resin. (Abs.)	315
LOKAN, R. Bagasse furnaces. (Abs.)	213	MALZEV, J., see BRANDT		MECHLAS, B., see SCHLIEPHAKE, D.	
LONSDALE, J. E. Cane drying-off. (Abs.)	174	MALZEV, J., et al. Beet sucrose determination. (Abs.).....	188, 347	MEK, V., see PAULUS, A. O.	
Chemical weed control. (Abs.).....	147	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MEGGITT, W. F. Chemical weed control see also HENDRICK, L. W.	83
and GOSNELL, J. M. Age and harvest time effects on cane yield and quality. (Abs.).....	175	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MEHAN, V. K., see SANDHU, S. S.	
see also GOSNELL, J. M.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MEINECKE, H., see BORNSCHEUER, E.	
LOOP, W., see PIECK, R.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MELLET, P. Cane molasses Brix determination. (Abs.).....	93
LOPEZ P. R., see KOLLNER, H.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MELNIK, A. N. Ozone and beet leaf injury. (Abs.).....	116
LORENZ, W., see PREY, V.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MERCIER, A. C., see PIROUS, P. H.	
LOSEVA, V. A., see IVANOV, S. Z.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MERKEL, D. Sodium as fertilizer. (Abs.)	275
LOUPE, D. T. Chemical weed control in Louisiana. (Abs.).....	241	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MERKES, R., see WINNER, C.	
and McCORMICK, L. L. Chemical weed control. (Abs.).....	366	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MERLE, J. P. Automatic boiling control	86
see also MATHERNE, R. J.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	Waste water treatment. (Abs.).....	117
LOYNET, G. and DE FRAISSE, C. H. Nitrogen trials in Réunion. (Abs.)	17	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MERTZ, W., see OGDON, J. H.	
LOZZIA DE C. M. E., see FRIAS DE F., A. M.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MESSIER, G. M., see McDougall, E. E.	
LU, C. J. Automatic boiling control..	277	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MEZT, K. Waste water treatment..	187
Sugar research and development in Taiwan. (Abs.).....	374	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	METZING, J., and SCHLAG, K. F. Masticite supersaturation measurement. (Abs.).....	218
LU, C. K. Mechanical cane harvesting and factory processing. (Abs.).....	277	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MEYER, E. and DE BEER, A. G. Cultivators. (Abs.).....	174, 302
LUCCI, G. C. Potassium absorption by triploid beet. (Abs.).....	338	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MEYER, H. K., see LADD, S. L.	
LUCHEV, I. S. et al. Vitamin B ₁₂ manufacture from vinasse. (Abs.).....	190	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MEYER, J. H. Cane foliar analysis..	147, 239
LUDWIG, J., see REUSS, J. O.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MEZENTSEV, S. K., see POPOV, A. E.	
LUKACS, L. and ZANA, J. Beet leaf spot control. (Abs.).....	211	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MIKHAILYUK, A. T., see CHUDAKOV, G. M. and TESHEV, A. S.	
Beet varietal trials in Hungary..	244	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MIKI, T. Polychlorinated biphenyls and organochlorine pesticides residue in sugar. (Abs.).....	156
LUMBROSO, J. D., see UNG, J. O.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	see also ONDA, F.	
LUTSENKO, O. K., see PAREFENENKO, V. V.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MILKOVA, Z. A., see IVANOV, S. Z.	
LYONS, J. Four-wheel-drive tractors	369	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MILLARD, E. W., see RAU, S.	
LYSIKO, B. F., see KOVAL', V. G.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MILLER, J. D. Cane eye spot varietal resistance. (Abs.).....	145
LYSYANSKI, M. W. et al. Beet diffusion variables calculation. (Abs.).....	89	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	Cane varietal frost tolerance. (Abs.)	303
see also ZHMYRYA, L. P.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	and GASCHO, G. J. Cane deterioration after frost. (Abs.).....	220
MAAG, G. W. and SISLER, G. H. Sucrose determination by polarization vs. gas-liquid chromatography. (Abs.)	250	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	and JAMES, N. W. Programmed calculator application in cane breeding. (Abs.).....	112
McALEESE, Q. J. et al. Eye spot susceptibility. (Abs.).....	270	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	see also DEAN, J. L. and JAMES, N. I.	
McCORMICK, L. L., see LOUPE, D. T.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MILLER, K. F., see BROADFOOT, R. and STREIN, R.	
McCULLAGH, S. F. H., see KIMBER, D. S. and WILLEY, L. A. T.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MILHOLLON, R. W. Chemical weed control. (Abs.).....	112
MACDONALD, J. D. et al. Beet stalk blight. (Abs.).....	337	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MILYUKIN, M. V., see KHARIN, S. E.	
MCDUGALL, E. E. et al. Fly-ash treatment. (Abs.).....	341	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MISCHNENKO, B. P., see ELAGIN, A. M.	
see also BATES, I.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MISCHAN, M. M., see DE SOUZA, L. G.	
McBAHRAN, B., see NIELSEN, N. A.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MISHCHUK, R. T. Carbonatation lime balance calculation. (Abs.).....	121
MACEDO, N. et al. Cane borer rearing	302	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	and ZAGORLUKO, A. Y. Liqueur recycling to liming. (Abs.).....	219
McELROE, B. and GIBSON, W. Drip irrigation tube plugging prevention	80	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MISHRA, B., see JHA, A.	
McEVROY, M. A. and ARCHIBALD, R. D. Continuous centrifugal capacity increase. (Abs.).....	182	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MITKA, D. S., see CHANOU, K. M.	
MACEY, D. Centrifugal shredder and fan balancing. (Abs.).....	241	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MITTAL, R. P. Green's economizer and steam generation. (Abs.).....	214
and MCGINN, P. A. Cane mill roller bearings and torque requirements	54	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MOBERLY, P. K., see RAU, S.	
MACFARLANE, J. Calcium chloride addition and clarification with flocculants. (Abs.).....	118	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MOMBANI, M. A. et al. Cane molasses exhaustibility. (Abs.).....	318
MACFARLANE, J. S. Wild beet. (Abs.)	242	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	- Sugar physico-chemical properties in Egypt	355
see also MACDONALD, J. D. and SKROYEN, I. O.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MOMENI, M. S., see SAYED, G. EL-K.	
MCGINN, J. A., see MACEY, D.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MOLENDA, J. and LEKAWSKI, W. Mossi sugar complex. (Abs.).....	120
MCGINNIS, R. A. Raffinose hydrolysis and beet molasses sugar extraction	121	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MOLLER, R. B. and CHAPMAN, L. S. Irrigation in Australia. (Abs.).....	49, 110
McGUFFEY, W. C. Beet quality. (Abs.)	19	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MONDELA, G. D. Sodium and calcium chlorides and alcohol-water vapour liquid equilibrium. (Abs.).....	190
MACHADO, J. R., see BRINHOLI, O.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MONTEIRO, C. E. Distillery waste and factory effluent treatment. (Abs.)	308
MACHADO, L., see CARVALHO, R. L.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MONTGOMERY, C. Mechanical cane harvesting. (Abs.).....	368
MACHLAJEWSKI, S. Beet seed and inter-row spacing effects on population	274	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MOORE, M. and KARE, J. Beet thick juice storage. (Abs.).....	56
McINTYRE, R. J. Auxiliary power supply. (Abs.).....	340	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORACHEAN, Y. B., see SRINIVASAN, T. R.	
Turbo-alternator and power flow control. (Abs.).....	54	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORAGHAN, J. USSR sugar industry	90
McKAY, C. M. Gilmore Louisiana-Florida-Texas-Hawaii-Puerto Rico sugar market 1973. (N. B.)	155	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORALES, R., see TRIANA, G.	
MCKENNA, C. C., see GILLASPIE, D. B.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORALES, S. and FLORES, P. M. Cane juice treatment with flocculants	23
MACLEAN, N. R. Cane agriculture and soil properties. (Abs.).....	51	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORFAT, J. N., see RIBEIRO, J. P.	
Fly-ash and filter cake as fertilizer	335	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORFEE, N. et al. Phosphorus determination. (Abs.).....	124
Soil compaction. (Abs.).....	335	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORIN, D. M., see FOGLIATA, F. A.	
McLENNAN, R. Cane damage by pigs	272	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORITSUGU, T. et al. Molasses exhaustibility calculation. (Abs.).....	318
McMASTER, L. and BOND, A. B. Cane diffusion losses. (Abs.).....	182, 214	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORRIS, N. M. et al. Heavy metals determination in sugar. (Abs.).....	380
McNEEL, K. E., see BOND, J. F.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORRIS, V. Clarification with flocculation aids. (Abs.).....	118
MACNELL, A. A. Sub-surface cane land drainage. (Abs.).....	301	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346	MORRIS, A. C. and NICOL, W. M. Pesticide and trace constituents determination in cane molasses..	251
MADDAV, V. V., see SINGH, O. P.		MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346		
MADDAN, W. L. and CHRISTIE, E. M. Herbicide effects on cane. (Abs.)	110	MALZEV, J., et al. Dextran and sucrose crystallization. (Abs.).....	91, 346		

