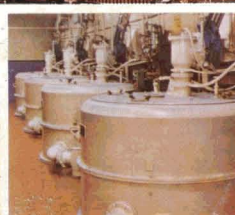
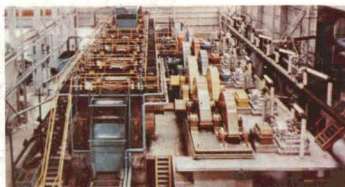


# INTERNATIONAL SUGAR JOURNAL

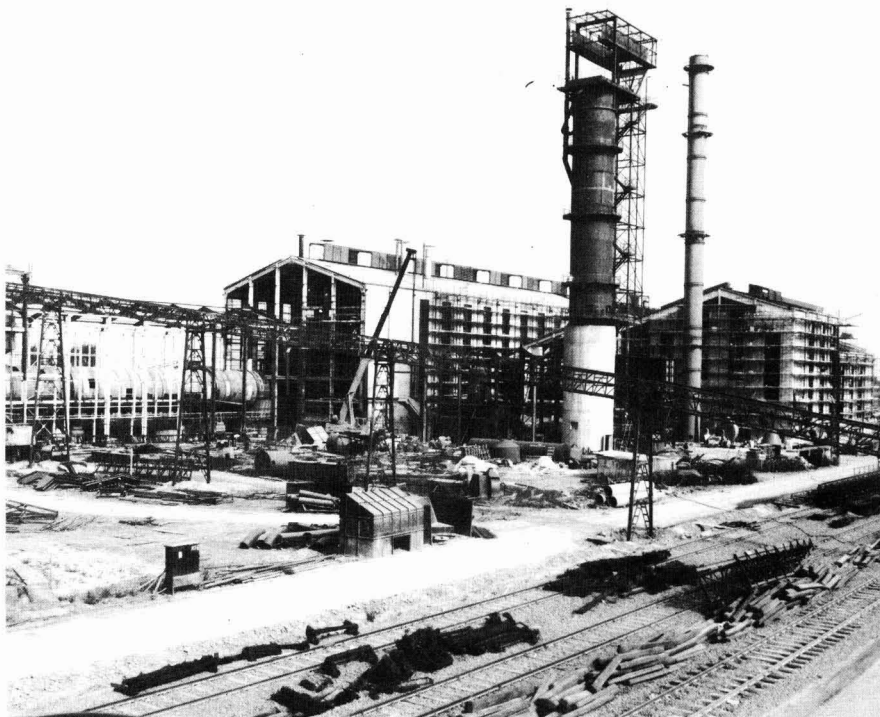


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DECEMBER 1979

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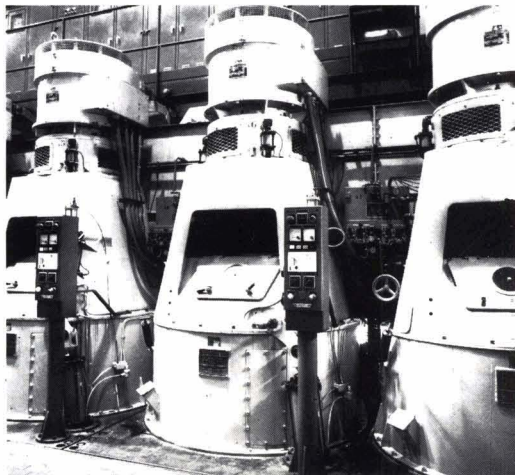
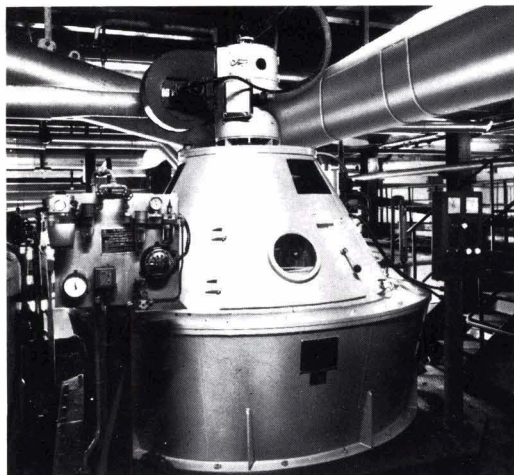
All Bosco sugar centrifugals are designed to reach high hourly outputs and to give the utmost reliability both from a mechanical and an electrical point of view in order to keep investment and operational costs to a minimum.

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- tight shut-off bottom doors
- fully drilled basket in stainless steel with reinforcing rings
- self-supporting structure
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- minimum power consumption

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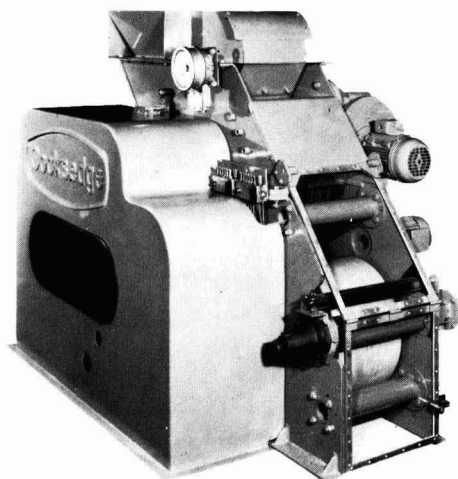
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throughout  
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# FS

## IN THE PHILIPPINES

**ISSCT  
MANILA 1980  
Stand 53-55**

Beyond the South China Sea lie the numerous islands which comprise the Philippine archipelago stretching some 1,150 miles in length with a land mass of over 116,000 square miles. In the agricultural economy of these islands sugar plays an important role and Fletcher and Stewart has long been actively engaged in supplying plant and equipment to the Philippine sugar industry.

In 1972 FS completed a turnkey cane sugar factory located at Davao on the island of Mindanao. The factory which has a design capacity of 4,000 tonnes of cane per day also incorporates a refinery capable of processing 250 tons of refined sugar per day. In its short life Davao has withstood severe typhoons and earthquakes which have devastated





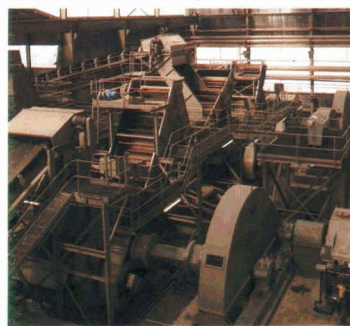
adjoining areas of the island, and despite the hazards has emerged with a first class record of operating efficiency.

Closely following the Davao factory FS was awarded a contract by the Bicolandia Sugar Development Corporation to build a 4,000 tonnes of cane per day raw sugar factory close to Naga City on the island of Luzon.

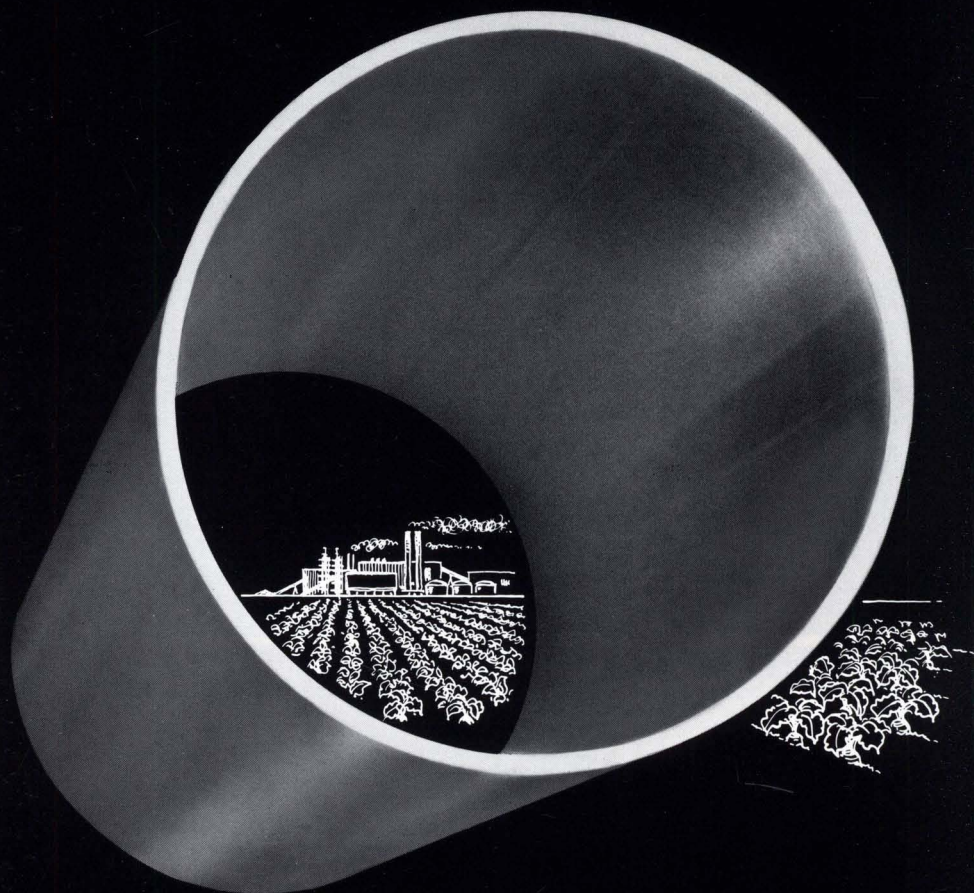
FS has recently completed a third turnkey project, the Northern Cotabato sugar factory sited on Mindanao island. Like the previous two factories Cotabato has a design capacity of 4,000 t.c.p.d. with provision for expansion to 5,500 t.c.p.d. at a later date.

This project, which is under the guidance of the Philippine Sugar Commission

(Philsucom), is part of an extensive programme of rationalisation which is geared to increasing the efficiency of its existing plant and equipment in order to benefit both its home and export markets. Most recently FS has been awarded a contract to build a refinery at Batangas on the island of Luzon to produce 550 tons of high quality refined sugar per day. The Batangas refinery will play an important role in the strategy for improving the quality of sugar in the Philippines so as to promote the further development of local industries such as fruit canning and soft drinks without the need for importing the special grades required by these users.



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Even at the worst conditions

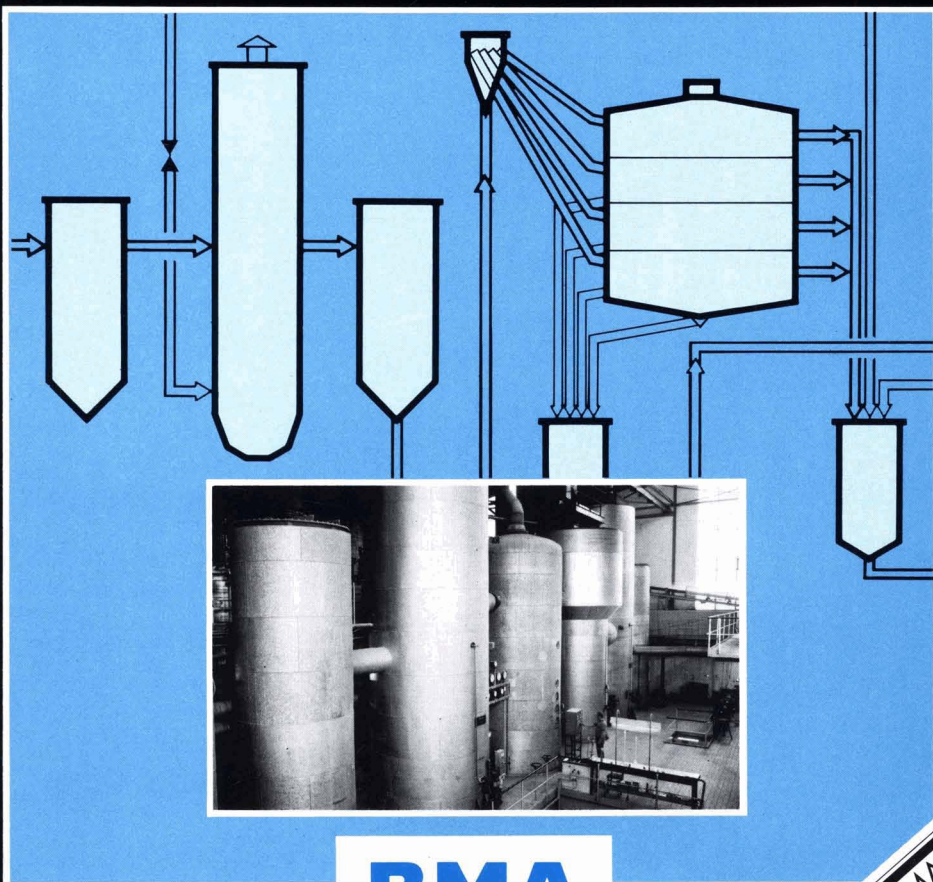
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# juice purification plants

ensure optimum nonsugar removal

## We supply

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- \* plants for treating sugar solutions with activated carbon
- \* Mechanical purifying facilities such as settlers, filters, arc screens, etc.



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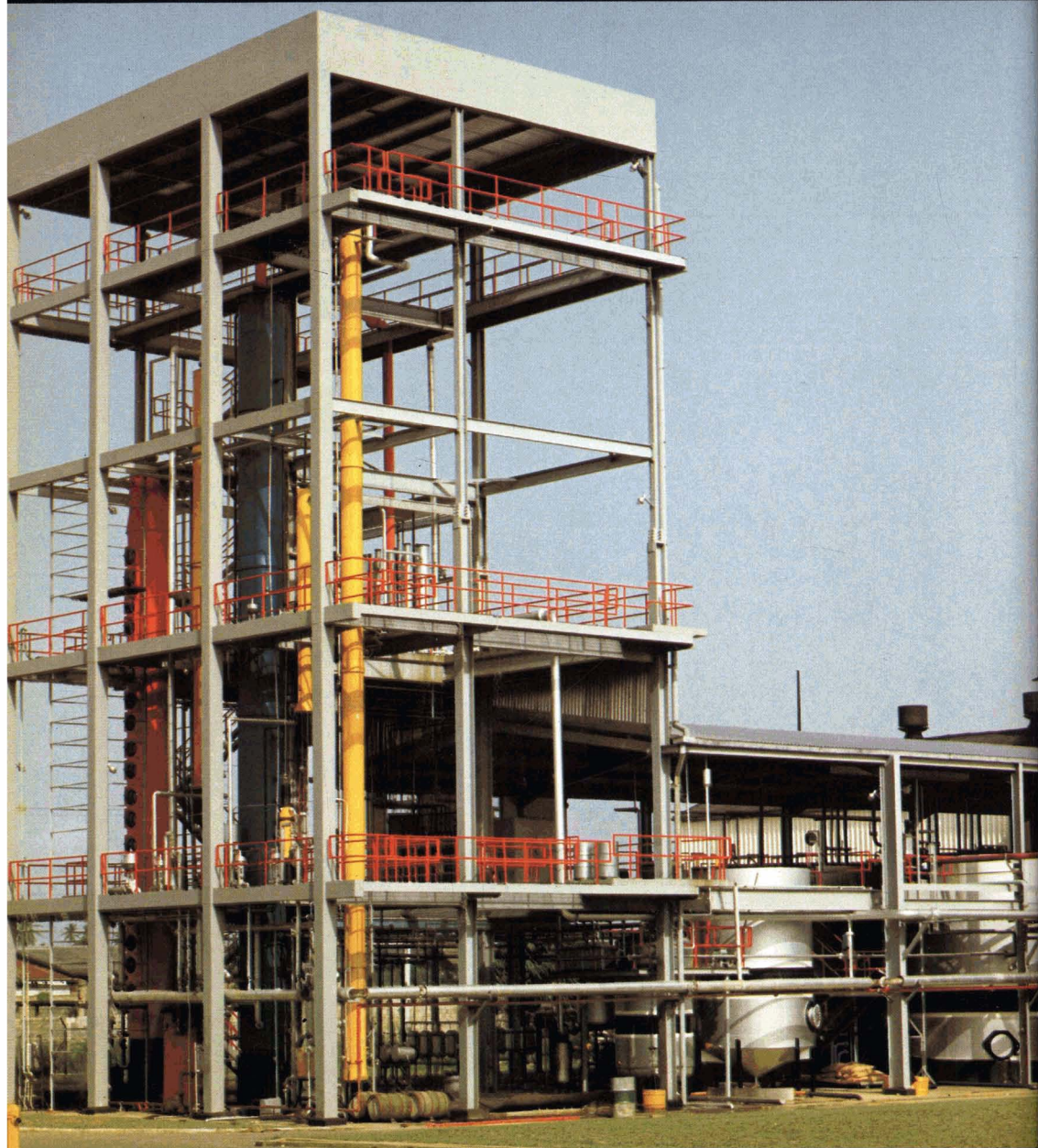
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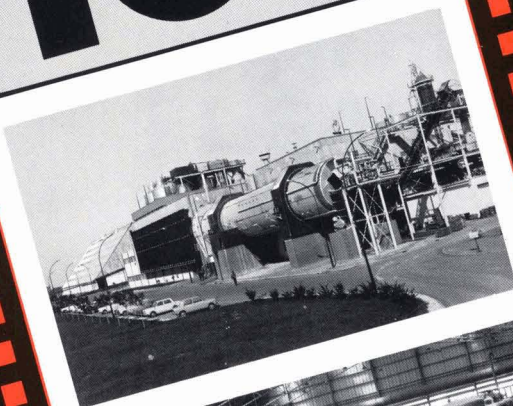
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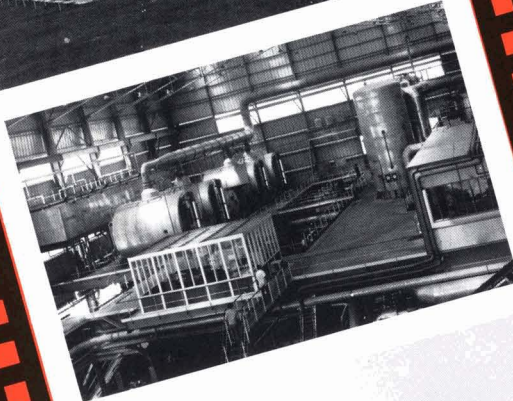


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modernizations)  
achieved within  
the last 20 years.**

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A sugar plant is not created by design alone.  
There's more to it.

There's planning and specification.  
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And also civil works, erection and supervision.

There's testing, commissioning and training of personnel.

And there's SWS to realize your plans.

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sugar industry engineers

Hengelo (Ov.) The Netherlands P.O.Box 147 Member of Vmf-Stork



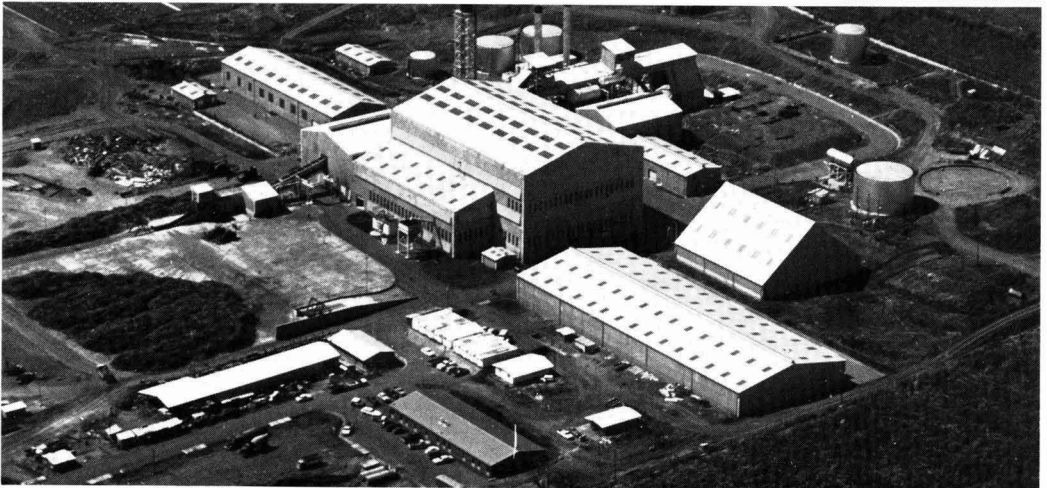
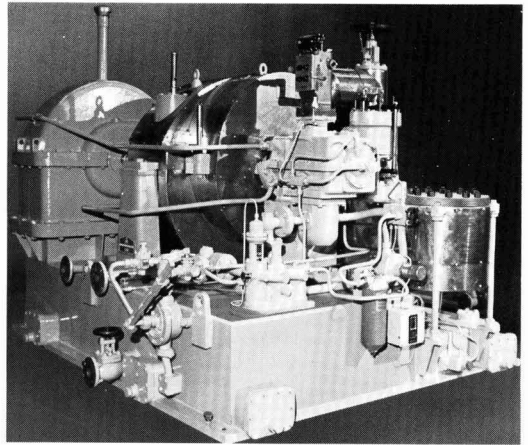
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There are 7 Brotherhood Steam Turbines installed at this new sugar factory in El Salvador completely engineered by Fletcher and Stewart Limited for the Institute Salvadoreno de Formento Industrial.

2 – 1750kW Turbo Generators to provide electrical power.

4 – 800 BHP single stage mill drive turbines and 1 – 1200 HP single stage turbine for driving the cane knives.

We invite you to send for details of the Brotherhood range of Sugar Mill Steam Turbines and Turbo Generators.



*Photograph by courtesy of Fletcher and Stewart Limited*

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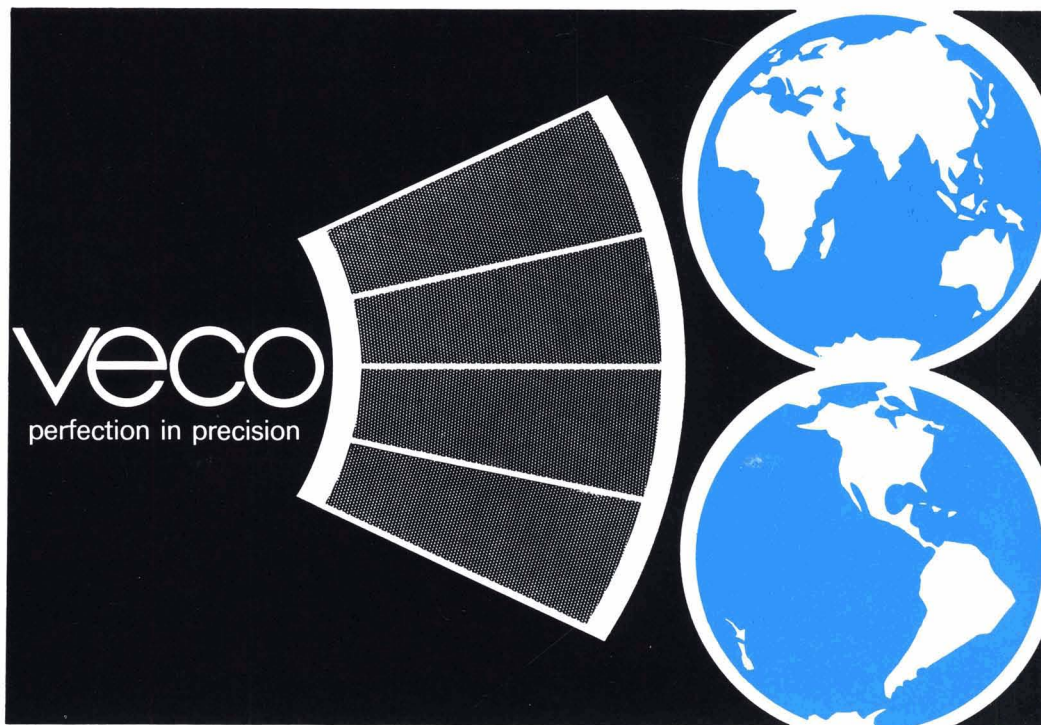
P3836

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# sugar-centrifugal screens

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all over the world continuous sugar-centrifugals of all types are equipped with Veco pure nickel chromeplated perforated sheets



technical data:

material nickel; also obtainable with chromium plating (900 DPN).

mirror smooth face

conical perforation, which means that Veco-segments feature a high discharge efficiency.

dimensions in accordance with specifications of centrifugal manufacturers.

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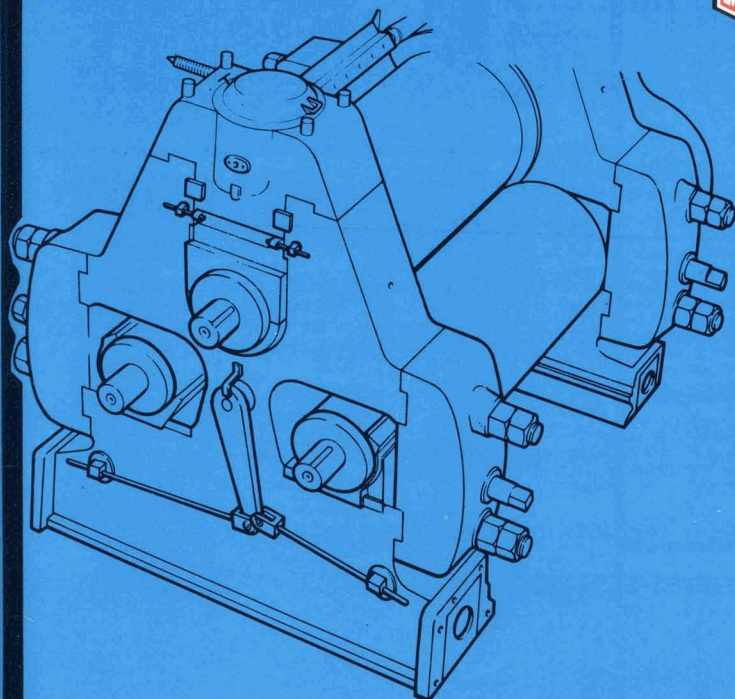
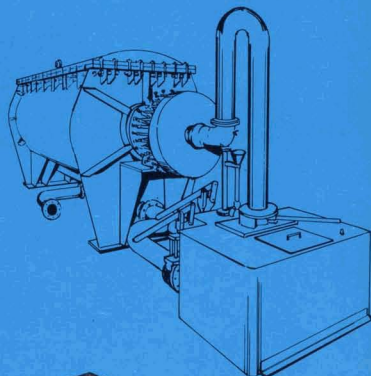
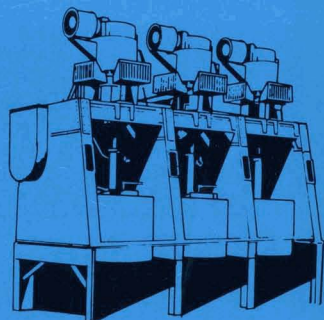
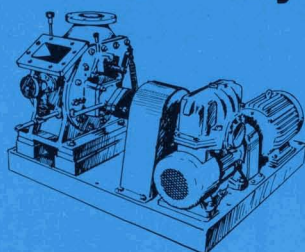
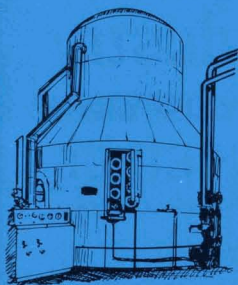
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Offer you  
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Sugar  
Machinery



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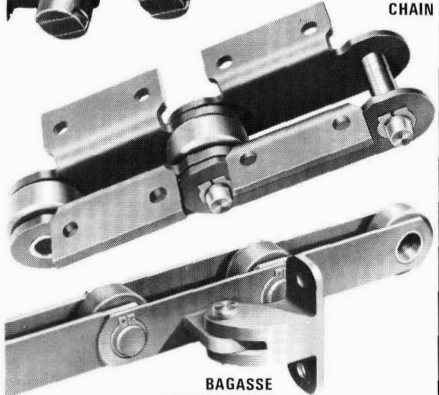
## PRODUCTS FOR THE sugar industry

### CHAINS FOR MECHANICAL HANDLING

INTERMEDIATE  
CARRIER  
CHAIN



CANE CARRIER  
CHAIN



BAGASSE  
CARRIER CHAIN

Specialised Renold chains have been supplied to the cane sugar industry since 1920. Over 90 years of precision chain manufacture ensure a product combining high strength with compactness, minimum weight and low cost for long life and trouble-free operation. Precision roller chains and wheels for power transmission are also available for all applications.



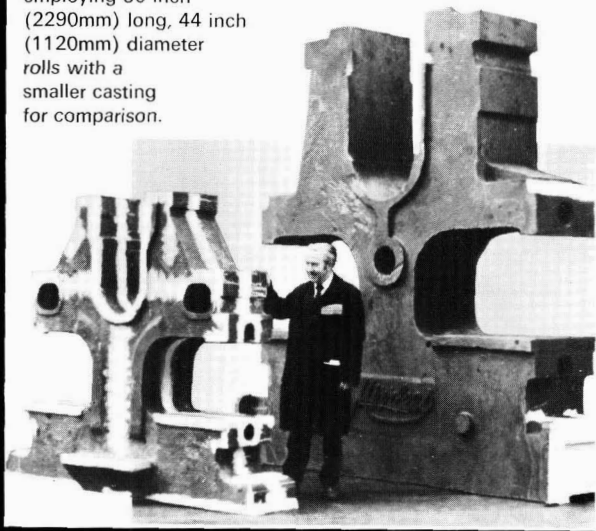
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Other Renold products include:-  
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Couplings, clutches and brakes.  
Power transmission ancillaries.*

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Holcroft Castings and Forgings, a Renold subsidiary company, supplies steel, iron and bronze castings and steel forgings.

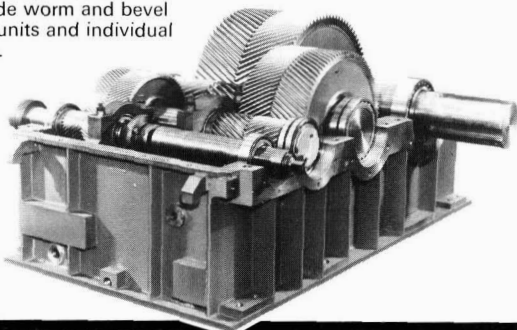
The photograph shows at 13½ tonne headstock casting for a 12 roll tandem employing 90 inch (2290mm) long, 44 inch (1120mm) diameter rolls with a smaller casting for comparison.



### POWER TRANSMISSION GEARING

One of three 800hp triple reduction, double helical gear units supplied to the Philippines. Spur gears up to 127mm circular pitch, 760mm face width and 4700mm diameter can be supplied for heavy tandem drives.

Other gear products include worm and bevel gear units and individual gears.



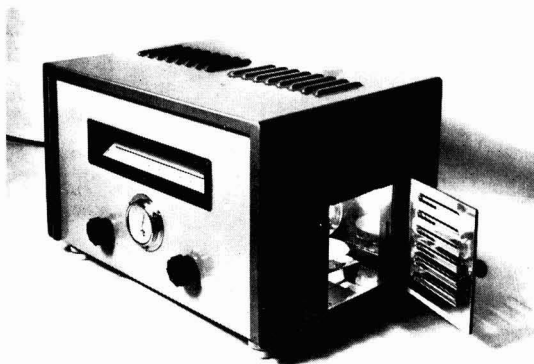


# Suma Products

## SUGAR ANALYSIS

### ROTARY DISSOLVING MACHINE

The action of this rotary dissolving machine is such that frothing and air trapping are either eliminated or reduced to the minimum while at the same time dissolving rapidly by a gentle wavy action. By its use the analyst may either speed up his work or devote himself to other duties until solution is complete. The angle of inclination and speed of rotation are so chosen that the solid material is held against the side of the flask on rotation and the solvent in contact with it is constantly changed. In the case of sugar analysis it was found that 26 grams of sugar are completely dissolved in 30 ml of distilled water in a 100-ml flask in  $3\frac{1}{2}$  minutes, without producing any frothing or trapping air bubbles in the solution. The dissolver operates from 200/250 or 100/125 volts single phase A.C. of 50 or 60 cycles.



Type CB

### MOISTURE BALANCE

The type CB automatic moisture balance illustrated here, is used for determining rapidly the moisture content of sugar. The balance is capable of an accuracy of  $\pm 0.05\%$  when 10 grm samples are used.

Heating is by infra-red lamp built into the equipment giving a maximum temperature of  $130^{\circ}\text{C}$  regulated by means of a resistance knob outside the body of the balance.

Aluminous spot projected on to a scale ranged 0/20% gives the moisture content directly at any instant of drying. The balance equipment is magnetically damped and is highly accurate.

Determinations can be made in from 5 to 30 minutes depending on the temperature and the nature of the product under test. This short duration is due to the penetration of the rays into the sample and not simply surface heating action.

All that is necessary is for the 10 grm sample to be weighed into the aluminium dish which is placed in the oven. The lamp is switched on, temperature adjusted and the spot read from time to time. As soon as two consecutive readings agree, the moisture content can be read directly on the scale.

Please state single phase voltage and frequency when ordering.

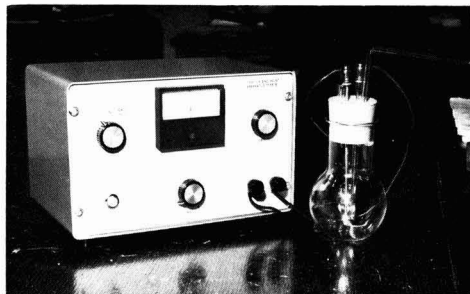
### REDUCING SUGAR ESTIMATION

(Electrometric end point detector)

The instrument comprises a battery-powered circuit embodying 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 press knob for checking the battery output.

The electrode system comprises a copper rod of  $\frac{1}{8}$  inch (3.18 mm) diameter which is connected to the positive terminal on the instrument panel and a platinum wire electrode connected to the negative terminal, both of sufficient length to permit adjustment so that they are always immersed in the solution under test. These electrodes are held in a rubber bung. Also fitted through the bung are a jet for the admission of the titration solution and a bent glass tube to act as a steam outlet. The bung is then introduced into the neck of a 250 ml flat bottomed flask.

For analytical comparison with the standard Lane & Eynon modified procedure, see I.S.J., June 1966, p. 173.



STANDARD POLARIMETERS FOR SUGAR ANALYSIS, also available according to requirements

## The Sugar Manufacturers' Supply Co. Ltd.

18 CITY ROAD, LONDON, ENGLAND EC1Y 2AP

Telephone: 01-638 9331.

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# DDS Crystallizer

Pat pending

## Type A and B

### Advantages:

- Continuous operation
- Compact space saving system
- Easy to install
- Minimum retention time required to obtain a certain exhaustion
- Due to the hydraulic drive, the motor cannot be overloaded
- No need for water dilution
- Effective agitation
- High cooling surface/volume ratio
- Rapid cooling without risk of fine grain formation
- The system is easy to extend
- Can be placed outdoors
- Simple and reliable automation

### Standard Design

The equipment consists of

- DDS crystallizer type A and B
- Cooling water pump
- Hydraulically operated reciprocating agitator

### Specifications

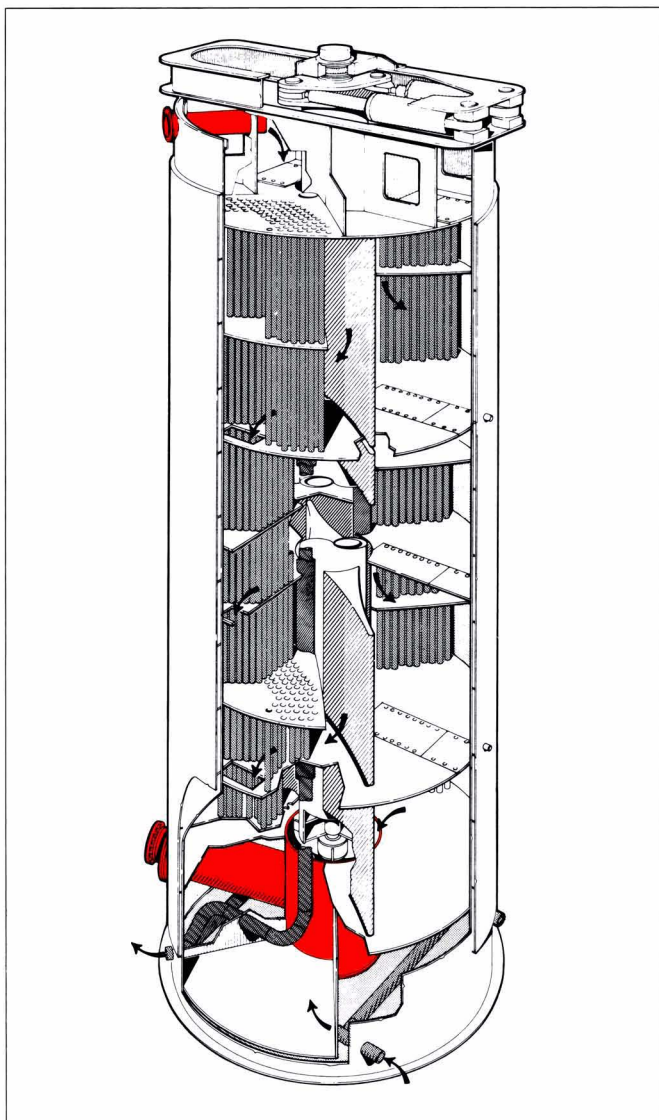
	Type A	Type B
Diameter – m	4.0	4.0
Height – m	12.9	13.4
Weight – tons	60	55
Massecurite vol. m <sup>3</sup>	100	100
Cooling surface m <sup>2</sup>	480	250

### Installation Examples

Afterproduct Massecurite (tons/24 hours)	400	600
Inlet temperature (°C)	80	80
Outlet temperature (°C)	35	35
Total number of crystallizers	2	3
Corresponding retention time (hours)*	18	18
Total number of crystallizers	3	4
Corresponding retention time (hours)**	27	24

\*) For usual exhaustion requirements, corresponding to raffinose corrected molasses purity of 59–60 in Danish factories.

\*\*) For obtaining molasses purities 0.5–1.5 below usual exhaustion requirements as mentioned above.



Aktieselskabet De Danske Sukkerfabrikker  
Engineering Division, 5 Langebrogade, DK-1001 Copenhagen K, Denmark  
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## CONTENTS December 1979

**Panel of Referees****A. CARRUTHERS**
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353	Notes and comments
355	The Kenana Sugar Project
359	Physiological and biochemical changes in sugar cane as influenced by soil moisture during low temperature stress By Onkar Singh and R.S. Kanwar
362	Sugar beet phenols Part II. By B. Winstrøm-Olsen, R.F. Madsen and W. Kofod Nielsen
368	Sugar cane agronomy
371	Cane pests and diseases
372	Cane breeding and varieties
373	Cane sugar manufacture
375	Beet sugar manufacture
377	Sugar refining
378	Laboratory studies
381	By-products
382	Trade notices
383	South Korea sugar imports and exports
384	Sudan sugar imports
384	Iran sugar imports
367, 383, 384	Brevities
xxxiv	Index to Advertisers

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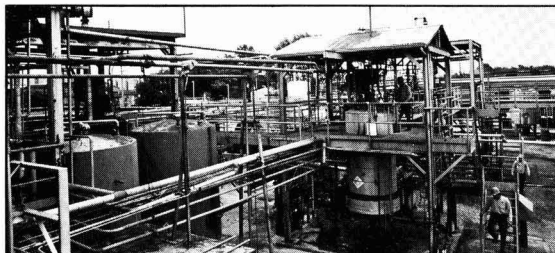
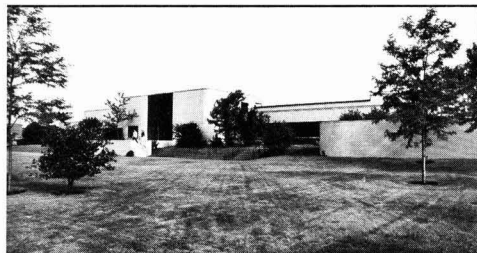
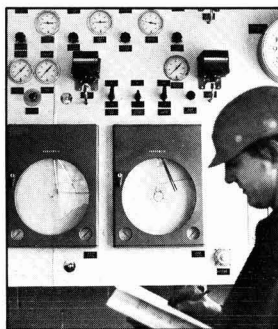
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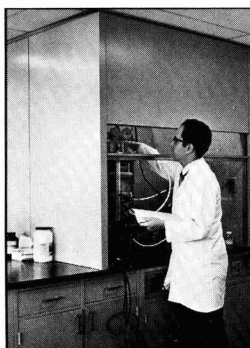
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# NOTES AND COMMENTS

## International Sugar Agreement

The Executive Committee of the ISO met in London in early October and, among other things, decided to resume use of the New York spot price as one of the bases for calculation of its Daily Price the level of which acts as a trigger for a number of actions under the Agreement. Since it is possible for the LDP and New York spot price to differ by more than 0.10 cents/lb, especially in a fluctuating market, it was decided that when this occurs the ISO Daily Price would be the lower of the two plus 0.05 cents, instead of the mean of the two. The Price Review Committee was to meet in November to consider price developments and, in particular, the effects of inflation and the fall in the value of the US dollar on the various prices mentioned in the Agreement.

The "prevailing price" — the 15-day average of the ISA Daily Price — exceeded 11 cents/lb on October 22 and the amount of sugar which members are authorized to import from non-members was consequently raised from 390,753 to 551,188 tonnes, but C. Czarnikow Ltd. consider that in fact little extra non-member sugar would be shipped in 1979. The next "trigger point" is a prevailing price of 12 cents/lb, when shortfalls could be reallocated, at the discretion of the Executive Committee. Such shortfalls currently total 126,671 tonnes, made up of 7,846 tonnes for Argentina, 15,000 tonnes for Austria, 50,000 tonnes for Guatemala, 5,227 tonnes for Peru and 48,598 tonnes for Trinidad.

The next stage would be if the prevailing price exceeded 13 cents/lb, when the global quota would be increased by 5%; however, this is not permitted if it occurs within 45 days of the end of the quota year, however, so that it seems at the time of writing to be unlikely for 1979. E.D. & F. Man consider that "forward prices have passed through and beyond the levels which the fundamental background would seem to warrant. World stocks are still high, after allowing for a 3.5 million tonne reduction in 1980. Thus, even assuming substantial ISA shortfalls and increased import demand for 1980, it is unlikely that the market will have need of ISA quota releases in excess of 100% of B.E.T.'s and shortfall reallocations."

## World sugar prices

The strengthening of sugar prices continued during October and from £120 per tonne on October 1, the LDP rose to £155 by October 26 before falling to £150 on October 30. Recovery was almost immediate and the rise in price resumed to £154 by November 1. The white sugar price rose in parallel for most of the month but the premium over raw sugar increased later in the month of October so that from £130 per tonne, the LDP(W) rose to no less than £172 by November 1. There has been steady demand and reports of poor crops in India and Cuba. The supposition that the rise might be more a reflection of the declining value of money has been shown to be incorrect as a parallel initial rise in

the prices of other commodities has been reversed while that for sugar has continued.

## EEC production quotas

The EEC sugar régime expires on June 30, 1980, and recommendations should have been made in the spring of 1979 for consideration by the Council of Ministers so that they can decide before January 1, 1980, on the arrangements to take effect six months later. In fact, representations have been made to the Commission by a number of interested parties and proposals to be put forward were to be discussed by the full Commission in early November.

The Farm Commissioner, Mr. Finn Olav Gundelach, is reported<sup>2</sup> to be strongly opposed to the quota system. This system of national quotas was initially introduced as a transitional measure but any move to remove them would almost certainly meet with resistance from some of the Ministers, especially those representing the higher cost producers whose industries have now been established to function up to and, in some cases, in excess of current levels of quota and would therefore be faced with the problems of over-capacity if they had to entertain open competition.

Critics of the quota system say that the fundamental reason for introducing production quotas was to protect those areas of high cost production within the Community which could be expected to reduce or cease sugar production if regional specialization was allowed to operate unhindered. It is also argued that quotas were set too high to prevent the build-up of substantial sugar surpluses within the Community. This, however, is rooted not in the system itself but in the manner in which it is practised. In any case it is apparent that only the quota system provides a basis for agreement in the Council of Ministers on the regulation of the market from 1980 on. This was apparently recognized also by Gundelach who now aims at reducing the level of quotas. Gundelach wants to cut the production quotas by up to 1 million tonnes which, however, is certain to meet stiff opposition from major sugar producing countries, such as France. Gundelach may also be considering limiting exports of C-quota sugar, which may not be sold for human consumption within the EEC and for which no export subsidies are paid, in order to be able to comply more closely with ISA requirements, thus opening the way for EEC affiliation. This proposal is also likely to be rejected by the Council of Ministers.

## US sugar legislation

The House of Representatives discussed the Sugar Bill and was defeated on October 23 by the appreciable margin of 249 to 158. The rejection of a bill which permitted ratification of the International Sugar Agreement by the US came as a disappointment but did not hinder the steady rise in sugar prices. The substantial opposition to the bill seems to have been a combination of the influence of consumers' lobbies who objected to what they consider to be the inflationary provision for raising the sugar price objective from 15 to 15.8 cents/lb, and of anti-Cuban sentiment whereby the fact that Cuba benefits from the Agreement was sufficient grounds to be against it, irrespective of the benefit provided by the ISA to 25 other exporting countries to which the US presumably remains friendly.

Under the circumstances, the Administration is prudently not acting hastily to try to obtain Congress-

<sup>1</sup> *The Sugar Situation*, 1979, (341).

<sup>2</sup> F. O. Licht, *International Sugar Rpt.*, 1979, 111, 604.

ional approval of ratification untied to US domestic measures, but USDA officials and Congressional leaders have met to discuss the prospects and timetable for possible approval of enabling legislation.

While under the present strengthening conditions of the sugar market, membership of the Agreement by the USA, the major importer from the free market, and the EEC, its major supplier, is not essential, failure to ratify by the US raises problems for the International Sugar Council which was to meet on November 19. The future of the Stock Financing Fund will have to be decided and, as C. Czarnikow Ltd.<sup>1</sup> comment: "Whether it will be possible to operate the whole procedure of Special Stocks and Fees in the absence of the USA must be doubtful but, on the other hand, countries which have already invested money in the establishment of new storage facilities will hardly be enthusiastic about these provisions of the Agreement being dismantled".

#### New London raw sugar contract

Rules and Administration Procedures for the proposed new raw sugar contract<sup>2</sup> were submitted to members of the UTSMa at the beginning of October and, in the absence of objections the contract, UTSMa Raw Sugar Contract No. 4, became effective with trading commencing on November 12. Transfers from the old No. 2 contract to No. 4 are permitted free of commission. The No. 2 contract will expire after October 1980.

#### EEC sugar exports, 1978<sup>3</sup>

At the beginning of 1978 most observers were of the opinion that world prices would not rise to the minimum price level written into the International Sugar Agreement and that therefore the EEC could have difficulties in disposing of its sugar surplus. This was not the case, however, and no difficulties are anticipated for 1979. On the contrary, export statistics for 1978 shows that the EEC was able to increase its deliveries substantially. Total sales increased from 1.9 million tons, raw value, in 1976 to 2.7 million tonnes in 1977 and 3.6 million tonnes in 1978. Despite the general upward tendency there were significant differences from one export market to the other.

Exports to Africa rose from 609,146 tonnes, (32.27% of the total) in 1976 to 1,410,885 tonnes (39.56%) in 1978. The second largest outlet were the countries of the Near and Middle East, who took 1,232,914 tonnes in 1978 (34.57%) from 482,206 tonnes (25.55%) in 1976. Exports to non-EEC member countries of Western Europe were slightly higher in 1978 than 1976 at 429,404 tonnes vs. 405,519 tonnes, while this represented a considerable fall as a proportion of the total (12.04% vs. 48%).

Sugar exports to Asia rose from 6,620 tonnes in 1976 (0.35%) to 204,689 tonnes in 1978 (5.74%), the bulk of 1978 exports being to China. Eastern Europe imports from the EEC declined from 317,145 tonnes in 1976 (16.8%) to only 53,329 tonnes (1.50%) in 1978, performance depending largely on the sugar crops of these countries. Exports to North America increased from 19,992 tonnes in 1976 (1.06%) to 78,910 tonnes in 1978 (2.21%) but may be expected to fall because of countervailing duties imposed by the US.

Central and South American countries took 130,671 tonnes in 1976 (3.66%) against only 35,785 tonnes in 1976 (1.90%), mainly because of production shortfalls

in Chile and Venezuela; recovery of these presently depressed industries could result in a decline in future exports. Exports to Oceania were negligible, amounting to only 5137 tonnes (0.27%) in 1976 and 13,589 tonnes in 1978 (0.38%).

The EEC enjoys a freight advantage over India and South American competitors as regards markets in the Middle East, Europe, and Africa, but the future of its exports will depend on which countries decide to join the ISA and the trend to achievement of self-sufficiency among importers, especially in Africa.

#### US loan sugar sales<sup>4</sup>

After two unsuccessful tenders, when all bids were rejected by the Commodity Credit Corporation<sup>5</sup>, a sale was achieved on October 25 of 3540 short tons of raw sugar at prices ranging from 14.31 to 14.85 cents per pound, f.o.b. As at October 30, outstanding loans under the CCC sugar loan programme totalled 1,170,828 short tons, raw value, of which 453,022 tons was beet sugar and 717,806 tons was cane sugar. Because a final decision on an overall loan extension programme is still pending, the US Department of Agriculture authorized a second one-month extension of loans on 1978 crop sugar that would normally have matured on October 1 so that the maturity date became November 30.

#### Indian sugar situation<sup>6</sup>

A feature of the past year or so has been the remarkable expansion in sugar consumption in India. This has led to some whittling away of the substantial tonnage of sugar held in store, which at one time promised to be such a burden on the Indian industry. There has now been a new development which may entirely change the statistical situation in India, so that where once heavy stocks were in prospect there is now the possibility of shortages.

Severe droughts have occurred in many areas and the 1979/80 crop is currently expected to amount to around 5.0 million tonnes, white value, which compares with 6.4 million tonnes in 1977/78 and a probable output in 1978/79 of the order of 5.9 million tonnes. The key to the Indian statistical position is, of course, the future direction of consumption. In the crop year October 1976/September 1977 it amounted to no more than 3,746,000 tonnes but, the following year, during the course of which it was freed from control, it rose to 4,476,000 tonnes. Current indications are that it will have been of the order of 6.1 million tonnes in 1978/79 and it was expected that further growth would occur in 1979/80.

The outlook has now been put in some doubt, however, by the announcement that ex-factory and retail prices for sugar are once again to be controlled. Producers are said to be disappointed at the level at which the prices have been set, which they claim are below the cost of production. While at first sight the establishment of maximum prices might be thought to be an encouragement to consumption, it might also discourage production. One way or another, it seems likely to lead to a further diminution of the Indian stock position. Indeed, it could even affect India's ability to fulfil its export entitlements to the EEC and under the ISA.

<sup>1</sup> *Sugar Review*, 1979, (1463), 211.

<sup>2</sup> *I.S.J.*, 1979, 81, 289.

<sup>3</sup> F. O. Licht, *International Sugar Rpt.*, 1979, 111, 443-449.

<sup>4</sup> Lamborn, 1979, 57, 173, 176.

<sup>5</sup> See also *I.S.J.*, 1979, 81, 322.

<sup>6</sup> C. Czarnikow Ltd., *Sugar Review*, 1979, (1457), 179.

# The Kenana Sugar Project

Sugar has become an increasingly important part of the diet of the Sudanese people and meeting the demand has added significantly to the country's import bill, of which it is by far the most costly food component. From 1974 to 1976 the country spent over U.S. \$250 million on imports of sugar. As a consequence the Sudan Government has given major emphasis to development of increased sugar production.

The 1972 IDCAS/UNIDO conference particularly confirmed the Sudan's suitability for sugar cane growing. All the necessary conditions are present for growers to anticipate excellent cane growth and yields. Compared with other producing countries the Sudan has many important natural advantages.

participation in its development. Detailed survey work, including aerial photography over an extended land area, topographical surveys and a detailed soil survey, was commenced in 1972 and a market report was also produced.

A detailed feasibility study was produced in April 1973 which projected a capital cost of \$145 million. Since its inception, however, the project has been affected by unprecedented inflation and economic instability in the industrialized countries that are providing the equipment and major contractors. A thorough revision of the forecast total cost of the project was undertaken recently and the capital cost is now forecast to be \$524 million, plus pre-production



Kenana factory under construction, April 1979

*Photo: Courtesy Richard Roxburgh*

The Government's Sugar and Beverage Corporation has three sugar factories operating at Guneid, Khasm-el-Girba and Sennar. The policy of expanding sugar production is demonstrated in the development of estates and new factories presently being undertaken and planned for Kenana, Haggat Assalaya, Melut, Mongalla and Setit. The successful realization of these projects will establish the Sudan as an exporter of sugar and should transform the country into a major producer of sugar with a surplus available for export, most probably to neighbouring Arab markets.

## *The Kenana project*

Under an agreement with the Sudan Government, signed on June 9, 1972, Lonrho Ltd. was to investigate and report on the viability of establishing a sugar estate with a view, in the event of favourable findings, to joint

expenses of some \$47 million. Maximum cash requirements will be approximately \$600 million. This total cost includes the high expenditure on infrastructure as well as the complete irrigation system. At present, apart from export credit facilities from France and Japan, the developments undertaken have been funded by equity and loans from shareholders.

Kenana Sugar Company Limited was incorporated on March 11, 1975, with the purpose of developing and operating an integrated cane estate and sugar factory with an annexed refinery. The estate, on a site 250 kilometres south of Khartoum, comprises 81,000 feddans (34,000 ha) of sugar cane, all irrigated by water pumped from the White Nile, and will produce 330,000 tonnes of refined sugar. It is anticipated that production of sugar will begin during 1979 and to this end substantial progress has been achieved.



### The site

The site selected has many favourable features required for sugar cane growing:

(1) *Soils*. — The uniform clay soils formed from Blue Nile deposits, rich in nutrients and ideal for surface irrigation, are available and are assessed to be ideal for growing cane.

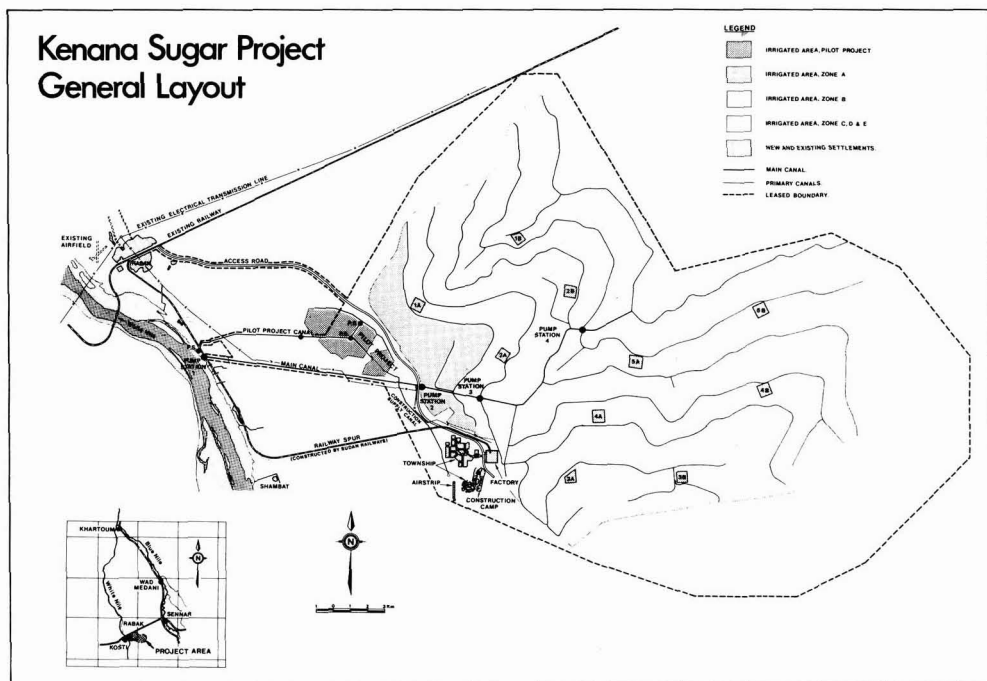
(2) *Climate*. — With a rainy season averaging three months, a high number of sunshine hours and high solar radiation, and with three months of low temperatures at night during the harvesting season, the local climate proves favourable for high rates of photosynthesis, high crop yields and excellent juice quality.

lines to Rabak. Telephone and postal services are available across the Nile at Kosti. The estate contains a gravel area of good load-bearing capacity, suitable for the siting of the factory, while deposits of sand and gravel for concrete works, foundations and road surfacing are available within the confines of the estate.

### Communications and access

The Company, as a matter of priority, established communications and easy access to the project site. These include:

- (i) a radio telex linking the site, Port Sudan and Khartoum,
- (ii) a 30 km rail spur from Rabak to the factory, completed in 1976 by Sudan Railways, which has been



(3) *Water*. — Good quality water is abundantly available throughout from the White Nile. The water will be lifted 40 metres by pumping and will be distributed across the estate by contour canals, and from these by gravity to the cane fields.

(4) *Land*. — Sufficient land is available for the estate in an area which is well-drained, non-saline and relatively easy to prepare for cultivation.

(5) *Power*. — Bagasse will provide fuel for steam-generated power to meet irrigation pumping requirements, factory and domestic demands during the crop season. The 33 kV power supply to the estate will provide power required prior to start-up of the factory. It will also provide an auxiliary source of power thereafter.

The estate is close to Rabak, with the factory itself about 30 km from the town. Khartoum, approximately 250 km to the north, and Port Sudan, approximately 1200 km to the north-east, are connected by railway

used extensively for transporting equipment and supplies directly to the factory site,

(iii) a 27 km all-weather gravel road from Rabak to the factory which was completed in mid-Summer 1976, enabling access to the site to continue during the rainy season, and

(iv) an all-weather 1500-metre gravel air-strip which was completed by mid-1976 and allows daily flights for personnel by DC 3 or other light aircraft direct to the project site.

### Irrigation

Howard Humphreys & Sons, civil engineering consultants of Reading, England, were engaged to advise on the infrastructure and civil works, including the irrigation canals, pumping works and structures, and housing and site development. In June 1974 they undertook the task of designing the canals and irrigation

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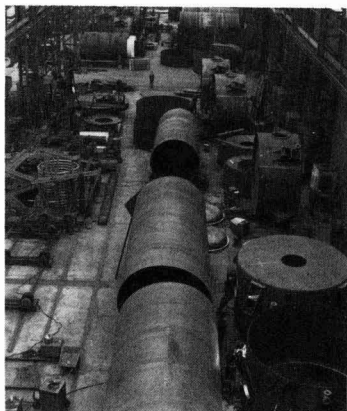
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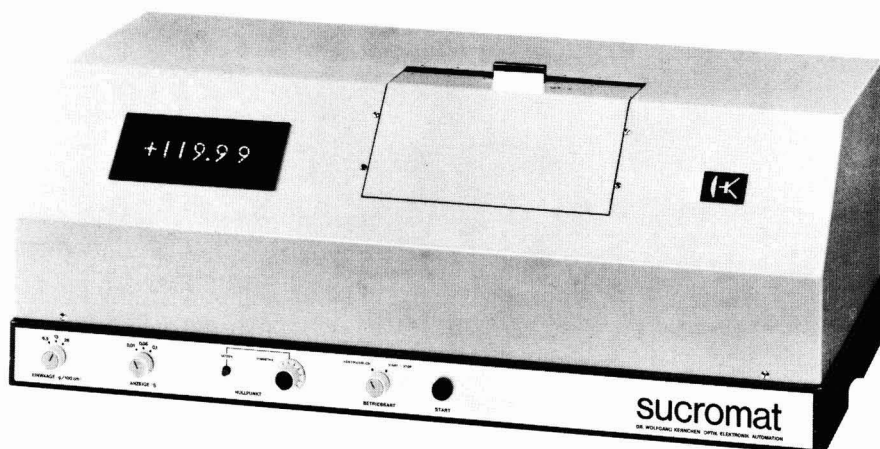
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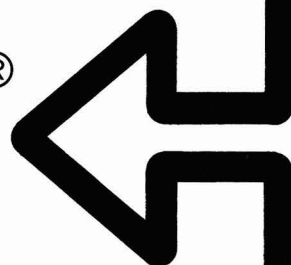
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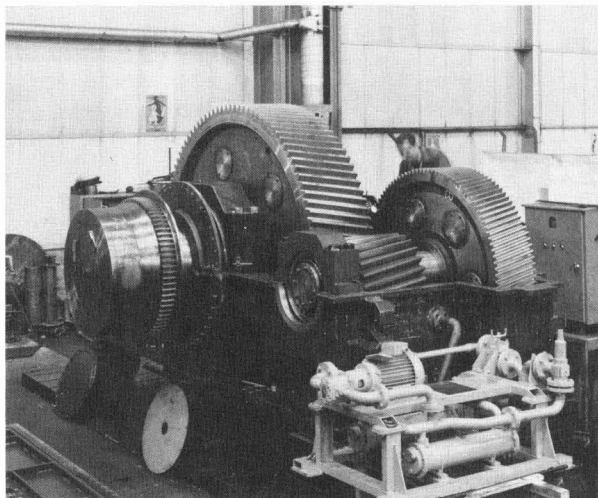


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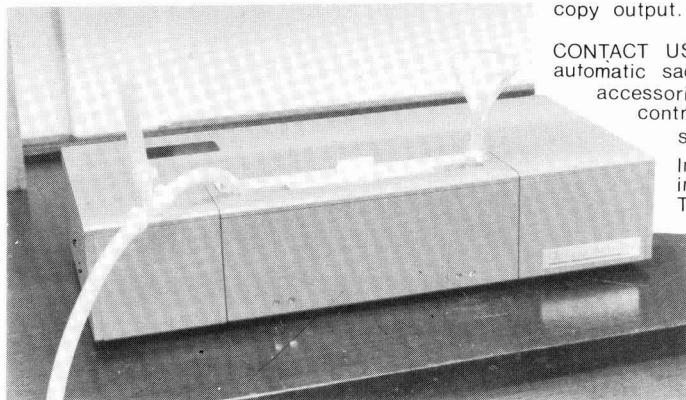
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works for the estate area. By the end of 1977, 19 km of the main canal and 100 km of primary distribution canal were completed while three of the four pumping stations were in operation. This had made 25,000 feddans (10,500 ha) available for planting, all of which is now under cane. Work is in progress on the final 10 km of main canal, the fourth pumping station and the remaining 170 km of primary canals. The bulk of this work will be completed by 1980.

The main canal transports the water to the fields through an irrigation network comprising:

(a) primary canals, which follow the topographical contours and utilize field outlet structures located in the primary canal banks; these in turn feed

(b) field channels, from which water is siphoned at approximately 1.5 metre intervals into

(c) long-line furrows, which form the actual field irrigation system.

The whole system is controlled by structures, regulators, gates and distributors of a type to ensure distribution of the right amount of water under the required head.

### Pumping

By contract dated July 10, 1975, Maschinenfabrik Andritz AG, of Graz, Austria, agreed to provide the design, construction and installation of the pumps at the four pumping stations. The tender value of the contract is approximately 216 million Austrian Schillings, or \$14.0 million.

The first and second pumping stations each have eight pumps with an aggregate capacity of  $42 \text{ m}^3 \cdot \text{sec}^{-1}$  per station, against a maximum calculated requirement of  $36 \text{ m}^3 \cdot \text{sec}^{-1}$  (or about 700 million gallons of water per day). The pumping station design allows for an additional pump to be added which would bring the total capacity to over  $47 \text{ m}^3 \cdot \text{sec}^{-1}$  each.

### Power

Initially, electricity for the pumps is taken from the National Grid; bagasse from the factory will eventually become the main source of fuel for generating power. The Public Electricity and Water Corporation of Sudan has been awarded the contract for the provision of the necessary 33 kV and 11 kV power lines. The National Grid will be used as a back-up source of power.

### Agricultural development

The land was largely free of trees and bushes so that clearing costs have been minimal. Moreover, its uniform topography has ensured that little levelling has been required and land preparation consists mainly of ploughing, harrowing and furrowing to obtain sufficient tilth for planting.

Land prepared for seed cane has been planted and fertilized, and subsequent irrigation carefully controlled, with more water being applied during the extremely dry and hot summer months. The planting rate will reach a maximum of 3000 to 3500 feddans (1260 – 1470 ha) per month during the most active planting months. It is anticipated that yields of over 56 tonnes of cane per feddan ( $133 \text{ tonnes} \cdot \text{ha}^{-1}$ ) will be produced in the plant crop. Cane will be harvested during the dry months of November to May.

The equipment to be used throughout the agricultural operations will be modern and specialized. The main repair facility will be established centrally, and preventive

maintenance, spares stores and refuelling facilities will be provided in each agricultural area.

Cane has been grown at the project site since 1973. The first cane grown for ultimate estate use was planted on the 2000-feddan (840 ha) Pilot Project Extension in early 1975, following completion of the 9 km pilot canal. It is from this area that the main estate first derived its seed cane.

Advantage was taken of the close co-operation with the existing sugar estates in the Sudan in the Company's early experiments to determine those cane varieties best suited for planting. Three were chosen (N:Co 310, Co 527 and N:Co 376) for use as crop cane. The Company will not limit itself to these three varieties but is intensifying its research into new varieties. At the same time it is increasing its research into many aspects of ensuring healthy cane growth, including fertilizer control, weed control, differing irrigation frequencies and control measures against insects, pests and disease.

There is sufficient area presently under cane and at different stages of growth for experts to agree that the cane growth is outstanding by world standards, with 64 tonnes of cane per feddan in 14-months old cane.

### Factory and refinery

The President of the Democratic Republic of the Sudan, General Gaafar Mohamed Nueri, laid the foundation stone for the factory at a ceremony held on November 25, 1976. The factory, due to be commissioned in December 1979, is designed to produce in excess of 330,000 tonnes of white sugar per annum. It will have an initial daily crushing capacity of 8500 tonnes of cane, rising to 17,000 tonnes in 1980. In spite of the unusually large size of the factory, in order to keep equipment within reasonable unit sizes and to minimize the possibility of down-time, each production line incorporates several units.



"Out-of-gauge" equipment being brought 1200 km across the desert from Port Sudan to site on heavy-duty articulated trailers. 1500 tonnes of such equipment was brought to site in this way.

Photo: Courtesy Richard Roxburgh

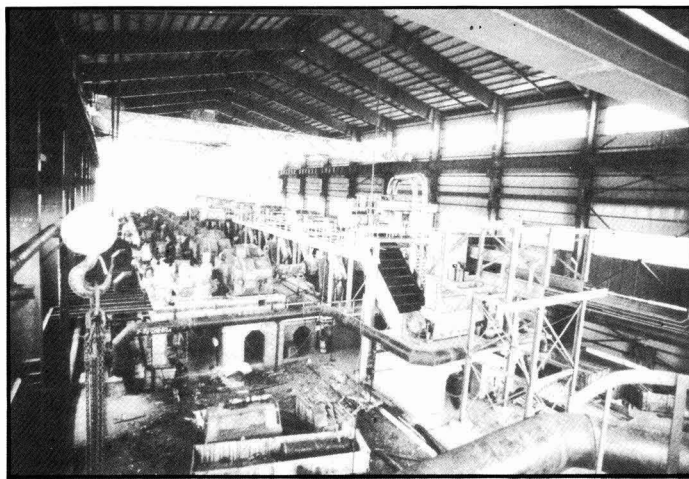
Chopped cane is brought to the factory in 12-tonne containers, hauled in pairs by road tractors. These containers are tipped onto feed tables, each of which passes the cane by way of two cane knife sets and a shredder to one of the two turbine-driven Fives-Cail Babcock milling tandems of seven mills each. The raw juice is limed and settled in a total of seven continuous clarifiers, with five vacuum filters for the mud. The evaporator station includes two quadruple-effects of



120,000 ft<sup>2</sup> h.s. each and employing vapour bleeding.

Within the raw sugar house there are nine 85 m<sup>3</sup> vacuum pans while the massecuites are cured in 15 54 in x 42 in batch-type A- and B-centrifugals and 12 continuous C-machines.

The refinery, built as an integral part of the plant, uses a remelt carbonatation process utilizing flue gases from the boilers. It incorporates four vacuum pans and a further 11 centrifugals. The crystal size produced may be varied to suit the market it is destined for. From the refinery, sugar passes by overhead conveyor into the bagging and weighing station where it is loaded into 50-kg sacks. Warehouse capacity exists for 60,000 tonnes (just over one month's production).



Interior of the mill house  
Photo: Courtesy Richard Roxburgh

One of the fundamental concepts was that the factory would incorporate a power house capable of generating sufficient electric power for both the factory operation and the irrigation pumps and township. Steam to drive the turbo-generators is produced by burning bagasse and one of the main reasons why the factory is built as a single large complex, rather than as two smaller separate factories, is to obtain maximum economy of steam utilization and maximum power generation from the quantity of bagasse available. All the bagasse is taken by overhead conveyor to a storage area from which it is reclaimed and taken to the boilers by rubber belt conveyors.

The steam plant itself consists of six high-pressure boilers, each generating 112 tonnes of steam per hour at a pressure of 31 kg.cm<sup>-2</sup> (450 psig). About 35% of the steam produced is piped direct to the mill turbines to drive the tandems while the major proportion is piped to the power house where it drives four turbo-generators of 10 MW capacity each. Two of these generators are back-pressure sets and two full condensing units, so that, when the factory is closed down between June and October, steam can continue to be produced and electricity generated for irrigation and the township, using furnace fuel or stored bagasse. In the event of any shortfall, additional power is available from Sudan's Blue Nile grid, but the estate should normally be self-sufficient 358

throughout the year.