INDEX

PAGE		PAGE		PAGE
	MORTAZAVI, M. et al. Soil, weather and fertilizer effects on beet yield and quality. (Abs.).....	21		
	MOSICH, K. K. et al. Masseurite evaporator performance. (Abs.).....	343		
	MOSSAKOWSKA, K., see JANUSZEWICZ, I.			
	MOTYLEWSKI, J., see BOGUMIL, T.			
	MOYCHAN, I. D. see STEBOGLOV, V. F.			
	MOYER, C. E. Cane molasses instability and spontaneous destruction ..	23		
	MRÁČKOVÁ, D., see SCHMIDT, J.			
	MUKHERJEE, S. and SRIVASTAVA, S. K. Cane juice ion exchange treatment and potassium recovery. (Abs.)..	119		
	see also BOSE, S.			
	MUKHERJEE, S. R., see SAHI, B. P.			
	MUKHERJEE, J. P. et al. Masseurite re-heating with evaporator vapour	183		
	MUKHOPADHYAY, S. K., see SAMUI, R. C.			
	MULLER, A., see JOURNET, M.			
	MULLER, G., see CRONEWITZ, T.			
	MULLER, H. J. Nitrogen and trace elements effects on beet yield and quality. (Abs.).....	274		
	MULLER, R. L. Automatic clarification and level control. (Abs.).....	372		
	Cane reception and sampling. (Abs.)	54		
	MUMFORD, D. L. Beet leathopper release for curly top induction...	115		
	and GREIFIN, G. D. Beet leathopper control. (Abs.).....	20		
	see also RUPPEL, E. G.			
	MUNIR, M. Molasses sugar extraction	100		
	MUNIZ, H. et al. Cane age and ripening	10		
	MURAWSKI, S., see WAGNEROWSKI, K.			
	MURO, M., M. and SILVERIO, R. C. Colour measurement. (Abs.).....	125		
	see also PLA, R. C.			
	MURRAY, J. D. and RUNGGAAS, F. M. Refinery liquor carbonatation...	219		
	and SHEPARD, G. S. Flocculant effect on clarification and filtration	182, 340		
	MUTHUSAMY, S. and SITHANATHAM, S. Cane varietal smut resistance ..	142		
	et al. Cane varietal smut susceptibility. (Abs.).....	207		
	see also SITHANATHAM, S.			
	MUTTO, S., see D'AMBRA, V.			
	MYATT, O. W. D. Pests in standover cane. (Abs.).....	209		
	NAKAGAWA, J., see ERINHOI, O.			
	NAKAGAWA, M. et al. Itaconic acid manufacture. (Abs.).....	252		
	NAKAMURA, I., see NAKAGAWA, M.			
	NARANO, O., see MACEDO, N.			
	NARHODKINA, V. Z., see KULINICH, N. V.			
	NALDER, C. R. Cane pests in Australia	271		
	Tully experiment station. (Abs.)..	78		
	see also VICKERS, R. P.			
	NAQA, H. A. and ALAM, S. M. Frost effect on cane processing.....	202		
	NARAIN, S. Oliver filtrate clarification	309		
	NARASIMHAR, K. T., see AHMED, S. A.			
	and RAMMOGOBY, N. V.			
	NARWAL, S. S., see SINGH, S.			
	NASR, I. A. Cane smut. (Abs.).....	370		
	Cane streak disease. (Abs.).....	143		
	NAVARRE, G. Vehicle noise reduction	117		
	and PIÑOL, J. Scale reduction in rum distillery column	285		
	NAVOLOKIN, V. V., see IVANOV, S. Z.			
	NECHIPALOV, V. N., see SCHEGOLEV, V. N.			
	NEDOBOR, O. N., see DOVGOPOLO, V. I.			
	NEE, C. I. and YSE, W. F. Furfural and levulinic acid manufacture from bagasse. (Abs.).....	158		
	NEKRASOV, K. A. Bag counting and level detection and control. (Abs.)	90		
	NELSON, J., see PAULUS, A. O.			
	NELSON, J. M. Beet plant spacing and yield. (Abs.).....	116		
	NELSON, P. H. and ZILLICH, E. Cane agriculture and processing. (Abs.)	302		
	NEMIROVSKII, L. I. Sugar factory designing. (Abs.).....	88		
	NESS, J. N. and STEWART, E. J. Crystallizer comparison. (Abs.)..	373		
	see also KIRBY, L. K.			
	NEUBREITER, H. Weed effects on beet yield, harvesting and processing	306		
	NEUHL, L. and BRÖZ, L. Sugar classification in fluidized bed. (Abs.)..	246		
	and KOSTELKOVA, E. Fluidized bed treatment of sugar. (Abs.).....	216		
	NICHOLSON, M. K. et al. Beet irrigation and N fertilization economies ..	117		
	NICKELL, L. G. and TAKAHASHI, D. T. Cane ripening with chemicals. (Abs.) 79, 81, 176			
	NICOL, W. M., see MORRIS, A. C.			
	NIELSEN, N. A. and MCEACHRAN, B. Factory control controls. (Abs.)	54		
	NIELSEN, P. J. Cane equipment purchasing and contracting. (Abs.)..	332		
	NICKELL, L. G. and TAKAHASHI, D. T. Cane irrigation requirements. (Abs.)	209		
	NIETRAWSKI, Z., see KOVATS, J.			
	NISHIMOTO, S., see KOJIMA, T.			
	NITSCHKE, Z. Xanthi sugar factory	120		
	NIX, K. J. Bagasse furnace. (Abs.)..	85		
	NOBLE, A. G., see STEWART, P. N.			
	NOMURA, N. S., see HILTON, H. W.			
	NORGADE, T. E., see BATTERHAM, R. J.			
	NORMAN, L. W., see KARR, J. F.			
	NOŠKOVA, V. Belt filter. (Abs.)....	88		
	NOVIKOV, V. A., see MAROCHKO, I. A.			
	and ROMASHKEVICH, I. B.			
	NOVOGURSKII, I. I., see KICHIGIN, N. M.			
	NOWAK, F. Evaporator water supply	90		
	NUD'GA, M. N., see FEDOTKIN, I. M.			
	NUKIC, G. N. Cane preparation. (Abs.)	214		
	NUKOR, D. and REARDON, T. J. Sugars determination by gas-liquid chromatography. (Abs.).....	189		
	see also KORT, M. J.			
	NUSS, K. J. Cane smut varietal resistance. (Abs.).....	175		
	ÖBEROI, D. S. and SINGH, R. Beet agriculture in Rajasthan. (Abs.)	83		
	OCAMPO, G. Bagasse cellulose manufacture. (Abs.).....	126		
	et al. Active carbon manufacture from bagasse. (Abs.).....	190		
	ODER, R., see WAGNEROWSKI, K.			
	ODER, H. A. Bagasse paper manufacture. (Abs.).....	222		
	O'DOHERTY, M. J., see WAYMAN, J. A.			
	OGORONICHUK, L. V., see BRENNAN, S. A.			
	OHBA, S. K. et al. UP cane varieties, soils and weather. (Abs.).....	238		
	OKOLOI, A. S. and KOZLO, M. S. Carbonatation and juice filtration.	88		
	OLDMEYER, B. K. Introgressive beet hybridization. (Abs.).....	242		
	OLDFIELD, J. F. T. et al. Automatic carbonatation control. (Abs.)....	87		
	- Dextran effect on carbonatation and filtration. (Abs.).....	26		
	- Phosphoric and organic acids determination in beet juice and molasses. (Abs.).....	124		
	OLEINIK, I. A., see ARKHIV, N. A.			
	POGORZHEL'SKII, B. I. and ROMAN-YUK, A. Y.			
	OLENIKOVA, A. Y., see BURAVLEVA, V. I.			
	OLIVIERO, A. Crystallizer. (Abs.)....	23		
	OLTMANN, W. and SEDLMAYR, T. Beet breeding. (Abs.).....	275		
	OLYANSKAYA, S. P. et al. Pectin effect on juice colour and lime salts ..	24		
	see also ZHURA, K. D.			
	OMEL'CHENKO, A. V., see TROINO, V. P.			
	OMORI, S. Lime regeneration in refinery	154		
	ONALIAS, F. Beet wastes as animal fodder. (Abs.).....	253		
	ONDA, F. et al. Ion exchange resin regeneration waste water decolorization. (Abs.).....	154		
	OPIL, V. and PRIDAL, J. Nonrotary blade-type centrifugal. (Abs.)..	312		
	O'REILLY, J. P., see RAZIVIN, A. A.			
	ORLOV, L. A. and BUZYKIN, N. A. White sugar cooler/dryer. (Abs.)	281		
	ORLOV, N. Y., see KIRBY, M. O.			
	ORLOVSKA, J. Beet storage in Poland	285		
	OROBINSKII, I. P., see IVANOV, S. Z.			
	ORSENTINO, J. R. Green vs. burnt cane harvesting. (Abs.).....	179		
	and HOOKS, S. L. Chemical cane ripening. (Abs.).....	144		
	ORSINI, L., see REMY, J. C.			
	ORTEGA, S. White sugar manufacture in Cuba. (Abs.).....	150		
	OSA, J. M., see MARIOTTI, J. A.			
	OSOKIN, V. I. and YAMSHANOV, A. I. Filter mud suspension level control	121		
	OSTANENKOV, A. M. and MATSON, V. A. Molasses sterilization in electromagnetic field. (Abs.).....	349		
	OSTASZEWICZ, D. Raffinose hydrolysis	347		
	OSUI, P. O., see UNSWORTH, E. F.			
	O'SULLIVAN, M., see KIRBY, M. O.			
	OSVALD, R., see ČEPELAK, J.			
	OSWELER, K. A. and SISLER, G. H. Micro-organisms determination in beet diffusion. (Abs.).....	89		
	OUDDIN, L. Cane ripening with "Polaris". (Abs.).....	369		
	OUTRIDGE, R. and TEAKLE, D. S. Sorghum as leathopper host. (Abs.)	370		
	OVIAROV, V. I. Factory wall deterioration prevention. (Abs.)..	24		
	OVIAROV, R. Cane land preparation organization. (Abs.).....	51		
	OYARZABAL, E. S., see MARIOTTI, J. A.			
	OZER, E., see ARYAR, O. C.			
	PADDOCK, D. R. and QUINAN, P. B. Clarification mud pumps. (Abs.)	84		
	PADMANABHAN, M. D. et al. Cane borer control. (Abs.).....	300		
	PAIR, C. H., see CARTER, J. N.			
	PAL, G. Carbonatation mud conveying	216		
	PALACI, J. Cane diffusion materials balance. (Abs.).....	309		
	PALANTAPAN, T. P., see VENKOPAN, P.			
	PALPAIYAI, L. Milk-of-lime screening	246		
	PALTAISEAS, E. D. Cane flowering induction. (Abs.).....	113, 145		
	PAN, Y. S. Cane pest and disease research in Taiwan. (Abs.).....	367		
	PANDEY, B. N., see SINGH, R. A.			
	PANDEY, L. N. et al. Cane red rot varietal resistance. (Abs.).....	208		
	PANTAGUA U. E. A. Cane spacing and fertilizer requirements. (Abs.)..	49		
	PANITZ, N., see EMMERICH, A. and SCHNEIDER, F.			
	PARAKHIN, N. E. Waste water treatment. (Abs.).....	246		
	PARASHAR, K. S. Beet varietal trials in India. (Abs.).....	116		
	Cane varietal trials in India. (Abs.)	333		
	see also WANKHEDE, N. P.			
	PARFENENKO, V. V. et al. Pectin preparation from beet pulp. (Abs.)	285		
	see also BUZINA, G. V.			
	PARFENOPOLO, M. G. and KARAUOV, N. E. Beet pulp coefficient of friction in briquetting. (Abs.)....	252		
	- Beet pulp vibration effect. (Abs.)	61		
	PARKHOKO, A. P. KDA-30-66 beet diffuser performance. (Abs.)....	313		
	et al. KDA-15-55 beet diffuser. (Abs.)	344		
	PARKHOMETS, A. P. et al. Beet flume-washer water mud particle size ..	185		
	- Waste water quantity determination. (Abs.).....	280		
	see also SCHEGOLEV, V. N.			
	PARR, J. F. et al. Johnson grass control	144		
	PARSLOW, R., see OLDFIELD, J. F. T.			
	PARTRIDGE, B. and REICHAUD, S. R. Bagasse moisture determination. see also HALE, D. J.	92		
	PASSOS, C. Mexican sugar industry ..	48		
	PASTEGA, I. A., see IVIN, P. G.			
	PATE, F. M. and COLEMAN, S. W. Cane tops as animal fodder. (Abs.)....	221		
	PATEL, K. K., see SULLIVAN, J. P.			
	PATEL, K. A., see SAHI, B. K.			
	PATTERSON, R. S. Factory equipment clearing. (Abs.).....	123		
	PAUL, K. N. Purity factor evaporator juice. (Abs.).....	308		
	PAULUS, A. O. et al. Beet powdery mildew control. (Abs.).....	148		
	PAVELKO, V. and GALEYEV, N. Y. Boiling parameters calculation ..	313		
	see also TOBILEVICH, N. Y.			
	PAVLENKO, V. S., see MAZOV, M. Y.			
	PAXTON, J. G., see BRETT, P. G. G.			
	PAYAN, L. et al. Cane varietal yield estimation. (Abs.).....	23		
	PAYNE, J. H. Cane diffusion vs. milling-cum-diffusion. (Abs.).....	170		
	PETERS, G. Chemical weed control. 211, 276			
	PELLERIN, A., see HOPFMANN-WALBECK, H. P.			
	PELTS, M. L., see KHELESKII, M. Z.			
	PEMBROKE, E. A. Supplementary irrigation and cane yield. (Abs.)	370		
	Plantain cane. (Abs.).....	283		
	PENCE, N., see BARNES, M. G.			
	PENG, S. Y. Cane herbicide tolerance testing. (Abs.).....	241		
	et al. Chemical control of grasses ..	241		
	PENNER, D., see HENDRICK, L. W.			
	PENOMO, R., see PAYAN, L.			
	PEREIRA, C. E. F. et al. Cane borer parasites. (Abs.).....	331		
	PÉREZ, A., E., see GIMÉNEZ L., O.			
	PÉREZ, F., see MUÑOZ, H.			
	PÉREZ, J. R., see RAZIVIN, A. A.			
	PERSCHAK, F. Galacturonic acid determination. (Abs.).....	60, 124		
	PERSLEY, G. J. Leaf scald. (Abs.)...47, 144			
	and RYAN, C. C. Cane leaf scald ..	335		
	PETRÁK, Z., see RÍMSA, V.			
	PETRASH, V. D., see CHERNYI, A. A.			
	PETRENKO, D. B., see SINAT-RADČENKO, D. E.			
	PETRIK, V. S., see ANTONOVICH, A. L.			
	PEPPER, E. Beet, molasses and pulp as animal fodder. (Abs.).....	381		
	PELLERIN, A., see HOPFMANN-WALBECK, H. P.			
	PHILLIPSON, R. T., see HIBBERT, D. and KOSTER, P. B.			
	PICHENZ, J. Beet planting and harvesting. (Abs.).....	244		
	PICOU, R. W., see CHEN, J. C. P.			
	PIECK, R. and LOOP, W. RT 4 beet diffuser. (Abs.).....	25		
	see also DREGETZ, J., HOUSSIAU, J. and SIMONARD, A.			
	PIERRARD, P. Molasses electrolysis	378		
	PIETILA, P. J. Final actuators. (Abs.)	372		
	PIETRZAK, M. Beet sampling and analysis. (Abs.).....	124		
	Quick-dissolving sugar procedure	280		
	PINCHU, Y. K., see TRACHENKO, S. I.			
	PINK, H. S. Soil erosion. (Abs.)...50, 272			
	PIÑOL, J., see NAVARRO, J.			
	PITROUS, P. H. and HERCIER, A. Centrifugals. (Abs.).....	378		
	PIVEN, K. Z. Waste water application to soil. (Abs.).....	344		

INDEX

	PAGE		PAGE		PAGE
PLA R., G. and MURO M., M. Raw and white sugar ash determination	124	RAU, S. and MILLARD, E. W. Polyethylene mulching. (Abs.)	175	RODRIGUEZ, R., see CARDET, E.	
PLAYER, M. R., see GOODENOUGH, P. W.		and MOBERLY, P. K. Nematode control. (Abs.)	174, 241	RODRIGUEZ, W., see CARRAZANA R., L.	
FLOPER, D. L., see MARIOTTI, J. A.		RAYNO, A. B. and LIONNET, G. R. K. Filter cake dewatering. (Abs.)	151	RODRIGUEZ C., E. <i>et al.</i> Cane sugar yield and pH calculation. (Abs.)	118
POCHLYA, S., see FRIML, M.		see also McMASTER, L.		ROELANTS, W., see ROUSSEL, N.	
POCHLYA, Z., see KASTNER, F.		RAYNO, B. D. <i>et al.</i> Continuous bagasse weighing. (Abs.)	150	ROGER, J., see DEVILLERS, P.	
PODGORCHANYI, G. I., see TIMOSHENKO, S. I.		RAY, T. R. Cane mill hydraulic motors	214	ROMANUK, A. Y. <i>et al.</i> Beet diffusion water electrolysis. (Abs.)	281
PODIGNO, N. T., see KHELEMSKI, M. Z.		RAZJVIN, A. A. <i>et al.</i> Nematodes. (Abs.)	114	and SPIRIDONOVA, I. M.	
POGORELOVA, N. V., see SHCHEGOLEV, V. N.		REARDON, T. J., see NUROK, D.		V. A. Stored beet recovery economics. (Abs.)	376
POGORZHELSKI, B. I. <i>et al.</i> Diffusion water treatment with aluminum sulphate. (Abs.)	279	REBOJA, J. I., see FROSTERA, A. R.		ROMANSKI, N. P., see RAFAF'SKI, V. F. and SPIRIDONOVA, I. M.	
POHLE, G. Boiler feedwater treatment	184	REED, W. L. Raw sugar weighers.	57	ROMSKAYA, N. A., see KUBRAK, B. K.	
POINTING, E. M. Cane field measurement. (Abs.)	338	REHBEIN, C. A. and BRAITHWAITE, M. J. Cane varieties in Australia	47	ROPOETNIK, Y. G. <i>et al.</i> Boiling with surface-active additive. (Abs.)	88
POKRASS, N. N., see CEMENSKAYA, S. P.		REHBEIN, R. E., see KINGSTON, G. F.		ROSENAU, J. R., see BARKER-ARKEMA, F. W.	
POLAK, J., see RÍMSA, V.		REICHARD, S. R. and VIDLER, T. L. Massesute conductivity electrode	85	ROSENBERG, L. Beet sugar technology	280
POLLACH, G. Carbonatation juice, mud suspension and milk-of-lime analysis. (Abs.)	284	see also KELSO, L. and PARTIDGE, B.		Israel sugar industry. (Abs.)	90
Sucrose determination with <i>B. stearotherophilus</i> . (Abs.)	60	REICHEL, C., see REINEFELD, E.		<i>et al.</i> Enviro-Clear clarifier.	263
POLYANSKI, K. K., see KHARIN, S. E.		REIMERS, J. F. Cane damage by grubs. (Abs.)	47	ROSS, B. G. Honokaa factory continuous operation. (Abs.)	86
POMBO, R., see OKUPO, G.		see also Cane land levelling. (Abs.)	78	ROSSI, A. Refining. (Abs.)	314
POMMEZ, P. and COEMER, R. Heavy metals determination in raw sugar	288	REIN, P. W. Cane mill extraction calculation. (Abs.)	189, 249	ROSTHORN, H. Chemical cane ripening	174
see also BROWN, C. R.		REINEFELD, A., see REINEFELD, E.		ROULLARD, E. E. A. Heat transfer and friction loss in hot-sucrose reheat. (Abs.)	182
PONANT, J. and WINDAL, G. Purity determination. (Abs.)	375	REINEFELD, E. W. German beet campaign 1974/75. (Abs.)	120	ROUSSEL, N. Phosphorus and potassium fertilization of beet. (Abs.)	149
POPOV, A. E. and MEZENTSEV, S. K. Beet sampling and analysis. (Abs.)	124	see also Colour formation by Maillard reaction. (Abs.)	379	<i>et al.</i> Beet varietal trials in Belgium. (Abs.)	244, 339
POPOV, V. D., see GULYI, I. S., SHUMSKAYA, E. E., SINAT-RADCHENKO, D. E. and ZUBCHENKO, V. P.		- Non-sugars behaviour in beet juice. (Abs.)	28, 157	ROUSELL, C. A. Honokaa factory expansion. (Abs.)	117
POPOV, V. E. Sugar factory designing	88	- Organic acids determination in beet juice. (Abs.)	250	ROZFFER, N. Tillage reduction effects.	80
POTTER, H. S., see SCHNEIDER, C. L.		see also SCHLEPPHAKE, D.		RUDY, V. E., see TSUKALO, Y. P.	
PRAHUB, K. A., see GUPTA, S. C.		REMSER, J. C., see SZKLARUK, F.		RUDDA, A. V. Chemical weed control.	270
PRASAD, H. C., see JHA, A. P.		REMY, J. C. <i>et al.</i> Vinasse and carbonatation mud as fertilizer. (Abs.)	222	Fertilizer requirements and cane response. (Abs.)	78
PRASAD, J. C., see JHA, A. P.		RENIUS, W. Green marring and beet nematode and springtail incidence	155	RUDENKO-GRETSUY, G. E., see VOLOSZHENKO, G. P.	
PREIS, G. A., see KRASNOPOL'SKI, N. I. and SYLNKO, A. I.		RENS, G., see DEEGEST, J.		RUHM, E., see CZERZATKI, W.	
PREY, V. and ANDRES, H. Colorants separation by gel chromatography. (Abs.)	318, 346	RENS, J. O. <i>et al.</i> Beet and sugar yield and sugar content prediction	115	RUNGOGAS, F. M., see MURRAY, J. P.	
and WESNER, H. Sugar crystal colorants. (Abs.)	91, 93	REVA, P. P. and ZHINSKAYA, N. J. Temperature effect on pH of factory products. (Abs.)	156	RUPPEL, E. G. <i>et al.</i> Beet powdery mildew in U.S. (Abs.)	52
<i>et al.</i> Beet juice treatment with flocculant and colour formation.	55, 90	see also Carboxylation vessel. (Abs.)	342	RUPPEL, R. F. Beet insect pests. (Abs.)	83
- Glucaric acid determination. (Abs.)	25, 50	see also LIKHITSKI, M. M.		RUSO, R., see BOBOVNIK, L. D.	
PRIDL, J., see OPLET, V.		REXLIS, L., see REINEFELD, E.		RUSSELL, F. B. Beet damage minimization in mechanical harvesting.	212
PRIKROPKO, I. <i>et al.</i> Beet bri sugar determination. (Abs.)	156	REYES L., H. Two-massesute boiling scheme and continuous crystallization. (Abs.)	23	RUTINSKAYA, A. S., see FANOV, S. Z.	
and UKRAINETI, K. V. Laboratory constant-temperature unit. (Abs.)	220	see also RICAUDOS, C. Pesticides and herbicide hazards. (Abs.)	300	RUTTER, K. H. Plastic piping. (Abs.)	312
see also VOLOSZHENKO, G. P.		Rabon stunting disease diagnosis.	79	RYAN, C. C. Controlled-environment chambers for cane disease research	332
PROSTIBOZHENKO, V. A., see KICHIGIN, N. M.		see also PINESAPPE disease control. (Abs.)	273	see also PERRY, G. J.	
PUGHARNA, J., see FRIML, M.		RICAUDOS, C. Pesticides and herbicide hazards. (Abs.)	300	RYAN, J. D. Refinery steam and power utilization. (Abs.)	57
PUGACHEV, V. A. <i>et al.</i> Syrup purity and classes yield optimization	278	RICH, J. E. A., see ABBOTT, J. P.		RYAZANTSEV, S. N., see ELIGIN, A. M.	
PUGACHEV, V. I., see CHUDAKOV, G. M.		RICHARD, B. <i>et al.</i> Cane varietal ripening differences. (Abs.)	177	RYAZANTSEVA, I. I. and GADZHIBEV, Y. S. Sodium sulphite addition and thick juice thermal stability.	278
PUSCZ, W., see BURBA, M.		RICHARD, B. <i>et al.</i> Cane varietal ripening differences. (Abs.)	177	RYCHKUN, M. Factory and refinery energy consumption. (Abs.)	57
PYTEL, I., see BOCKO, J.		RICHARD, C. A. and CHAMALYA, M. J. Cane varietal trials in U.S. (Abs.)	176	RYSDER, G. K. Temperature effect on beet yield and sugar content. (Abs.)	307
		and HENDERSON, M. T. Stool Brix and cane sugar content. (Abs.)	145	<i>et al.</i> Inorganic constituents and beet growth, yield and sugar content.	212
		see also MARTIN, F. A.		RYUBENKOVA, M. L., see KRAVETS, Y. O.	
QUAYLOOM, S. A., see KUHLMANN, R. W.		RICHY, P., see SCHONROCK, K. W. R.		SAPFR, G. R., see SCHNEIDER, C. L.	
QUINAN, P. B., see PADDOCK, D. R.		RIDDEL, L., see IVIN, P. G.		SAFRANKOVA, J., see BERNARDOVA, H.	
		RIDEAU, J. P. <i>et al.</i> Waste water treatability prediction. (Abs.)	280	SAFRONOV, I., see BURLANEK, J.	
RAAB, A. H. K. F., see ROSENBERG, L.		RIDGE, D. R. and KELLY, G. J. Irrigation water quality. (Abs.)	50	SAGEL, J. Sucrose, dextrose and invert sugar determination. (Abs.)	317
RAATS, P., see KOSTER, P. B.		see also LEVERINGTON, K. C.		SAH, B. K. and PATEL, K. A. Cane yield correlation with sugar content and c.e.s. (Abs.)	300
RAFAF'SKI, V. F. <i>et al.</i> Beet diffuser corrosion prevention. (Abs.)	310	RIECK, H., see EMMERICH, A.		SAH, B. P. <i>et al.</i> Soil phosphorus fixation. (Abs.)	272
see also SPIRIDONOVA, I. M.		RIESSMANN, J. H. and WEIGHING, J. L. Leaf spot control. (Abs.)	20	SAHNI, S. S., see SANDHU, S. S.	
RAIS, J., see BURLANEK, J.		RÍMSA, V. <i>et al.</i> Beet virus yellows tolerance determination. (Abs.)	52	SAINI, S. S. <i>et al.</i> Plant spacing and beet seed yield. (Abs.)	83
RAJAN, S. D., see AHMED, S. A. and RAMAMOORTHY, N.		RIPOLI, T. C. and BALASTREIRE, L. A. Cane transport requirements calculation. (Abs.)	368	SAINT JOHN, G. E. Fluid couplings. (Abs.)	117
RAJU, K., see SOMU, T.		RISHI, N. <i>et al.</i> Cane varietal mosaic susceptibility.	137	SAIVARAJ, K., see PADMANABHAN, M. D.	
RAM, H. H., see MATHUR, B. K.		RISSEUW, I. Irrigation water quality	301	SAKA, Y., see TANGAKI, S.	
RAM, R. S., see SANDHU, S. S.		RIVAS, G. B., see ABRIKOV, V.		SAKAL, R., see PANDRY, L. N.	
RAMAACHANDRAM, G. Cane milling.	308	RIVAS, L. De Smet cane diffuser.	503	SAKUMA, J. M. Drip irrigation scheduling. (Abs.)	80
RAMALINGAM, S. S. Alcohol manufacture from molasses. (Abs.)	61	ROACH, B. T. Cane yellow spot varietal resistance. (Abs.)	50	SAKUN, A. N. Wet weathering.	246, 280, 310
RAMAMOORTHY, N. <i>et al.</i> Cane deterioration after harvesting. (Abs.)	220	Inter-row spacing and cane yield.	335	SALANKI, I. Beet molasses sugar extraction. (Abs.)	216
see also RED, S. E.		ROBERTS, D. L. Cane cleaner. (Abs.)	114	SALAZAR, J. A., see SEIP, J. J.	
RAMASWAMY, C., see SRINIVASAN, T. R.		ROBERTS, E. J. and CARPENTER, F. G. Acid beverage flocc.	283	SALEH, T. M., see FAHY, T.	
RANDABEL, M. Temperature control in polarimetry and refractometry	251	<i>et al.</i> Acid beverage flocc.	326	SALLENBERG, J. F., see BELLEN, J. M.	
RANDOLPH, A. D. and WHITE, E. T. Classified crystal recycling in continuous boiling. (Abs.)	372	- Cane arabinogalactan isolation and composition. (Abs.)	163	SAMAL, H. H. Napier grass control.	205
RAO, C. S. Scale insect. (Abs.)	208	see also CARPENTER, F. G. and GODSHALL, M. A.		and JOHNSON, S. H. Wireworm control. (Abs.)	112
RAO, K. C. <i>et al.</i> Cane ripening with sodium sulphate. (Abs.)	273	ROBERTSON, L. S. and VAN DOREN, D. M. Beet seedbed preparation	306	SAMU, R. C. and MUKHOPADHYAY, S. K. Boron and molybdenum effects on beet and sugar yield. (Abs.)	83
- Vanadium sulphate effect on cane sugar yield. (Abs.)	300	see C. J. L.		SANGHES, A. J. Cane mill modernization. (Abs.)	53
RAO, P. J. M. Bagasse paper manufacture. (Abs.)	349	ROBICHAUX, H. CP 65-357 cane variety	369	SANGHESVIERGA, G. V. Cane pests in Guatemala. (Abs.)	49
Vuyyuru sugar factory. (Abs.)	340	ROBINSON, W. S. Cane agriculture in Hawaii. (Abs.)	369	SANDHU, J. S. <i>et al.</i> Leafhopper control	331
RAO, S. H., see RAO, M. V.		ROCHER, M. Errors in sugar determination by (Abs.)	189	see also KANWAR, R. S. and KOONER, B. S.	
RAO, T. K. G., see SETHANATHAM, S.		RODRIGUEZ, S. Two-drifl cane planting	179	SANDHU, S. S. <i>et al.</i> Cane smut varietal resistance. (Abs.)	273
RASE, H. F., see SCHRAUFNAGEL, R. A.		RODRIGUEZ, A., see BATULE, E.			
RASKIN, Y. V., see PARKHOMETS, A. P.		RODRIGUEZ, B. M. Evaporator and pan scale removal. (Abs.)	119		
RASTOGI, K. B., see SAINI, S. S.					
RATHI, K. S. Cane intercropping. (Abs.)	300				