The design and construction of the factory reflect the international nature of the project, with Arkel International Inc. of the United States acting as consulting engineers in connexion with the plant, responsible for commissioning, but French and Japanese companies supplying equipment. Compagnie Française d'Etudes et de Construction Technip was awarded the contract for detailed engineering, supply of the majority of the sugar processing plant and on-site supervisory services, while Nissho-Iwai Co. Ltd. was responsible for provision of equipment mainly related to the power house and power generation. Capper Neill International Ltd. of the UK was awarded the contract for erection of the factory.

Experience gained in transporting equipment to site will make a major contribution to the successful export

of 150,000 tonnes of sugar per year through Port Sudan, together with surplus molasses which could total a further 100,000 tonnes each season. Sugar for local consumption will be transported by rail wagons and road lorries, together with river barges which will be especially useful for moving sugar to Southern Sudan along the White Nile.

#### *Outlook*

Kenana forms part of the Government's overall national development plan to turn the Sudan into a major sugar exporting country and this is reflected in the co-operation which has been extended by all sectors of central and local Government. Apart from generating foreign exchange, the project will have a significant impact on the lives of the people in the Rabak/Kosti area, with the creation of 10,000 permanent jobs, which in turn will provide secondary employment for a similar number of people in the surrounding area.

#### *Summary*

An account is given of the history and development of the Kenana sugar estate and factory/refinery which indicates the importance of the project to the Sudan.

#### **Le projet sucrier de Kenana**

On donne un exposé sur l'histoire et développement du domaine sucrier et de la sucrerie/raffinerie de Kenana, qui indique l'importance du projet pour le Soudan.

#### **Das Zuckerprojekt Kenana**

Man berichtet über die Geschichte und Entwicklung der Zuckerplantage und der Zuckerfabrik/Raffinerie von Kenana, was auf die Bedeutung des Projekts für die Sudan hinweist.

#### **El proyecto azucarero de Kenana**

Se presenta un examen de la historia y desarrollo de la finca azucarera y fábrica/refinería de Kenana que indica la importancia del proyecto para el Sudán.

# Physiological and biochemical changes in sugar cane as influenced by soil moisture during low temperature stress

By ONKAR SINGH AND R.S. KANWAR

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## Introduction

The sugar cane crop during its maturity phase from November to February, quite often experiences low temperature stress in most parts of Northern India, causing deterioration in juice quality<sup>1,2</sup> and, during certain years, shortage of seed cane for the next planting<sup>3,4</sup>. Similar results have also been reported from other countries by various workers<sup>5,6,7,8</sup>. Qualitative studies<sup>9</sup> have suggested that keeping the soil wet (near field capacity) during frost protects the sugar cane crop from injurious effects of low temperature at early growth stage. Frequent irrigations when frost occurs during the maturation of sugar cane have also been advocated<sup>10,11,12</sup>. The physiological basis for such an effect of irrigation is not well established, and the present studies have been made to elucidate this.

## Materials and methods

An experiment was conducted for two years during 1976–78 at the PAU Sugarcane Research Station, Jullundur. Sugarcane variety CoJ 46, a moderately frost-resistant variety, was planted in a randomized block design with four replications, in the second week of March. The soil was a sandy loam with wilting point of 4.5% and field capacity of 13.5%. Normal crop husbandry practices were used. After common irrigations were given on December 1, 1976 and December 7, 1977, sections of the crop were irrigated at intervals of 10, 20, 30 and 40 days until the 3rd week of February. The crop experienced the following rainfall (Table I) and frosty spells (Table II) during the course of the studies.

Table I. Rainfall, mm

Year	December	Date	January	Date	February	Date	Total
1976–77	2.6	3	47.4	11,24, 25,26	—	—	50.0
1977–78	18.7	26,27 29	8.0	28,29	29.3	9,13, 16,17, 18	56.0

Table II. Occurrences of frost in 1976/77 and 1977/78

	Light	Moderately intense	Severe
1976-77	19	5	26
1977-78	13	3	8

The maximum and minimum temperatures were recorded daily at 7.30 a.m. inside the crop at heights of 30 cm (bottom portion), 120 cm (middle portion) and 240 cm (top portion), and soil temperatures at depths of 7.5, 15 and 30 cm. Similar observations were also

recorded under open-field conditions. Only monthly averages of the data from different crop heights and soil depths have been presented in Table III. However, the detailed observations showed that the maximum temperature under open-field conditions always remained higher than inside the cane crop.

Frequent irrigations at 10-day intervals were found to lower the maximum temperature by comparison with 20, 30 and 40-day intervals. The minimum temperature was always higher inside the crop than the open-field conditions. However, inside the crop it remained higher with 10 and 20-day irrigation intervals by comparison with 30 and 40-day intervals. The top portions of the crop experienced lower minimum temperatures than the middle and bottom portions throughout the period of observation while the reverse was true under open-field conditions. On the whole, irrigation, depending on the intervals, increased the soil temperature inside the crop, the relative increase being highest with 10-day intervals followed by that with 20-day intervals. The lowest minimum temperature was recorded at a soil depth of 7.5 cm, followed by 15 cm and 30 cm, irrespective of the site of observations and irrigation treatments.

Cane samples were taken from the plots at fortnightly intervals. The juice was extracted with a laboratory cane crusher and samples analysed for electrical conductance ( $\text{mmho.cm}^{-1}$ ) by means of a conductivity bridge, pH and titratable acidity ( $\text{cm}^3$  of 0.1N NaOH required to bring 50  $\text{cm}^3$  juice to pH 8.3), gum content (ppm) by the method of Friloux *et al.*<sup>5</sup>, reducing sugars by Fehling's method, pol and apparent purity. The leaf and sheath moisture and relative turgidity were determined by the method of Weatherly<sup>13</sup>. The

measurements are recorded in Tables IV and V.

## Results and discussion

Soil moisture at 10-day irrigation intervals was significantly higher than with the other treatments. However, only frequent irrigations, i.e. at 10 and 20-day intervals,

- 1 Kanwar *et al.*: *I.S.J.*, 1977, 79, 340-346.
- 2 Singh & Singh: *ibid.*, 1975, 77, 131-132.
- 3 Gill: *Ann. Rpt. Sugar Res. Sta. Jullundur* (India), 1964.
- 4 Gill & Singh: *Indian Sugar*, 1972, 22, 627-632.
- 5 Friloux *et al.*: *Sugar y Azúcar*, 1965, 60, (1), 43-46.
- 6 Irvine: *Proc. 14th Congr. ISSCT*, 1971, 1-8.
- 7 Irvine & Friloux: *Sugar y Azúcar*, 1965, 60, (11), 58-59.
- 8 Sund: *Proc. 12th Congr. ISSCT*, 1965, 561-568.
- 9 Singh & Singh: *Indian Sugar*, 1974, 24, 751-754.
- 10 Kanwar: *Sugar News* (India), 1978, 10, 11-15.
- 11 Kanwar & Sharma: *Prog.Fmg.* (PAU), 1971, 7, 14.
- 12 Singh: *Indian Fmr.Digest* (PAU), 1972, 5, 15-16.
- 13 *New Phytol.*, 1950, 49, 81-83.

Table III. Mean maximum and minimum temperatures of air and soil, °C

Date	Irrigation intervals, days												Open-field conditions		
	10			20			30			40					
	Max.	Min.	Soil	Max.	Min.	Soil	Max.	Min.	Soil	Max.	Min.	Soil	Max.	Min.	Soil
Dec.1976	20.6	4.1	9.1	20.7	4.0	9.1	20.8	3.9	9.8	20.6	4.0	8.4	—	—	—
Jan.1977	19.1	3.8	8.0	19.0	4.0	7.4	18.9	3.6	7.2	19.0	3.9	7.5	—	—	—
Feb.1977	21.7	4.4	7.0	21.8	4.2	6.8	21.2	4.3	6.7	21.4	4.2	6.7	—	—	—
Dec.1977	19.7	7.0	11.4	20.6	6.6	11.5	—	—	—	21.9	4.8	11.6	22.4	4.9	11.6
Jan.1978	16.3	5.2	9.6	16.9	4.0	9.0	—	—	—	18.3	3.0	8.7	18.4	3.1	11.1
Feb.1978	16.6	8.4	9.5	18.3	5.7	9.5	—	—	—	18.5	5.9	9.4	19.4	5.0	10.3

Table IV. Moisture content % leaves (L) and leaf sheaths (LS)

Date	Irrigation interval, days							
	10		20		30		40	
	L	LS	L	LS	L	LS	L	LS
Dec.1976	74.1	74.94	71.3	75.4	68.35	72.79	68.1	72.4
Jan.1977	62.05	71.98	59.8	67.8	58.1	66.31	56.6	64.8
Feb.1977	62.51	67.22	61.2	66.0	60.07	64.51	59.3	62.9
Dec. 1977	65.93	72.16	65.0	70.9	64.6	70.2	64.7	70.1
Jan.1978	64.12	70.41	62.9	69.6	60.8	66.4	60.6	65.2
Feb.1978	65.45	67.3	64.9	68.1	63.2	63.9	62.2	61.7

Table V. Electrical conductivity of cane juice, mmho.cm<sup>-1</sup>

Date	Irrigation interval, days			
	10	20	30	40
Dec.1976	5.0	5.23	5.23	5.29
Jan.1977	4.39	4.42	4.63	4.78
Feb.1977	4.33	4.44	4.63	4.77
Dec.1977	5.19	5.34	5.19	5.49
Jan.1978	4.82	4.73	5.24	5.49
Feb.1978	5.03	5.22	5.73	5.81

resulted in significantly higher moisture content and relative turgidity in the leaf and sheath tissues as compared with the restricted irrigations, i.e. 30 and 40-day intervals throughout the period.

Electrical conductivity of the juice decreased significantly during severe low temperature stress and increased during the post-frost period. However, such changes in electrical conductivity were minimal at irrigation intervals of 10 days followed by those at 20 days and were maximal at a 40-day interval followed by a 30-day interval. It appears from this that the low temperature stress, specifically under restricted soil moisture conditions, rapidly increases the soluble salts in the cane juice, and juice quality deteriorates accordingly. The gum content in the juice during frost increased gradually between 10- and 20-day irrigation intervals but abruptly for 30- and 40-day intervals. It decreased significantly during the post-frost period. This suggests that the rhythm in the levels of gum content under low temperature stress is better controlled by the

higher soil moisture, than under restricted soil moisture.

A significant decrease in pH with a corresponding increase in titratable acidity of cane juice began with the onset of low temperature stress and continued to the end of February. Such changes were higher with 40-day irrigation intervals and lower with 10-day intervals followed by 20-day intervals. These results indicate that the frequent irrigations during low temperature stress also control the increase in titratable acidity in the juice.

Data on the changes in gum content, pH, titratable acidity, reducing sugars, sucrose and purity coefficient of cane juice were recorded and are summarized in Table VI. In general, the level of reducing sugars increased significantly with corresponding decrease in sucrose and purity during severe low temperature stress. The trend reversed during the post-freeze period. However, when these changes were compared between the irrigation treatments, it was noticed that the frequency of the rhythm was substantially reduced by irrigation at shorter





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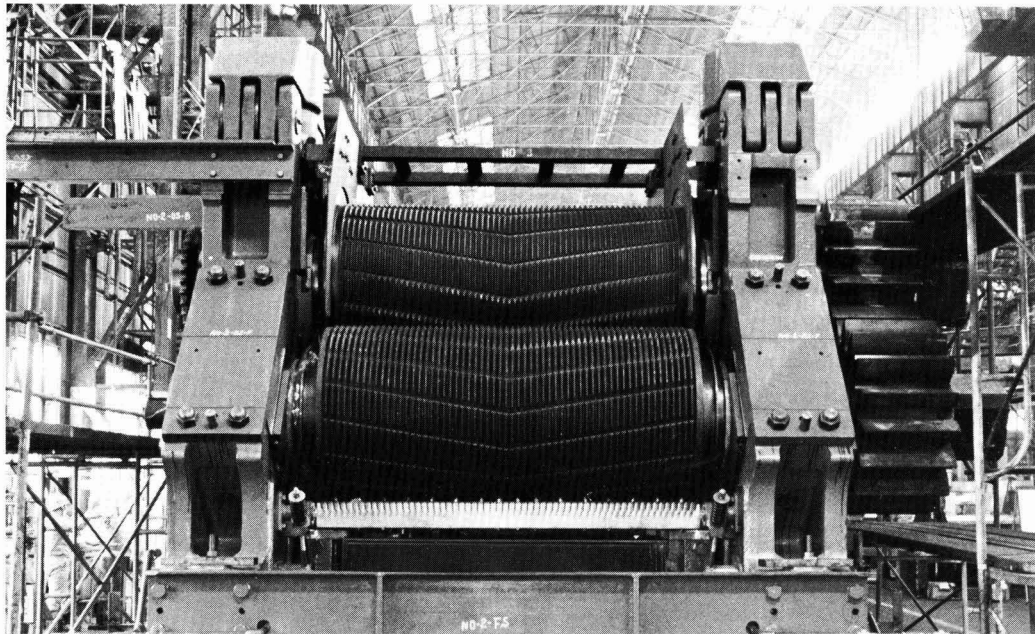


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intervals, i.e. 10 and 20-days, as compared with restricted irrigations, i.e. at 30- and 40-day intervals. Interestingly, the yield of cane (Table VII) was significantly higher with more frequent irrigation (10- and 20-day intervals) as compared with restricted irrigation (30 and 40 days) during 1976-77. However, during 1977-78, only irrigation at 10-day intervals significantly outyielded the remaining treatments.

#### Physiological and biochemical changes in sugar cane

stress. Reducing sugars increased, with a corresponding decrease in sucrose and purity of juice, during frost, but the condition was reversed afterwards. These physiological changes due to low temperature were minimized by application of irrigation at intervals of 10 days. Interestingly, the highest yield of millable canes was

**Table VI. Mean composition of juice during the winters of (A) Dec. 1, 1976 – Feb. 23, 1977 and (B) Dec. 7, 1977 – Feb. 20, 1978**

		Irrigation interval, days			
		10	20	30	40
Gum content, ppm	A	17.34	18.96	22.29	25.64
	B	15.84	16.87	18.43	18.87
pH	A	5.22	5.12	5.05	5.01
	B	5.38	5.36	5.28	5.24
Titratable acidity, cm <sup>3</sup> of 0.1N NaOH	A	10.27	10.91	11.64	12.11
	B	10.39	10.88	11.82	12.13
Reducing sugars % juice	A	1.22	1.23	1.30	1.33
	B	0.83	0.87	1.01	1.09
Pol	A	14.72	14.39	14.43	14.29
	B	16.45	16.23	15.92	15.37
Apparent purity	A	80.27	78.63	78.30	77.66
	B	82.85	82.62	81.47	80.63

**Table VII. Millable cane yield, tonnes.ha<sup>-1</sup>**

	Irrigation interval, days			
	10	20	30	40
1976/77	61.6	58.9	53.5	49.8
1977/78	58.4	55.3	54.7	54.6
Mean	60.0	57.1	54.1	52.2

From the foregoing it may be safely concluded that irrigation at intervals of 10 days in periods of low temperature stress during the ripening-maturity phase of CoJ 46 is the best means of minimizing the detrimental effects of frost on juice quality. The higher turgidity in the leaf as well as in the sheath tissues was probably more conducive to optimal physiological functions of the sugar cane plant.

#### Summary

The maximum temperature was always higher under open-field conditions than in the interior of the crop and the reverse was true in the case of minimum temperature. The top portion of the crop experienced the lowest minimum temperature followed by the middle and bottom portions, while the reverse was true under open-field conditions. The soil temperature was lowest at a depth of 7.5 cm and increased with the depth of soil both inside and outside the crop. Irrigation intervals of 10 and 20 days induced significantly higher moisture content in soil than intervals of 30 and 40 days as well as higher moisture content and relative turgidity in leaf and sheath tissues, throughout the low temperature stress.

The gum content and electrical conductance of juice increased significantly during frost and thaw, while the juice pH decreased, with a corresponding increase in titratable acidity, with the onset of low temperature

obtained with 10-day irrigation intervals during the winter.

#### Modifications physiologiques et biochimiques de la canne à sucre sous l'influence de l'humidité du sol au cours de la sollicitation par le froid

La température maximum était toujours supérieure dans les conditions de plein champ qu'à l'intérieur de la récolte et l'inverse était vrai pour le cas de la température minimum. La partie supérieure de la récolte a subi la température minimum la plus basse, suivie par les parties du milieu et du pied, tandis que l'inverse était vrai sous les conditions de plein champ. La température du sol était la plus basse à une profondeur de 7,5 cm et augmentait avec la profondeur à la fois à l'intérieur et à l'extérieur de la récolte. Des intervalles d'irrigation de 10 et 20 jours ont induit une teneur en humidité du sol nettement plus élevée que des intervalles de 30 et 40 jours, ainsi qu'une teneur plus élevée en humidité et une turgescence relative plus élevée dans les tissus de feuilles et gaines, tout au long de la sollicitation par le froid.

La teneur en gommes et la conductivité électrique du jus augmentèrent de façon significative pendant la période des gelées et rosées, tandis que le pH du jus baissait, avec un accroissement correspondant en acidité titrable dès la sollicitation par basse température. Durant les gelées on constata un accroissement en sucres réducteurs, avec une baisse correspondante en saccharose et en pureté du jus, mais les conditions s'inversèrent par après. Ces modifications physiologiques dues aux basses températures étaient minimisées par l'application de l'irrigation à des intervalles de 10 jours. Il est intéressant de noter que la production la plus élevée en canne broyable a été obtenue par irrigation à 10 jours d'intervalle au cours de l'hiver.



**Physiologische und biochemische Veränderungen im Zuckerrohr unter dem Einfluß von Bodenfeuchtigkeit bei extrem niedriger Temperatur**

Das Temperaturmaximum war unter den Bedingungen des freien Feldes immer höher als im Inneren der Kultur, und entgegengesetzt war es der Fall beim Temperaturminimum. Die höheren Lagen der Kultur hatten die niedrigsten Temperaturminima gefolgt von den in den mittleren und unteren Lagen, während es unter offenen Feldbedingungen entgegengesetzt war. Die Bodentemperatur war am niedrigsten in 7,5 cm Tiefe und nahm mit der Bodentiefe zu, sowohl innerhalb als auch außerhalb der Kultur. Bewässerungspausen von 10 und 20 Tagen induzierten einen bedeutend höheren Feuchtigkeitsgehalt im Boden als Intervalle von 30 bis 40 Tagen sowie höheren Feuchtigkeitsgehalt und relative Turgeszenz in Blatt und Blattscheidengewebe während extrem niedriger Temperaturen.

Der Gehalt an Gums und die elektrische Leitfähigkeit des Saftes nahmen bei Frost und Tau signifikant zu, während der pH-Wert des Saftes abnahm mit einer entsprechenden Zunahme an titrierbarer Säure bei einem Schock durch extrem niedrige Temperaturen. Reduzierende Zucker nahmen bei Frost zu mit einem entsprechenden Rückgang an Saccharose und Saftreinheit, jedoch wandelten sich diese Bedingungen später ins Gegenteil um. Diese physiologischen Veränderungen infolge niedriger Temperaturen wurden gemindert durch Bewässerung in zehntägigen Intervallen. Interessanter Weise wurde der höchste Ertrag an zu verarbeitendem Rohr bei einem 10tägigen Bewässerungs-

intervall im Winter erzielt.

**Cambios fisiológicos y bioquímicos en caña de azúcar como influenciado por agua en el suelo durante esfuerzo a causa de temperatura baja**

La temperatura máxima estuvo siempre más alta en condiciones de campo abierto que en el interior de la cosecha y el contrario estuvo verdad en el caso de la temperatura mínima. La porción más alta de la cosecha sufrió la temperatura mínima la más baja con, en secuencia, temperaturas mínimas menos baja para las porciones medias y en el fondo; estuvo verdad el contrario en condiciones de campo abierto. La temperatura del suelo estuvo la más baja en una profundidad de 7.5 cm y creció con profundidad de suelo dentro y por fuera de la cosecha. Regadío en intervalos de 10 y 20 días indució contenidos significativamente más altos de agua en el suelo que intervalos de 30 y 40 días, tanto como más alto contenido de agua y turgencia relativa en tejidos de la hoja y la vaina durante el esfuerzo a causa de temperatura baja. El contenido de goma y conductancia eléctrica de jugo creció significativamente durante helada y deshielo, mientras que el pH del jugo se disminuyó, con un aumento correspondiente en acidez por titración, del comienzo del esfuerzo a causa de temperatura baja. Había durante helada aumento de azúcares reductores, con una disminución en sacarosa y pureza del jugo, pero esta condición se invirtió después. Estos cambios fisiológicos como función de temperatura baja se redujeron al mínimo por aplicación de regadío en intervalos de 10 días. Es interesante que el rendimiento más alto de caña para molienda se obtuvo con intervalos de regadío de 10 días durante el invierno.

## Sugar beet phenols

### Investigation of phenolic compounds from sugar beet in relation to the formation of colour

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#### PART II

#### IDENTIFICATION OF THE COMPOUNDS IN THE CHROMATOGRAMS

In the previous sections we have used the chromatograms from the HPLC analyses to characterize juice from various sources. We shall now discuss the nature of the compounds using identified peaks to quantify the amount of compounds concerned. We had three methods at our disposal:

- investigations of elution volume,
- recovery of substance when purifying a standard compound, and
- investigations of the absorption spectra of standard compounds and peaks in the chromatograms.

#### Elution volumes

A large number of standard compounds (from Sigma Chemical Company) have been studied. A number are listed in Table I according to their elution volume ( $V_e$ ). The elution volumes found for the compounds in the last part of the table may show some variation and depend, to a certain extent, on the time the data were obtained. The relative volume of eluate for two

compounds was constant. It may be seen that compounds with low polarity leave the column late. Substituting  $-CH_3$  for a  $-H$  leads to a substantial increase of elution volume. Compounds containing nitrogen have a low elution volume.

#### Recovery of substances

To evaluate the features of the substances which are purified during the procedure with alumina, a solution of each of the standard substances was purified like raw juice. The juice after purification was run on HPLC, and the area of the peak (if any) was compared with the area of a chromatogram of a solution of the standard compound. The ratio between the two areas is called the recovery (R). Theoretically, the highest value of R is 1.00. Losses during the purification procedure mean that the value found in practice is considerably below 1.00. A list of values for R is given in Table I. It will be seen that a condition of purifying a substance is that the compound contains OH-groups in the 1,2-positions. This fact places important restrictions on the kind of substance found in the HPLC chromatograms of raw juice. With a recovery of 0.45, the concentration of the

Table 1: Phenolic compounds

The compounds are eluted from a "µBondapak" C<sub>18</sub>-column with 0.2 (v/v)% acetic acid at a flow rate of 1.0 cm<sup>3</sup>.min<sup>-1</sup> after adsorption of a 25 µl sample containing 0.005% of the compound in 0.2% acetic acid.

Compound	Formula	MW*	λ(E <sub>max</sub> )†, nm	V <sub>e</sub> ‡, cm <sup>3</sup>	R §
L-Norepinephrine = L-Noradrenaline = L-Arterenol		169.2	280	3.1	0.48
L-Epinephrine = Adrenaline		183.2	280	3.7	0.45
DL-Normethanephrine		183.2	280	4.4	0.00
Dopamine = 3-Hydroxy-tyramine		153.1	280	5.0	0.45
DL-3,4-Dihydroxymandelic acid		184.1	280	5.4	0.05
L-Dopa = L-β-(3,4-Dihydroxyphenyl)-alanine		197.2	280	6.0	0.43
DL-Methanephrine = DL-m-O-Methyl- epinephrine		197.2	280	6.6	0.00
L-Tyrosine		181.2	280	7.8	0.00
Pyrogallol		126.1	265	8.6	0.30
DL-α-Methyl-Dopa = DL-2-Methyl- 3(3,4-dihydroxyphenyl)-alanine		211.2	280	9.5	0.48
Hydroquinone		110.1	290	10	0.005
DL-4-Hydroxy-3-methoxy-mandelic acid = Vanillylmandelic acid = Vanilmandelic acid		198.2	280	11	0.00
DL-Isoproterenol = 1-(3',4'-Dihydroxy- phenyl)-2-isopropylaminoethanol = Isopropylarterenol		211.2	280	12	0.49
3-Methoxytyramine = 3-Methoxy- 4-hydroxy-phenethylamine		167.1	280	14	0.00
L-3-Methoxy-tyrosine = L-3-O-Methyl-dopa		211.2	280	15	0.00
Resorcinol		110.1	280	18	0.00
Catechol		110.1	280	19	0.49
Protocatechuic acid = 3,4-Dihydroxybenzoic acid		154.1	290	28	0.24
3,4-Dihydroxyphenylacetic acid = Homoprotocatechuic acid		168.0	280	35	0.32
p-Hydroxy-benzoic acid		138.1	250	57	—
4-Hydroxy-3-methoxy-phenylacetic acid = Homovanillic acid		182.0	280	126	0.00
Caffeic acid		180.2	300	154	0.29
Ferulic acid		194.2	300	>154	—

\* Molecular weight.

† Wavelength at maximum absorbance.

‡ Elution volume.

§ Recovery of the compounds by purification on alumina.

compounds in the sample for HPLC is about ten times the concentration in the juice.

#### Absorption spectra

All the standards examined contain an aromatic unit and have a maximum absorbance within the range 260-300 nm. The maximum values for  $\lambda(E_{\max})$  found are given in Table II. They were determined with a Pye Unicam SP8-100 spectrophotometer and the UV detector of the HPLC equipment, and are in agreement with values found in the literature<sup>19</sup>. Most of the compounds have a maximum at 280 nm. Compounds like caffeic acid with 4 conjugated double bonds have a maximum at 300 nm.

Table II. Maxima of peaks from HPLC chromatograms

Compound No.	Approx. retention vol., cm <sup>3</sup>	Figure	$\lambda(E_{\max})$ , nm
I	2.8		280
II	2.9 - 3.1	8	280
III	3.7 - 3.8		290
IV	4.6 - 5.0		peaks at 280 and 290
V	5.2 - 5.4		280
VI	5.7 - 6.1	9	280
VII	~6.5		290 or above
VIII	7.3 - 7.4		290
IX	17 - 21	10	260 and 290-300

The compounds purified from the factory juice were analysed at several wavelengths. On the basis of a large number of chromatograms, the absorption spectra of the peaks in the chromatograms from juice were recorded. Three of these are given as Figures 8, 9, and 10.

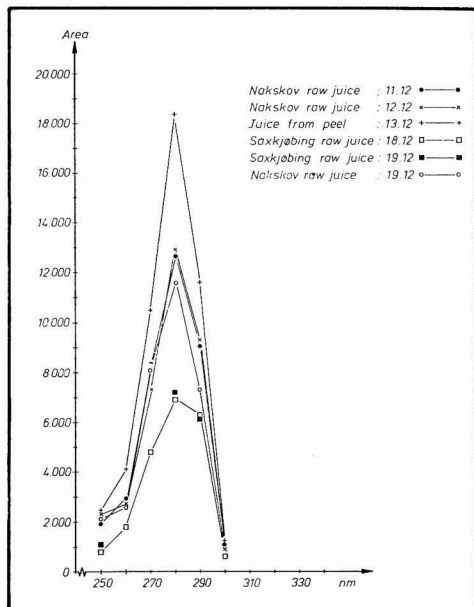


Fig. 8. Absorption spectra of peaks from purified juice found at an elution volume of 2.9 - 3.1 cm<sup>3</sup> in HPLC chromatograms

A summary of the results obtained is given in Table II for the high peaks. Most of the compounds represented by a peak in the chromatograms have a maximum in the range 260-300 nm. However, compound IX (Fig. 10) and possibly some of the small peaks have another shape.

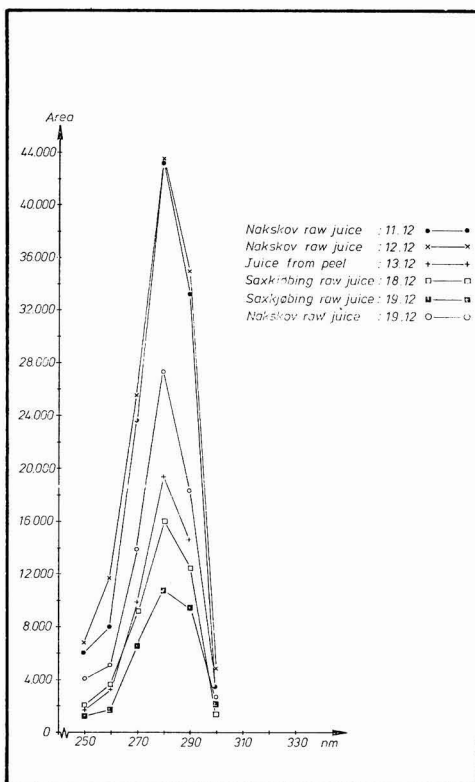
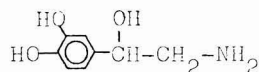


Fig. 9. Absorption spectra of peaks from purified juice found at an elution volume of 5.75 - 6.06 cm<sup>3</sup> in HPLC chromatograms

On the basis of the information achieved we have reached the following conclusions:

Compound I is norepinephrine:



<sup>19</sup> "Handbook of Chemistry and Physics", 50th edn., (Chemical Rubber Co., Cleveland), 1969.



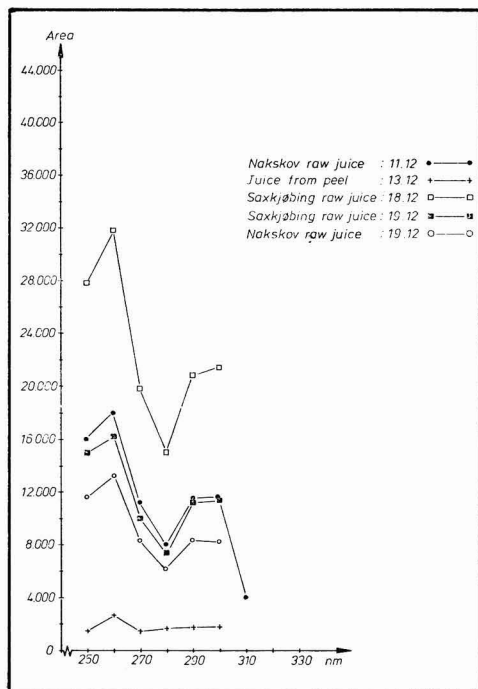
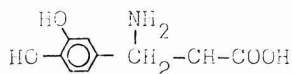
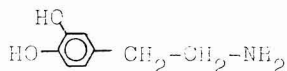


Fig. 10 Absorption spectra of peaks from purified juice found at an elution volume of 17 - 21 cm<sup>3</sup> in HPLC chromatograms

Compound VI is dopa:



One of the compounds IV is dopamine:

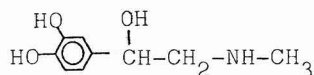


This compound is represented by the peak at 4.95 cm<sup>3</sup> in Fig. 2.

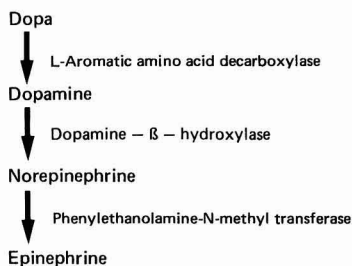
A number of observations may be made concerning the other peaks. The main part of the quantitatively

predominant peaks is eluted between 3 and 9 cm<sup>3</sup> and includes most of the phenolic compounds containing nitrogen (see Table I). A generic term for these compounds, including those identified, is catecholamines. This term will be used from now on.

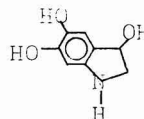
The shoulder after the 3.74 cm<sup>3</sup> peak in Fig. 2 could possibly be epinephrine:



The pathways of syntheses and metabolisms of the catecholamines are known from the physiological studies<sup>20</sup>.



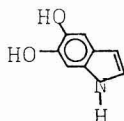
The 3.74 cm<sup>3</sup> peak (Fig. 2) represents a compound which, structurally, must be closely related to epinephrine and possibly also to norepinephrine according to our observations. In general, addition of an -NH-group to an aromatic ring will result in a shifting of the absorbance maximum towards a higher wavelength. For compound III the following formula may be suggested:



<sup>20</sup> Crout: "Catecholamine metabolism". Chapter in "Hormones and hypertension". Ed. Manager (C. C. Thomas, Springfield, IL.), 1966.

#### Sugar beet phenols

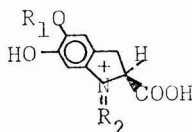
Theoretically, by dehydration this compound is transformed to:



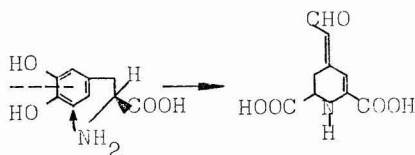
This compound has two aromatic rings, an indole ring system known from tryptophan and, like compound IX, may possibly be found in the later part of the chromatogram (see Table II).

A double ring structure formed by dopa and dopamine could explain some of the other compounds which have a maximum absorption at 290 nm.

It should be borne in mind that one of the natural pigments in beetroot is betanine. A unit in this compound is:



A biosynthetic pathway for another important unit in betalains is formulated on the basis of L-dopa, undergoing an oxidative cleavage and subsequent cyclization to become betalamic acid<sup>2</sup>:



A peak in the chromatograms might be an intermediate for this transformation.

The degradative metabolism of the catecholamines has been studied among higher animals, fungi, and bacteria<sup>21</sup> and should be the subject of investigations on the metabolism of sugar beet.

Analyses of the chromatograms can be used to exclude some phenolic compounds. We have concluded that catechol and pyrogallol are not of any importance in relation to the phenolic compounds in juice from sugar beet.

#### Quantitative analyses

For separated, identified peaks in a chromatogram from purified juice, for which the compound in question is available as a product of a known content, it is possible to estimate the amount of the compound in the juice. Data for norepinephrine and dopa are given in Table III. The day-by-day variations of the content are considerable and in agreement with variations in the size of the peaks in Figs. 8 and 9. The content of norepinephrine is about 1-2 ppm in raw juice and of dopa about 1-5 ppm with an average of 2.4 in ten determinations.

To estimate the approximate total concentration of catecholamines in raw juice we have added the areas in the chromatograms, and we have placed this sum in relation to the areas and concentrations of norepinephrine and dopa. In all cases the total content is below 20 ppm catecholamines in raw juice. The content in digestion juice of the green material is much higher, especially in relation to the content of RDS.

#### Summary

A method for analysing polyphenol compounds in raw juice has been developed. After addition to the raw juice of EDTA and ascorbic acid as a reducing agent, and filtration of the sample with "Celite" filter aid, the phenolic compounds are reversibly adsorbed on alumina at pH 8.4. After washing the alumina, the compounds in question are desorbed with acetic acid, and then separated and characterized by reverse phase HPLC.

In raw juice there are about a dozen compounds with OH-groups in the 1, 2-positions of aromatic rings. Of these some 6-8 are predominant. It is demonstrated that they are compounds called catecholamines and possibly some closely related compounds. Norepinephrine, dopa, and probably dopamine have been identified.