INDEX

	PAGE
SANDULIYAK, A. V., see TRACHENKO, S. I.	
SANFORD, B. F. Air pollution reduction	150
SANG, S. L. <i>et al.</i> Continuous carbonation	309
- Trace metals determination. (Abs.)	346
SANGUINA, A., see CASTRO, P. R. C.	
STO. DOMINGO, J. P. Ghana sugar factory performances. (Abs.)	277
SAPOTZNIKOVA, I. R., see KHELEMSKI, M. Z.	
SAPRONOV, A. R. and KOLCHEVA, R. A. Sugars decomposition. (Abs.)	60
<i>et al.</i> Colour formation and prevention. (Abs.)	60
see also BOBOVNIK, L. D.	
SAREEN, K., see SINGH, B. and SINGH, G.	
SAROI, J. S., see KAR, K.	
SARRIS, J., see RIDZAI, J. P.	
SAUER, G. A. Automatic tailgate openers. (Abs.)	211
SAVCHUK, K. N. Carbonation gas scrubbing. (Abs.)	216
Condensers. (Abs.)	311
Lime kiln charging. (Abs.)	90
SAWYER, G. M. and CULLEN, R. N. Fly-ash slurry dewatering. (Abs.)	85
see also McFARLAND, E. B.	
SAYED, G. EL-K. <i>et al.</i> Cane alpha-amylase activity. (Abs.)	157
- Cane deterioration after harvesting and juice quality. (Abs.)	157
- Starch determination. (Abs.)	157
- Starch removal from cane juice. see also HEMADA, S. EL-N.	150
SCARDUA, E. and SOUSA, J. A. G. C. Drip irrigation scheduling and cane yield. (Abs.)	331
SCHAAPE, A. Cane processor. (Abs.)	110
SCHAEER, R. Cane diffusion vs. milling costs. (Abs.)	53
SCHAFMAYER, H., see SCHÄFFELE, W. R.	
SCHAUFELER, W. Beet virus yellows and SCHAFMAYER, H. Micro-granulators. (Abs.)	374
and WINNER, C. Pest control and beet emergence. (Abs.)	19
SCHELLEROVA, E., see BERNARDOVA, H.	
SCHENKADYER, I., see KAMAL, R.	
SCHWIEBE, H. Carbonation. (Abs.)	278
Oxygen application and colour formation in carbonation. (Abs.)	26, 246
and BÜSCHING, L. Raffinose determination. (Abs.)	28
see also KOSTER, P. B.	
SCHLAG, K. F., see METZING, P.	
SCHLIEPHAKE, D. and AUSTMEYER, K. Boiling. (Abs.)	380
- Mosaic-like rheological properties determination and automatic boiling control. (Abs.)	55, 187
<i>et al.</i> Cossette transport in diffusion	25
SCHNEBL, W. Beet and cane agriculture in Morocco. (Abs.)	82
SCHMIDT, L. Beet leaf yield. (Abs.)	274
<i>et al.</i> Beet varietal trials in Czechoslovakia. (Abs.)	52
- Plant population effect on beet and sugar yield. (Abs.)	181
see also AL-WINDI, I. and STEHLIK, V.	
SCHMIDT, W. H., see KROEFT, M. E.	
SCHNEIDER, C. Fungal beet disease control. (Abs.)	306
and POTTER, H. S. Beet root rot control. (Abs.)	116
and ROBERSON, L. S. Beet diseases in U.S. (Abs.)	19
and SAFIR, G. R. Photographic estimation of beet yield under affect of blackroot. (Abs.)	181
SCHNEIDER, F. <i>et al.</i> Sucrose diffusion coefficient determination. (Abs.)	347
- Sugar moisture determination.	93, 249
SCHNEIDER, G. Dust explosion prevention. (Abs.)	246
SCHNIELE, H. Beet processing. (Abs.)	381
SCHNIDEROVA, Z., see BURIANEK, J.	
SCHROENROCK, K. W. R. Beet molasses ion exchange treatment. (Abs.)	87
and COSTESSE, D. Beet sucrose determination. (Abs.)	347
<i>et al.</i> Carbonation with magnesium oxide. (Abs.)	56
SCHRAUFNAGEL, R. A. and RASE, H. F. Levulinic and formic acids manufacture from sucrose. (Abs.)	61
SCHREIER, O. Beet damage by birds.	274
SCOTT, D. A., see HUDSON, J. C.	
SCULLY, P. C., see RAVNO, B. D.	
SEABRO, F., see YANG, S. M.	
SEBASTIAN, K. Beet washer. (Abs.)	248
SEDLMAYR, T., see OLTMANN, W.	
SEETHARAMAN, R. N., see SOMU, T.	
SEIF, J. J. and GAYLE, F. L. Factory research in U.S. (Abs.)	150
and SALAZAR, J. A. Mechanical cane harvesting. (Abs.)	147
<i>et al.</i> Cut-chop vs. whole-stalk cane harvesting. (Abs.)	205
see also BIRKETT, H. S.	