In raw juice the concentration of norepinephrine is 1-2 ppm and that of dopa 1-5 ppm. Together they amount to about 20-50% of the content of catecholamines in raw juice. The structures of the other compounds are discussed.

Altogether the compounds studied are believed to be of major importance with regard to colour formation within the sphere of beet sugar production, not only as colour-forming substances on their own but also as precursors of intermediates for known betalains from beetroot.

Catechol and pyrogallol are phenolic compounds of little importance in raw juice.

#### Les phénols de la betterave sucrière. Etude des composés phénoliques des betteraves en relation avec la coloration

On a mis au point une méthode d'analyse des composés polyphénoliques dans le jus brut. Après

<sup>21</sup> Towers & Subba Rao: *Recent Adv. in Phytochem.*, 1972, 4, 141.

Table III. Catecholamines in juice

"N" and "Sx" represent raw juice from the Naskov and Sæxkjøbing factories, respectively.

Juice	RDS	Norepinephrine	Dopa	Catecholamine (*)	Total (†)
		ppm	ppm	ppm	ppm
N 11/12	13.4	1.9	4.2	17	11
N 12/12	16.4	1.9	4.5	20	13
N 14/12	15.2	0.9	2.2	18	12
N 15/12	15.2	0.8	1.0	9	6
Sx 18/12	14.0	1.1	1.6	19	13
Sx 19/12	13.1	1.2	1.2	16	10
N 19/12	14.4	1.8	2.5	11	7
N 20/12	13.6	1.3	1.4	12	8
N 21/12	14.6	1.9	2.9	9	7
N 22/12	13.0	1.5	2.6	16	11
Green material	3.0	1.2	46 (‡)	50	52
Beetroot	8.4	1.3	50 (‡)	60	57

(\*) Estimated from the content of norepinephrine

(†) Estimated from the content of dopa

(‡) Calculated as dopamine

addition au jus brut d'EDTA et d'acide ascorbique comme agent réducteur et filtration de l'échantillon avec du "Celite" comme adjuvant, les composés phénoliques sont adsorbés, de façon réversible, sur de l'alumine à pH 8,4. Après lavage de l'alumine, les composés en question sont désorbés avec de l'acide acétique puis séparés et caractérisés par chromatographie liquide à haute performance en phase inversée. Dans le jus brut, il y a environ une douzaine de composés avec des groupes OH sur les positions 1,2 des anneaux aromatiques. Parmi ceux-ci, quelques 6-8 sont prédominants. On démontre que ce sont des composés appelés catecholamines et, peut-être, quelques composés fortement apparentés. On a identifié la norépinéphrine, la dopa et, probablement, la dopamine. Dans le jus brut, la concentration de la norépinéphrine est de 1-2 ppm et celle de la dopa 1-5 ppm. Ensembles, elles représentent environ 20-50 % des catécholamines du jus brut. On discute de la structure des autres composés. On pense que l'ensemble des composés étudiés joue un rôle important dans la coloration en sucrerie de betteraves non seulement en tant que substances générant de la coloration par elles-mêmes mais aussi en tant que précurseurs d'intermédiaires pour les bêtaïnes de betteraves bien connues. Le catéchol et le pyrogallol sont des composés phénoliques de peu d'importance dans le jus brut.

#### Zuckerrüben-Phenole. Untersuchung der phenolischen Inhaltsstoffe von Zuckerrüben im Hinblick auf die Farbbildung

Eine Methode zur Analyse von Polyphenolen im Rohsaft ist entwickelt worden. Nach Zugabe von EDTA und Ascorbinsäure als Reduktionsmittel zum Rohsaft und nach dessen Filtration durch "Celite"-Filtrationshilfsmittel, werden die phenolischen Verbindungen reversibel auf Aluminiumoxid bei pH 8,4 adsorbiert. Nach Waschen des  $Al_2O_3$  wurden die untersuchten Verbindungen mit Essigsäure desorbiert und dann durch Rückphasenhochdruckflüssigkeitschromatographie

trennt und charakterisiert. Im Rohsaft wurden ca. ein Dutzend Verbindungen mit OH-Gruppen in der 1,2 Stellungen an aromatischen Ringen gefunden. Von diesen machen ungefähr 6 bis 8 den Hauptteil der Masse aus. Es wird gezeigt, daß diese Verbindungen entweder Catecholamine oder eng mit diesen verwandt sind. Norepinephrin, Dopa und wahrscheinlich Dopamin wurden identifiziert. Im Rohsaft beträgt die Konzentration an Norepinephrin 1-2 ppm und diejenige von Dopa 1-5 ppm. Beide zusammen machen ungefähr 20-50% des Gehaltes an Catecholaminen im Rohsaft aus. Auch die molekulare Struktur der anderen Bestandteile wird diskutiert. Insgesamt ist man der Meinung, daß die untersuchten Verbindungen von größter Bedeutung für die Farbbildung bei der Rübenzuckergewinnung sind, und zwar nicht nur was die farbbildenden Stoffe allein anbelangt, sondern auch als Vorläufer von Zwischenprodukten für bekannte Betalaine aus der Rübenwurzel. Catechol und Pyrogallol sind phenolische Inhaltsstoffe von geringer Bedeutung im Rohsaft.

#### Fenoles de remolacha azucarera. Investigación de compuestos fenólicos de remolacha azucarera respecto de la formación de color

Se ha desarrollado un método para analizar compuestos polifenólicos en jugo crudo. Después de adición al jugo crudo de EDTA (ácido tetra-acético de etilenadamina) y ácido ascórbico como agente reductor, y filtración de la muestra con "Celite" filtro-ayudo, los compuestos fenólicos se adsorben reversiblemente sobre alumina a pH 8,4. Después de lavado de la alumina, los compuestos en cuestión se desorben con ácido acético y entonces se separan y se caracterizan por reversa-fase cromatografía líquida de alta presión. En jugo crudo hay una docena de compuestos con grupos OH en las posiciones 1,2 de anillos aromáticos. De éstos, unos 6-8 predominan. Se demuestra que son compuestos nombrado catecolaminas y posiblemente algunos compuestos intimamente relacionados. Norepinefrina, dopa y probablemente dopamina se han identificado. En jugo crudo, la concentración de norepinefrina alcanza 1-2 ppm y de dopa 1-5 ppm. Combinado, estos compuestos representan 20-50% del contenido de catecolaminas en jugo crudo. Las estructuras de otros compuestos se discuten. En conjunto, los autores creen que los compuestos estudiados son de mayor importancia respecto de formación de color dentro el esfero de producción de azúcar de remolacha, no sólo como materias colorigénicas por su propia cuenta sino como precursores de materias intermedias para betalainas conocidas de remolacha, también. Catecola y pirogalola son compuestos fenólicos de menor importancia en jugo crudo.

Chinese sugar production, 1978/79<sup>1</sup>. — Production of cane sugar in China in 1978/79 amounted to 2,038,400 tonnes, raw value, while beet sugar production amounted to 535,900 tonnes.

<sup>1</sup> World Sugar J., 1979, 2, (1), 4.



# SUGAR CANE AGRONOMY

**A preliminary study of the energy inputs in the production of sugar cane.** P. A. Donovan. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 188-192.—The expenditure on labour, herbicides, fertilizers, fuels and lubricants, machinery maintenance, chemicals other than herbicides, electricity and contracting work has been converted from monetary terms to input energy expressed as megajoules per tonne of cane produced. Comparison of farm sizes and factory area characteristics show statistically significant differences; this also applies to rain-fed and irrigated areas—in the former, 88% of the energy inputs is represented by fertilizers, fuel and machinery maintenance, whereas in the latter case the same three factors plus electricity account for 94% of the inputs. Considerable scope for energy saving is indicated by comparison of farms with high and low energy inputs, and by comparison of five methods of weed control, ranging from use of tractors for spraying and cultivation to hand hoeing.

**Water duties for sugar cane grown during spring and autumn cycles at Pongola.** D. B. Hellmann. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 200-205. When the South African sugar industry expanded into new areas where irrigation was required, no data were available on the amount of water to apply. Continued experimentation has been carried out at Pongola Experiment Substation, covering up to 10 ratoon crops. Results, discussed with the aid of tables and graphs, show that 51 mm of effective water applied on a 21-day cycle can be recommended for both spring and autumn cycle crops; this represents 2844 ha.cume<sup>-1</sup> where sprinkler irrigation is used (giving 80% efficiency) 168 hours per week, or 1525 ha.cume<sup>-1</sup> with surface irrigation used at 60% efficiency 120 hours per week. This recommendation could be applied to a considerable proportion of the cane grown in the irrigated cane areas of South Africa.

**Long-term rainfall trends in the South African sugar industry.** T. G. J. Dyer and J. M. Gosnell. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 206-213. Records from 18 rainfall stations were subjected to spectral analysis, which showed significant long-term oscillations with a mean wavelength of 19.2 years, varying from 17.7 years in the northern rain-fed areas to 22.5 years in the southern part of the cane belt. Shorter oscillations were also found. From this analysis, subjective projections and predictions based on sunspot behaviour, it is probable that most of the South African cane area will experience below-average rainfall in a number of years centred on the mid-1980's.

**Wide planting furrows.** C. Richard. *Sugar Bull.*, 1978, 56, (19), 16-18.—While planting in wide furrows has not given significantly higher cane yields with all varieties,

tests with specific varieties have shown significant increases with 18- or 14-inch furrows by comparison with furrows only 12 inches wide. However, it is stressed that, where the new practice is adopted, there is need to have the proper equipment to cover the wide furrows; otherwise there is risk of insufficient space between cane stalks lying in the furrow—the space should be almost numerically equal to the furrow width.

**Drip irrigation. Fundamental principles, experience and application in the cultivation of sugar cane.** E. Paz-Vergara P. *Bol. Técn. Divn. Técn. Inst. Central Invest. Azuc. (Peru)*, 1976, 5, (3/4), 1-38 (Spanish).—A general description is given of Latin American irrigation practices and characteristics of sprinkler and furrow irrigation described by contrast with drip irrigation. The principles of drip irrigation and the response of crops and their yields are indicated. The possibility of its use for desalination is mentioned and information is presented on equipment, materials and costs, specifically in relation to cane cultivation. A bibliography available in the ICIA and related communications are listed.

**Texture and salinity of soils in the Agrarian Cooperative "El Ingenio Ltda. No. 42".** J. C. Sevilla G. *Bol. Técn. Divn. Técn. Inst. Central Invest. Azuc. (Peru)*, 1976, 5, (3/4), 39-58 (Spanish).—Analysis of soil samples taken in the area of CAP "El Ingenio" showed that the salinity values were not limiting for the achievement of good cane yields. Moreover, the analyses also indicated the presence of a shallow loamy soil above a stony layer very near the surface in most of the fields sampled.

**Summary of investigations on fertilization with N, P and K carried out in the Casa Grande Agricultural Experiment Station during the decade 1960-1970.** S. Valdivia V. *Bol. Técn. Divn. Técn. Inst. Central Invest. Azuc. (Peru)*, 1976, 5, (3/4), 59-77 (Spanish).—A summary is made of the results of fertilization experiments conducted at the Station, some of which have been published previously. Different nitrogen sources showed no significant differences in cane quality or yield. No yield response was found to different rates of K, nor was there a N × K interaction. No response to N occurred at rates between 160 and 240 kg.ha<sup>-1</sup>, but significant responses were obtained to higher rates.

**Effect of salinity on the germination of sugar cane.** S. Valdivia V. and J. Pinna C. *Saccharum* (Publ. Cient. Inst. Central Invest. Azuc., Peru), 1977, 5, (1), 51-59 (Spanish).—Evaluation of the effects of various levels of salinity on the germination of cane setts was studied in field experiments using variety H 32-8560. A highly significant correlation ( $r = 0.80$ ) was found between the two. To obtain good germination, better than 85%, the salinity, measured in terms of the conductivity of extract, should be less than 55 mmho.cm<sup>-1</sup>, while a 50% reduction was observed when salinity corresponded to a conductivity of 9.7 mmho.cm<sup>-1</sup>.

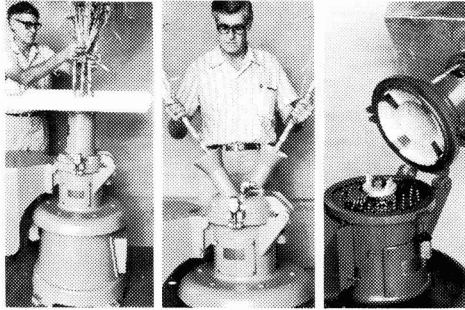
**Application of vinasé by aspersion.** J. M. Lorenzetti and P. G. R. Freitas. *Saccharum* (STAB, Brazil), 1978, 1, (2), 16-22 (Portuguese).—Between 1970 and 1975 vinasé was distributed to cane fields at Usina São José by way of irrigation canals in which it was diluted 1:3 with water. This method gave rise to a number of problems, and in 1975 studies began on the distribution of vinasé in canals to pumping stations from which it was fed to spray points 60 m apart, each covering an area of 2800 m<sup>2</sup>. The rates of application are quoted and the benefits

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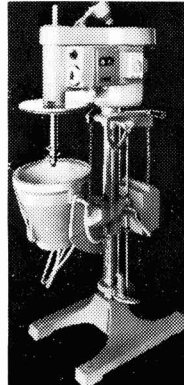
Above left Model 265B will grind prepared cane or that which has come from a pre-breaker. It will also take full stalks including the tops and roots. The opening through which the cane is fed is 6" dia. (152 mm). Power by 10 h.p. motor.

Above centre Model 265 B.M. is identical to the Model 265B except that it has two smaller inlet funnels and will only handle stalks. Inlet diameter 2½" (63 mm). It is fast in operation. It has a water inlet on top so that the machine can be flushed out at the end of tests while still running. This shows machine with receiving bin.

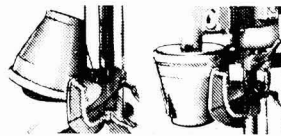
Above right Illustration of internal cutting arrangement. The cutters which are mounted on a vertical spindle perform a scissors action with the four blocks in the head of the machine. Screen plates with holes of various sizes are available. DIMENSIONS: Cutter grinder. (Packed 29" x 51" x 53") = 45.5 c.ft. (1.285 m³) Weight 1100 lb. (499 kg)

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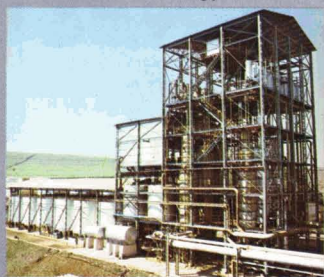
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derived are discussed. The cost of vinasse application is lower than that of conventional fertilizer application and the response is better. Other advantages of the system are described.

**Use of the Class A pan in determination of true evapotranspiration in the cultivation of sugar cane.** N. A. V. Nova, O. O. S. Bacchi and R. Scardua. *Brasil Açuc.*, 1978, 91, 164-173 (Portuguese).—A method described in a doctorate thesis by Souza in 1976 provided a measure of true evapotranspiration of cane based on rainfall and soil tensiometric measurements. By comparison of such measurements with Class A pan evaporation data, a crop coefficient varying between 0.62 and 1.05 with time during the year, and a pan coefficient of 0.75 or 0.85, could be obtained which, when applied to pan data, gave a simple and adequate value to evapotranspiration suitable to govern the supply of irrigation water to a cane crop.

**Good results from minimum tillage.** Anon. *S. African Sugar J.*, 1978, 62, 349.—After difficulties in crop re-establishment on a farm where the heavy clay soil forms a crust during the winter months and poses problems in seedbed preparation, the grower investigated minimum tillage methods. The cane was cut, and further growth permitted until the majority of tillers appeared. Spraying with "Roundup" at 8 litres/ha<sup>1</sup> was followed, 1-2 weeks later (when the cane started dying), by seedbed preparation and furrow formation (in one operation) by means of a rotary cultivator. Seed cane was then planted and covered by hand; planting was not subject to any delays, even after heavy rain, and there was virtually no erosion (by contrast with the previous system). Germination and growth of the crop were very good.

**A preliminary study on the effect of soil oxygen concentration on sugar cane growth.** Y. S. Sheu, T. C. Yang and S. J. Yang. *Rpt. Taiwan Sugar Research Inst.*, 1978, (80), 1-11 (Chinese).—Investigations of the effect of soil oxygen concentration on cane growth showed that a low concentration induced by poor drainage reduced root development and cane growth, as well as leaf N, P and K in the initial weeks of the growing season. All factors studied correlated closely with soil oxygen concentration in the period from June to October. As a result of the poor drainage, yield fell by 17-50% according to soil condition and planting date.

**Cultural practices in relation to the low-temperature effect on sugar cane in north India.** R. S. Kanwar. *Sugar News* (India), 1978, 10, (2), 11-15.—The adverse effects of frost on cane are examined, and possible means of protecting cane from frost are described.

**Exploring "no man's land" of sugar cane research.** G. Arceneaux. *Sugar J.*, 1978, 41, (3), 35-36.—The value of small-scale milling to give estimates of sugar recovery from cane, particularly where different varieties are involved, is discussed<sup>1</sup>; references are made to the use of high-extraction milling to supplement results of field experiments at Central Romana in the Dominican Republic, where the varietal correction factor is routinely determined for all promising seedlings in variety trials and for parent canes used in the breeding programmes. Mention is made of inconsistency in estimations of sugar loss caused by the stalk borer, *Diatraea saccharalis*; the error was attributed to wide variation in the weight of internodes, which affected the validity of the practice of

denoting borer damage levels as percentages of affected internodes. While expression of the damage in terms of rind punctures per weight of cane would be more universally applicable, the term "percentage of bored joints" is so well established that it would be impractical to replace it; hence, both methods are used.

**N-P-K fertilization of sugar cane in the Mata zone of Minas Gerais.** M. S. Manhães, D. F. Azeredo and A. A. Peixoto. *Brasil Açuc.*, 1978, 91, 314-320 (Portuguese). Trials were made, with one replication, using two levels of N, two of P and two of K on plant cane of variety CB 45-3 in a red-yellow latosol, harvested at 16 months. Nitrogen had no consistent positive effect but phosphorus increased yield. Potassium reduced the recoverable sugar in one experiment, but in another increased the production of cane. The best doses were 90 kg/ha<sup>1</sup> P<sub>2</sub>O<sub>5</sub> and 50 kg/ha<sup>1</sup> of K<sub>2</sub>O.

**A new sugar cane herbicide.** J. Everitt and J. Louw. *S. African Sugar J.*, 1978, 62, 403.—"Bladex Plus SC" (containing "Cyanazine" and "Atrazine" as active ingredients) at 9 litres/ha<sup>1</sup> has given good control of guinea grass (*Panicum maximum*) and yellow nutgrass (*Cyperus esculentus*) as well as other grasses and broad-leaved weeds in cane fields. It has been registered for use as a post-emergence herbicide in cane in South Africa.

**Irrigation research in Hawaii.** *Ann. Rpt. HSPA Expt. Sta.*, 1977, 11-16.—Peak effort in drip irrigation research was made during 1973/74. During the subsequent six years, over 30,000 acres in Hawaii has been provided with the system and efforts have been directed to perfecting the use of accumulated hydraulic data, testing of equipment, development of controllers, fighting ant damage to tubes, study of the use of dirty water and sewage effluent for irrigation and evaluating subsurface (deep) irrigation as an alternative to drip (shallow) irrigation. Drip tubes were subject to testing and water distribution profiles developed to aid designing of irrigation system layouts. The use of rubber tubes for subsurface irrigation would be cheap and it was found that blocked orifices could be cleared when the rubber expanded under application of 20 psi pressure for reactivation of the system for a second year's use. An irrigation controller employing a microprocessor has been developed to a prototype and the software is essentially complete for testing. Microscopic examination of tubes and tube orifices in a drip system has shown that plugging is due to many mechanisms; the present system of irrigation water filtration and chlorination appears satisfactory to prevent plugging but should be tested for any new source of water to be used.

**Fertilization, soils and nutrition research in Hawaii.** *Ann. Rpt. HSPA Expt. Sta.*, 1977, 17-20.—Preliminary work indicates that phosphate may be applied to cane soils through drip irrigation tubing and will provide adequate nutrient levels. Phosphate application in irrigation water is inferior to placement below the seedpiece in a plant crop, especially during early growth, but should give as good results as side-dressing of a ratoon crop and eliminate a special fertilization operation. A urea/ammonium nitrate nitrogen source for irrigation water application is under study; it contains 32% N, is compatible with hard water and is cheaper to store and transport, while the N is not volatile and the solution is odourless.

<sup>1</sup> Arceneaux: *I.S.J.*, 1976, 78, 86.

**Cane growth and metabolism research in Hawaii.** *Ann. Rpt. HSPA Expt. Sta.*, 1977, 21-30.—In the 2½ years after Federal registration of "Polaris" the cane area treated in Hawaii rose to about 60% of that harvested. New ripeners are under study; MON-8000, a formulation of the sodium salt of "Glyphosate", has shown promise in offering a greatly increased ripening effect with less variability in the results and at lower application rates. High leaf nitrogen (over 1.45%) appears to protect the cane from ripener effect while low leaf nitrogen (below 1.26%) indicates that the cane is already ripe; the ripener produces a good response at intermediate levels of N (between 1.26 and 1.45%). Trials at different locations showed that variable results were obtained and depended on the ripener and the time of application. An elevated spray boom has been developed for application of ripeners to mature cane, and tests have shown that some chemicals showed activity when applied to cane through drip irrigation tubing. Application of gibberellic acid is better at regular intervals of 30 days than 15; the response depends on the variety of cane. It acts by increasing the length, weight and pol content of lengthening joints but does not increase leaf area. A study on flowering and climatological data for 1973-77 and for ten varieties has been made and a number of conclusions drawn. Transport through the cell plasma membrane has been studied and its linkage with electrolyte balance established, which may be useful in agronomic practice. The presence of an invertase active at pH 2.5 in leaf tissue has been confirmed, and it was also located in sheath tissue. There are several invertases in cane, and work is continuing on their regulation by chemical means. About 13% of carbon fixed by cane is metabolized via starch in cane leaves, and storage during daylight is greater than the rate of starch metabolism, resulting in accumulation. The activity of starch-synthesizing and -degrading enzymes is under study, but has been shown to differ with cane variety. A number of characters have been studied as criteria for assessment of drought resistance, and this work is to continue.

**Weed control research in Hawaii.** *Ann. Rpt. HSPA Expt. Sta.*, 1977, 31-33.—Trials have continued with "Round-up" for perennial grass treatment and application to irrigation water ditchbanks, while studies are being made on the persistence of soil residues. "Velpar" has shown promise in treatment of tougher weeds, including guinea grass, para grass and other grass and broad-leaved species. Perennial Johnson grass is not controlled, and dallis grass only responds to treatment in higher rainfall areas. Small plot trials showed good pre- and post-emergence activity against most weeds by "Ravage", but this has not yet been cleared for field testing. Laboratory studies have been completed on its degradation. Restrictive Federal regulations have also prevented receipt of any new herbicide for testing. Application of a number of herbicides in a single shock dose through drip irrigation tubing was tested; further work will use injection of herbicide into a water flow through the tubing, which may correct the non-uniformity of distribution observed. "Eptam" gave the best results on grasses, but broad-leaved weeds appeared after two weeks and were not controlled. "Evik" ("Ametryne") showed no effect initially but gave partial (but inadequate) control after several weeks.

**Studies on intercropping of maize in sugar cane.** J. P. Patil, V. D. Patil, S. S. Patil and B. K. Nikam. *Maharashtra Sugar*, 1978, 3, (9), 35-40.—The sucrose content of cane was not appreciably affected by growing maize as an intercrop, but the yield was reduced by up to 32%. The net return was greatest from maize grown in alternate rows at 45 cm plant spacing, with addition of 50 kg.ha<sup>-1</sup> of N fertilizer.

**Improving cane quality.** G. K. Zende. *Maharashtra Sugar*, 1978, 3, (9), 43-46.—Factors affecting cane quality are listed and the need for attention to a number of points in order to raise quality is indicated. Suitability of a number of cane varieties for different areas of Maharashtra is mentioned and the use of particular agronomic practices discussed, including the application of ripeners and micronutrients. The importance of correct water management is briefly mentioned, as is the need to ensure optimum yield response by finding the best methods and intervals of fertilizer application. Other important topics include the use of good quality seed cane, timely disease and pest control measures, harvesting of cane on a maturity basis and payment of cane on a quality basis.

**Anhydrous ammonia as a source of fertilizer for sugar cane.** M. V. Dahiphale. *Sugar News (India)*, 1978, 10, (3), 6-13.—Anhydrous ammonia was compared with other forms of nitrogen fertilizer in trials at three locations over three seasons. Yield differences were not significant, but it is concluded that larger-scale trials are warranted, since it is a cheaper form of N than other compound and solid fertilizers.

**The role of nutrients in sugar cane and signs of their hunger.** U. S. Singh. *Indian Sugar*, 1978, 28, 19-25. The role of major and minor elements in the sugar cane and symptoms of deficiency are described; they include nitrogen, phosphorus, potassium, calcium, magnesium, sulphur, iron, manganese, zinc, copper, boron and molybdenum.

**Effect of intercropping on the yield of spring-planted sugar cane.** S. S. Narwal and K. L. Behl. *Indian Sugar*, 1978, 28, 27-29.—Studies were made of the effects of three intercrops grown in cane fields in Haryana, the yields and income from the combined crops being calculated and other effects noted. A good additional income may be obtained by growing moong between rows of cane at 75 and 90 cm spacing. It matured quickly and interfered least with cane growth, whereas cowpeas and bhindi reduced cane yields by 11% and 15%, respectively.

**Nitrogen and sugar cane. XV. Nitrogen metabolism in relation to growth.** U. S. Singh. *Indian Sugar*, 1978, 28, 81-85, 105.—In investigations on nitrogen metabolism in cane stalks and leaves it was found that the stalk accumulated 21.6% total N during the tillering phase, 51.4% during the elongation growth period and 63.4% during the sugar accumulation phase; corresponding accumulation of total dry matter was 21.9%, 64.9% and 76.2%. The leaves accumulated 78.4%, 48.6% and 36.6% N and 78.1%, 35.1% and 23.8% dry matter in the three phases. N requirement per tonne of dry matter in the stalk was 11.03, 1.90 and 2.21 kg in the three growth periods, while for the leaves the requirement was 26.17, 14.91 and 13.07 kg.tonne<sup>-1</sup>. The patterns of N and dry matter accumulation with growth as shown by these values are discussed.

# CANE PESTS AND DISEASES

**Brown spot of sugar cane in Taiwan.** W. H. Hsieh and D. S. Tseng. *Rpt. Taiwan Sugar Research Inst.*, 1978, (79), 29-36.—A cane leaf disease occurring on a wide scale in a region of eastern Taiwan gave symptoms similar to brown spot and was in fact found to be caused by a new strain of the brown spot pathogen, *Cercospora longipes*. The disease is characterized by 0.3-2.0 x 1.0-5.0 mm reddish-brown lesions on the leaf and leaf sheath. The reactions of 41 cane varieties and of *Saccharum spontaneum* to the disease are recorded.

**"Heptachlor" resistance in sugar cane white grub, *Alissonotum impressicollis*, and wireworm, *Melanotus tamsuensis*.** S. A. Hsieh. *Rpt. Taiwan Sugar Research Inst.*, 1978, (79), 37-42 (Chinese).—Populations of both title pests have been found in Taiwan which are highly resistant to "Heptachlor", evidently a result of application of the pesticide in a localized area over a number of consecutive years.

**Non-volatile nematicides: an initial assessment in north Queensland sugar cane fields.** K. J. Chandler. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 85-91. Trials with "Aldicarb" ("Temik") at 5.6 and 2.8 kg.ha<sup>-1</sup> and "Oxamyl" ("Vydate") at 8.4 kg.ha<sup>-1</sup> are reported. Tabulated data indicate that both nematicides increased sugar yield from plant and ratoon crops as a result of reduction in nematode numbers and associated cane growth improvements. "Aldicarb" at the higher dosage rate generally gave the best results. The question of suitable time of application is briefly discussed.

**Evaluation of new rodenticides in Queensland cane fields.** B. E. Hitchcock and R. E. Kerkwyk. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 93-95. In trials on control of *Rattus conatus* in cane fields, two new anti-coagulants, "Diphenacoum" at 0.01% and "Diphacinone" at 0.025%, were similar in effect to thallium sulphate at 0.3%. The results are expressed in terms of the number of damaged cane stalks counted after preharvest burning. The machine-packed, whole-wheat baits used were dropped from an aircraft. The effectiveness of the chemicals against the climbing rat, *Melomys littoralis*, could not be determined because of its absence from the cane fields.

**Eye spot disease in far north Queensland.** T. G. Willcox and C. M. McAleese. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 103-106.—The development of eye spot in the title area from 1970 to 1976 is traced and the effect of the disease on cane sugar content indicated. Its spread was attributed to weather conditions and to planting of the variety Q 101, which was removed from the lists of approved varieties in 1976. While, under conditions favouring spread of the fungus, a number of current commercial varieties are susceptible to varying

degrees of infection, it is thought unlikely that the scale would be that of the Q 101 infection.

**Diagnosis of RSD using sugar cane uprights.** D. S. Teakle, R. G. Birch and J. M. Appleton. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 107-110. Tests, in which uprights of bana grass (*Pennisetum purpureum* x *P. americanum*) and of Q 28 cane were inoculated with ratoon stunting disease pathogen, showed that the cane can be used as an alternative to uprights of elephant grass or bana grass for the rapid diagnosis of the disease, symptoms of which developed within 2-3 weeks when inoculation was carried out directly through the cut end of the spindle. While bana grass grows more vigorously and uniformly than Q 28 cane and develops more vascular discoloration, the cane produces more specific symptoms of the disease as well as of bacterial mottle, red stripe and leaf scald (the bacteria of which possibly interfere in RSD development). Sensitivity of both plants to diluted RSD inoculum appeared to be similar.

**Land management and the creation of habitat for *Eldana saccharina* Walker (Lepidoptera: Pyralidae).** P. R. Atkinson. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 137-138.—Investigations have shown that damage to or clearing of riverside woodland creates opportunities for the growth of reeds, grasses and sedges along the banks and on the river beds, and that *Cyperus immensus*, a host of *E. saccharina* borer, constitutes a high proportion of the sedges in one cane-growing region of South Africa. In addition, disturbance and drainage of beds of *Cyperus papyrus* also lead to heavy infestations of the pest. Planting of fast-growing trees such as *Schinus terebinthifolius* is recommended where the woodland has been cleared; otherwise, the woodland should be left as a safeguard against erosion and borer infestation.

**Mill yard surveys of the lepidopterous cane borers *Eldana saccharina* Walker and *Sesamia calamistis* Hampson.** R. J. Smaill. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 139-142.—results of surveys conducted in the mill yards of seven South African sugar factories are reported, and 1977/78 curves showing the incidence rates by months are compared with those for 1976/77. Amatikulu is shown to be the most seriously affected factory, as regards *E. saccharina* incidence, and monthly mean maximum temperatures are given for it. *S. calamistis* is more widely distributed than *E. saccharina* but is less harmful.

**Mass rearing and artificial infestation methods for *Eldana saccharina* Walker (Lepidoptera:Pyralidae).** P. R. Atkinson. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 143-145.—Details are given of the standard method used at the South African Sugar Association Experiment Station for mass rearing of the borer and artificial infestation of cane with it so as to ensure uniform distribution and give infestation rates which are sufficient e.g. to permit evaluation of insecticides. Cane tends to be an unsuitable host for *E. saccharina* because of the difficulty which young larvae apparently experience in penetrating the stalk.

**Morphology of the lesser sugar cane borer *Elasmopalpus lignosellus* Zeller (Lepidoptera: Phytitidae).** E. E. Carbonell. *T. Saccharum* (Publ. Cient. Inst. Central Invest. Azuc., Peru), 1977, 5, (1), 18-50 (Spanish).—A complete morphological study is presented of the title borer, considered a minor pest of sugar cane which it attacks during its first three months of growth.

# CANE BREEDING AND VARIETIES

**Cane varieties in Jamaica.** *Ann. Rpt. Sugar Ind. Research Inst.*, 1974, 36-66.—Details are given of the distribution of cane varieties and trends in Jamaica, while tabulated details are given of varietal trials in 1974. Outstanding in terms of sugar yield was HJ 5741, which occupied 27% of the total estate area harvested, thus displacing B 4362 which had been the dominant variety for the previous 12 years.

**Release of new variety: N 11.** Anon. *S. African Sugar J.*, 1978, 62, 267.—Information is given on N 11, newly released for general cultivation in South Africa. A progeny of the Brazilian variety, CB 40/35, and N:Co 293, it has shown high resistance to smut, leaf scald and mosaic and has consistently outyielded N:Co 376 in terms of sugar under irrigation conditions on well-watered, fertile sites. While its sugar yield is lower than that of N:Co 376 under rain-fed conditions, its higher sugar content (some 1.2 units greater than that of N:Co 376) and disease resistance could warrant its use in areas where such conditions are typical. It performs poorly on recently formed sands, however.

**Sugar cane improvement in São Paulo state.** F. Brieger. *Saccharum* (STAB, Brazil), 1978, 1, (2), 13-16 (*Portuguese*).—A graph shows the changes in varieties grown in São Paulo between 1972 and 1977. The most common variety remains CB 41-76 but new ones have been introduced and are increasing in popularity (IAC 52-150, CB 47-355, CB 40-13 and, especially, NA 56-79) while others have disappeared (CB 36-24, CB 40-77, IAC 50-134 and Co 419). Other varieties have continued in use, some with increased areas and others reduced (IAC 51-205, IAC 48-65, CB 46-47, CB 49-260, etc.). Susceptibility to disease is one cause of elimination of varieties and examples of these in Brazil are given. Parameters governing the selection of varieties are listed and discussed, including yield and sucrose in both plant cane and ratoons; adaptation to the soils, climate, etc.; response to fertilizers; resistance to pests and diseases; adaptability to cultivation practices; and good industrial characteristics.

**Study of the behaviour of some sugar cane varieties (*Saccharum* spp.) at low temperatures.** Experiment II. O. Brinholi, E. C. Ferraz, D. A. S. Marcondes and J. R. Machado. *Brasil Açuc.*, 1978, 91, 258-265 (*Portuguese*). Eleven cane varieties were grown in an area subject to low temperature and their resistance to frost determined. The most resistant was N:Co 310 and the least resistant CB 41-76 and CB 56-155.

**Loss of genotypes of sugar cane in group transplanting.** T. G. Pimenta, R. Ruschel and T. G. Pereira. *Brasil Açuc.*, 1978, 91, 302-304 (*Portuguese*).—It has been found that, when seedlings from sugar cane crosses are planted in groups to permit the testing of large numbers in a re-

stricted area, many of them do not develop and are lost, only the stronger survivors continuing to the next stage of selection.

**Cane breeding and selection in Hawaii.** *Ann. Rpt. HSPA Expt. Sta.*, 1977, 4-10.—A rapid increase in preliminary testing of new varieties made possible replacement of smut-susceptible varieties in Hawaii, and several promising smut-resistant ones occupy more than 100 acres each. Two derivatives of Thailand *Saccharum spontaneum* seedlings have shown themselves adapted to the Hilo and Ka'u climates and have high yield potential, so being of interest as a source of breeding material. The area under variety H 59-3775 increased to 44.2% in 1977, far ahead of H 50-7209 (19.6%), H 54-775 (13.0%) and H 57-5174 (11.4%). The second is losing ground because of its smut susceptibility. A total of 4269 crosses were made in the 1976/77 crossing season, including 1987 "melting pot" crosses and 314 biparental crosses. Lower than normal temperatures and rainfall during the crossing season reduced pollen production, but seed set and germination were excellent. Field testing continued, a new strain of smut being a factor for selection. A number of triploid clones have been derived from crosses of known tetraploid clones (obtained using callus tissue and cell suspension techniques) with diploid Hawaiian commercial hybrids; these are to be used to determine their performance as parents in crosses and to find if a relationship exists between ploidy level and cane performance. A rapid enzyme technique has been developed to allow production of healthy protoplasts within 3-4 hours. After callus tissue has differentiated into shoots on a conventional medium it is transferred to a 1% agar, 7% sucrose medium in which the tissue develops a vigorous root system and the plants can be moved into vermiculite. Biochemical study of enzyme activity in cane has shown significant differences following different levels of N treatment.

**Some observations on propagation and selection in young potted sugar cane seedlings.** D. W. Thomas. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 193-194.—Cane seedlings, which had been grown in pots for 8 months (the normal period in the breeding programme at Mount Edgecombe), were cut at soil level and weighed, and the juice Brix determined. Both the underground parts and the stalks (setts) were used to establish single stools in the field. When the underground parts were used, only 45-58% of the plants survived, whereas 82-98% of the stalks survived. A correlation coefficient of 0.34 was found between the above-ground weights of the potted seedlings and the weights of the field-grown stools, while one of 0.32 was established between seedling and stool Brix.

**More discussion on new varieties.** C. Ricaud. *Sugar Bull.*, 1978, 56, (21), 12.—While CP 70-321 and CP 70-330 give adequate yields and are early-maturing high-sucrose cane varieties, their leaves remain upright during growth and do not form a canopy, so that weeds can grow between the cane. They are also susceptible to ratoon stunting disease, and setts must be heat-treated before planting. CP 70-330 is susceptible to cold and has a moderately high fibre content, while CP 70-321 has a slight tendency toward brittleness.

**CoS 758—a new mid-late sugar cane variety for east U.P.** B. K. Mathur and A. Nath. *Indian Sugar*, 1978, 28, 127-128.—A description is given of CoS 758 variety which, in trials during 1973-76, performed almost as well as the mid-season variety, BO 17, in respect of yield and juice purity.



# CANE SUGAR MANUFACTURE

**Problems associated with the operation of high-generation bagasse boilers.** R. E. Bickle and M. K. Moir. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 249-253.—After two months' operation of a new Babcock & Wilcox bagasse-fired boiler installed at Pioneer factory in 1976, problems were encountered in the form of tube blockage by sludge (principally a mixture of calcium and magnesium silicate, carbonate and phosphate) and in breaks in bagasse feeding direct from the final mill to the furnace, eventually causing mechanical defects in the boiler. Remedial measures are described. It is stated that the design of the boiler, rated at 181,200 kg.hr<sup>-1</sup> and three times larger than one installed at the same factory 10 years previously, was sufficiently different that installation should have been accompanied by a critical analysis of all existing related equipment and past operating procedures in order to effect its complete integration into the plant.

**'O' ring seals in juice heater headers.** T. W. Gatley. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 255-258.—Erosion of juice heater tubeplates in the area covered by the header is a persistent problem which can be sufficiently serious to require the fitting of new tubeplates. However, one means of preventing it is the use of 'O' rings compressed between the outside of the tube, the tubeplate and the recess in the header. After the season's operation, there was little trace of leakage at one end of a juice heater modified in this way at Fairymead factory; previously, both tubeplates and headers had suffered bad erosion. However, the 'O' ring is more expensive than a flat seal.

**Design data for bulk sugar storage bins.** D. G. Fry. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 267-272.—After a 3000-tonne storage bin at Proserpine factory collapsed, inspection failed to show causes of the failure, although the design was considered satisfactory; overstressing of some inferior welded connexions between the bin shell and columns may have started a chain reaction of failure, it is suggested. The designer of the bin, which was subsequently rebuilt with only slight modification, examines various design factors; the information given is applicable to the design of bins of up to 1500 tonnes capacity.

**The application of a programmable controller to a cane truck handling system at Playstowe mill.** R. Diplock and K. Marshall. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 313-316.—The system used at Playstowe for automatic control of cane train movement, weighing of cane per bin, discharging of contents and removal of trucks carrying empty bins is described. The system performed excellently for a whole season during which 940,000 tonnes of cane were crushed.

**Chemical cleaning of evaporators.** P. C. Ivin. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 321-326.—Pilot-scale evaporators, operating under the same conditions as final effects, were set up at Racecourse and Kalamia sugar factories. Each comprised three stainless steel tubes surrounded by a steam chamber supplied directly with vapour from the full-scale effect. Syrup was also fed from the preceding main vessel. Examination of the scale in the pilot vessel revealed considerable variation in composition with time and from top to bottom of the tubes. When the syrup was supplied from the final effect, the pilot evaporator scale contained mostly silica; when syrup was supplied from the 4th effect, CaO became the dominant component and the silica content dropped to a low level. Similar variability in composition was found at Kalamia, where most of the scales were characterized by high silica and relatively low CaO contents. Chemical cleaning tests were conducted on the pilot evaporators. While boiling for 1 hr with 20-25% w/v NaOH solution at atmospheric pressure, or boiling for 1 hr with 30% NaOH under vacuum, did not remove all scale, the evaporator performances were not greatly affected by this; the corrosion rates under the effect of the caustic soda were acceptable, but the use of additives such as 3% CD 280 permitted a reduction of NaOH concentration to 5%, while still giving similar results on 1 hour's boiling. A two-stage treatment involving boiling for 1 hr with a 1.5% alumina-ferric solution, followed by 1½ hr at 85°C with 4.5% NaOH solution, required higher capital cost but used the least corrosive materials, was more economical in use and provided an efficient means of scale removal.

**Introduction of a maintenance system.** R. A. Allaway and N. H. Barnes. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 327-333.—The computer-based maintenance system introduced at Mossman is described, aspects covered including job planning, budgeting and job control and progress reporting. Since the system is in its early stages it is not yet known whether it has been effective in its primary aim of reducing maintenance costs.

**Shredder hammer performance at three Bundaberg mills.** I. G. Flanders, J. S. Glass and G. N. McLucas. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 335-342.—The design, performance, maintenance and costs of shredder hammers at Millaquin, Bingera and Fairymead factories are examined. The performances of the shredders were approximately the same. The capital and maintenance costs were higher for hammers having tungsten carbide tips and were lowest for those with removable cast steel heads having wearing faces of hard alloy. A club head hammer was cheapest to install but its maintenance costs were high. Extrapolation of costs to allow for magnetic protection of tungsten carbide tips and for shredders with equivalent loading showed that hammers with replaceable hard-faced heads were likely to be more economical.

**The development of non-bituminous mill journal lubricants.** I. D. Blackburne, R. G. Hafner, J. F. Rae and K. B. Hurst. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 343-348.—The advantages of non-bituminous lubricants over bituminous compounds used for cane mill journal lubrication are indicated in this examination of the performances of both types of lubricant. Laboratory tests were confirmed by data obtained from a number of mills using non-bituminous lubricants in the 1977 crushing season.

**Sugar mill gearing.** J. R. Partridge. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 349-354. The types, arrangements, selection, design, lubrication and installation of gearing generally used for cane mills are discussed.

**Mourilyan ash removal system.** J. T. Logan and A. L. Fitzmaurice. *Proc. 45th Conf. Queensland Soc. Sugar Cane Tech.*, 1978, 355-358.—When a new Riley Dodds boiler was installed at Mourilyan, problems arose with the ash removal system which had been used for the previous boilers, the difficulties being due to the much greater quantity of very fine ash from the highly efficient dry arrestors. The settling tank for the ash slurry and the paddle-wheel settled ash remover were relocated above ground near the boiler, the drive was strengthened, and bagasse was continuously fed at about 44% on dry ash to the sluice way along which the ash travels to the settling tank (the bagasse having been found to improve settling, reduce the solids content of the sluice water and to contribute to easy discharge of the settled underflow from the paddle-wheel). One season of operation showed that the system is trouble-free, requires little maintenance and produces an ash which drains readily when piled and is easy to transport by truck without spillage. The ash is then spread on fields.

**Fifty-third annual review of the milling season in Southern Africa (1977-1978).** J. P. Lamusse. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 1-19.—Details are given of the performances of the eighteen South African sugar factories, the two Swaziland factories at Big Bend and Mhlume, Nchalo factory in Malawi, and Buzi and Maputo factories in Mozambique.

**Activated sludge treatment of sugar mill/wattle bark mill effluents at Dalton, Natal.** D. E. Simpson and J. Hemens. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 20-25.—The Union Cooperative Bark & Sugar Co. Ltd. processes some 500,000 tonnes of cane and 30,000 tonnes of wattle bark per year in factories at Dalton. The effluents from the mills are discharged, via drainage channels, to a series of ponds which act as sedimentation basins; effluent from these ponds is pumped to an aeration basin equipped with two rotary surface aerators. The overflow is transferred to a settling tank, from which the supernatant is used as make-up for cooling water supply to the sugar factory. Observations of the activated sludge process used showed that, during most of the period of the investigation, the final effluent had a high suspended solids concentration which adversely affected its re-use. When bark mill waste was the only feed to the ponds, sludge bulking was observed, but the settling quality was satisfactory when sugar factory effluent was included. It was found necessary to add N and P for the activated sludge treatment. The soluble COD of the mixed effluent was reduced by 94% and the soluble BOD by 99.3% at a flow rate of 302m<sup>3</sup> per day during a 4-month period. Capital and operational costs of the plant are summarized.

**Optimization of the crushing programme for the season by dynamic programming.** R. G. Hoekstra. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 26-32. Dynamic programming is a technique for determination of variables which eliminates most of the possible combinations of values of variables, so that eventually only

a small proportion of the total number of combinations needs to be calculated. It is completely different from linear programming, its advantages being that non-linear relationships present no problems while the written computer programme is entirely self-contained, needing no interfacing with a special linear programming package. The author describes application of the technique to optimization of the season's crushing programme for a factory. It is shown how, within any given constraints on throughput rates, cane availability and starting and finishing dates, the programme will specify starting and finishing dates and month-by-month crushing rates. Expected monthly values of process variables and time utilization, the drop in overall recovery as a result of increased throughput, and the various types of costs are taken into account. The output includes monthly performances, efficiencies and costs as well as the final maximum profit for the season. An example is given of the procedure used.

**Steamside chemical cleaning of evaporator tubes.** J. W. V. Lewis, R. Archibald and C. Mack. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 33-35.—After routine examination of evaporator tubes at factories operated by Hulett's Sugar Ltd. had revealed serious steamside fouling, laboratory investigations were carried out to find a suitable cleaning formula. The results were then used to establish factory cleaning procedures. At Amatikulu, brass tubes were treated with 10% acetic acid, 5% "Magnus 1007" and 85% water for 12 hours at 25°C; at Darnall, brass tubes were treated with 10% acetic acid, 0.5% NP6, 9.5% power paraffin and 80% water for 10 hours at 50°C, while mild steel tubes were treated with 10% acetic acid, 2.5% NP6, 7.5% "Solvesso 150" and 80% water for 72 hours at 25°C; at Mount Edgecombe, the procedure used was the same as at Amatikulu. Results showed that treatment considerably improved the heat transfer coefficient, the degree of improvement depending on the extent of fouling.

**Justification of power factor correction equipment.** J. van Dokkum. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 36-38.—The author demonstrates how to calculate power factor improvements with the aim of reducing electricity charges in a sugar factory.

**A simple and inexpensive evaporator entrainment separator.** R. Archibald and C. Mack. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 39-40.—Entrainment in two evaporator effects at Darnall factory was reduced by between 92.6% and 97.0% by means of a separator made from angle iron so arranged that it presents a corrugated configuration. The entire structure spans the full diameter of the evaporator and is suspended from two channel irons which are in turn supported by four legs resting on the tube plate. Slight tilting of the structure allows juice droplets to run off. Pressure drop was found to be negligible.

**Development of a sweep sampling device for the direct sampling of knifed cane from a belt conveyor.** R. Bodger and C. B. van der Riet. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 41-44.—At Amatikulu, samples of cane passing on a belt conveyor from the knife sets to the shredders are pushed into plastic bags suspended from a side rail by an electrically operated sweep arm pivoted from a frame straddling the 2 metres wide conveyor. During three months' operation, nine times per day, the sampler presented no problems in operation.

# BEET SUGAR MANUFACTURE

Precise chemico-technical control and calculation of a balance for production involving partial withdrawal, storage and processing of thick juice. A. Ya. Zagorul'ko *et al. Sakhar. Prom.*, 1978, (9), 48-52 (Russian).—A detailed balance was drawn up to determine the increases in losses resulting from thick juice storage and post-campaign processing and indicate those areas where the losses could be reduced. The additional losses amounted to 0.34% on weight of beet, made up of 0.05% in storage, 0.20% in processing and 0.09% in molasses.

Application of deionization purification to produce liquid sugar and spray-dried products. S. E. Bichsel. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 150-161.—The development of beet thick juice treatment by ion exchange in the US industry is summarized. The latest stage involves treatment of thick juice produced directly or from storage, followed by concentration to a liquid sugar or by spray drying, while the non-sugars are separated from the ion exchangers, reconstituted and partly used for addition to pulp and partly as a fertilizer. The liquid sugar obtained in this way is superior to conventionally produced liquid sugar, having lower colour, ash and floc content.

Coordination of mass flow in the beet end of a sugar factory using a computer. J. Oledzki, D. Piotrowski, M. Szczeniowski and K. Urbaniec. *Gaz. Cukr.*, 1978, 86, 194-196 (Polish).—A block diagram is used to demonstrate a system devised by Chemadex for coordination of material flow between individual stations extending from the hopper feeding the beet slicers to the evaporators. Tests at Chelmza sugar factory confirmed the validity of the basic theory.

Final tests and thoughts on improving the quality of thin juices without alkalinity reserve by partial anion exchange. F. Perschak. *Zuckerind.*, 1978, 103, 743-747 (German).—The tests conducted in 1976 and reported earlier<sup>1</sup> were continued in 1977, and the dimensions worked out for an ion exchange unit handling juice from 7000 tonnes of beet per day at an exchange rate of 10 equivalents per tonne of beet. The costs of 70 days' operation (expressed in tonnes of white sugar) are also calculated on the basis of an extra 1667 tonnes of sugar recovered by the process in the earlier experiments; at a 5-year amortization and an interest of 10%, the defrayed costs are estimated to be the equivalent of 3032 tonnes of sugar. While there is no obstacle to installation of a full-scale unit at the author's factory (Hohenau), the project was postponed because of high beet quality and the lack (with one exception) of need for alkalinity correction. Where there is sufficient natural alkalinity during a campaign, or where the unit is somewhat overdimensioned, cations corresponding to the excess OH<sup>-</sup> ions can be exchanged for ammonium, to give a desalting effect similar to that of the carbonate process<sup>2,3</sup>, part

of the thin juice softening plant could be used for the ammonium exchange and regeneration carried out with an ammonium salt instead of NaCl, while the other part would operate on the Na<sup>+</sup> cycle.

Reduction in energy and investment costs by use of electronic data processing. E. Farwick. *Zuckerind.*, 1978, 103, 748-753 (German).—The application of a computer to calculate heat and mass balances (which have a considerable effect on the energy and capital costs of a sugar factory) is explained, and programmes for diffusion, juice purification, evaporation and boiling described. A computer-designed 3-masseccute boiling scheme is reproduced, as are tables of data for evaporator bleed users and for the individual bodies in a quadruple-effect evaporator. Application of the programmes has been of benefit in the planning of new factories, expansion of existing factories and examination of current operational practices.

Constructional problems of modern induction motors for driving sugar centrifuges. A. Glowacki. *Przegląd Elektrotechniczny*, 1973, 49, (1), 12-16; through *S.I.A.*, 1978, 40, Abs. 78-1122.—Mathematical theory for and problems in the design of induction motors to drive batch sugar centrifugals are discussed and illustrated by existing designs. Attention must be paid to cooling of the motor and thus protecting insulation, and also to the strength to withstand alternating dynamic forces. Two electromagnetically independent parts are necessary: the high-speed part has a cage and a separate resistance; the low-speed part is a low-power motor with many poles. It is hoped that such motors driven by thyristorized inverters will soon replace constant-current motor + thyristor assemblies. The constant-current type accommodate well to varying demands, and may consume only 1 kWh/cycle of a 1000 kg centrifugal (compared with 2 kWh for induction motors), but cost three times as much to install, and are worthwhile only when power is very expensive.

Standard applications of thyristor drives for various branches of industry. F. Bändel, G. Beringer and R. Stöckmann. *Technische Mitteilungen AEG Telefunken*, 1976, 66, (1), 9-15; through *S.I.A.*, 1978, 40, Abs. 78-1123.—Operating principles and advantages of converted D.C. drives are described, and some particular applications are discussed. Thyristor-fed D.C. shunt motors are very suitable for driving sugar centrifugals; they permit rapid transition between speeds for filling, centrifuging and discharge without peaks of current, and speeds can be adjusted during operation if required. Other advantages include constant acceleration and braking moments and high electrical efficiency compared with A.C. motors.

The optimization of the energy economy in the sugar factory. P. Christodoulou. *Hellenic Sugar Ind. Quarterly Bull.*, 1978, (34), 207-244 (Greek).—See *I.S.J.*, 1978, 80, 212.

A modern non-stirred main limer. I. Vigh. *Cukoripar*, 1978, 31, 98-99 (Hungarian).—A liming system is described which consists of two identical vertical vessels linked by a juice and lime feed and juice discharge line. Lime is fed to the incoming heated, prelimed juice before it is distributed from a horizontal line passing across

<sup>1</sup> Perschak: *I.S.J.*, 1978, 80, 182.

<sup>2</sup> Moebes: *ibid.*, 1960, 62, 257.

<sup>3</sup> Elmer *et al.*: *ibid.*, 1970, 72, 214.

both vessels. In each vessel it flows down through a series of perforated plates and enters a rising exit pipe towards the bottom and to one side of the tank. From this riser, the juice enters a slightly inclined pipe to be transferred to carbonation. At an active volumetric capacity of 53 m<sup>3</sup> and a residence time of 20 minutes, the limber is capable of giving a well homogenized juice-lime mixture from 3000 tonnes of beet per day at a raw juice draft of 135%. In 1976/77, use of fractionated cold and hot liming permitted 89.3% invert sugar destruction and a colour of 16.6°St/100°Bx compared with 85.8% and 35.1°St/100°Bx, respectively, in the previous system used during 1971-75.

**Current situation in the Spanish sugar economy and prospects of integration in the EEC.** F. Lozano B. *Sucr. Franç.*, 1978, 119, 403-413 (French).—A survey is presented of the Spanish sugar industry and economy, the major part being concerned with beet sugar production, since cane sugar accounts for only 2% of the total national output.

**Use of sleeve-type filter cloths on FiLS filter-thickeners.** Yu. F. Tsyukalo, V. T. Rud', A. P. Belenko, E. F. Pinchukova, L. V. Lipai, Yu. V. Anikeev and V. A. Chernenko. *Sakhar. Prom.*, 1978, (10), 28-29 (Russian). TT-842 sleeves made from a mixture of caprone and a "Terylene"-type synthetic fibre have proved satisfactory when used in FiLS filter-thickeners for the treatment of 1st carbonation mud, meeting requirements of mud density, filtrate turbidity and service life.

**The discrepancy between the sugar content of beet supplied for processing and the sugar content of beet cossettes.** G. F. Tyazhelova. *Sakhar. Prom.*, 1978, (10), 66-71 (Russian).—Data from Ramon sugar factory, covering the period 1965-74, have shown differences between the sugar content of beet samples as determined in the tarehouse and the sugar content of cossettes. The discrepancies, ranging from 0.31% to 1.47% (absolute), were attributed to dirt and leaf tare, to sugar losses in flume-wash water and to free and absorbed water, as well as to storage losses and analytical error.

**The difficult problem of sampling industrial beets at reception.** D. Bourdon. *Ind. Alim. Agric.*, 1978, 95, 707-713 (French).—Factors determining beet sugar content (climate, soil type, variety and agronomic factors) are discussed, and the importance of correct sampling at the beet yard examined. The point in a load from which samples are taken and the minimum number of samples to give an accurate, representative reading of sugar content are considered, and the viewpoints of a farmer and of a factory manager on the subject are expressed.

**Treatment of sugar factory vegetal waste.** M. Cuer. *Ind. Alim. Agric.*, 1978, 95, 759-762 (French).—A description is given of the plant used to separate and wash the 450 tonnes of extraneous matter a day which is removed from beet at Pithiviers sugar factory in France; of this trash, 6% is soil, 1% is sand and stones, 20% is beet rootlets and pieces, and 63% is leaves and weeds. All of the extraneous matter passes on a belt conveyor at 15-20 tonnes.hr<sup>-1</sup> to a hopper which feeds it to a Mick horizontal, rotary drum formerly used for milk-of-lime preparation. Some of the sand and dirty water is discharged at a point halfway along the drum, while the rest of the waste is discharged at the end. Decanted

water recycled from tanks located after the other separation plant is split into two streams, one of which flows, at 30 m<sup>3</sup>.hr<sup>-1</sup>, back through the Mick drum to the halfway discharge port, while the other, at 50 m<sup>3</sup>.hr<sup>-1</sup>, flows to the feed hopper. The remainder of the impurities pass from the drum to a vertical tube (which they enter at a point two-thirds towards the top) immersed in a vertical tank having a funnel-shaped bottom section. Water is injected into the tube at a point one-third from the bottom; the ascending current separates the impurities into two groups according to their densities: the weeds, leaves and beet fragments are carried up to a discharge port towards the top of the tank, while the sand and stones fall to the bottom, from which they are discharged to an inclined paddle-type separator. The green trash and beet fragments pass to a sloping screen (from which the water is decanted for recycling), after which the weeds and leaves fall onto a crusher and are subsequently fed by screw conveyor to a press. The beet fragments are eventually fed to the diffuser after chopping or coarse crushing.

**Diffusion juice purity.** M. Roche. *Ind. Alim. Agric.*, 1978, 95, 767-769 (French).—Since determination of raw juice purity is subject to errors, the sources of which do not have the same effect on thin juice purity determination, the author questions the value of determining raw juice purity, particularly in view of the fact that the difference between the two purities does not represent purification efficiency. However, on examination, he does feel that raw juice purity is still of value as a guide to diffuser performance and as an indication of beet quality.

**The determination of residence time distribution, of cossettes and juice in diffusion, and in other sugar factory processes.** T. Cronewitz, G. Müller and H. Schiweck. *Ind. Alim. Agric.*, 1978, 95, 771-777 (French).—Determination of residence time in sugar factory processes is discussed. While LiCl can be used for juice and massecuite (since the Li<sup>+</sup> ion does not generally occur, at least in determinable quantities, in these products, and Li salts are readily soluble), it is unsuitable for determination of cossette and juice residence times in diffusion because of constant change in the cation composition of the juice phase as a result of the carboxylic groups present in cell wall pectins and the ion exchange properties of the cell walls. However, staining with methylene blue or using red beet gives a satisfactory indication of residence time; various acetates (particularly ethyl and methyl acetate) also act as suitable tracers and are easily determined by gas-liquid chromatography using the head-space technique. Advice is given on the procedures to use with the various tracers mentioned, and details are given of a GLC method used for juice and cossette residence time determination.

**A new technique of sugar drying: the rotary multi-tube, concentric-nest dryer/cooler.** V. Duhem. *Ind. Alim. Agric.*, 1978, 95, 795-803 (French).—Details are given of a Fives-Cail Babcock sugar dryer/cooler which consists basically of two sets of horizontal tubes located concentrically around a central shaft. Sugar to be dried is fed through the inner circle of tubes together with hot air; when it reaches the end of the tubes, it is transferred via enclosed chutes to the outer circle of tubes and flows back along these against the flow of cold air. Typical data quoted are reduction of moisture content from 1% to 0.03% and cooling to a temperature 15°C above ambient at a sugar flow rate of 20 tonnes.hr<sup>-1</sup>.



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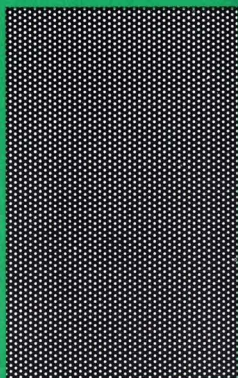
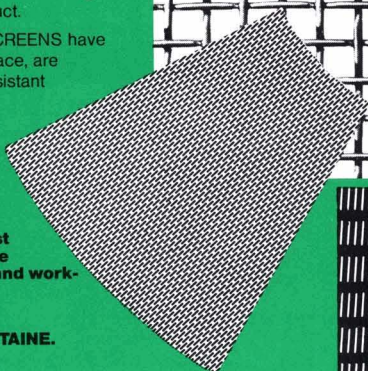
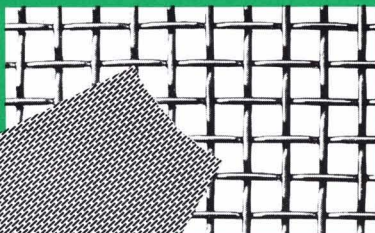
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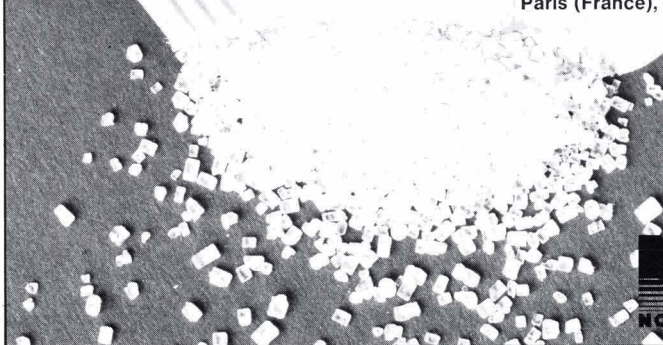
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# SUGAR REFINING

**Studies on desalting of sugar solution with ion exchange resin in a sugar refinery. I. Contamination of the I-type strongly basic anion exchange resin by desalting sugar solution in the reverse system.** F. Maekawa, K. Kawasaki, Y. Horiki and T. Saito. *Proc. Research Soc. Japan Sugar Refineries' Tech.*, 1978, 28, 78-85. **II. Restorative treatment on the I-type strongly basic anion exchange resin contaminated by desalting sugar solution in the reverse system.** K. Kawasaki, F. Maekawa and Y. Horiki. *ibid.*, 86-92 (Japanese).

I. Examination of resin fouling in the course of liquor demineralization on the reverse cycle showed that it was chiefly due to inorganic compounds such as magnesium oxide and silica, as well as colouring compounds, most of which were formed by alkaline decomposition of sugars in contact with the strongly basic anion exchanger in OH<sup>-</sup> form. Static investigations showed that the total capacity of all the resins studied fell by more than 20% in 50 cycles, their salt-splitting capacities being particularly affected. The degree of fouling depended on such factors as resin structure and reactivity, from which it is assumed that the best type is the porous resin having macro- and micro-pores; however, pore size and distribution considerably affect exchange capacity. It is suggested that a study should be made of resin suitability according to sugar solution properties, of means of preventing fouling, and of optimum restoration of resin properties after fouling.

II. Restoration of contaminated resin was investigated. Of four treatments studied, use of a 10% NaCl solution containing 1% NaOH was found to be the best with regard to organic fouling, while 4% HCl solution was the most effective against inorganic fouling; the other solutions tested were 10% NaCl with and without 1% HCl. Hence, the method adopted for resin restoration was treatment with the HCl followed by the NaCl + NaOH, both stages being carried out at 70°C.

**Decolorization of sugar solution by a new ion exchange resin.** K. Sasaki, T. Naito and K. Tsukui. *Proc. Research Soc. Japan Sugar Refineries' Tech.*, 1978, 28, 39-46 (Japanese). — A new resin, "Ionac 3AS", was tested at the authors' refinery on 62° Bx liquor decolorization in 1976. The results of the tests (up to 35 cycles) are reported. While the effluent from the early stages of the cycle had the fishy smell of amine, in later stages this was not apparent. The greater the initial colour content of the liquor, the greater was the amount of colour removed by the resin. The average decolorizing capacity was high, even with 35 cycles, the treated liquor: resin volume ratio being 40:1. The decolorizing efficiency (84% in the initial cycle) was almost the same as that of other low cross-linkage resins such as "Amberlite IRA 401" and "Dia Ion SA-11A". Since "Ionac 3AS" is of smaller particle size than these other two resins, there was some loss of resin during back-washing at a "normal" flow rate; flow rate was limited when a high-

concentration liquor was being treated. Further tests are to be carried out to determine, among other things, the effect of regeneration with HCl on the chemical and physical properties of the resin.

**A maintenance management system of steam traps.** K. Nakazato and E. Fuwa. *Proc. Research Soc. Japan Sugar Refineries' Tech.*, 1978, 28, 47-51 (Japanese). As a contribution to fuel economy, a system of steam trap inspection and maintenance was introduced at the Tobata refinery of Meiji Sugar Mfg. Co. Ltd. From inspection of the traps in each process station, a damage rate of 22.3% was found; relating this to the inspection cycle showed that an inspection should be made every six months in order to keep the damage rate low at 5%. The monetary losses resulting from faulty steam traps are shown, and a graph is presented which shows the financial effect of inspection and repair frequency.

**Treatment of waste water from a sugar refinery by the activated sludge process.** K. Akiyama and M. Okada. *Proc. Research Soc. Japan Sugar Refineries' Tech.*, 1978, 28, 52-60 (Japanese). — Details are given of the activated sludge process adopted at the authors' refinery in 1974 in answer to local authority regulations relating to effluent discharge into the harbour at Kobe. Results include a 94% COD reduction to a level of 20 mg.litre<sup>-1</sup> or less (the average daily level stipulated in the regulations), even when the initial loading was 3000 mg.litre<sup>-1</sup> suspended solids. An excess sludge quantity of 720 kg.day<sup>-1</sup> occurred as suspended solids. The treatment effluent temperature was maintained at 20-30°C by the use of coolers. The running costs of the system designed to handle 3500 m<sup>3</sup> per day, are indicated.

**Applications of flocculants in the carbonatation refining process.** F. M. Runggas. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 118-122. — See *I.S.J.*, 1979, 81, 184.

**The activation of bone charcoal by thermal and chemical treatment. I. The effect of high kiln temperature on bone charcoal structure.** J. C. Abram and M. C. Bennett. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 1-18. — It had been concluded from work by the Bone Char Research Project<sup>1</sup> that, because of severe loss of B.E.T. nitrogen surface area on heating of char above 550°C, the optimum temperature for kilning char was 500°C for colour removal. It was subsequently found that decolorization activity of a nearly new char kilned at about 630°C was extraordinarily high, and this also occurred with fine grist char at Thames, kilned at 750°C, provided it was washed with water or NaOH solution afterwards. The effects on char structure of heating at temperatures between 400 and 1000°C were therefore studied using electron microscope examination, X-ray diffraction, gas adsorption measurements of surface area, mercury porosimetry, nitrogen desorption and gas phase density determinations, as well as absorption from solution to measure area changes in the hydroxyapatite and carbon components. The improvement was found to be associated at above 700°C with formation of lime, perhaps by loss of CO<sub>2</sub> from calcium carbonate present as part of the char structure or as carbonatation precipitate. A marked change in structure occurred with decreases in total and apatite surfaces and in carbon content (but with no change in carbon surface area), but these probably did not affect decolorization activity, the increase in which is probably due to the gain observed in the number of pores of 40-100 nm diameter.

<sup>1</sup> *Tech. Rpt.*, 1960, (56); 1961, (60).

# LABORATORY STUDIES

**Application of gas chromatography in a preliminary investigation into changes in some non-sucrose constituents during sugar boiling.** P. G. Morel du Boil and K. J. Schäffler. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 96-105.—A description is given of a gas-liquid chromatographic method for determining sucrose, dextrose and levulose in sugar factory products. The samples are first treated with sodium benzoate to dissolve the sugars, and oximation carried out in the presence of dimethyl-amino-ethanol (added to hydroxylamine hydrochloride just before use). Silylation is performed by addition of hexamethyldisilazane and trifluoroacetic acid, and GLC separation then carried out, using xylose as internal standard for the monosaccharides and trehalose for sucrose. Full details are given of the quantities involved. Comparison of this oximation-silylation procedure, using temperature programming and applied to 30 samples of syrup and molasses, with direct silylation under isothermal conditions showed no significant difference, while the direct silylation method often presents difficulties in quantitative evaluation because of production of a large number of overlapping anomeric peaks by dextrose and levulose. Application of the modified method to determine the fate of the two monosaccharides in the boiling house, using chloride as reference for direct comparison of the syrup and molasses streams, showed that there was a seasonal trend in the levulose:dextrose ratio in molasses; reducing substances other than the monosaccharides are formed during boiling house operations, increase in the levulose:dextrose ratio being mainly due to a loss of dextrose. Amino-nitrogen levels fell between syrup and molasses, although there was no apparent seasonal trend. An increase in optically active substances between syrup and molasses was also found. A tentative correlation was established between pol and sucrose, dextrose and levulose contents.

**Some factors affecting the performance of polyacrylamide flocculants in juice clarification.** G. S. Shephard. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 106-112.—Laboratory studies were conducted on polyacrylamide flocculants of different degrees of hydrolysis (DH) to determine the effect of preparation of the polymer solutions on clarification efficiency. While a flocculant concentration below 0.05% led to a rapid decrease in efficiency, above this concentration a constant settling rate was observed, although variations in concentration appeared to have no effect on turbidity or final mud volume. Flocculant solution pH and ionic strength also affected only the settling rates, the effect of pH being governed by the DH. While water of high ionic content should be avoided, since this caused a fall in settling rate, there was little advantage in using distilled or deionized water in place of tap water, since the quantity of dissolved ionic species would have to be raised considerably before there was any significant decrease in efficiency. Solution equilibrium was attained after 2

hours, while further agitation did not bring any improvement in settling rate. The flocculant of low (30%) DH ("Superflox A110") increased the initial settling rate with increase in the quantity of phosphate precipitated to a maximum at 360 ppm, after which it was almost constant to 400 ppm, while the flocculant of intermediate (45%) DH ("Superflox A130") gave maximum initial settling rate at 270 ppm  $P_2O_5$  precipitate, after which the rate fell. The flocculant of high (60%) DH ("Superflox A150") gave a much lower initial settling rate which remained almost constant over the entire range of phosphate precipitation. As regards turbidity, all three flocculants fell to relatively close minima at 300 ppm phosphate, after which the turbidities remained constant. The calcium concentration in the limed juice also had varying effect on the flocculant efficiencies, the turbidity values and the pattern of the turbidity curves being very similar to those for phosphate precipitation effect, while mud volume was constant after 200 ppm  $Ca^{++}$  with the flocculant of lowest DH, rose slightly with that of intermediate DH and rose more markedly with the flocculant of highest DH.