SEK, J., see KEMBLAWSKI, Z.	
SELDON, J. E., see STEINDL, R. L.	
SELEMBENEV, V. P., see CHIKIN, G. A.	
SEMENCHENKO, V. I., see KOONER, B. S.	
SEMENENKO, V. Z., see ZARHAROV, K. P.	
SEMENTETS, P. A., see MATVEENKO, P. S.	
SEMENOVSKI, V. A., see KOVAL' E. T.	
SEMENYUK, V. S., see ZAGORUL'KO, A. Y.	
SEN, A., see SINGH, K.	
SEPUTIN, E. and VAN STEYVOORT, L. Beet virus yellows control. (Abs.)	306
- Insect control. (Abs.)	243
SEVRYUK, V. K., see BELORON', E. E.	
SHAFIQ, M. and SAMANIGEO, R. Raw sugar impurities and filtrability.	27
SHAKHNOVICH, B. M. Waste water treatment. (Abs.)	378
SHALIMOVA, T. Y. <i>et al.</i> Carbonation	185
SHAPIRO, A. I. Condensate in beet diffusion. (Abs.)	246
SHARKOV, V. V., see TROINO, R. P.	
SHARMA, H. L., see KANWAR, R. S. and SINGH, B.	
SHARMA, K. R., see SINGH, G.	
SHARMA, K. R., see SANDHU, S. S.	
SHARMA, P. P., see SAINI, S. S.	
SHARMA, R. C. Self-synchronizing motors. (Abs.)	245
SHARMA, R. K., see BHARDWAJ, K. M.	
SHARMA, S. K., see KOONER, B. S.	
SHARMA, S. P., see YADAV, H. N.	
SHECHGOOLEV, V. N. and PARKHOMETS, A. P. Beet flume parameters calculation. (Abs.)	121
<i>et al.</i> Beet slicing. (Abs.)	87
SHEN, J. S. Cane breeding in Taiwan.	367
SHEPEL'SKII, O. I. <i>et al.</i> Beet thick juice storage. (Abs.)	217
SHEPHERD, G. S., see MURRAY, J. P.	
SHEPHERD, E. E. Cane train running simulation. (Abs.)	51
SHESTAK, N. B., see BEL'KO, G. I.	
SHESTOV, A. G., see CHABAN, E. E.	
SHEVCHENKO, A. M., see SUKHODOL, V. F. and VOLOSHANENKO, G. P.	
SHEVTSOV, L. D., see TABUNSHCHIKOV, N. P.	
SHIBATA, T. C., see CHEN, Y.	
SHINGUR, A. G., see TARANENKO, L. S.	
SHIUE, H. I., see CHENG, W. C. and SANG, S. L.	
SHOKHET, A. L., see KHVALKOVSKII, P. P.	
SHORE, M., see OLDFIELD, J. F. T.	
SHUNDAROVA, N. T., see IVANOV, S. Z.	
SHTANGEEV, K. O., see GOROKH, V. N.	
SHTANGEEV, V. O. <i>et al.</i> Temperature fluctuation and crystallization in boiling. (Abs.)	185, 217
SHUKLA, A. C., see AGARWAL, M. L.	
SHUKLA, R. S., see AGARWAL, S. K. D.	
SHUKLA, R. S. Steam turbine failures	119
SHUKLA, S. L., see SINGH, K.	
SHULER, J. H. <i>et al.</i> Conveyor chain pin corrosion. (Abs.)	119
SHUMSKAYA, E. E. and POPOV, V. D. Fluidized bed crystallization.	153, 184
SHUT, N. A., see BEL'KO, G. I.	
SHVETS, V. N. <i>et al.</i> Lactic acid bacteria effect on molasses alcohol manufacture. (Abs.)	285
- Molasses colorants and properties	317
- Molasses colorants and yeast zeta-potential. (Abs.)	252
SILINA, N. P. Sucrose reaction with salts. (Abs.)	91
SILVA, L. U., see SPUFFELLO, J. P.	
SILVEIRA, J. Cane properties and mechanical harvesting. (Abs.)	16
SILVERIO R., C., see MURO M., M.	
SIMMONS, N. W. Cane smut varietal resistance and crop profitability.	329
SIMMONS, S. R. and DOTZENKO, A. D. Soil erosion prevention by rotary tillage. (Abs.)	337
SIMONART, A. <i>et al.</i> Waste water treatment with condensate. (Abs.)	55, 310, 311
SINAT-RADCHENKO, D. E. and POPOV, V. D. Sugar solution thermo-physical properties calculation. <i>et al.</i> Sugar solution molar concentration calculation. (Abs.)	346
SINGH, A., see MATHUR, B. K. and SINGH, R. A.	
SINGH, B. <i>et al.</i> Gur physico-chemical properties. (Abs.)	92
see also AGARWA, M. L.	
SINGH, C. A. K. and BHARGAVA, K. S. Alternative cane mosaic host. (Abs.)	143
SINGH, D. J. C. and GUPTA, K. M. Chemical weed control. (Abs.)	301
SINGH, G. and KAREEN, K. Cane growth regulator effects. (Abs.)	368
<i>et al.</i> Cane ripening with chemicals. - Irrigation and nitrogen effects on cane yield. (Abs.)	295
SINGH, J. P. <i>et al.</i> Fungicides and cane yield. (Abs.)	272
SINGH, K. <i>et al.</i> Beet diseases in India - Beet sowing time, irrigation and yield. (Abs.)	273

	PAGE
SINGH, L., see BOSE, S.	
SINGH, M. and VARMA, R. K. Condensate utilization in factory processes. (Abs.)	22
see also BHARDWAJ, K. M.	
SINGH, O. P. <i>et al.</i> Cane borer parasite	239
see also SRIVASTAVA, S. N. L.	
SINGH, P. P. Beet intercropping with cane. (Abs.)	15
SINGH, R., see GUPTA, D. N., OBEROI, D. S. and OJHA, S. K.	
SINGH, R. A. <i>et al.</i> <i>Isaria pilosula</i> control	301
SINGH, R. P., see PANDEY, L. N.	
SINGH, S. Cane mosaic alternative host <i>et al.</i> Sowing and harvesting dates effect on beet yield and sugar content. (Abs.)	369
see also KANWAR, R. S. and KHURANA, S. M. P.	181
SINGH, S. P., see SINGH, Y.	
SINGH, U. S. Nitrogen effect on cane. (Abs.)	17, 111, 175
and BAJPAI, P. D. Soil factors and cane chlorosis. (Abs.)	48
SINGH, Y. and SINGH, S. P. Harvest data and irrigation interval effects on beet.	338
SINGLA, M. L., see KOONER, B. S.	
SIPITANOU, K. M. and MITRA, D. S. Limestone properties. (Abs.)	377
SIRKNO, S. I., see GULTI, I. S.	
SIROTENKO, A. M., see GULTI, I. S.	
SISLER, G. H., see MAAG, G. W. and OSWELER, K. A.	
SITHANANTHAM, S. <i>et al.</i> Cane planting time and borer incidence. (Abs.)	48
- Potassium and pesticide effects on - cane leaf composition. (Abs.)	368
see also MUTHUSAMY, S.	
SIVASWAMY, M. S., see GURUMURTHY, S. SKALA, L. and FRIML, M. Saccharinic acids. (Abs.)	220
SKALSKI, K. Flume water treatment. (Abs.)	25, 90, 186, 227
SKINNER, J. O. Cane sugar	125
SKINNER, P. O. Chemical control. (Abs.)	125
SKOYEN, I. O. <i>et al.</i> Beet powdery mildew control. (Abs.)	116
SKRPILEV, V. E., see BORZDAYA, V. N.	
SLATER, L. B. Bagasse pelleting	381
SLAVYANSKI, A. A., see PUGACHEV, V. A.	
SLOANE, G. E., see MORITSUGU, T.	
SLYN'KO, A. I. <i>et al.</i> Centrifugal pump erosion and corrosion. (Abs.)	153
SLYTERENKO, T. P., see SHVETS, V. N. and STARNIKOVA, E. V.	
SMITH, H. Boiler and beet pulp dryer emission. (Abs.)	184
SMITH, H. A. <i>et al.</i> Raw sugar manufacture from crude sugar in Mexico	274
see also SUND, K. A.	
SMITH, D. Sugar y Azúcar Yearbook 1975. (N.B.)	58
SMITH, E. S. Eleccie factory closure and Koloa expansion. (Abs.)	117
SMITH, H. T. E. Mechanical cane harvesting. (Abs.)	79
SMITH, I. A., see SMITH, D.	
SMITH, N. H. Cane steam treatment and colour formation in juice and raw sugar	259
SMITH, P. D. Juice purity drop in cane milling. (Abs.)	118
SMITH, P. M., see TEAKLE, D. S.	
SNYDER, F. W. Beet seedling leaf and root growth differences. (Abs.)	212
Immaturity and water absorption effects on beet fruit properties.	116
and ZIELKE, R. C. Water and beet seed germination. (Abs.)	20
see also ZIELKE, R. C.	
SOBER, E. Effect of limestone and coke size on lime quality. (Abs.)	378
Lime kiln firing. (Abs.)	25
SOBIESZAK, C. Automatic factory process control. (Abs.)	186
Sugar factory planning. (Abs.)	120
SOBOL', P. A., see LILA, N. G.	
SOKOLOWSKI, A. and LAMPRECHT, A. Heat transfer in beet diffusion. see also DEMBICKI, H.	186
SOLDATI, A. A., see CERRIZUELA, E. A.	
SOLLARS, E. D. Seed cane growing and cutting. (Abs.)	81
SOLOGUB, N. A., see SLYN'KO, A. I.	
SOLYANKI, A. O., see LYSYANSKI, V. M.	
SOMERA, B. J., see MORITSUGU, T.	
SOMORA, Z. Milk-of-lime doser. (Abs.)	87
SOMOROV, I. B. Beet reception. (Abs.)	88
see also KICHIGIN, N. M.	
SOMU, T. <i>et al.</i> Cane pests and diseases in India. (Abs.)	301
SOOPRAMANEN, G. F., see JULIEN, E.	
SOROKIN, A. I., see PARKHOMETS, A. P.	
SOUSA, J. A. G. Cane agriculture in Brazil. (Abs.)	110
Overhead irrigation. (Abs.)	17
Ratoon stunting disease control. see also SCARDUA, E.	238
SPARDO, R. F. and BAXTER, S. W. D. Cane harvester. (Abs.)	210

INDEX

PAGE	PAGE	PAGE
SPINOSO, J. G., see ENGIOLIO, J.	SUKSUPHA, K., see ABDULBHAN, P.	THOMSON, J. B. Drip irrigation and
SPRIDONOVA, I. M. <i>et al.</i> Beet slicer	SULLADMATH, V. V. <i>et al.</i> Pineapple	cane agriculture. (Abs.).....
knife treatment.....	disease control. (Abs.).....	271
343	20	see also UCHIDA, R. S.
SPONDER, D. Cane data processing by	SULLIVAN, E. F. Chemical weed control	TICHA, B., see FRIML, M.
computer. (Abs.).....	SULLIVAN, J. P. <i>et al.</i> Dextrose deter-	TICOM, U. U., see SCHNEIDER, F.
214	mination. (Abs.).....	TIEDGE, H. G., see HOBOHM, J.
371	317	TIEDMANN, W. E., see VICKERS, R. P.
SPRY, E. G. Weather effect on herbi-	SUMMERS, T. E. Cane damage by grubs	TILLEY, L. G. Cane planting
cide performance. (Abs.).....	and JACKSON, R. D. Cane borer	material selection. (Abs.).....
332	parasite. (Abs.).....	271
SRIDHARAN, D. Alcohol manufacture	SUNNER, M. E. and BEAUFILS, E. R.	Chemical weed control. (Abs.)... 209
from cane molasses. (Abs.).....	Cane nutrient requirements deter-	TIMOSHENKO, F. T., see KOSMINSKI,
61	mination. (Abs.).....	I. V.
SRINIVASAN, T. K., see SITHANANTHAM,	SUND, E. E. and SMITH, E. Cane	TIMOSHENKO, S. F. and PODVORZHNYI,
S.	damage by frost in U.S. (Abs.)... 146	G. I. Beet pumps. (Abs.).....
SRINIVASAN, T. R. and MORACHAN,	SUNDARESAN, K., see BALASUNDARAM,	121
Y. B. Cane studies in India. (Abs.)	N. and THANGAVELU, S. P.	TIT, C., see BOGER, D. V.
301	SUPRENCHUK, V. K., see CORDOVES, M.	TRACHENKO, N. M. Beet pulp pressing
<i>et al.</i> Cane deterioration after har-	SUTHERLAND, R. F. Cane harvesting	and press. (Abs.).....
vesting. (Abs.).....	data processing by computer... 54	TRACHENKO, S. I. <i>et al.</i> Evaporator
210	SUZOH, N. L. C. Clarification and non-	scale reduction. (Abs.).....
SRINIVASEN, S. Evaporator incandens-	sugarcane effect on juice and raw sugar	217
able gas removal. (Abs.).....	colour. (Abs.).....	311
86	309	TOLBEVICH, N. Y. <i>et al.</i> Condensers... 311
SRIRAMULU, C. R. <i>et al.</i> White sugar	SUZUKI, N., see TANIGAKI, S.	TOBOLA, A., see GERRARD, E.
boiling scheme. (Abs.).....	SVACHULA, V. and VRATNY, P. Amino-	Toca, C. R. Cane quality and staleness
308	acids in beet leaf blades, petioles	effects on processing and molasses
SRIVASTAVA, N. S. L. Cane planter... 17	and root. (Abs.).....	exhaustion. (Abs.).....
SRIVASTAVA, R. L. Factory perform-	27	119
ance evaluation. (Abs.).....	SVOBODA, A., see ZDARSKY, J.	TODD, E. H. Cane varieties in Florida
308	SVODOVOVA, M., see BRETSCHNEIDER, R.	TODDO, R. B. V. Mechanical cane
SRIVASTAVA, S. K., see MUKHERJEE, S.	SWAYAMPRAKASAM, S., see AHMED, S. A.	harvesting and transport. (Abs.)
SRIVASTAVA, S. N., see SINGH, K.	SWETT, F., see BATTERHAM, R. J.	80
SRIVASTAVA, S. N. L. <i>et al.</i> Fertilizer	SWINBELLS, R. J. and WHITE, E. T.	TONG, J. F., see SANG, S. L.
trials in India. (Abs.).....	Crystallization of continuous	TONGNEROVA, D. and HAMPLOVA, K.
308	centrifugals. (Abs.).....	Sugar and masscuite crystal size
SRIVASTAVA, T. N., see KALRA, A. N.	85	analysis. (Abs.).....
and VARMA, A.	- Masseuite layer thickness and	TOOHEY, C. L. Q 87 cane variety. (Abs.)
SRIVASTAVA, U. P., see SINGH, J. P.	crystal residence time in centri-	157
STARBUCK, R. <i>et al.</i> Carotene	frugals. (Abs.).....	209
production from molasses. (Abs.)	373	"Spring" planting in Australia. (Abs.)
61	SYCH, O. L., see KOVACH, V. G.	17
STADLER, F., see CRONEWITZ, T.	SYCHEVSEKII, N. A., see BURYMA, A. K.	TOPPER, J. V., see KENNEDY, A. S.
STAKER, R., see HIDI, P.	SYMES, R. T. Cane transport. (Abs.)	TOULIERE, S., see GUERAN, J.
STALLINGS, J. D., see KELLER, A.	210	TOUZEL, J. P., see RIDEAU, J. P.
STAMPER, E. R. Chemical weed control.	SZABO, J., see UHIDY, A.	TOUZEL, L. I., see KOLOMIETS, V. F.
(Abs.).....	SZABO, J., see UHIDY, A.	TOVBY, D. A., see BULL, T. A.
144, 205	SZABO, J., see UHIDY, A.	TOYAMA, R., see TAKATORI, Y.
STANKIEWICZ, W. <i>et al.</i> Sugar dryer... 342	SZABO, J., see UHIDY, A.	TRAEVIER, D. and HULL, J. E. Herbi-
STASEY, G. I. Scroll-type beet diffuser	SZABO, J., see UHIDY, A.	cide performance. (Abs.).....
operation. (Abs.).....	SZABO, J., see UHIDY, A.	305
313	SZABO, J., see UHIDY, A.	TREBIN, K. I., see SINAT-RADCHENKO,
STEHLIK, V. and SCHMIDT, L. Beet ash	SZABO, J., see UHIDY, A.	D. E. V.
content. (Abs.).....	SZABO, J., see UHIDY, A.	TREBIN, L. I., see BAZHAL, I. G.
242	SZABO, J., see UHIDY, A.	TREBIN, W. E. Alcohol manufactur-
STEIB, R. J. Freezing effect on red	SZABO, J., see UHIDY, A.	ure from molasses. (Abs.).....
rot pathogens. (Abs.).....	SZABO, J., see UHIDY, A.	190
143	SZABO, J., see UHIDY, A.	253
and CHILTON, S. J. P. Planting rate	SZABO, J., see UHIDY, A.	TRIANA, G. <i>et al.</i> Bagasse hydrolysis
effect on cane mosaic and yield... 145	SZABO, J., see UHIDY, A.	TRIFONOVA, E. A., see ZAGORULKO,
see also COCHRAN, B. J.	SZABO, J., see UHIDY, A.	A. Y.
STEIN, F., see FOWLER, L. G.	SZABO, J., see UHIDY, A.	TRIPATHI, G. M., see SANDHU, J. S.
STEINDL, D. R. L. Ratoon stunting	SZABO, J., see UHIDY, A.	TRIPATHI, K. B., see MATUR, B. K.
disease diagnosis. (Abs.).....	SZABO, J., see UHIDY, A.	TRIPP, V. W., see MORRIS, N. M.
332, 334	SZABO, J., see UHIDY, A.	TRIVIP, P. P. Crystallizer cooling ele-
see also FEARLE, D. S.	SZABO, J., see UHIDY, A.	ment. (Abs.).....
84	SZABO, J., see UHIDY, A.	119
STEINDL, R. J. <i>et al.</i> Continuous boiling	SZABO, J., see UHIDY, A.	TRIFIMOV, V. A., see CHUDAKOV, G. M.
see also BROADFOOT, R.	SZABO, J., see UHIDY, A.	TROINO, V. P. <i>et al.</i> Circulation ratio
STEINER, G. W., see LADD, S. L.	SZABO, J., see UHIDY, A.	and heat transfer in boiling. (Abs.)
STEINLE, G., see KOSTER, P. B.	SZABO, J., see UHIDY, A.	153
STEINLE, R., see FRIML, M.	SZABO, J., see UHIDY, A.	153
STERLICKOV, A. I., see DERZHAVETS, A. S.	SZABO, J., see UHIDY, A.	- Optimum pan relative charge
STERZINGER, M. and ZDARSKY, J. Cane	SZABO, J., see UHIDY, A.	- Vacuum pan tube length and tube
milling-cum-centrifuging.....	SZABO, J., see UHIDY, A.	plate angle effects. (Abs.).....
323, 361	SZABO, J., see UHIDY, A.	217
STEVENSSON, J. C. and WHAYMAN, E.	SZABO, J., see UHIDY, A.	TRULL, T. H., see DIAZ G., E. P.
Cane starch isolation and iodine	SZABO, J., see UHIDY, A.	TRUYENS, L. <i>et al.</i> Liquid and farm-
affinity.....	SZABO, J., see UHIDY, A.	yard manure effects. (Abs.).....
44	SZABO, J., see UHIDY, A.	306
STEWART, J. M. and CRAWFORD, W. B.	SZABO, J., see UHIDY, A.	TRZCINSKI, W. and BAROWSKA, E.
Bagasse boiler simulation. (Abs.)	SZABO, J., see UHIDY, A.	Losses in stored beet. (Abs.)... 279
85	SZABO, J., see UHIDY, A.	TSENG, H. T. Cane borer parasite... 207
STEWART, E. J., see KIRBY, K. L. and	SZABO, J., see UHIDY, A.	Tsot, C. H., see CHEE, W. S.
NESB, J. S.	SZABO, J., see UHIDY, A.	TSYGANKOV, P. S., see KRIVICH, A. N.
STEWART, G. A., see VICKERS, R. P.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STEWART, I. J. Nitrogen. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
78	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
Phosphorus. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
209	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
Potassium. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
271	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
Standover cane. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
47	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STEWART, P. N. <i>et al.</i> Clarification mud	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
treatment by centrifuge. (Abs.)	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
85, 373	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STEWART, W. Cane juice mud separa-	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
tion by polyelectrolyte for Brix	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
measurement. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
188	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STIEGER, W. Beet harvester perform-	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
ances. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
244	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STOUT, E. L., see AKESON, W. R.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STRASHVSEKII, E. L., see TRACHENKO,	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
S. I.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STRATIENKO, O. V., see LYSYANSKI,	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
V. M.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STRAUTENIKS, A. K. and LAZBE, Y. Y.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
Dust separation cyclone. (Abs.)... 216	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STROBEL, G. A. Cane eye spot suscepti-	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
bility. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
79	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
and HAPNER, K. D. Toxin-binding	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
protein and cane eye spot suscepti-	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
bility. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
77	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
and HESS, W. M. Cane cell toxin-	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
binding protein. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
48	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STRUBE, H. Optimum beet population	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
and hot water cooling and	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
recycling. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
374	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STUDNICKY, J. <i>et al.</i> Carbonation with	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
magnesium oxide. (Abs.)... 55, 342	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STUPELLO, J. P. <i>et al.</i> Cane distilla-	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
tor. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
380	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
- Cane molasses purity determina-	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
tion. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
125	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
see also DE OLIVEIRA, E. R.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
STRESS, O. V. Fiji disease. (Abs.)... 367	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
Purrow irrigation water utilization	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
SU, W. T. Soil salinity reduction. (Abs.)	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
111	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
112	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
SUAREZ, S., see SKLARUK, F.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
SUDO, K., see HONDA, S.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
SUDO, S., see CASTRO, P. R. C.	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
SUE, I. Lime kiln fuel, design and	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
operation. (Abs.).....	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
55, 185	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
SUKHODOL, V. F. <i>et al.</i> Alcohol manu-	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.
facture from molasses. (Abs.)... 158	SZABO, J., see UHIDY, A.	TSYKOURA, V. R., see FURER, M. E.