**Sugar entrainment monitoring.** K. J. Schäffler. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 123-124.—The flame photometric method described by Dale & Lamusse for on-line evaporator and vacuum pan entrainment monitoring<sup>1</sup> is considered to have a number of disadvantages which are listed. However, a technique has been devised at Hulets Sugar Ltd. in which sucrose is inverted in the presence of a solution of resorcinol in HCl at 95°C and the levulose reacts with the resorcinol to form an orange coloured compound which is measured at 520 nm. Ferric sulphate serves as sensitizer and cancels out any iron interferences. While continuous monitoring using the method still suffered from a number of serious drawbacks, the problems were overcome by using sequential automatic analysis. Flocculation is necessary because of the turbid nature of condenser and other factory waters, but treatment with basic lead acetate solution produces a water-white solution having 95-97% transmission at 514 nm. A Technicon AA II auto-analyser installed in the Research & Development Dept. of the company analyses samples from five raw sugar factories at the rate of 30 per hr.

**An improved method for the determination of soil "available" phosphorus.** J. R. Burrows. *Proc. 52nd Congr. S. African Sugar Tech. Assoc.*, 1978, 195-199.—Details are given of a modification of the Murphy & Riley method for determination of available P in soil<sup>2</sup>, based on use of a 12-molybdoantimonylphosphate complex; the method has been adapted for automatic routine analysis using a LKB 2071 sample processor and a LKB 7400 calculating absorptiometer. Colorimetric measurement of orthophosphate by the new method gives results comparable to those given by the Dickman & Bray method<sup>3</sup>, while use of the automatic analyser saves 7 man-hours per 200 samples.

**Theoretical aspects of detection of sugars in high-pressure liquid-chromatographic systems by polarimetry and refractometry.** G. B. Cox and I. K. O'Neill. *UV Spectrom. Group Bull.*, 1977, (5), Suppl., 64-70; through *Anal. Abs.*, 1978, 35, Abs. 3C16.—Because of the problems arising in the U.V. detection of sugars, optical rotation is

<sup>1</sup> *I.S.J.*, 1978, 80, 180.

<sup>2</sup> *Anal. Chim. Acta*, 1975, 6, 95-112.

<sup>3</sup> *Ind. Eng. Chem., Anal. Ed.*, 1940, 12, 665-668.



proposed as an alternative detection principle for carbohydrate analysis. The theory of polarimeter and chromatographic sensitivity is discussed and consideration given to the problems of cell volume, time constant, sensitivity and temperature effects; optimum instrument parameters are derived mathematically. By comparison with the response of the refractive index detector, that of the polarimeter is assessed to be slightly less sensitive but less affected by variations in temperature and eluant composition.

**Gas-chromatographic determination of di- and trisaccharides.** H. Schwind, F. Scharbert, R. Schmidt and R. Kattermann. *J. Clin. Chem. Clin. Biochem.*, 1978, **16**, (2), 145-149; through *Anal. Abs.*, 1978, **35**, Abs. 3C18. Three methods are discussed. In the first, the sugars are converted into their methoximes and acetylated with acetic anhydride; then the resulting derivatives are subjected to GLC at 260°C on OV-225, with gentiobiose as internal standard. Monosaccharides can also be determined by this method, with use of an ECNSSM column at 190°C. The second method involves reduction with NaBH<sub>4</sub> and acetylation of the resulting alditols with acetic anhydride; GLC is then carried out as in the first method, but trehalose is used as internal standard. With use of temperature programming, the derivatives of monosaccharides, amino-sugars and disaccharides can be separated on the same column. In the third method, methoximes formed as in the first method are trifluoroacetylated; derivatives of disaccharides can be separated on OV-101 at 130°C, with trehalose as internal standard, and those of trisaccharides on the same column at 160°C, with raffinose as standard.

**Notes on control and sugar balance.** E. David. *ATAC*, 1977, **36**, (6), 51-53 (*Spanish*).—The author discusses the significance of new equipment and techniques employed in sugar laboratories, including the use of the refractometer for Brix determination, balances based on the load cell principle, automatic saccharimeters, etc., all of these tending to eliminate human errors. A modern trend is to true sucrose balances instead of using polarization, especially in the case of molasses and intermediate products. Use of Clerget double polarization for sucrose and refractometric Brix produces much more accurate figures for sugar loss in molasses, and an example is quoted of how two different factories with "high" and "low" molasses apparent purities were in fact operating at comparable efficiency when the true purities were worked out. The use of continuous belt weighers for bagasse, together with weights of cane and maceration water, now makes it easier to calculate the weight of mixed juice by difference where juice scales are not employed.

**Colorimetric determination of reducing sugars in mixed juice, final molasses and raw sugar.** I. Díaz, M. Juanes and C. García. *ATAC*, 1977, **36**, (6), 57-65 (*Spanish*). Application of the colorimetric method for reducing sugars determination devised by Edson & Poe<sup>1</sup> has been studied for sugar industry products. To 2 cm<sup>3</sup> of a standard is added 6 cm<sup>3</sup> of 2,4-dinitrophenol solution in a basic medium comprising phenol, NaOH and Rochelle's salt, and the mixture heated in a boiling water bath for 6 minutes, after which it is immediately cooled and its absorbency measured at 420 nm. Standard solutions of 0.01-0.1% w/v of dextrose were employed and linear graphs prepared of absorbency vs. concentration. The effect of heating time was examined and absorbency

#### Laboratory studies

found to increase between 2 and 6 minutes, after which time it became constant. The colour was stable, no change in absorbency being observed during a period of up to 70 minutes after cooling. Replicate tests on mixed juice, molasses and raw sugar samples with two colour instruments demonstrated the precision of the technique, while recovery experiments showed values of 100-112% on the added dextrose. The values obtained are very similar to those given by the Eynon & Lane method, greatest differences being found with molasses. The cost of the analysis and the time taken are less for the colorimetric method than for the Lane & Eynon method, and it is recommended that the colorimetric method become the official method of the Cuban sugar industry.

**Fractionation of sugar colorants by high-pressure liquid chromatography.** N. H. Smith. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 19-34.—A high-pressure liquid chromatographic technique has been applied to fractionation of sugar colorants. In contrast to gel-permeation methods, which yield few colour peaks, the technique separates more than a dozen colorants, although these are not identified. Applications of the method are described to illustrate its usefulness; these include examination of colorant composition variation between individual raw sugars, the role of enzymatic browning in sugar colour, and the colorant composition of granulated refined sugar.

**A study of sugar inversion losses by high-pressure liquid chromatography (HPLC).** M. A. Clarke, M. A. Brannan and F. G. Carpenter. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 46-56.—The technique was applied to study of the decomposition of sucrose at pH levels between 2 and 10, at 20, 40, 60 and 80°C, over 1-20 days; measurements were made of sucrose, dextrose and levulose changes with time. The more rapid loss of levulose after formation, by comparison with dextrose, was observed. Dextrose concentrations were more readily and accurately followed, but the technique is not accurate enough to measure precisely the loss of sucrose.

**Determination of refined sugar proteins by polyacrylamide gel electrophoresis.** M. A. Godshall and E. J. Roberts. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 57-72.—The proteins in raw and refined sugars were separated by dialysis and individual proteins examined by means of polyacrylamide gel electrophoresis. Semi-quantitative measurement of the proteins separated was possible using a colorimetric method based on elution of the protein dye, Coomassie Blue R-250, from the gels. The quantities of protein found ranged from slightly more than 1 ppm in raw sugars to 0.011 ppm in refined sugar. The separated proteins were found to cause flocculation of indigenous sugar cane polysaccharide in sugar solutions. One protein class was reduced markedly by affination and carbonation and eliminated by char treatment, the other persisted to refined sugar but was largely reduced during refining, especially in the affination and crystallization stages.

**The role of charged particles in floc formation.** E. J. Roberts and M. A. Godshall. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 73-81.—It has been shown that all cane sugars contain a heterogeneous polysaccharide which is indigenous to sugar cane. This polysaccharide forms a colloidal solution which carries a

<sup>1</sup> *Anal. Chem.*, 1932, **4**, 300-302.

negative charge over a wide pH range. It was also shown that refined cane sugar contains protein which changes its charge from negative in alkaline and neutral solutions to positive in acid solutions. Combining solutions of the isolated polysaccharide and the isolated protein at low pH in the presence or absence of sugar results in floc formation. It seems reasonable, therefore, to conclude that the two materials are the basic factors in floc formation in acidified sugar solutions.

**Microbiology of sugar: a taxonomic study.** R. D. Skole, J. N. Hugu and A. B. Rizzuto. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 81-99.—A survey is presented of the various micro-organisms encountered in raw sugars of different origins received by Amstar Corporation refineries. The yeasts included *Saccharomyces cerevisiae*, *S. rouxii*, *S. mellis*, *S. cerevisiae* var. *ellipsoideus*, *S. carlsbergensis* and *Hansenula* spp., while the most common moulds were *Aspergillus* spp., with smaller numbers of *Penicillium* and other genera. Representative cultures of aerobic bacterial groups present were identified as *Bacillus stearothermophilus*, *B. brevis*, *B. coagulans*, *B. circulans* and *B. subtilis*. Aerobic mesophilic bacteria included *B. megaterium*, *B. subtilis*, *B. brevis*, *B. circulans*, *B. sphaericus*, *B. coagulans* and *B. polymyxa*, while the only anaerobic thermophilic bacteria encountered were *Clostridium nigrificans* and *C. thermosaccharolyticum*. A spore-forming anaerobic mesophilic bacterium was identified as *C. butyricum*, while an aerobic spore-forming bacterium was found to be *B. cereus*.

**Codex standards for sugars.** J. A. Hupfer. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 100-117. The work of the Codex Alimentarius Commission's Committee on Sugars in developing international standards for sugars is discussed by the Committee's US representative. Standards devised for 10 carbohydrate sweeteners are reviewed, including those for white sugar, powdered sugar and soft sugars. The current status of each standard and the progress made toward acceptance of Codex standards in the USA are noted.

**Determination of cadmium, zinc, lead and copper in refined sugar by an electroanalytical technique.** R. Cormier, L. H. Mai and A. D'Antico. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 162-174.—The determination of metal elements in sugar products usually requires tedious preparations which may give rise to a loss of accuracy in the results. Use of a differential pulse anodic stripping voltammeter, coupled with a rotating mercury film electrode, may overcome this problem. Such analysis can be done, down to a sub-ppb level, without any prior ashing, ion exchange or other similar treatment.

**Raw sugar quality analyses, from 1968 to 1976, at the New York Sugar Trade Laboratory.** W. Altenburg. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 175-182.—The moisture, ash, colour, grain size and polarization of more than 500 raw sugar samples are measured at the New York Sugar Trade Laboratory each year, and the averages of the values obtained each year from 1968 to 1976 are recorded and discussed.

**Raw sugar quality standards.** J. V. Lopez-Oña. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 195-213.—The No. 10 contract standards (for grain size,

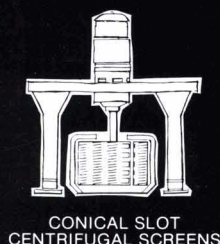
colour, ash and safety factor) were introduced in 1968, and the author discusses the variations in raw sugar quality, as defined by the standards, of cargoes received by the National Sugar Refining Co. in Philadelphia. The numbers of premium and penalty cargoes (*i.e.* above and below standard) received in 1974 and 1975 are analysed. The author questions the value of the safety factor or moisture standard.

**Ten year trend in raw sugar analysis.** Anon. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 214-224. Graphical records are presented of the characteristics of raw sugar refined by BC Sugars since 1966; in the first half of this period they were mainly from Fiji and in the second half mostly from Queensland, while sporadic cargoes came from other origins, and their data are recorded separately.

**Cane payment on a sucrose content basis.** N. A. da Gloria, J. F. G. Pereira and A. A. Rodella. *Saccharum* (STAB, Brazil), 1978, 1, (1), 15-25 (Portuguese).—A study on sampling and analytical methods necessary for introduction of a cane payment system based on sucrose analysis began in Alagoas in 1972/73 but was extended to São Paulo on the institution of Planalsucar. The paper is a summary of work carried out in Brazil to date, with reference included to work in other countries; it is appreciated that, with the National Alcohol Programme, the prices of sugar and alcohol are the same, so that use of cane for either is equally economical and this may affect the conclusions reached as regards cane analysis and payment. Studies have been made on sampling, especial reference being made to use of the core sampler, and the digestion and press methods for cane analysis are described, with a table showing the effect of fibre content on pol % cane. Core sampling followed by the more rapid press juice extraction is recommended because of the practice of cane storage at the factory for night crushing. Development of formulae for calculating pol % cane and the cane value are discussed, and it is recommended that the system be adopted in Brazil in order to encourage maximum sugar production per unit area.

**Method for assessment of sugar cane quality.** A. P. Gupta. *Indian Sugar Crops J.*, 1977, 4, 87-88.—A method for estimation of pol % cane, based on analysis for pol % juice and pol % bagasse, and a procedure for determining fibre % cane are described.

**Interaction of surface-active agents with sucrose molecules in aqueous solutions.** N. S. D'yachenko. *Ukrain. Khim. Zhurn.*, 1978, 44, 995-996 (Russian).—Nuclear magnetic resonance was used in a study of the interaction between surfactants and sucrose molecules in sucrose solutions of 10, 20, 30, 40 and 50% concentration to which 0.03, 0.06 and 0.09% cetyl trimethylammonium bromide was added. With increase in the sucrose concentration (in the absence of surfactant), the sucrose-water reaction becomes stronger than that between sucrose molecules, as indicated by a shift in the NMR signals of the water protons to a stronger magnetic field. When a surfactant is introduced, the energy of the water molecules bound by the hydrogen bonds to the sucrose molecules becomes dissipated by the dispersive interaction between the surfactant and the sucrose. The water molecules are then replaced by surfactant molecules. Hence, the surfactant is adsorbed by the sucrose and the latter becomes hydrophobic.



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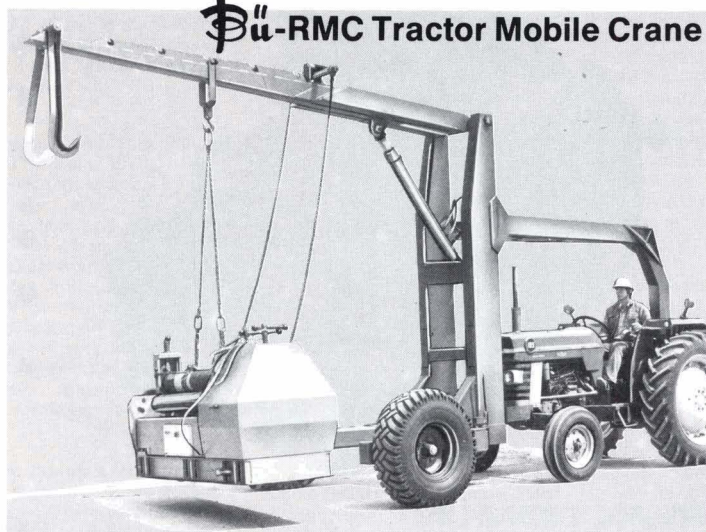


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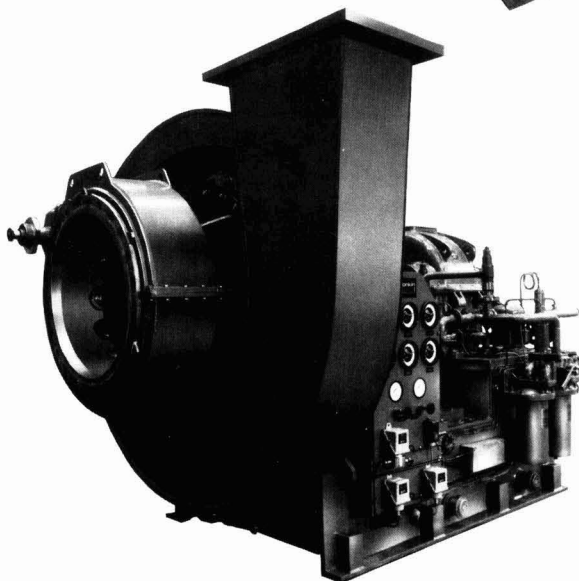
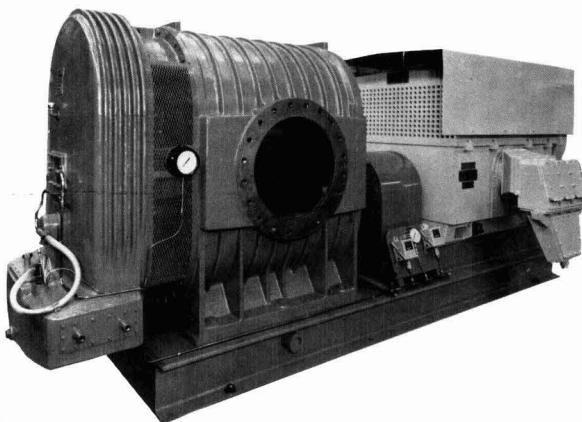
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# BY-PRODUCTS

## Commercial manufacture of citric acid by fermentation.

**III. Effect of fermentation conditions and different growth media on citric acid production by *Aspergillus niger*.** P. K. Agrawal, C. S. Bhatt and L. Viswanathan. *Sharkara*, 1975, 14, (3), 3-14. — A local strain of *A. niger* was isolated and cultured under controlled conditions, after which spore suspensions were grown on various media. Investigation of the effects of fermentation parameters on citric acid production showed that maximum yield after 7 days was obtained with a Doelger & Prescott medium (prepared from  $\text{NH}_4\text{NO}_3$ ,  $\text{KH}_2\text{PO}_4$  and  $\text{MgSO}_4$ ) in which the sucrose concentration was 14%. Increase in the sucrose content to 20% increased mycelial growth and energy production rather than citric acid yield up to 7 days, after which it resulted in a much greater quantity of citric acid (54.06 g.cm<sup>-3</sup> after 14 days) than did 14% sucrose (47.94 mg.cm<sup>-3</sup>). Other media gave much lower yields, while both clarified and unclarified molasses were found to be unsuitable. Optimum pH of the medium was 2.0 and optimum temperature 25°C. Surface fermentation gave much more citric acid with the Doelger & Prescott medium than did submerged fermentation.

**GH2 pulp presses at Sárvár sugar factory.** G. Katics. *Cukoripar*, 1978, 31, 70-73 (Hungarian). — Information is given on the GH2 vertical pulp presses at the author's sugar factory which are manufactured in East Germany under licence from Selwig & Lange Maschinenfabrik. Some performance data are given.

**Alcoholic fermentation.** C. J. Franco. *Proc. Symp. Industrialization Sugar Cane* (STAB, Brazil), 1978, 16 pp (Portuguese). — Aspects of alcoholic fermentation are discussed, including selection of the yeast to be used, initiation of fermentation and the desirability of running two parallel fermentations in case of accident which interrupts one, preparation of dilute must and maintenance of reducing sugars content for continuous fermentation, mineral nutrition, industrial multiplication and prevention of infection, and preparation of the yeast suspension. Factors which interfere with fermentation are reviewed, as is the control of temperature, and the analyses needed for fermentation control, as well as determination of the sugars fermented and alcohol produced.

**Preparation of juice for alcohol manufacture.** L. A. R. Pinto. *Proc. Symp. Industrialization Sugar Cane* (STAB, Brazil), 1978, 10 pp (Portuguese). — Fermentation of a must is most efficient if the feed is maintained with optimum characteristics, i.e. sterile, at between 28 and 30°C and from 18 to 20°Bx with 15-16% reducing sugars. This contrasts with the variability of raw material, viz. juice of between 6 and 20°Bx and molasses of between 80 and 85°Bx. The molasses may be diluted with various other materials or mixtures of e.g. clarified

juice, water, last mill juice, filtrate, etc., to give the desired characteristics; the last two are most favoured, since they can lead to problems in sugar manufacture but do not have any harmful effect on fermentation. A flow diagram of the process used for alcohol manufacture at Usina Santa Lydia is presented and discussed, and the results of operation are tabulated.

**Concentration of vinasse.** L. P. de Biase. *Proc. Symp. Industrialization Sugar Cane* (STAB, Brazil), 1978, 6 pp (Portuguese). — Vinasse is used widely in Brazil as a fertilizer but it is recognized as being ecologically harmful. At Usina Santa Elisa a plant has been installed for concentration of 70 tonnes.hr<sup>-1</sup> of vinasse from 6° to 60°Bx. The plant, its operation and automatic control are described and the advantage discussed of being able to dispose of the vinasse as a non-polluting fertilizer and as an animal feed supplement.

**Cost of sugar and direct alcohol parity.** P. B. Neto. *Proc. Symp. Industrialization Sugar Cane* (STAB, Brazil), 1978, 22 pp (Portuguese). — At Usina da Pedra, in the 1977 season, 795,962 tonnes of cane were crushed for sugar manufacture while 403,634 tonnes were used for the direct production of alcohol, the latter also being produced from molasses. Using the detailed figures from the season, an economic examination is made and graphs produced to find the break-even points in terms of sugar and alcohol production.

**Saccharification of bagasse pith.** C. I. Nee and W. F. Yee. *J. Appl. Chem. Biotechnol.*, 1977, 27, (12), 662-666; through *S.I.A.*, 1978, 40, Abs. 78-1034. — Laboratory-scale experiments are described. On the basis of previous tests, a process for hydrolysis of pentosans was devised, in which bagasse pith was treated with 2%  $\text{H}_2\text{SO}_4$  in an autoclave at 125°C. The average pentose concentration in the hydrolysate was 3%, and total pentose yield was 93.2% of the theoretical. An improved process for hydrolysis of the pentose-exhausted cellulosic residue to glucose was developed. The residue was milled with 3.5-4.0 parts 41-43% HCl at 25-30°C for 4-15 hours. HCl was distilled off under vacuum; the solution was diluted and heated at 100°C for 3 hr to convert the oligosaccharides to glucose, and the lignin was then separated by means of a suction filter. Under optimum conditions, the glucose yield reached 91.9% of the theoretical, and >90% of the HCl was recovered. It is stated that it would be easy to crystallize glucose from the solution, which was of high purity.

**Analysis of fatty acid esters of sucrose by means of HPLC.** R. Cormier, L. H. Mai and P. Pommeze. *Proc. 1976 Tech. Session Cane Sugar Refining Research*, 35-45. — High-pressure liquid chromatography has been applied to the separation and determination of individual sucrose fatty acid esters, including the complex of esters formed by esterification of sucrose with tallow.

**Cane diffuser for autonomous distilleries.** C. Ebeling. *Brasil Açuc.*, 1978, 91, 249-257 (Portuguese). — Application of a diffuser to production of cane juice for direct fermentation to alcohol is discussed. It is possible to eliminate separate liming, heating, clarification and filtration of juice as normally carried out after milling, since these processes can be embodied in the diffuser operation, while losses are also lower than in a mill, and it is calculated that an additional 540 m<sup>3</sup> of alcohol would be produced from a distillery processing 2000 tcd over a 150-day season.

# TRADE NOTICES

**New silo discharger.** Bowerhill Engineering Ltd., Lysander Road, Bowerhill, Melksham, Wilts., SN 12 6SP, England.

A new discharger from Bowerhill Engineering is designed for installation in flat-bottomed silos or storage vessels. It can be fitted to round or square units up to 12 metres in diameter and is suitable for silos with capacities up to 2500 tonnes. A drive mechanism is housed within a triangular cross-beam over the floor of the silo, supported at each end, and permits a screw auger to rotate around the base area, drawing material to the centre of the silo for discharge through an aperture onto a cross conveyor. Deflectors over the outlet prevent any gravity flow of the silo contents. The rate of extraction may be varied by remote control.

**Self-optimizing weigher control.** Richard Simon & Sons, Park Lane, Basford, Nottingham NG6 ODT, England.

A new self-optimizing control facility has been devised which, when fitted to Simon high-speed gravity and belt-feed net weighers, ensure that product "give-away" (to ensure compliance with minimum net weight legislation) is kept to a minimum and that containers are packed to finer limits. The controller has two separate sections, encased in a lockable, sealed cabinet containing the basic weighing function and the correction unit. A compact and ultra-precise load-cell is used to transmit to the basic weighing portion of the controller the weight required; when accurate weightment has been achieved, the controller cuts off the feed in, discharges the load and restarts the filling cycle.

The correction unit acts as an in-built checkweigher but with one important advantage; the checkweigher detects any tendency of the weightments to vary from the desired weight and feeds back corrections to the basic weighing section to have effect on subsequent weightments. This completely automatic function allows the weigher to cope with changes in material density, etc., and with dust build-up on the weigh pan. An optional print-out facility is available to monitor weightments.

## PUBLICATIONS RECEIVED

**Serving the sugar industry.** VEB Chemiefabrik Stassfurt/Kombinat, Atzendorfer Strasse 19, DDR-325 Stassfurt, East Germany.

Descriptions are given of sugar factory equipment manufactured by VEB Maschinenfabrik Sangerhausen, an enterprise of the VEB CAS/Kombinat. The range includes plant for automatic beet sampling, sample washing and analysis for sugar, wet unloading of beet, a beet slicer, pulp press, filters, lime kiln, vacuum pans, crystallizers, distribution troughs, sugar screens, waste sugar pans and pulp drying and pelleting units.

**High-pressure water jetting.** — One of the latest applications of high-pressure water jet equipment manufactured by Harben Systems Ltd., of Salisbury, Wiltshire, England, is maintenance of asbestos roofing material at sugar factories in the West Indies in a clean and white state so as to attain maximum possible reflection of sunlight and thus minimize the working temperature within the factory. Marine and Industrial Cleaners Ltd., of Bridgetown, Barbados, have been appointed as distributors.

**Power transmission and conveying components.** Rexnord Inc., P.O. Box 2022, Milwaukee, WI 53201, USA.

A 624-page catalogue from Rexnord gives detailed descriptions and product index of the company's power transmission and conveying components, including chains and sprockets, roller bearings, shaft couplings, belt conveyor idlers and spray nozzles, as well as bucket and apron elevators, apron feeders and belt conveyor trippers. Apart from specification information, the catalogue covers product applications and, maintenance procedures, and contains selection and rating charts plus various engineering data.

## PUBLICATIONS RECEIVED

**Sugar factory process automation.** Fischer & Porter GmbH, Postfach 701, D-3400 Göttingen, Germany.

A paper presented at the Spring Meeting of the Yugoslavian Sugar Association and Yugoslavian Sugar Institute in 1978 has been reproduced as a special bound version. Written by Hans Kemter, Sales Director of Fischer & Porter GmbH, it is concerned with the trends in automation within the sugar industry, as exemplified by Appeldorn and Wevelinghoven sugar factories in West Germany. Fischer & Porter equipment described in connexion with Appeldorn includes the SIGMA 4000 process control system, electromagnetic flowmeter, liquid vortex flowmeter, differential pressure transmitter, instruments for continuous measurement of process variables and control components; at Wevelinghoven, boiling is automatically controlled by the Fischer & Porter rheometer system involving a DCI 4000 microcomputer. Some 150 automatic rheometer boiling systems are at present in operation. The article is well illustrated.

**Liquid level switches.** Delaval Turbine GmbH, D-6361 Reichelsheim 4, Germany.

A recent brochure from Delaval Turbine GmbH gives details of "Gems" liquid level switches, available as metallic and non-metallic types, single- or multi-level stations, with floats of various materials.

**BAI activities.** Booker Agriculture International Ltd., Bloomsbury House, 74/77 Great Russell Street, London WC1B 3DF, England.

A colourful 24-page brochure describes BAI activities in the field of agricultural management, consultancy and technical services. Since 1964 assignments have been undertaken in more than 50 countries, and information is given to demonstrate the type of work entailed in such assignments, including those of a continuing nature.

**Queen's Award for the "Talofloc": process.** — A presentation of the Queen's Award for Technological Achievement was made on September 24 at the Bromley headquarters of Tate & Lyle Agribusiness by H.M. Lord Lieutenant of Greater London, the Right Hon. The Baroness Phillips. The Award was accepted on behalf of TALO Products and Processes, a division of Tate & Lyle Process Technology Ltd., by Dr. Michael Bennett, Chief Executive. Also attending the ceremony were the Mayor of Bromley, Earl Jellicoe (Chairman, Tate & Lyle Ltd.) and Saxon Tate (Group Managing Director, Tate & Lyle Ltd.) as well as other senior directors of the parent company. The Award was made for inventing and pioneering the "Talofloc" process for removing impurities in the refining of raw sugar. It involves the use of a non-toxic, sparingly soluble surfactant that enables colour to be removed quickly and economically by a simple chemical process. The precipitated coloured impurities can be separated by flotation, an operation which is much quicker than sedimentation and uses much less equipment than filtration. Tate & Lyle Engineering has obtained US Food and Drug Administration approval for the "Talofloc" process. It has been adopted in 26 countries and there are 78 operating licensees; approximately 25% of the world's refined cane sugar is now made with its aid while it is incorporated into the majority of new refineries being built. Since the first commercial operations in 1970, annual turnover has grown to over £2,000,000. Recognition of the Company's achievement in the form of the Queen's Award, said Dr. Bennett, leader of the team which pioneered the development, has given the process a distinction much appreciated in overseas markets and has contributed significantly to increased recent interest.

*Statements published in this section are based on information supplied by the firm or individual concerned. Literature can generally be obtained on request from the address given.*

# BREVITIES

**A/S De Danske Sukkerfabrikker Annual Report 1978/79.** Because the EEC is not a member of the ISA but Norway is, the traditional supplies of sugar by Denmark to that country have had to be on a basis of the refining of raw sugar originating from ISA member countries. Should a working relationship between the EEC and ISA signatories be worked out for the new sugar regime after July 1980, Danish sugar will again have free access to Norway, but reductions in sugar production and free market exports will be necessary. During 1978 drought and low temperatures hindered germination of the beet seed, and the wet, dull summer and autumn gave a low sugar content. Only 352,000 of the contracted 365,000 hectares was harvested, and the contracted area offered for 1979 has been reduced to 353,000 ha. Of the 352,000 tonnes of sugar produced in the 1978/79 campaign, domestic consumption took 200,000 tonnes, the balance being exported to Britain, the Faroes, Iceland, West Germany, etc., as well as the refined re-exports to Norway. Investments in the factories are for increasing efficiency and no capacity increases are planned. Capital is also being spent on environmental protection. Reduced beet area and so beet seed requirements in Spain have been compensated by increased sales in Italy, while the sugar machinery division has received an order for a complete cane sugar factory in Vietnam, among other plant sales. Membrane filtration and ultrafiltration equipment sales have developed well.

**Guyana crop data 1978.** — Tabulated data published by the Guyana Sugar Corporation Ltd. show that a total of 4,218,302 long tons of cane were crushed in 1978 as against 3,108,378 tons in 1977 and 4,037,314 tons in 1976. Pol % cane was lower than in 1977 and markedly lower than 1976 (9.71 vs. 9.78 and 10.12%) and sugar production was 324,805 tons against 241,527 tons in 1977 and 332,457 tons in 1976. Lost time through strikes was only 3.50% of gross crushing time, against 24.82% in 1977.

**Cuban cane harvest 1978/79<sup>1</sup>.** — Further to the Cuban sugar production figures previously reported<sup>2</sup>, details of harvesting and processing performance have become available. Chopper-type cane harvesters are said to have cut 44% of the cane crushed, the average daily output per machine reaching 92 tonnes, about 3.5 tonnes more than in 1977/78. Machine efficiency fell short of the plan by 25%, mainly because of stoppages due to breakdowns, rain and organizational shortcomings. 300 more machines worked in the harvest than in the previous one. Some 38% of the cane was handled green. Lost mill time due to breakdowns and other operating stoppages was reduced to 7% in 1978/79 against over 19% in the 1971 harvest. Some 180,000 hectares of new cane were reportedly planted during January — May 1979, 18% short of the target but over 30,000 ha more than in the corresponding months of 1978. Although it is not likely that a further 60,000 ha would have been planted in June, to meet the target, the relatively high renewal rate achieved indicates a substantial area of comparatively high-yielding plant cane will be available for harvesting in 1979/80. Attention to the ratoons is also reported to have improved, some 1,450,000 ha having been cultivated or over 330,000 ha more than at the corresponding date in 1978. Compared with 1978, an additional 20,000 ha has received compound fertilizer and about 46,000 ha more has received nitrogen. Given reasonable weather, these preparations point to another bumper Cuban crop in 1979/80.

**Early ripening cane varieties in India<sup>3</sup>.** — Three new early maturing varieties have been developed at the Sugarcane Breeding Institute, Coimbatore, and allocated the numbers CoC 607, CoA 7601 and Co 7201. They reach peak ripeness in eight months with a slight decline in sucrose after the ninth month, and could therefore permit growth of three crops in two years. The varieties will yield as much as 169-221 tonnes of cane per hectare with 18-19% sucrose in juice of 90% purity, giving 20-27 tonnes of sugar per hectare. By contrast, the late-maturing variety Co 6304 reaches 16% sucrose and 85% purity juice at 12 months with yields of 210 tonnes of cane.

## South Korea sugar imports and exports<sup>4</sup>

	1978	1977	1976
	tonnes, raw value		
<b>Imports</b>			
Australia	281,098	298,468	179,751
Brazil	15,180	0	0
Peru	13,350	0	0
Philippines	37,120	5,976	0
South Africa	35,552	0	0
Taiwan	134,650	121,877	98,600
Thailand	39,772	2,093	34,785
	<u>556,722</u>	<u>428,414</u>	<u>313,136</u>
<b>Exports</b>			
Egypt	0	0	11,932
Hong Kong	69,176	55,723	35,056
Indonesia	36,887	9,000	5
Iraq	0	0	10,739
Jordan	0	9,750	11,936
Kenya	0	0	542
Kuwait	0	0	9,947
Spain	0	11,420	0
USA	976	200	868
	<u>107,039</u>	<u>86,073</u>	<u>81,025</u>

**Dominican Republic sugar crop damage.** — Hurricane David caused devastation in the Dominican Republic at the end of August, with many dead and thousands made homeless. Between 15 and 20% of the 1979/80 sugar crop is estimated to have been destroyed. Heavy rains in June and July had flooded plantations, washed away bridges and damaged roads and railway lines, bringing the 1978/79 cane harvest to a premature end, with a production of some 810,000 tonnes, 100,000 tonnes less than the target<sup>5</sup>. The average sugar content of the cane fell from a normal 11-12% to about 8-9½%. The Consejo Estatal de Azúcar incurred losses of 26.8 million pesos in 1976/77, 43.0 million pesos in 1977/78 and estimates losses of 25-30 million pesos for 1978/79. The CEA is arranging a ten-year loan equivalent to \$90 million from a group of international banks.

**Kenya project for alcohol from molasses<sup>6</sup>.** — Kenya Chemical and Food Corporation has embarked on a project to convert the molasses made by Kenyan sugar factories into power alcohol for incorporation in motor fuel. The estimated cost of the complex, to be built near Kisumu in Western Kenya, will be 550 million shillings. When in full production the project will provide 20 million litres of power alcohol, 30,000 tonnes of citric acid, 18,000 tonnes of bakers' yeast and about 2 million litres of vinegar annually. The citric acid and yeast will be sufficient to meet the entire needs of the country and give a sizeable surplus to be exported.

**Indonesia sugar production<sup>7</sup>.** — Almost all of Indonesia's 58 sugar factories were built in the late 19th and early 20th centuries. The industry, which had produced more than 3 million tonnes in the early 1930's was badly damaged during World War II and, although the cane area was increased after the war, low yields meant that sugar production did not increase. As a result of measures adopted by the government, sugar production is gradually recovering and is expected to reach 1.45 million tonnes in 1979/80 against 1.3 million tonnes in 1978/79. Five new sugar factories have been built since the war and a sixth was due for completion at Jatitujuh at the end of June, with a capacity of 4000 t.c.d. Expansion and modernization programmes for nine other factories have raised their combined capacities by 16,750 t.c.d. while there are plans to rehabilitate two more.

<sup>1</sup> F.O.Licht, *International Sugar Rpt.*, 1979, 111, 497.

<sup>2</sup> *I.S.J.*, 1979, 81, 257.

<sup>3</sup> *Indian Sugar*, 1979, 28, 739.

<sup>4</sup> *I.S.O.*, through C. Czarnikow Ltd., *Sugar Review*, 1979, (1458), 187.

<sup>5</sup> *Bank of London & S. America Review*, 1979, 13, 560.

<sup>6</sup> *Standard Chartered Review*, September 1979, 10-11.

<sup>7</sup> *World Sugar J.*, 1979, 2, (3), 16, 26.

## Sudan sugar imports<sup>1</sup>

	1978	1977
	tonnes, raw value	
Argentina	11,305	0
Brazil	31,250	79,758
China	0	11,226
Cuba	10,500	0
Czechoslovakia	23,300	0
EEC	72,850	5,435
Egypt	0	3,473
Germany, East	3,900	0
Greece	0	2,717
India	67,088	34,837
Korea, South	0	35,218
Portugal	0	5,163
	220,193	177,827

**Jamaica sugar crop reduction<sup>2</sup>.** — Jamaica's sugar production seems likely to fall below its original production target of 350,000 tonnes by roughly 84,000 tonnes, largely as a result of adverse weather conditions, according to the Sugar Industry Authority. Heavy rains also affected juice quality and increased the TCTS ratio from 10.2 to 14. Smut and rust diseases were other factors contributing to the shortfall, reducing cane production by as much as 30% in some fields. In 1978, a prolonged strike and heavy rainfall in some areas led to an output of not more than 307,000 tonnes, substantially below that year's target also of 350,000 tonnes.

**Papua-New Guinea sugar project.** — Booker Agriculture International has been appointed by the Independent State of Papua-New Guinea to establish a domestic sugar industry at Gusap in the Ramu Valley in the northern mainland. The development will be undertaken by Ramu Sugar Holdings Ltd. and will involve an estate of 6000 ha of rain-fed sugar cane and construction of a factory to produce 40,000 tonnes of mill white sugar per annum, together with estate roads, housing, ancillary buildings and services. The project is estimated to cost some \$100 million and is due to start commercial production in 1983.

**Chemviron award 1980.** — Chemviron S.A. created its award for outstanding contributions to the study of water treatment as it relates to environmental health. The prize — a cash award of \$10,000 plus a commemorative medal and certificate — is awarded every second year. It is limited to papers originating in Europe and to the area of physico-chemical treatment of potable and waste water, with candidature open to virtually anyone from universities, municipal authorities or industry. Details are available from Chemviron, Chaussée de Waterloo 1135, B-1180 Brussels, Belgium.

**Sugar consumption in East Europe<sup>3</sup>.** — The patterns of change in per caput consumption have differed markedly between six countries of Comecon (the Council for Mutual Economic Assistance), as indicated in the following table:

	1960	1970	1975	1977
	kg, white value			
Bulgaria	29.3	34.4	36.8	39.8
Czechoslovakia	17.7	32.9	32.5	34.0
Germany, East	36.3	37.7	38.0	38.0
Hungary	27.9	39.2	43.0	41.5
Poland	26.6	33.5	39.5	37.0
USSR	28.0	38.8	40.8	42.0

**Headquarters move for the Queensland Bureau<sup>4</sup>.** — The Bureau of Sugar Experiment Stations has sold its headquarters premises on Gregory Terrace, Brisbane, and work has commenced on site preparation and construction of a new headquarters building at Longpocket, adjoining the Brisbane suburb of Indooroopilly. Completion of the new premises is scheduled for early 1980. In mid-1978 the Bureau purchased from CSR Ltd. the site and buildings of the David North Plant Research Centre at Longpocket, and facilities at the Centre have since been modified to provide additional space for quarantine and the transfer of commercial cane varieties and germ plasma to and from overseas countries.

## Iran sugar imports<sup>5</sup>

	1978	1977	1976
	tonnes, raw value		
Argentina	28,043	13,696	0
Austria	0	2,556	0
Brazil	170,104	64,307	9,724
Chile	30,839	0	0
EEC	555,636	166,379	12,434
Egypt	0	2,839	0
Finland	0	1,848	0
India	0	0	135,127
Poland	0	11,367	0
Portugal	0	0	7,594
Sweden	3,391	12,826	0
Switzerland	23	1,217	0
Thailand	87,809	99,783	23,140
Other countries	23	2	0
	875,868	376,820	188,019

**Cane alcohol programme for the Philippines<sup>6</sup>.** — The Philippines plans to build ten new sugar-using alcohol distilleries costing \$US 380 million as a step towards widescale production of alcohols. The Ministry of Energy said that the distilleries costing be built over the next ten years, are expected to produce 12,000 barrels of pure alcohol daily from sugar and cassava. The alcohol produced will be mixed with petrol as fuel and reduce Philippine dependence on oil by as much as 15%. Three distilleries, costing \$38 million each, will be built within the next three years. The Government will develop 270,000 hectares of virgin lands into cane and cassava plantations to help supply the plants.

**Tonga Group Ltd. Annual Report, 1979.** — A total of 785,437 tonnes of cane was harvested from company-owned and managed land in the 1978/79 season, against 824,698 tonnes in 1977/78. Some 37,000 tonnes were harvested mechanically with two chopper-type harvesters. Melville Sugar Estates was taken over during the year jointly with C. G. Smith Sugar Ltd. and the factory closed; a further 99,781 tonnes of cane from that company's 2155 ha under cane were harvested, 51,432 tonnes being harvested after the take-over, and diverted to the Tongaat factory. A total of 157,000 tonnes of cane was harvested in the Ndwedwe area of KwaZulu, of which 56,000 tonnes were harvested and delivered by Zulu contractors and the balance by locally organized labour. Crop restriction had been practised during the season in order to curtail cane and sugar production; this involved reducing the cane area and curtailing irrigation to reduce yield. This was necessitated by the South African sugar industry's agreement to reduce farm mean peaks in face of low sugar prices and oversupply. The Tongaat factory crushed 1,875,351 tonnes of cane to produce 210,038 tonnes of sugar in 1978/79, against 211,398 tonnes of sugar produced from 1,927,336 tonnes of cane in the previous year. Overall recovery was a record at 87.78%. Two new mechanically-induced draught cooling towers were commissioned towards the end of the season and will reduce the dependence of the factory on river water for cooling purposes.

**World's largest bagasse boiler<sup>8</sup>.** — A new boiler of 277,000 kg steam per hour capacity, consuming at that rating 125 tonnes of bagasse per hour, has been commissioned at the Victoria mill of CSR Ltd. in Australia. The firing system comprises 8 feeders, 8 pneumatic distributors and a multi-section dumping-type grate. For stable conditions, even when bagasse moisture is high, the furnace has a lining of refractory concrete and combustion air is preheated to 257°C. Flue gases are cleaned by six cyclone wet scrubbers operating in parallel, and gas flow is 646 tonnes.hr<sup>-1</sup> at full boiler load, handled by a double-width induced fan. The unit is equipped with an advanced system to provide automatic control of steam pressure and of flow rate. The auxiliary oil burners can be operated remotely from the control panel. A self-supporting chimney 65 m high has been designed to withstand winds up to 240 km.hr<sup>-1</sup> and is fitted with a device for constant monitoring of smoke density.

<sup>1</sup> I.S.O., through C. Czarnikow Ltd., *Sugar Review*, 1979, (1454), 166.

<sup>2</sup> F. O. Licht, *International Sugar Rpt.*, 1979, 111, 472.

<sup>3</sup> *Die Lebensmittelind.*, 1979, 26, 359.

<sup>4</sup> *Australian Sugar J.*, 1979, 71, 156.

<sup>5</sup> *Lamborn*, 1979, 36, 143.

<sup>6</sup> F. O. Licht, *International Sugar Rpt.*, 1979, 111, 502.

<sup>7</sup> See *I.S.J.*, 1979, 81, 288.

<sup>8</sup> *Australian Sugar J.*, 1979, 71, 95.



# Beware of sand.

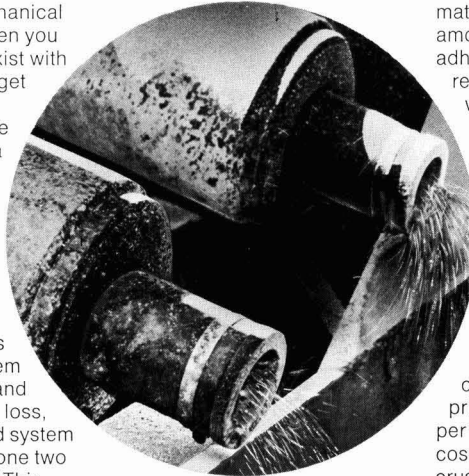
If you are involved with mechanical harvesting of sugar cane, then you face a problem that didn't exist with hand cutting. Soil and sand get into the process. Thorough washing won't always get the sand out. And all it takes is a little bit of sand to ruin expensive machinery. Or to overload equipment. And contaminate your juice.

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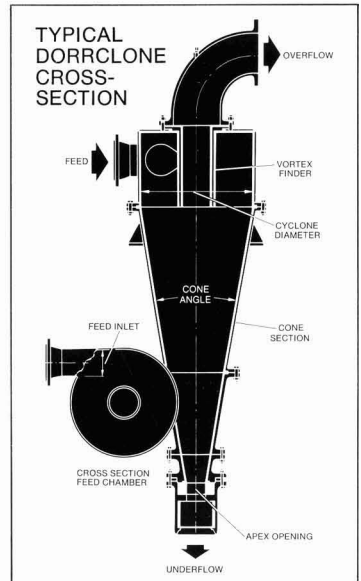
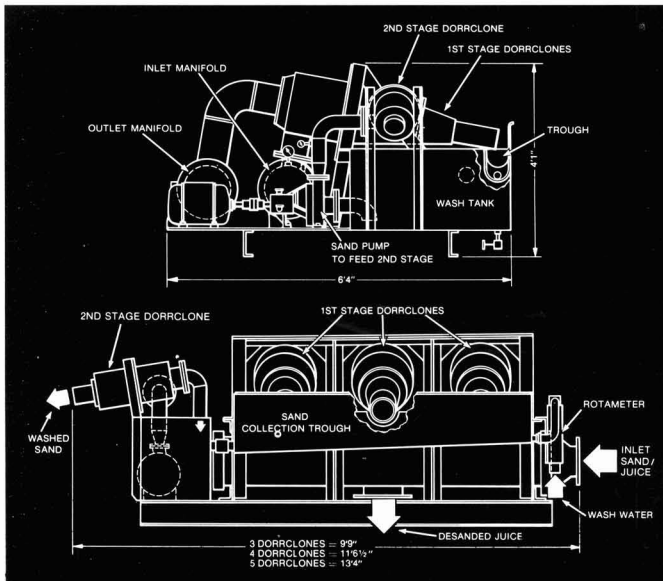
material is washed with a small amount of washwater to recover the adhering sugar. The second stage removes the grit from the sweet wash water. The two-stage approach assures minimum sugar loss.

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## Index to Advertisers

ABR Engineering	page
Maschinenfabrik Andritz AG	Inside Front Cover
ASEA	xxi
Australian Sugar Journal	xx
	Inside Back Cover

Bosco Industrie Meccaniche S.p.A.	ii
Brasil Acucareiro	Inside Back Cover
Braunschweigische Maschinenbauanstalt	vii
Thomas Broadbent & Sons Ltd.	xxix
Peter Brotherhood Ltd.	xi
Bünger Engineering Ltd.	xxxix

Cocksedge & Co. Ltd.	iii
----------------------	-----

A/S De Danske Sukkerfabrikker	xvi
M. Dedini S.A. Metalúrgica	xxviii
Bryan Donkin Co. Ltd.	xxxii
Dorr-Oliver Inc.	xxxiii

Maschinenfabrik H. Eberhardt GmbH & Co.	Outside Back Cover
Engrenages et Réducteurs Citroën-Messian	xxiv

Ferguson Perforating & Wire Co.	xxxix
Fives-Cail Babcock	ix
Fletcher and Stewart Ltd.	iv, v
Fontaine & Co. GmbH	xxx

Gilmore Sugar Manuals	Inside Back Cover
-----------------------	-------------------

J. Helmke & Co.	xxxix
Gebr. Herrmann GmbH	viii
Hitachi Zosen	xxvi
Hodag Chemical Corporation	xix

Indeck Power Equipment Co.	xxxiv
----------------------------	-------

Jeffress Bros. Ltd.	xxvii
---------------------	-------

Dr. W. Kernchen Optik-Elektronik-Automation	xxiii
---	-------

Norit N.V.	xxx
------------	-----

Optical Activity Ltd.	xxiv
-----------------------	------

Renold Ltd.	xiv
-------------	-----

SEUM	xxii
SIRCO Environmental Systems Ltd.	xxxiv
Smith/Mirriees	xiii
Stork-Werkspoor Sugar B.V.	x
Sugar Manufacturers' Supply Co. Ltd.	xv
Sugar News	Inside Back Cover

Vallourec	vi
Veco Zeefflatenfabriek B.V.	xii

Western States Machine Co.	i
World Sugar Journal	xxii

Zanini S.A. Equipamentos Pesados	xxv
----------------------------------	-----

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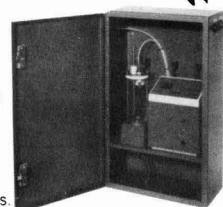
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Main pump station No. 2 of the Kenana sugar project

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## PANEL OF REFEREES

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### ERRATA AND CORRIGENDA

- Page 15. Line 55 of Column 1. Read "1976" for "1978".
- Page 15. Line 4 of Column 2. Read "1976" for "1978".
- Page 53. Line 2 of Column 2. Read "P.B." for "B.P".
- Page 71. Line 44 of Column 1. Read "boiling" for "boiler".
- Page 186. Line 48 of Column 1. Read "Korting" for "Kotting".
- Page 219. Line 46 of Column 1. Read "Dauval" for "Daucal".
- Page 240. Line 63 of Column 2. Read "81, 239" for "81".
- Page 240. Line 64 of Column 2. Read "81, 239" for "81".
- Page 245. Line 47 of Column 1. Read "Vigoureux" for "Vigoreux".
- Page 250. Line 27 of Column 1. Read "Urbaniec" for "Ubraniec".
- Page 279. Line 51 of Column 1. Read "evaporation<sup>5</sup>" for "evaporation<sup>1</sup>".
- Page 284. Line 21 of Column 2. Read "Procter" for "Proctor".
- Page 285. Line 57 of Column 2. Read "1979" for "1978".
- Page 313. Line 56 of Column 1. Read "Bereshchuk" for "Bereschuk".

# INDEX TO VOLUME LXXXI

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; Carbonatation; 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. 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", "d", "da", "de", "del", "el", "la", "van" or "von" it is indexed under A, D, E, 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*; (NB), *New Books*; (NC), *Notes and Comments*; (Stat.), *Statistics*; (TN), *Trade Notice*.

## SUBJECTS

	page		page		page
Acetic acid: manufacture from		Alcohol:		Animal fodder:	
bagasse, W. Jaeggle. (Abs.)	350	manufacture from cane products,		mushroom mycelium propagation.	
- molasses in Kenya. (Brev.)	383	economics in US. H.S. Birkett and		J.T. Aguinaldo. (Abs.)	59
Affination. E. Svoboda and J. Klepal.	23	J.A. Polack. (Abs.)	254	protein manufacture from sugar	
centrifugals. (TN)	318	- in India. M.K. Patil. (Abs.)	252	factory effluent. G. Kaiser	
non-sugar removal. A.F. Bugaenko		- from molasses. (TN)	318	<i>et al.</i> (Abs.)	282
and A.I. Lapkin. (Abs.)	347	- renewable sources, US. conference	319	vinasse. L.P. de Biase. (Abs.)	381
-- A.P. Koz'yavkin and N.I. Odorod'		sucrose crystallization in aqueous		- B.B. Patel. (Abs.)	252
ko. (Abs.)	24	system. L. Carrazana R. <i>et al.</i>	219	yeast. L.D. Il'ina <i>et al.</i> (Abs.)	222
polysaccharide removal. E.J. Roberts		<i>see also</i> Distillery and Fermentation		- S.T. Kale. (Abs.)	254
<i>et al.</i> (Abs.)	314	Algeria: sugar imports. (Stat.)	31	- A. Madi <i>et al.</i> (Abs.)	27
protein reduction. M.A. Godshall		Amino-acids: cane leaf content, influence		- beet pulp mixture. Raffinerie	
and E.J. Roberts. (Abs.)	379	of manganese. G.S.C. Rao and		Tirlemontoise. (Pat.)	317
refined sugar water content calculation.		A.P. Gupta. . . . .	99	- fermentation. V.N. Shvets <i>et al.</i>	253
E. Svoboda and J. Klepal.	217	effects on dextrose:levulose ratio		- plant in Cuba. (Brev.)	63
Afghanistan: sugar factory. (Brev.)	96	in sugar factory products.		<i>see also</i> Bagasse; Molasses; Pulp,	
Air: flow in beet piles. T. Baloh. . . . .	88	E. Reinefeld <i>et al.</i> (Abs.)	57	Beet and Yeast	
-- V.T. Serkin <i>et al.</i> (Abs.)	345	fusel oil production during molasses		Argentina: bagasse paper factory. . . . .	255
-- S. Vajna. (Abs.)	88	fermentation. K. Hokama <i>et al.</i>	221	argentine agricultural research. Anon. . . . .	55
Albumins: determination in raw sugar.		lysine plant in Yugoslavia. (Brev.)	351	- breeding. J.A. Mariotti. (Abs.)	152
I.F. Bugaenko and A.I. Lapkin. . . . .	347	- production from beet molasses.		- research. J.A. Mariotti. (Abs.)	152
Alcohol: bibliography. M.P.S.B.		L.E. Slater. (Abs.)	59	- irrigation and soil drainage.	
Gonçalves. (NB)	186	Maillard reaction products fractionation.		L.M. Blaquier <i>et al.</i> (Abs.)	145
cane molasses treatment for loss		L. González <i>et al.</i> (Abs.)	188	- payment and topping.	
reduction. A.D. Robertson. (Abs.)	349	proline content and drought resistance		C. Hoffmann. (Abs.)	15
content in cane sugar factory		in cane. K.C. Rao and S. Asokan.	244	chemical weed control. R.A. Arévalo. 207	
products. J.D. Blake and		reaction with carbonyl compounds		sugar exports 1978. (Stat.)	127
K.E. McNeil. (Abs.)	343	and colour formation. L. González		Ash: constituents determination in	
fermentation. W. Engelbart and		C. <i>et al.</i> (Abs.)	219	white sugar. N.A. da Glória <i>et al.</i>	187
H. Dellweg. (Abs.)	253	tryptophane production from beet		content of bagasse cellulose, effect	
- C.J. Franco. (Abs.)	381	molasses. L.K. Smirnova <i>et al.</i>	27	of prehydrolysis. S. Shahine <i>et al.</i>	59
- beet molasses. V.N. Shvets <i>et al.</i>	282	valine production from beet		- beet, effect of irrigation. J. Simon. 211	
-- effect of colour removal. V.N.		molasses. Z. Popova and I. Murgov.	350	- cane juice, effect of cane extra-	
Shvets <i>et al.</i> (Abs.)	253	<i>see also</i> Glutamic acid		neous matter. R.P. Scott <i>et al.</i>	348
recycled vinasse. N. Taygun		Animal fodder: bagasse and cane		----- topping height. L.K. Kirby	
<i>et al.</i> (Abs.)	282	molasses. P.N. Soman. (Abs.)	93	and G. Kingston. (Abs.)	337
ultrasonics. J. le Mao and		pellets. H.G. Ayala <i>et al.</i> (Abs.)	27	- liquid sugar manufacture by ion	
R.O. Prudhomme. (Abs.)	350	beet pulp. A.M. Paulais. (Abs.)	252	exchange. S.E. Bischel. (Abs.)	375
- cane molasses. K. Hokama <i>et al.</i>	221	- E. Pfeffer. (Abs.)	125	- massecuite and sugar, effect of	
- molasses, vacuum vs. atmospheric		- and molasses. A. Giouzelyanne. 282		boiling system. J.F. Silva and	
pressure. A. Ramalingam. (Abs.)	27	- R. Teissier <i>et al.</i> (Pat.)	29	F. Zepelon. (Abs.)	179
- process package. (TN)	318	-- fluorine determination.		- raw sugar. W. Altenburg. (Abs.)	380
- sugar factory effluent. G. Kaiser		P.B. Koster <i>et al.</i>	4	- J.V. Lopez-Oña. (Abs.)	380
<i>et al.</i> (Abs.)	282	-- pesticide residue determination.		determination. J. Dobrzycki. (Abs.)	187
fuel programme in Colombia. (Brev.)	351	P.B. Koster. (Abs.)	91	- in cane molasses and yeast.	
manufacture from bagasse and		-- and trash. W. Loop and		G. Núñez T. and C. Díaz de A.	58
cane. R.P. Humbert. (Abs.)	282	J. Huberlant. (Abs.)	222	- by ion exchange. T.K.K. Menon	
- molasses. K. Mannivannan. (Abs.)	252	- tops. D. Charlesworth. (Abs.)	27	and V.C. Nair. (Abs.)	58
-- US. (Brev.)	159	- B. Frank. (Abs.)	253	- in sugar. Anon. (Abs.)	315
- cane. H. Bruschke. (Abs.)	253	- D. Stacey. (Abs.)	253	distribution in white sugar.	
- K. Rudolph <i>et al.</i> (Abs.)	253	-- and pulp. D. Charlesworth. . . . .	221	D. Hibbert <i>et al.</i> (Abs.)	25
- Australian economic report. . . . .	351	-- and molasses. B. Frank. (Abs.)	221	iron determination in sugars.	
- in Brazil. (Brev.)	65,224	cane by-products project in Cuba.		- Korenaga and - Takashi. (Abs.)	348
- A.P. Saranin. (Abs.)	94	O. Almazán del O. and A. Roca G.	222	metals determination in raw sugar.	
cost comparison with sugar		- utilization. O. Almazán. (Abs.)	252	K. Tomobe and T. Nagasaka. . . . .	315
manufacture. P.B. Neto. (Abs.)	381	- molasses. C.M. Geerken. (Abs.)	27	- refined sugar. R. Cormier <i>et al.</i>	380
impurities analysis. L.G. de		- P. Lercano <i>et al.</i> (Abs.)	27	- interaction with sucrose. L. Poncini. 36	
Souza and A.M.S. Llistó. (Abs.)	282	- A. Molina. (Abs.)	27	potassium in cane juice, effect of	
- juice. P.M.A.M. Chenu. (Abs.)	126	- tops. J. Deville and Y. Wong You		vinasse application. F. Brieger. . . . .	59
- C. Ebeling. (Abs.)	381	Cheong. (Abs.)	126	- sodium and calcium concentration	
- W.H. Kampen. (Abs.)	253	- F. Geoffroy and M. Vivier. (Abs.)	59	in molasses fermentation.	
- and molasses. L.A.R. Pinto. 381		lysine. (Brev.)	351	V.N. Shvets <i>et al.</i> (Abs.)	221
- in Philippines. (Brev.)	255, 288	molasses. C.O. McKenzie. (Pat.)	284	reducing sugars ratio in cane	
- molasses in Hawaii. (Brev.)	256	- F.M. Snyder. (Pat.)	29	molasses, effect of alcohol.	
- Kenya. (Brev.)	383	- J.F. Wilson and R.S. Parish. (Pat.)	60	A.D. Robertson. (Abs.)	349

# INDEX

	page		page		page
Ash:		Bagasse:		Beet:	
removal with active carbon.		enzymatic saccharification		dirt and stone separators. J. Ruzicka	
H. Zaorska. (Abs.) . . . . .	250	R.K. Andren <i>et al.</i> (Abs.) . . . . .	350	<i>et al.</i> (Abs.) . . . . .	277
-affination. (A.P. Kozyavkin and		-- N. Toyama. (Abs.) . . . . .	282	drilling and harvesting dates in India.	
N.I. Odorod'ko. (Abs.) . . . . .	24	fuel value. J.E. Atchison. (Abs.) . . . . .	125	A.D. Karve <i>et al.</i> (Abs.) . . . . .	18
-clarification of remelt and raw		furfural and acetic acid manufacture.		elevator. N.D. Khomenko and	
syrup. N.L.C. Suzor. (Abs.) . . . . .	181	W. Jaeggle. (Abs.) . . . . .	350	V.G. Yarmilko. (Abs.) . . . . .	22
-electrodialysis. T. Hiramoto. (Abs.)	314	- manufacture. G. Ocampo S. <i>et al.</i>	253	extraneous matter pressing.	
- F. Perschak. (Abs.) . . . . .	279	- and protein manufacture.		H. Lange. (Abs.) . . . . .	221
-juice hydrocyclone treatment. Anon.	213	G.D. Agrawal. (Abs.) . . . . .	94	-- W. Loop and J. Huberlant. (Abs.)	222
silica determination. P. Devillers		hemcellulose isolation and effect		-- P. Mathismoen. (Abs.) . . . . .	221
<i>et al.</i> (Abs.) . . . . .	251	on paper. A.E. el-Ashmawy <i>et al.</i>	94	-- separation and treatment. M.	
-- in raw sugar. I.F. Bugaenko and		lignin chemical composition.		Cuer. (Abs.) . . . . .	376
A.I. Lapkin. (Abs.) . . . . .	347	C.J. Triana F. <i>et al.</i> (Abs.) . . . . .	221	growth, effect of intercropping	
sugar solution conductivity and		micro-organisms. T. Sais H. <i>et al.</i>	219	with barley. E. Long. (Abs.) . . . . .	177
purity determination. J. Ponant.	220	mixtures thermal insulation and		herbicide phytotoxicity. E.	
see also Boilers; Bone char; Clarifica-		mechanical strength. R. Espinosa P.	222	Dalleinne. (Abs.) . . . . .	18
tion; Furnaces; Bagasse; Ion exchange		pelletizing and use as animal fodder.		- and soil disinfectant effects.	
and Pulp, Beet		H.G. Ayala <i>et al.</i> (Abs.) . . . . .	27	G. Pritoni <i>et al.</i> (Abs.) . . . . .	245
Australia: bagasse boiler. (Brev.) . . . . .	384	pith enzymatic saccharification.		leaf catcher. F. Hruska. (Abs.) . . . . .	218
bulk terminal. (Brev.) . . . . .	287	L.H. Wang and Y.C. Kuo. (Abs.) . . . . .	126	lift. N.D. Khomenko <i>et al.</i> (Abs.)	277
Bureau of Sugar Experiment Stations		-hydrolysis and dextrose recovery.		mannitol occurrence. J. Caplovic	
new headquarters. (Brev.) . . . . .	384	C.I. Nee and W.F. Yee. (Abs.) . . . . .	381	and F. Rendos. (Abs.) . . . . .	57
cane agriculture journal changes.	159	prehydrolysis and digestion.		marc determination. H. Gruszecka.	348
- alcohol economics. . . . .	351	E.J. Villavicencio. (Pat.) . . . . .	28	maturity determination.	
- breeding for Fiji disease resistance.	51	presses. J. Farmer. (Abs.) . . . . .	120	M.A. Dymko <i>et al.</i> (Abs.) . . . . .	246
- milling-diffusion. P.S. Kelly and		sampling and moisture deter-		nematode hatching agent prepara-	
R.G. Porter. (Abs.) . . . . .	311	mination. R.W.A. Luxford. (Abs.)	348	J.D. Willett and L.M. Cheek.	283
- pests. B.E. Hitchcock. (Abs.) . . . . .	341	sand and water content, effect on		nitrogen compounds and quality.	
- railway system in North Queensland	63	burning. Anon. (Abs.) . . . . .	214	M. O'Sullivan. (Abs.) . . . . .	218
- rust in Queensland. (Brev.) . . . . .	160	storage. R. Hesch. (Pat.) . . . . .	285	- uptake, assimilation and metaboli-	
- sugar production 1978/79. (NC)	97	utilization. P. López G. (Abs.) . . . . .	253	zation. K. Koch. (Abs.) . . . . .	245
- transport. T.G. Fuelling. (Abs.)	340	- J.M. Paturau. (Abs.) . . . . .	59, 252	phenols. B. Winstørp-Olsen	
- variety adoption. C.W. Chardon		yield and consumption in Hawaii.		<i>et al.</i> . . . . .	332, 362
<i>et al.</i> (Abs.) . . . . .	342	D. Murata and W. Gibson. (Abs.)	21	pieces processing. N.A. Arkhipovich	
CSR Ltd. annual report 1979. (Brev.)	256	- effect of cane tops. R.P. Scott		<i>et al.</i> (Abs.) . . . . .	313
deep-water wharf. Anon. (Abs.) . . . . .	215	<i>et al.</i> (Abs.) . . . . .	348	processing and by-products utiliza-	
eye spot disease. T.G. Willcox and		see also By-products; Furnaces; Paper		tion. M.G. Koukios. (Abs.) . . . . .	182
C.M. McAleese. (Abs.) . . . . .	371	and Pulp		- problems caused by excessive	
Fiji disease. B.T. Egan. (Abs.) . . . . .	306	Bangladesh: sugar industry		nitrogen fertilizer. G. Hanslip.	18
- P.A. Jones. (Abs.) . . . . .	82	modernization. (Brev.) . . . . .	63	quality, effect of agronomic factors.	
- resistance testing of Réunion		Barbados: sugar production 1978.	31	C. Winner. (Abs.) . . . . .	84
cane varieties. (NB) . . . . .	90	Barrier seals. (TN) . . . . .	30	--- and weather. P.S. Bhatnagar	
flooding and drainage problems.		Beet: agriculture in Austria. C. Nuh		and B. Raj. (Abs.) . . . . .	84
D.W. Beattie. (Abs.) . . . . .	78	and G. Onat. (Abs.) . . . . .	177	-- nitrogen, frost, etc. M. Lollier.	121
furnace ash handling systems.		- combined with cane agriculture		- evaluation by diffusion juice purity	
G.M. Sawyer and R.N. Cullen.	120	in Spain. E. Lorduy. (Abs.) . . . . .	206	determination. M. Roche. (Abs.)	376
irrigation and land utilization.		- economics. S.K. Tewari and		reception. V.S. Vyshtak and	
A. Hegarty. (Abs.) . . . . .	78	P.S. Bhatnagar. (Abs.) . . . . .	84	A.I. Sidorenko. (Abs.) . . . . .	277
- scheme. J. Wright. (Abs.) . . . . .	239	- in Iran. M. Baghestani. (Abs.) . . . . .	17	at Aarberg. Anon. (Abs.) . . . . .	217
- trials. N.R. Maclean. (Abs.) . . . . .	337	- West Germany. W.C. von Kessel.	17	research centre in US. Anon. (Abs.)	91
leaf scald. I.T. Freshwater. (Abs.) . . . . .	82	- faulty practices and crop		sample and cossette sugar content	
Queensland Cane growers report		profitability. W.C. von Kessel.	177	differences. G.F. Tyazhelova.	376
1979. Anon. (NB) . . . . .	186	- harvest date x nitrogen fertilizer		sampling. D. Bourdon. (Abs.) . . . . .	376
raw sugar refining. A.C. Chatterjee		x irrigation trials in Iran.		- for yield prediction. M. Martens.	246
and A.R. Bhide. (Abs.) . . . . .	122	A. Kaschani and H. Farazdaghi.	17	seed germination, effect of fungi-	
- quality. Anon. (Abs.) . . . . .	380	- for high yield. D.S. Oberoi and		ces. W. Hrubesch and F. Wieser.	245
roller bearing cane mills.		H.G. Singh. (Abs.) . . . . .	17	- harvesting. E. Niculescu and	
G.D. Jacklin <i>et al.</i> (Abs.) . . . . .	119	- and quality. P.S. Bhatnagar and		A. Stefanescu. (Abs.) . . . . .	308
soil copper deficiency.		G.B. Pant. (Abs.) . . . . .	17	- pelleting. D. Charlesworth. (Abs.)	178
E.A. Pembroke. (Abs.) . . . . .	14	- in India. P.S. Arya and S.S. Saini.	246	- spacing and plant population.	
sugar economy study. (Brev.) . . . . .	128	- N. Mukerji. (Abs.) . . . . .	84	R. Vanstellen. (Abs.) . . . . .	177
- exports. (Stat.) . . . . .	223	- M.H. Patel. (Abs.) . . . . .	246	- yield, effect of steckling size.	
- factory power supply to public		- practices in UK. W. Hollowell and		S.S. Saini <i>et al.</i> (Abs.) . . . . .	307
grid. K.W. Wattle <i>et al.</i> (Abs.) . . . . .	343	D. Charlesworth. (Abs.) . . . . .	274	slicer. R. Cisk and A. Andrzejewski.	345
- technology research. Anon. (NB)	56	- research in Austria. Anon. (NB)	56	- ribless knives and cossette cross-	
- industry. Anon. (NB) . . . . .	185	- France. Anon. (Abs.) . . . . .	275	section area calculation. V.N.	
Toft agreement with Brazilian		- India. Anon. (Abs.) . . . . .	308	Nechitalo and V.P. Zubchenko.	23
company. (Brev.) . . . . .	287	- UK conference. . . . .	102	- speed optimization. V.G. Belik	23
Austria: beet agriculture. C. Nuh and		- winter beet. Z. Szrednicki. (Abs.)	275	A.M. Shcherbakov. (Abs.) . . . . .	23
G. Onat. (Abs.) . . . . .	177	analysis automatic line.		sugar content, effect of agronomic	
-- and factory technology research.		M.Z. Khelenskii <i>et al.</i> (Abs.) . . . . .	188	factors. S.R. Bostanov. (Abs.) . . . . .	277
Anon. (NB) . . . . .	56	betaine determination. G. Steinle		-- D. Bourdon. (Abs.) . . . . .	376
- diffuser and carbonation control		and E. Fischer. (Abs.) . . . . .	91	-- maleic hydrazide. O.P. Singh	
by computer at Tulln. J. Dober.	312	bolter elimination. W. Perowne		<i>et al.</i> (Abs.) . . . . .	18
		and P. Longden. (Abs.) . . . . .	274	-- weather and mechanical hand-	
		- A. Vigoureux. (Abs.) . . . . .	245	ling. A.I. Chekal' and	
Bagacillo: distillery waste mixture		seed stalk removal effect on weight		V.V. Popovich. (Abs.) . . . . .	277
as fertilizer. R.S. Dubey <i>et al.</i> (Abs.)	93	and sugar content. F.C. Ehlig		- products, dextrose:levulose ratio.	
Bagasse: active carbon preparation.		<i>et al.</i> (Abs.) . . . . .	307	W. Mauch and E. Krause. (Abs.)	124
A.M.H.R. Khan <i>et al.</i> (Abs.) . . . . .	125	breeding. M.H. Arnold. . . . .	195	- yield and quality, effect of irriga-	
alcohol manufacture. R.P. Humbert.	282	- genetic parameter variability and		tion. J. Simon. (Abs.) . . . . .	211
- K. Mannivannan. (A.P.) . . . . .	252	correlation. H.L. Sharma <i>et al.</i>	309	tarehouse equipment. O. Krieger.	315
-- in US. (Brev.) . . . . .	159	- hybrid blend testing. A.W. Erichsen		- line. A.Y. Zagorul'ko <i>et al.</i> (Abs.)	92
animal fodder. P.N. Soman. (Abs.)	93	<i>et al.</i> (Abs.) . . . . .	309	tops as animal fodder.	
board factory closure in South		brei analysis, effect of freezing.		D. Charlesworth. (Abs.) . . . . .	27, 221
Africa. (Brev.) . . . . .	64	A. Arbizani and P. Laghi. (Abs.)	220	-- B. Frank. (Abs.) . . . . .	221, 253
- manufacture. B.S. Bryant. (Abs.)	350	- nitrate and sugar content.		-- D. Stacey. (Abs.) . . . . .	253
- M.S. Iyengar. (Abs.) . . . . .	222	D.G. Westfall <i>et al.</i> (Abs.) . . . . .	84	washer. R.P. Polischuk and	
cellulose manufacture. A. Fogarassy.	29	campaign starting and finishing dates		V.I. Kotlyarov. (Abs.) . . . . .	88
- S. Shahine <i>et al.</i> (Abs.) . . . . .	59	in Poland. G. Sobczyk. (Abs.)	182	washing. H. Dabrowski. (Abs.)	345
compost effect on cane yield.		cleaning, mud solids content and		yield, effect of cultivation and	
P.K. Moberly and J.H. Meyer. . . . .	339	disposal. F. Kastner. (Abs.) . . . . .	22	liquid fertilizer. T. Agosti. (Abs.)	245
depithing equipment. J. Lois C. . . . .	93	composition, effect of herbicides.		- sowing date. J. Webb and	
drying. R.T. Khurd. (Abs.) . . . . .	53	T. Banaszewicz and		K. Jaggard. (Abs.) . . . . .	178
- heat economy evaluation.		H. Kozaczenco. (Abs.) . . . . .	211	- and quality, effect of irrigation	
S.K. Ghosh. (Abs.) . . . . .	154	damage by pumping. S. Dusek and		water table depth. G.A. Reichman	
		J. Dyntar. (Abs.) . . . . .	22	<i>et al.</i> (Abs.) . . . . .	18