INDEX

	PAGE
URBANIEC, K., see KUBASIEWICZ, A.	
URBINA-VIVAL, C. and HIRUMI, H.	
Beet yellow wilt. (Abs.)	180
USHER, J. F. Cane root system maintenance. (Abs.)	209
Drip irrigation. (Abs.)	331
Second-hand cane equipment cleaning. (Abs.)	78
USMENTSEVA, A. Z. et al. Sugar pesticide determination. (Abs.)	93, 347
USTOCHENKO, V. N., see DOVOGPOLOV, V. I.	
V	
VACCARI, G., see MANTOVANI, G. and MATTEUZZI, D.	
VAISMAN, M. L. Vacuum creation in pans. (Abs.)	278
et al. Sugar factory steam requirements. (Abs.)	217
see also FROINO, V. P.	
VAKULKO, P. S., see MAKSIUK, P. S.	
VALLANCE, L. G. Calcium silicate effect on cane. (Abs.)	111
Cane harvest date and yields. (Abs.)	273
Cane ripening with 'Polaris'. (Abs.)	241
Nematodes. (Abs.)	238
VAISECHI, O., see DE OLIVEIRA, E. R.	
VALTER, V., see BOUCEK, S. and UHEREK, J.	
VALY, E. B., see FRONTERA, A. R.	
VAN DER POEL, P. W. Beet diffusion infection determination. (Abs.)	56
see also BLOK, J.	
VANDENBIEK, R., see DIGREST, J.	
VAN DOREN, D. M., see ROBERTSON, L. S.	
VAN GILS, W., see DE VLETTER, R.	
VAN GROENINGE, V. C. Mechanical cane loading and dirt rate. (Abs.)	111
VAN MALLAND, H., see REINEFELD, E.	
VANOSI, L. Dextrose and molasses fermentation processes. (Abs.)	126
Yeast composition and nutritional value. (Abs.)	94
VANSTALLEN, R. Beet nutrient deficiencies. (Abs.)	82, 337
Dressed seed determination. (Abs.)	115
Farmyard and liquid manure application. (Abs.)	149
Herbicide damage to beet. (Abs.)	339
Micro-granulator feed rates. (Abs.)	274
Soil liming effect on beet yield and sugar content. (Abs.)	83
Soil structure and treatment. (Abs.)	211
and VIGOUREUX, A. Bolted beet control. (Abs.)	339
see also ROTSSSEL, N., TRUYENS, L. and VIGOUREUX, A.	
VAN STEYVOORT, L. Beet agriculture in Belgium. (Abs.)	18, 243
Black fly control. (Abs.)	52
see also SEUTIN, E.	
VAN WILK, R. Steel turnplates. (Abs.)	86
VARDHARAJAN, G., see PADMANABHAN, M. D.	
VARMA, A. et al. Cane borer rearing. (Abs.)	207
see also KALRA, A. N.	
VARMA, R. K., see SINGH, M.	
VASATKO, J., see STUDNICKY, J.	
VASILYU, V. L. and KUCHEN, N. M. Beet damage in loading/unloading and piling. (Abs.)	121
et al. Sugar storage. (Abs.)	376
VASILYVA, P. K. White sugar pneumatic conveying. (Abs.)	376
et al. White sugar pneumatic conveying. (Abs.)	376
see also ZAPORSIN, A. F.	
VAVRINEZ, G. Beet molasses formation	178
VÁZQUEZ, J. Cane transport in Cuba.	114
VÁZQUEZ, G. M. A., see GONZÁLEZ F., M. D.	
VELASCO, V. S. and DOWLING, J. F. Sugars behaviour in invert syrup	284
VELAZQUEZ R., R. Bagasse drying and heat utilization. (Abs.)	53
VELINS, M. Beet diffusion disinfectant	378
VENTURI, G., see AMALDI, M. P.	
VENUGOPAL, K. and PALANIAPPAN, T. P. Temperature and cane sugar content. (Abs.)	144
VERNOIS, G. Evaporator scale reduction. (Abs.)	247
Evaporator tube scaling and corrosion. (Abs.)	379
Filter cake utilization. (Abs.)	281
VERSTRAETE, P. H. Pre-sieve work and beet planting. (Abs.)	276
VEURMAN, J. D. Contouring effect on soil erosion and cane yield. (Abs.)	77
Soil conservation. (Abs.)	48
VIATOR, D. P. Cane trash contents.	146
VIATOR, H. P. and HENDERSON, M. T. Cane varietal lodging resistance evaluation. (Abs.)	178
VIATOR, S. F. Cane borers in Louisiana	170
VICDOMINI, M., see COCCIOLI, F.	
VICKERS, R. P. et al. Wet weather cane harvesting. (Abs.)	333, 334
VILBER, T. L., see BECKER, S. R.	
VIGGO, S. Cane mill roller grooving.	53
Imbibition water addition point.	53
VIGIL, A. Cane mill feeding. (Abs.)	53

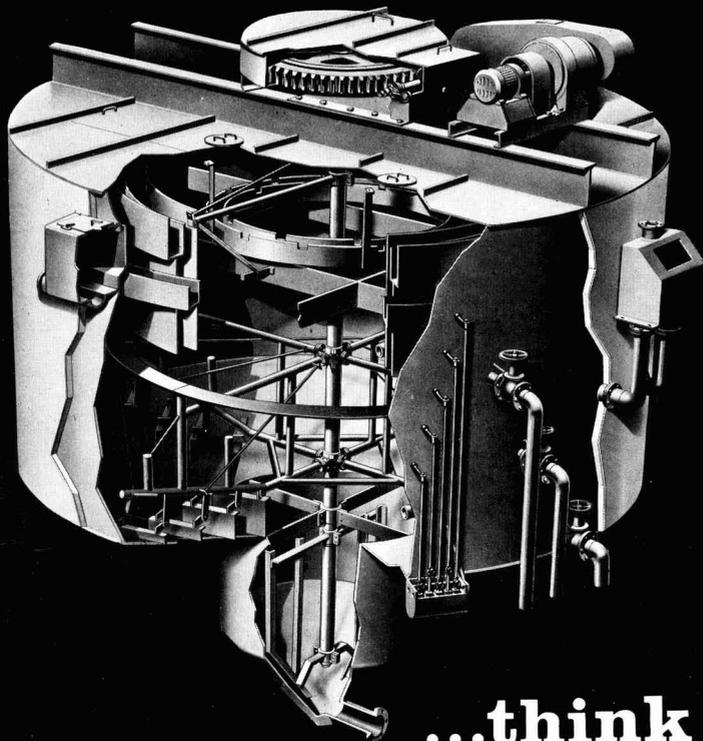
VIGNES, E. C. Cane molasses sugar determination. (Abs.)	220
VIGOUREUX, A. Beet field operations	149
Beet harvesters. (Abs.)	211
Beet loader. (Abs.)	274
Beet topping and clamp protection against frost. (Abs.)	181
Chemical weed control and hoeing	21
Wild beet control. (Abs.)	306
and VANSTALLEN, R. Wild beet control. (Abs.)	18, 82, 337
and VREVEN, T. Filter cake and farmyard manure as fertilizer. (Abs.)	337
see also VANSTALLEN, R.	
VILLEA, R., see CASTRO, P. R. C.	
VILLAMIL, E. and CASEY, J. A. Evaporator and distillation column scale reduction. (Abs.)	23
VILSHANSKI, A. et al. Automatic milk-of-lime quantity and density control. (Abs.)	378
VITON, A. Costa Rica, Guatemala and Salvador sugar industries. (Abs.)	119
VIVASSAK, K., see TRUYENS, L.	
VOITKEVICH, V. G., see BOGOROSH, A. T.	
VOLOKHOV, A. Y. Centralized lubrication. (Abs.)	344
VOLOSHANENKO, G. and SHEVCHENKO, A. M. Organic acids determination. (Abs.)	156
et al. Amino-acids and peptides meiosisgenesis. (Abs.)	346
VON KESSEL, W. C. Beet agriculture in Finland. (Abs.)	149
Beet fertilization. (Abs.)	115
Beet harvesters. (Abs.)	212
Beet harvesting losses and damage	149
Beet machinery. (Abs.)	306
Beet spring work. (Abs.)	275
Late weeds and beet yield. (Abs.)	18
Weather effects on beet. (Abs.)	244
VON MÜLLER, A. and WINNER, C. Nitrogen and plant density effects on beet yield and quality. (Abs.)	338
VRAŇNY, P., see SVACHULA, V.	
VREVEN, T., see ROUSSEL, N. and VIGOUREUX, A.	
VUKOV, K. Beet juice active alkalinity	217
Beet properties and slicing. (Abs.)	187
Colorants adsorption by calcium carbonate. (Abs.)	246, 246, 316
Colour formation in beet juice. (Abs.)	278
VYAS, S. R., see DHANKHAR, H. S.	
W	
WAGNEROWSKI, K. Masseculite viscosity in boiling. (Abs.)	216
et al. Beet diffusion water treatment	90
WALERIANCZY, E., see MALEC, K. and STANKIEWICZ, W.	
WALKER, R. L. Mechanical cane harvesting costs. (Abs.)	114
see also FREEMAN, C. E.	
WALLACE, G. A., see BATES, L.	
WALLENSTEIN, H. D. and EGGER, H. Beet juice acids determination.	27
WALSH, L. Rats and cane damage.	273
WANG, Z. N. and LEU, L. S. Cane pest fungal parasites. (Abs.)	208
WANKHEDE, N. P. and PARABHAI, K. S. Cane intercropping with cotton.	51
WASILEWSKI, J. C., see SULLIVAN, J. P.	
WASMUND, R. Automatic evaporator control. (Abs.)	343
Steam air content and heat transfer	248
WATSON, C. C. Bagasse furnace emission analysis. (Abs.)	151
WATTS, R. S. Polarimeter errors. (Abs.)	348
WAYMAN, J. A. et al. Beet topping.	209
WEARNE, R. C., see GOTHARD, D.	
WEBB, W. A. C. <i>Borreria</i> sp. control.	331
Chemical weed control. (Abs.)	78
and CLARKE, N. Orange freckle.	78
WEBER, M., see CLARKE, N.	
WEBER, H. Sugar colour determination. (Abs.)	250
WEBER, A. L. Cane juice liming and continuous flow measurement.	118
Cane milling and sugar house efficiencies. (Abs.)	374
WEIGHING, J. L., see RIESELMAN, J. H.	
WELLER, E. P. Chemical weed control economic. (Abs.)	110
WELNER, R. Waste water treatment	245
WELLS, W. D. and JAMES, G. P. Dextran and cane processing difficulties	374
WESNER, H., see PREY, W.	
WESTERMAN, D. T., see CARTER, J. N.	
WESTFALL, D. G. and BARNES, M. Beet bred nitrate and sugar contents.	19
WHAYMAN, E. and CREES, O. L. Clarification with flocculant. (Abs.)	245
and WILBERSDORF, A. L. Starch components and iodine complex spectra. (Abs.)	67
Starch effect on carbonatation. (Abs.)	99
see also STEVENSON, J. C.	

	PAGE
WHITE, E. T., see AWANG, M., BROADFOOT, R., RANDOLPH, A. D. and SWINDELLS, R. J.	
WHITNEY, E. D. and DONEY, D. L. Agronomic factors and nematode development. (Abs.)	20
see also DONEY, D. L.	
WHITNEY, R. W., see COCHRAN, B. J.	
WIENINGER, I. and KUBANDINOW, N. Beet thick juice heating and colour formation. (Abs.)	55, 217
WIKLICKY, L. Nitrogen effect on beet quality and sugar content. (Abs.)	211
WILDMAN, S. V. and GOLDSMITH, T. J. Steam turbines for power generation. (Abs.)	86
WILDSMITH, C. G. Conveyor and power transmission chains. (Abs.)	182
WILCOX, T. G. Cane varieties in Australia. (Abs.)	209
WILBERSDORF, A. L., see WHAYMAN, E.	
WILLETT, H. Double drilling and mechanical cane harvesting. (Abs.)	205
WILLEY, L. A. and MCCULLAGH, S. F. H. Beet varietal trials in UK. (Abs.)	84
WILLIAMS, D. J. Locust control. (Abs.)	332
see also OLFELD, J. P. T.	
WILLIAMS, G. Drip irrigation. (Abs.)	369
WILLIAMS, J. C. Reducing sugars degradation and colorant properties	336
WILLIAMS, J. F. Tidal land reclamation in Taiwan. (Abs.)	91
WILLIAMS, J. R. Cane pest parasites and hosts. (Abs.)	81
WILLIS, J. F. Cane crop failure probability evaluation. (Abs.)	81
WIND, E., see DE VLETTER, R.	
WINDAL, G. Factory process automatic control. (Abs.)	279
Purity determination. (Abs.)	375
see also FOMANT, V.	
WINDER, G. H., see DUNNING, R. A.	
WINNER, C. Beet nitrogen requirement determination. (Abs.)	181
Beet varietal performance assessment and MERKES, R. Beet population effect on yield and quality. (Abs.)	246
et al. Population and inter-row spacing effects on beet yield and quality. (Abs.)	244
see also BEISS, U., BÖTGER, H., SCHAUFEL, W. R. and VON MÜLLER, A.	
WINTER, S. R. Irrigation and nitrate-N accumulation in beet fields. (Abs.)	337
WIŚNIEWSKI, R., see BURCZYŃSKI, Z.	
WOLF, W. et al. Chromium determination. (Abs.)	27
WONG, YOU CHEUNG, Y., see DEVILLE, J.	
WOODWARK, W., see HIBBERT, D.	
WOOLCOCK, R. F., see WESNEY, D.	
WOLEJY, J. P., see GILLASPIE, A. G.	
WRIGHT, J. Cane damage by soldier fly. (Abs.)	47
Contour banks. (Abs.)	331
WRIGHT, P. G. Evaporator steam requirement and heat transfer calculation. (Abs.)	84
see also BROADFOOT, R. and FREW, J. A.	
WU, J. P. Drip irrigation system design. (Abs.)	51
WU, M. M. H. et al. Cane field soil fungi. (Abs.)	336
see also CHAO, C. C.	
WU, T. H., see MAI, S. C.	
WÜSTEMANN, R., see EBERS, G.	
Y	
YADAV, H. N. and SHARMA, S. P. Cane borer control. (Abs.)	301
YADAV, S. Y., see SINGH, O. P.	
YALUMOV, R., see LUCHEV, I. S.	
YAMANE, T. and ASAI, H. Refining in Malaysia. (Abs.)	154
YAMSHCHOV, A. I., see OSOKIN, V. I.	
YANG, S. C. Foliar and soil fertilizer application. (Abs.)	336
YANG, S. J. Cane agricultural research in Taiwan. (Abs.)	367
YANG, S. M. Fungi and cane varietal yield decline. (Abs.)	145
Soil fungi and cane growth. (Abs.)	113
and SPABERG, F. Beet rot, black rot and sheath disease control. (Abs.)	178
YANG, T. T. and HSEH, T. S. Fertilizer effects on cane growth and juice quality. (Abs.)	365
YANTSCH, M. I. Beet furze sand trap	185
YANVAREV, N. I., see BUROV, V. A.	
YAO, K. W. Soil drainage and salinity reduction. (Abs.)	112
YARMIKO, E. D. Boiler feed condensate complexing properties. (Abs.)	247
YARMIKO, V. G., see BORZADA, V. N.	
YURYMA, A. K., KOVAL, E. T. and KULINICH, N. V.	
YATSENKO, V. S., see EMEL'YANOV, V. A.	
YAUGER, W. L., see HILTON, H. W.	
YEH, H. J., see PENG, S. Y.	
YONEMITSU, I. Seed cane growing. (Abs.)	81

INDEX

PAGE		PAGE
	YOSHIDA, Y., <i>see</i> KASHIMURA, K.	
	YOUNG, C. J., <i>see</i> UOHIDA, R. S.	
	YOUNG, R. A., <i>see</i> NICHOLSON, M. K.	
	YSE, W. F., <i>see</i> NEE, C. I.	
ZABLITSKII, V. I., <i>see</i> PARKHOMETS, A. P.		
ZABORSIN, A. F. and VASIL'YEVA, T. K.		
White sugar pneumatic conveying	344	
<i>et al.</i> White sugar drying. (Abs.)	88	
- White sugar dust separator. (Abs.)	88	
<i>see also</i> VASIL'YEVA, T. K.		
ZAGATO, E. A. G., <i>see</i> BITTENCOURT, V. C.		
ZAGORODNYAYA, L. I., <i>see</i> OLYANSKAYA, S. P.		
ZAGORODNYI, P. P. <i>et al.</i> Beet thick juice electrodialysis. (Abs.)	89	
ZAGORUL'KO, A. Y. and KORBEINIKOVA, L. A. Turbidity removal for colour determination. (Abs.)	316	
<i>et al.</i> Beet molasses composition in USSR. (Abs.)	250	
- Brix and sugar determination	316	
- Masseurite cooling and molasses exhaustion. (Abs.)	278	
<i>see also</i> GOLOVNYAK, Y. D., MISHCHUK, R. T. and USMETSSEVA, A. Z.		
ZAGRODZKI, S. Beet diffusion water treatment and juice purity. (Abs.)	26, 216, 246	
ZAKHAROV, K. P. <i>et al.</i> Pre-carbonation mud removal and juice nitrogen and pectin contents. (Abs.)	185	
ZAKHAROVA, I. V., <i>see</i> KHVALKOVSKII, T. P.		
ZAKHAROVA, T. V., <i>see</i> KHVALKOVSKII, T. P.		
ZAMBELLO, E., <i>see</i> BITTENCOURT, V. C.		
ZANA, J., <i>see</i> LUKÁCS, L.		
ZAN'KO, N. A., <i>see</i> PARKHOMETS, A. P.		
ZAOBSKA, H. Beet diffusion water treatment and pulp quantity	26, 218	
ZAREGHANSKII, E. L., <i>see</i> TROINO, V. P.		
ZDANOVICH, I. L., <i>see</i> BRENNAN, S. A.		
ZDÁRSKÝ, J. and SVOBODA, A. Gur manufacture and analysis. (Abs.)	245	
<i>see also</i> STERZINGER, M.		
ZELAZNY, K., <i>see</i> JANUSZEWICZ, I.		
ZELENY, R., <i>see</i> SCHMIDT, L.		
ZEMLYANSKII, V. M., <i>see</i> KLOCHROV, V. P.		
ZENDE, G. K. Potassium as fertilizer	300	
ZEPF, G. A. and CLAYTON, J. E. Mechanical cane harvesting costs. (Abs.)	146	
<i>see also</i> CLAYTON, J. E.		
ZHARKOV, A. L. Convective mass transfer in sucrose crystallization	251	
<i>see also</i> KHARIN, V. M.		
ZHIZHINA, R. G., <i>see</i> ZAKHAROV, K. P.		
ZHMYRYA, L. P. <i>et al.</i> Dextrose hydration number. (Abs.)	318	
<i>see also</i> DADENKOVA, M. N.		
ZHURA, K. D. and OLYANSKAYA, S. P. Carbonation. (Abs.)	152	
<i>see also</i> OLYANSKAYA, S. P.		
ZHURBITSKII, M. A., <i>see</i> PARKHOD'KO, A. P.		
ZIEGLER, J. G. Barometric condensers	309	
Boiling. (Abs.)	56	
ZILKER, E. C. Beet characteristics	18	
Beet crown yield, sugar content and quality. (Abs.)	20	
Beet seed production in US. (Abs.)	83	
Beet varietal trials in US. (Abs.)	371	
and SNYDER, F. W. Beet crown and root impurities. (Abs.)	125	
<i>see also</i> SNYDER, F. W.		
ZILICH, E., <i>see</i> NELSON, P. H.		
ZINKO, B. M. Factory equipment components strain hardening. (Abs.)	184	
ZODE, N. P., <i>see</i> KAKDE, J. R.		
ZOZULYA, S. A., <i>see</i> DOVGOPOL, V. I.		
ZUBCHENKO, A. V., <i>see</i> BURAYLEVA, V. I. and BYVALTS'EV, A. I.		
ZUBCHENKO, V. P. <i>et al.</i> Continuous vacuum pan mathematical model	153	
ZUMMO, N. and FREEMAN, K. C. Cane bacterial sun spot. (Abs.)	143	
ZWAARDEMAKER, J. J. Clarification with magnesium oxide. (Abs.)	118	
ZYUKIN, M. A., <i>see</i> DERZHAVETS, A. S.		

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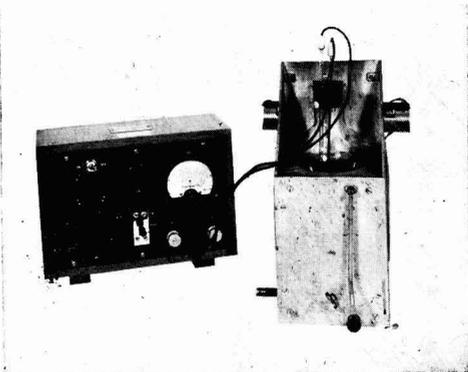
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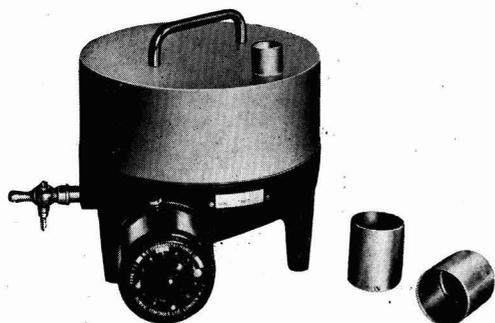
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REDUCING SUGAR ESTIMATION

This electrometric end point detector is battery operated and embodies an on/off switch, a potentiometer which permits a range of mV potentials to be applied across two electrode terminals, a sensitive galvanometer with centre zero and a knob for checking the battery output. The electrode system comprises a copper rod which connects to the positive terminal and a platinum wire electrode to the negative terminal. Titrations are complete when the meter needle returns to zero. (See also *I.S.J.*, 1966; 68, 173-174)

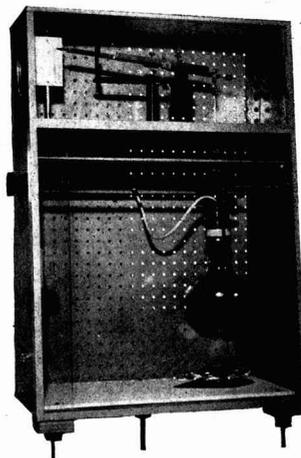


SUGAR MOISTURE MEASUREMENT



For the rapid estimation of moisture in sugars, the oven (left) is fitted with a thermostat which gives a temperature control of $\pm 0.25^{\circ}\text{C}$ over a range of 60°C from a central adjusted temperature. Results can be obtained in about 15 minutes. This type of oven must be used in conjunction with a vacuum pump or factory vacuum line for drawing the air over the heating element, through the sample and into the vacuum line or pump trap. A timing device can be supplied as an extra.

The sensitive infra-red balance (right) is designed for direct indication of moisture in refined sugars containing up to 0.25% water. A 20-g sample is dried by means of a 150W i.r. lamp and the loss in weight indicated continuously by the pointer on a 50-division scale where each division is equivalent to 1 mg. Reproducibility is to within half a division.



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