# INDEX

	page		page		page
Cane:		Cane:		Cane:	
breeding, B.T. Roach, (Abs.)	342	fibre content, effect of frost.		production cost minimization.	
- in Argentina, J.A. Mariotti <i>et al.</i>	51	V.H. Chiappino, (Abs.)	281	M.L. Agarwal, (Abs.)	15
- arrow mould formation.		-- and yield, effect of harvest and		quality determination.	
A.M. Whittle, (Abs.)	306	ratonning dates, K.C. Leverington		V.H. Chiappino, (Abs.)	57
- in Brazil, J.Y.J. Miosque and		<i>et al.</i> (Abs.)	337	- effect of agronomic factors.	
G.R. Machado, (Abs.)	117	field condition evaluation.		G.K. Zende, (Abs.)	370
- cell cultures, M.C. Liu <i>et al.</i> (Abs.)	118	T.C. Ripoli <i>et al.</i> (Abs.)	271	-- on processing, B. Pasricha, (Abs.)	20
- character inheritance, M.B.G.R.		flowering, S. Singh, (Abs.)	174	- in US, effect of frost, G.J. Durbin,	21
Batcha and K. Palanichamy,	153	- and apex chemical composition.		raton crop treatment, R.S. Kanwar	
- for Fiji disease resistance, Anon.	51	Z.A. Menshawi, (Abs.)	176	and H. Kaur, (Abs.)	145
- first-generation inbred perform-		- control, Z.A. Menshawi, (Abs.)	148	ratonning, effect of mechanical	
ances, A.S. Ehirajan <i>et al.</i> (Abs.)	210	- effect of nitrogen and moisture.		harvesting, S.J. Yang, (Abs.)	109
- flowering, K.J. Nuss, (Abs.)	152	A.I. Allam <i>et al.</i> (Abs.)	109	reducing sugars decrease during	
- in Egypt, A.I. Allam <i>et al.</i> (Abs.)	244	frost damage assessment by titratable		growth, T.T. Yang and T.S. Hsieh,	238
-- Z.A. Menshawi, (Abs.)	152	acidity measurement, F.A. Martin,	124	ripening, E.J. de A. Leme and	
- India, Q.Q. Khan and		-- effect of irrigation, O. Singh and		R. Scardua, (Abs.)	175
P.K. Bhatnagar, (Abs.)	117	R.S. Kanwar,	359	- with chemicals, Anon. (Abs.)	370
- in Hawaii, Anon. (Abs.)	372	- effects, R.S. Kanwar, (Abs.)	369	- M. St. J. Clowes, (Abs.)	339
- hybrid cytogenetics.		growth abnormality in Senegal.		- J. Fernandes <i>et al.</i> (Abs.)	206
P.A. Kandasami, (Abs.)	210	C. Ricaud, (Abs.)	273	- H. Jaramillo <i>et al.</i> (Abs.)	337
- in India, S. Krishna and		- on calcareous soils, H. Evans,	38	- M.H.R. Julien, (Abs.)	175
R.B. Gaddagimath, (NB)	186	- effect of minimum tillage, Anon.	369	- G. Kingston <i>et al.</i> (Abs.)	337
- inheritance of herbicide tolerance.		- soil oxygen content, Y.S. Sheu	369	- A. Kumar and R. Narasimhan,	112
T. Kuntahartono <i>et al.</i> (Abs.)	145	<i>et al.</i> (Abs.)	369	- Y.C. Pan and Y.P. Lee, (Abs.)	174
- in Mauritius, Anon. (Abs.)	117	- minimum temperature require-		- K.C. Rao and S. Asokan, (Abs.)	48
- <i>Miscanthus</i> germplasm in Taiwan.		ment, O.O.S. Bacchi and		- K.W. Ratts, (Pat.)	284
C.C. Lo, <i>et al.</i> (Abs.)	118	J.A.G.C. Sousa, (Abs.)	175	- H. Rostron, (Abs.)	174
- for mosaic resistance, R.D. Breaux		- nitrogen metabolism, U.S. Singh,	370	- C.P.M. Sweet, (Abs.)	174
and H. Koike, (Abs.)	149	- and photosynthesis, U.S. Singh,	338	- K. Venkatamaran <i>et al.</i> (Abs.)	338
- mutation by radio-activity.		- regulator trials, S.Y. Peng and		- P.C. Yang and F.W. Ho, (Abs.)	174
H.K.S. Rao <i>et al.</i> (Abs.)	117	L.T. Twu, (Abs.)	206	- aerial application, Anon. (Abs.)	77
- in Taiwan, C.C. Lo, (Abs.)	244	guttation, T.T. Yang and C.T. Chen,	176	- C.A. Lang, (Abs.)	339
- nobilization with <i>Saccharum</i>		height, effect of sett treatment with		- effect on composition and enzyme	
<i>officinatum</i> , W.M. Symington,	117	growth promoters and fungicide,		activity, A.S. Chacravarti <i>et al.</i>	48
- <i>Saccharum spontaneum</i> .		J.D. Nimbalkar and G.R. Naik,	15	-- post-harvest deterioration.	
B.T. Roach, (Abs.)	118	intercropping, S.S. Narwal and		M. St. J. Clowes and R.A. Wood,	339
- Philippines germplasm collection.		K.L. Behl, (Abs.)	370	-- quality, A.S. Alves <i>et al.</i> (Abs.)	174
A.T. Barredo and T.R. Escobar,	83	- effect on growth and yield.		- effect of temperature and water	
- progeny frost resistance, R. Cesnik		J.D. Chougule and K.U. Sanghavi,	48	management, D.P. Gowing and	
<i>et al.</i> (Abs.)	210	- with maize, J.P. Patil <i>et al.</i> (Abs.)	370	N. Baniabassi, (Abs.)	148
- research in Argentina.		- and planting effect on yield and		root development factors.	
J.A. Mariotti, (Abs.)	152	quality, K.S. Rathi <i>et al.</i> (Abs.)	48	M. Fonseca and M. Dominguez,	241
- seedling losses in group transplant-		- with wheat, P.A. Kandasami <i>et al.</i>	145	- nitrogenase activity, effect of	
ing, T.G. Pimenta <i>et al.</i> (Abs.)	372	leaf amino-acids, effect of manganese,		N-fixing bacteria, A.P. Ruschel	
- potting compound trials.		G.S.C. Rao and A.P. Gupta,	99	<i>et al.</i> (Abs.)	176
R. Cesnik <i>et al.</i> (Abs.)	51	- area estimation, U.S. Singh, (Abs.)	239	- uptake of soil water, G. Kingston,	144
- propagation, D.W. Thomas,	372	- index and yield, effect of fertili-		row spacing effect on yield, stalk	
- yield and selection, R.S. Bond,	118	zers, E.L. Rosario <i>et al.</i> (Abs.)	176	population and sugar content.	
- selection, W.M. Symington, (Abs.)	342	- flavonoid photography, N.H. Paton		R.J. Matherne and J.E. Irvine,	206
- influence of clonal competition.		<i>et al.</i> (Abs.)	152	- <i>Saccharum robustum</i> taxonomy.	
A.M. Galvez and L.T. Empie,	153	- nitrogen and tillering, U.S. Singh,	109	J. Daniels <i>et al.</i> (Abs.)	118
- single stools, P.M. Lyrene, (Abs.)	152	- nutrient status, effect of variety		sample preparation, J.F.G. Pereira,	187
- tissue culture, R.C. Barba <i>et al.</i>	244	and fertilizers, J. Orlando <i>et al.</i>	112	sampler, R. Bodger and	
- M. Krishnamurthi, (Abs.)	117	- phenolic acids identification.		C.B. van der Riet, (Abs.)	374
- in US, P.H. Duncelman and		N.H. Paton, (Abs.)	124	- sampling and analysis, N.A. da	
S. Nagatomi, (Abs.)	51	- sheath enzyme, F.E. Prado <i>et al.</i>	174	Gloria <i>et al.</i> (Abs.)	380
- varieties performance evaluation.		maturity testing value.		- A.C. Sturion, (Abs.)	180
R.H. Farquhar, (Abs.)	342	R.G. Hoekstra, (Abs.)	111	- Brix measurement for maturity	
- in Réunion, Anon. (NB)	90	metabolism, Anon. (Abs.)	370	testing, D.G. Dakshindas, (Abs.)	338
- visual selection, J.A. Mariotti <i>et al.</i>	51	mineral content estimation.		seedling production from fuzzi,	
- in West Indies, D.I.T. Walker <i>et al.</i>	210	T.C. Ripoli <i>et al.</i> (Abs.)	281	W.M. da Silva, (Abs.)	152
- with wild germplasm.		nitrogen fixation and fertilizer		sett germination, effect of soil	
P. Sankaranarayanan, (Abs.)	153	uptake, A.P. Ruschel <i>et al.</i> (Abs.)	148	salinity, S. Valdivia V. and	
bud germination inhibition by leaf		- mobility, U.S. Singh, (Abs.)	239	J. Pinna C. (Abs.)	368
sheaths, G.T.A. Benda, (Abs.)	148	- uptake and utilization, U.S. Singh,	239	-- and emergence, effect of planting	
burning and extraneous matter		nitrate reductase activity, effect of		delay, D.A.C. Frazão <i>et al.</i>	83
reduction, J.P. Lamusse,	231	age and fertilization, E.L. Rosario		- protection with fungicide.	
- in US, N. Rozeff,	296	and K. Sooksathan, (Abs.)	176	S.M. Yang and H.J. Braud, (Abs.)	116
character inheritance.		nitrogenase activity, effect of		soil determination by ashing, Anon.	213
P.A. Kandasami, (Abs.)	153	fertilization and irrigation.		standing-over, T.G. Wilcox, (Abs.)	240
- crop age and juice composition.		A.P. Ruschel <i>et al.</i> (Abs.)	176	stool destruction by herbicides.	
S.P. Dua and R.C. Singh, (Abs.)	238	nodal tissue phenols content, effect		Anon. (Abs.)	49
cultivation, effect of varieties.		of injury and disease, K.I. Wilson		sugar content prediction, T.L. Lin	
C.L. Toohy, (Abs.)	117	and D.N. Srivastava, (Abs.)	242	and W.H. Tung, (Abs.)	238
- experimental analysis, A. Martinez		optimum plot size for yield trials.		- recovery calculation, S.N. Sinha	
G. and F. Cienfuegos I, (Abs.)	145	M.O. Abu-Zeid and M.G. Mansi,	148	<i>et al.</i> (Abs.)	20
- by minimum tillage, W. Hadlow		phosphatases, A.R. Sampietro <i>et al.</i>	15	- Refining Research Technical	
and E.W. Millard, (Abs.)	109	photosynthesis at different wave-		Session,	
-- P.K. Moberly and P.E.T.		lengths, A.G. Alexander and		- yield, effect of flooding and drain-	
Turner, (Abs.)	146	O. Biddulph, (Abs.)	148	age inadequacy, D.W. Beattie,	78
deterioration after burning and		plant and raton crop nitrogen		- harvesting, etc. C.R. Nalder,	15
harvesting, B.T. Egan <i>et al.</i> (Abs.)	109	utilization, F. Chui and G. Samuels,	144	tissue components and physiology.	
- harvesting, J.E. Irvine and		planting, "bud chip" setts.		G. Ramchandran, (Abs.)	338
B.L. Legendre, (Abs.)	110	M.N. Gokhale, (Abs.)	117	- topping height and juice ash content.	
- G. El-K. Sayed <i>et al.</i> (Abs.)	156	-- B.B. Ramaiah <i>et al.</i> (Abs.)	147	L.K. Kirby and G. Kingston,	337
- dextran occurrence, S.E. Ferrari		-- M.N. Sath, (Abs.)	271	tops as animal fodder, J. Deville and	
and A.A. Rodella, (Abs.)	52	- clonal method, R.G. Sharma,	238	Y. Wong Yoo Cheong, (Abs.)	126
- effect of billet length and burning.		- depth and sett germination.		-- F. Geoffroy and M. Vivier,	59
P.C. Ivin and D.H. Foster, (Abs.)	157	J.E. Lonsdale, (Abs.)	110	trash content in Brazil.	
-- on sugar refining quality.		- on flat land, L.L. Louden, (Abs.)	207	A.C. Fernandes <i>et al.</i> (Abs.)	113
E. Whyman and T.W.		- and harvest times in India.		- effect of mechanical harvesting	
Meredith, (Abs.)	184	K.C. Rao, (Abs.)	304	N. Tambosco <i>et al.</i> (Abs.)	113
- sulphitation, A.A. Delgado,	181	pol and fibre determination.		-- and loading, Anon. (Abs.)	305
evapotranspiration and irrigation.		A.P. Gupta, (Abs.)	380	-- A.C. Fernandes and	
G. Hunsigi and S.C. Srivastava,	148	pollen, M. Krishnamurthi, (Abs.)	152	E.R. de Oliveira, (Abs.)	305
- rainfall mathematical modelling.		potassium deficiency.		-- E. Zamorano C. (Abs.)	113
A.C. Early, (Abs.)	146	R.P. Humbert, (Abs.)	304		

# INDEX

	page		page		page
Cane:		Carbonation:		Centrifugals:	
trash effect on milling, F.A. Fogliata		heat and mass balance calculation		operation, mathematical study.	
<i>et al.</i> (Abs.) . . . . .	180	by computer, E. Farwick. (Abs.)	375	E. Svoboda and J. Klepal. (Abs.)	23
-- S. El-N.A. Hemaida <i>et al.</i> (Abs.)	155	juice flow simulation by computer.		orders. (Brev.) . . . . .	30
-- sugar recovery, W.F. Allison . . .	119	C.H. Chen <i>et al.</i> (Abs.) . . . . .	180	performance, effect of viscosity and	
-- as fuel in Hawaii, D. Murata and		-- lime salts determination and		temperature, P. Devillers <i>et al.</i>	26
W. Gibson. (Abs.) . . . . .	21	-- control, W. Uhlenbrock. (Abs.)	278	-- evaluation from sugar water	
-- incorporation in soil. . . . .	14	-- phosphatation, S.P. Mishra. (Abs.)	85	content, E. Svoboda and J. Klepal. 217	
C.M. McAleese. (Abs.) . . . . .	14	liming vessel, I. Vigh. (Abs.) . . . .	375	<i>see also</i> Affination	
management and irrigation effects		mud application to soil. Anon. . . . .	252	Chains. (TN) . . . . .	286, 382
on yield, J.M. Gosnell and		-- G. Vaccari and C.A. Accorsi. . . .	222	for rake conveyors, G.N. Stepanov. .	250
J.E. Lonsdale. (Abs.) . . . . .	148	-- W.C. von Kessel. (Abs.) . . . . .	308	Chile: beet area. (Brev.) . . . . .	223
-- and soil and water conservation.		-- conveying, Z. Kembrowski <i>et al.</i>	312	sugar company difficulties. (Brev.) .	224
C.T. Wise. (Abs.) . . . . .	338	-- density, effect of sleeve-type filter		-- statistics. (Stat.) . . . . .	319
-- and tops effect on juice extraction,		cloths, Y.F. Tsyukalo <i>et al.</i> . . . .	376	China: new sugar factories. (Brev.) 173,	288
quality and clarification.		-- dewatering, H. Zoidl. (Abs.) . . .	313	sugar industry and UK companies. .	127
R.P. Scott <i>et al.</i> (Abs.) . . . . .	348	-- pump. (TN) . . . . .	318	-- production 1977/78. (NC) . . . . .	129
vertical and horizontal planting.		-- quantity and treatment . . . . .		-- 1978/79. (Brev.) . . . . .	367
P.P. Singh and K. Kumar. (Abs.)	109	F. Bellabarba. (Abs.) . . . . .	218	trade agreement with Philippines. .	319
weigher, J.R. Reghenzani. (Abs.)	340	-- recalcination, K. Saiga <i>et al.</i> (Abs.)	314	Chromatography, Gas-liquid: beet	
yield decline in India, G.R. Naik <i>et al.</i>	15	-- separation, V.M. Priimak <i>et al.</i> . .	183	diffusion residence time determina-	
-- effect of borer attack, R. Pérez G.		-- A.F. Yakimov. (Abs.) . . . . .	87	tion, T. Cronewitz <i>et al.</i> (Abs.) . .	376
<i>et al.</i> (Abs.) . . . . .	151	-- solids content and disposal.		-- molasses volatile fatty acids	
-- Azotobacter culture, M.L.		F. Kastner. (Abs.) . . . . .	22	determination, J. Hrivnák and	
Agarwal <i>et al.</i> (Abs.) . . . . .	304	optimum pH, K.E. Reznik and		M. Medved. (Abs.) . . . . .	188
-- cultivation, J.D. Chougule and		V.D. Vitvitskii. (Abs.) . . . . .	218	cane molasses and fermented mash	
K.D. Patil. (Abs.) . . . . .	14	-- and alkalinity determination.		analysis, E. Rosado and H. Batiz.	57
-- J. Fernandez <i>et al.</i> (Abs.) . . . .	112	F.A. Baczek and V.M. Jesic. . . . .	182	impurities in cane spirit, L.G. de	
-- drainage inadequacy.		-- N. Sendökmen and O.C. Akyar. . .	182	Souza and A.M.S. Llistó. (Abs.)	282
C.W. Chardon and A.V. Rudd. . . .	337	Osijek factory, K. Vojin. (Abs.) . .	23	pectin esterification determination.	
-- A.V. Rudd. (Abs.) . . . . .	15	polysaccharide removal, E.J. Roberts		H. Andres <i>et al.</i> (Abs.) . . . . .	91
-- excess sodium, S. Valdivia V. . .	109	<i>et al.</i> (Abs.) . . . . .	314	pesticide residue determination in	
-- flowering, M.H.R. Julien <i>et al.</i> .	175	preliming optimum alkalinity		beet pulp and molasses.	
-- moisture stress, burning and		determination, L.P. Reva and		P.B. Koster. (Abs.) . . . . .	91
harvesting delay, M. Ilaga. (Abs.)	206	G.A. Simakhina. (Abs.) . . . . .	92	sucrose determination, D. Nurok	
-- row spacing, K.H. Tang. (Abs.)	109	-- vessel, A.P. Parkhod'ko. (Abs.) . .	277	and T.J. Readorn. (Abs.) . . . . .	58
-- soil elements, E.R. Beaufils and		-- L.P. Reva <i>et al.</i> (Abs.) . . . . .	183	-- in cane juice, M.A. Brokensha	
M.E. Sumner. (Abs.) . . . . .	110	refinery liquor non-sugar removal.		<i>et al.</i> (Abs.) . . . . .	349
-- salinity, J.C. Sevilla G. (Abs.)	368	I.F. Bugaenko and A.I. Lapkin. . . .	347	-- and molasses, K.J. Schäffler	
-- tillage method, A.A. Casagrande		-- protein reduction, M.A. Godshall		and I.A. Smith. (Abs.) . . . . .	349
and O.P. Godoy. (Abs.) . . . . .	147	and E.J. Roberts. (Abs.) . . . . .	379	-- compared with polarization.	
-- subsoiling, R. Ricaud. (Abs.) . .	111	second, effect of juice pre-treatment		Anon. (Abs.) . . . . .	187
-- zinc, T.C. Juang <i>et al.</i> (Abs.) . .	110	with lime, A.P. Lapin <i>et al.</i> (Abs.)	54	dextrose and levulose determina-	
-- estimation in Brazil, J.C. Ometto.	110	sugar solution, K. Bara. (Abs.) . . .	348	tion, Anon. (Abs.) . . . . .	188
-- and photosynthetic productivity,		sulphitation process, R.S. Dubey. .	53	---- P.G. Morel du Boil and	
effect of soil salinity, G.V. Joshi		in USSR, Y. F. Tsyukalo <i>et al.</i> . . .	313	K.J. Schäffler. (Abs.) . . . . .	378
and G.R. Naik. (Abs.) . . . . .	48	K.P. Zakharov <i>et al.</i> (Abs.) . . . .	313	sugars determination, H. Schwind	
-- quality, D. MacColl. (Abs.) . . . .	111	vessel, S.P. Mishra. (Abs.) . . . . .	53	<i>et al.</i> (Abs.) . . . . .	379
-- effect of potassium and		-- V.P. Pasechnik <i>et al.</i> (Abs.) . . .	218	-- J.E. Sullivan and L.R. Schewe.	58
phosphorus, B. Sharanappa <i>et al.</i>	48	<i>see also</i> Clarification and Juice, Beet		-- in high fructose corn syrup.	
-- soil characteristics.		Cellulose: manufacture from bagasse.		I.R. West and G.J. Moskowit. . .	123
A.A. Tomaneng. (Abs.) . . . . .	206	A. Fogarassy. (Pat.) . . . . .	29	water determination in beet	
-- sugar content, effect of irrigation.		-- S. Shahine <i>et al.</i> (Abs.) . . . . .	59	molasses, R. Detavernier <i>et al.</i>	123
E. Llerena <i>et al.</i> (Abs.) . . . . .	207	Central American Sugar Technologists		Chromatography, Gel: dextran hydro-	
-- weed competition, R.A. Arevalo		meeting. (Brev.) . . . . .	287	lysate continuous fractionation.	
<i>et al.</i> (Abs.) . . . . .	144	Centrifuges: beet thick juice treatment.		P.E. Barker <i>et al.</i> (Abs.) . . . . .	282
<i>see also</i> Animal fodder; By-products;		W.K. Nielsen. (Abs.) . . . . .	88	factory product colloid content	
Diffusers; Diffusion; Diseases; Fac-		carbonatation mud separation.		determination, A. Rodriguez <i>et al.</i>	187
tory; Fertilizers; Irrigation; Juice;		V.M. Priimak <i>et al.</i> (Abs.) . . . . .	183	pectin molecular weight determina-	
Mechanization; Molasses; Payment;		clarifier mud treatment.		tion, H. Andres <i>et al.</i> (Abs.) . . . .	91
Pests; Soil; Transport; Varieties and		P.N. Stewart <i>et al.</i> (Abs.) . . . . .	154	Chromatography, High-performance	
Weather		dextrose treatment and crystalliza-		liquid <i>see</i> Chromatography, High-	
Carbon, Active, A.R. Dominguez		tion, A. Voilley <i>et al.</i> (Abs.) . . . .	315	pressure liquid	
and A.Y. Hyndshaw. (Abs.) . . . .	122	Centrifugals. (TN) . . . . .	286, 318	Chromatography, High-pressure	
from bagasse, A.M.H.R. Khan <i>et al.</i>	125	A.C. Chatterjee. (Abs.) . . . . .	52	liquid: betaine determination.	
beet juice treatment, H. Zaoarska. .	250	M. Friml and R. Stengl. (Abs.) . . .	277	G. Steinle and E. Fischer. (Abs.)	91
cane juice treatment, C.S. Lee. . . .	180	S. Pichaimuthu. (Abs.) . . . . .	53	phenols determination in beet	
colour removal, S. Sakamaki and		W. Werner and K. Buge. (Pat.) . . .	283	juice, B. Winstrom-Olsen <i>et al.</i> 332,	362
T. Onishi. (Abs.) . . . . .	122	BMA. Anon. (Abs.) . . . . .	183	sucrose esters analysis, R. Cormier	
consumption determination.		continuous. Braunschweigische		<i>et al.</i> (Abs.) . . . . .	381
A. Curbelo S. (Abs.) . . . . .	184	Maschinenbauanstalt. (Pat.) . . . .	317	-- inversion determination.	
effect on sugar determination in high-		Maschinenfabrik Buckau R. Wolf		M.A. Clarke <i>et al.</i> (Abs.) . . . . .	379
colour products, A. Zagoril'ko		AG. (Pat.) . . . . .	316, 317	sugar colorants fractionation.	
<i>et al.</i> (Abs.) . . . . .	26	-- Hein Lehmann AG. (Pat.) . . . . .	316	N.H. Smith. (Abs.) . . . . .	379
fixed vs. moving bed, E. Krauss P. .	184	A. Mercier. (Pat.) . . . . .	61	sugars detection, G.B. Cox and	
regeneration kiln, S. Zagrodzki <i>et al.</i>	314	-- H. Schaper. (Pat.) . . . . .	61	I.K. O'Neill. (Abs.) . . . . .	378
sucrose inversion catalysis.		-- India components manufacturer.		-- determination, D.C. Hunt <i>et al.</i>	25
A.A. Larina and V.G. Aleinikov. .	314	A. Chatterjee and B.R. Math. . . . .	119	-- H.D. Scobell <i>et al.</i> (Abs.) . . . .	26
Carbonatation, F. Buia. (Abs.) . . .	312	-- low-grade massecuite treatment.		Chromatography, Ion exchange: cane	
G. Giordano. (Abs.) . . . . .	312	B.B. Pawar <i>et al.</i> (Abs.) . . . . .	85	molasses treatment, H. Hongisto and	
V.A. Kolesnikov <i>et al.</i> (Abs.) . . .	87	-- molasses yield and purity.		H. Heikkilä. (Abs.) . . . . .	181, 248
automatic control, J. Dober. (Abs.)	312	-- A.P. Chinnaswamy <i>et al.</i> (Abs.)	85	dextrose and levulose separation.	
BMA system. Anon. (Abs.) . . . . .	217	-- for white sugar, D. Hoks. (Abs.)	157	A.J. Melaja <i>et al.</i> (Pat.) . . . . .	28
carbon dioxide absorption kinetics.		-- low-grade sugar purity automatic		Chromatography, Liquid: molasses	
I.M. Fedotkin <i>et al.</i> (Abs.) . . . . .	278	control, K.F. Miller and P.G. Wright.	343	sugar recovery, M. Munir. (Abs.)	345
continuous, S.L. Sang <i>et al.</i> (Abs.)	248	-- washing, A.P. Kozayvkin <i>et al.</i>	89	-- Süddeutsche Zucker-AG. (Pat.)	285
effect on beet juice glutamine		massecuite curing efficiency		Chromatography, Paper: colorants	
content, J. Nedelkovits and		calculation, N.V. Soundarrajan		separation, L. González <i>et al.</i> . . .	188
K. Fábán. (Abs.) . . . . .	91	<i>et al.</i> (Abs.) . . . . .	58	sugars determination, S.N. Karchik	
with flocculants, Anon. (Abs.) . . .	184	-- feed automatic control.		<i>et al.</i> (Abs.) . . . . .	26
A.A. Ivanyuk <i>et al.</i> (Abs.) . . . . .	183	-- K. Kalitynski. (Abs.) . . . . .	250	Chromatography, Thin-layer: cane	
-- F.M. Runggas. (Abs.) . . . . .	377	-- flow rate, J. Gebler <i>et al.</i> (Abs.)	251	juice phospholipids determination.	
flow measurement and control.		-- pre-curing, V. Maurandi. (Abs.)	251	A. Garg. . . . .	200
W. Hogrefe. . . . .	323	-- washing and molasses sugar		phenolic acids identification.	
gas carbon dioxide content, effect		content, Y. D. Kot and		N.H. Paton. (Abs.) . . . . .	124
of lime kiln coke, L. Bazyński. . .	346	L.N. Binevskaya. (Abs.) . . . . .	346	Citric acid: manufacture.	
-- utilization efficiency, N. Marinetti		motors, F. Bändel <i>et al.</i> (Abs.) . .	375	P.K. Agrawal and L. Viswanathan. .	93
and G. Mantovani. (Abs.) . . . . .	88	-- A. Glowacki. (Abs.) . . . . .	375	-- A.J. Kabil. (Pat.) . . . . .	29

# INDEX

	page		page		page
Citric acid: manufacture		Colour: content		Computers:	
- from beet molasses, yeast activity measurement. V.M. Golubtsova.	222	- effect of clarification and boiling. J.F. Silva and F. Zarpelon. (Abs.)	179	product feed automatic control.	
- molasses. H. Husted and H. Rudy.	60	- in evaporator juice, effect of 1st carbonatation juice liming. A.P. Lapin <i>et al.</i> (Abs.)	54	T. Kalitynski. (Abs.)	250
- optimum potassium ferrocyanide dose determination. W. Lesniak.	94	- liquid sugar manufactured by ion exchange. S.E. Bichsel. (Abs.)	375	refining automatic control. T. Ozeki and M. Ishida. (Abs.)	314
- from sugar. P.K. Agrawal <i>et al.</i>	381	formation in aminocarbonyl reaction. L. González C. <i>et al.</i>	219	simulation of boiling. M. Rodríguez B. and V. Polonik. (Abs.)	216
- synthetic medium, effect of cane molasses addition. D.V. Vadehra <i>et al.</i> (Abs.)	94	- by beet phenols. B. Winstrom-Olsen <i>et al.</i>	332, 362	- cane mill feeding. J.R. Abreu G. 215	
Clarification. J.C. Gaiofatto and A.T. Sobrinho. (Abs.)	181	- in dextrose-dipeptide reaction. L. González C. <i>et al.</i> (Abs.)	219	- transport. O.S. Libunao. (Abs.)	114
continuous. N.N. Joshi <i>et al.</i> (Abs.)	154	low-grade sugar reflectance as purity control parameter. K.F. Miller and P.G. Wright. (Abs.)	343	- O.S. Libunao and R.M. Lantini. 241	
dolomitic lime effect. J.M. Zuazua N. 181		Maillard reaction products fractionation. L. González <i>et al.</i> (Abs.)	188	- carbonatation and sulphitation juice flow. C.H. Chen <i>et al.</i>	180
effect of cane extraneous matter. R.P. Scott <i>et al.</i> (Abs.)	348	measurement. J. Dobrzycki. (Abs.)	187	- crystallization. S.M.R. Maudarocus and E.T. White. (Abs.)	343
- juice phospholipids. A. Garg.	200	- raw sugar payment. J.V. López-Ofia. (Abs.)	187	- evaporation and juice heating. W. McWhinney and A.J. Pinkney.	344
- colloids. M. Darias P. and J. Martín B. (Abs.)	52	- sugar products. Anon. (Abs.)	315	- sugar factory processes. H. Pérez de A. and P. Friedman.	67
- filtrate recycling to mixed juice. Anon. (Abs.)	213	- raw sugar. W. Altenburg. (Abs.)	380	sugar factory mass flow coordination. J. Olecki <i>et al.</i> (Abs.)	375
- on polarization. B. Guzmán. (Abs.)	124	- J.V. López-Ofia. (Abs.)	380	white sugar grist determination. G. Rens. (Abs.)	251
efficiency and white sugar ash content. N.A. da Glória <i>et al.</i>	187	- effect of storage. N.V. Kostenko <i>et al.</i> (Abs.)	24	Control, Automatic: beet diffusion. G. Windal. (Abs.)	182
with flocculants. M.C. Bennett <i>et al.</i> (Abs.)	179	- seasonal changes. Anon. (Abs.)	188	- and carbonatation. J. Dober.	312
- J.C.P. Chen. (Abs.)	21	removal by affination. A.P. Kozyavkin and N.I. Odorod'ko. (Abs.)	24	- by equivalent cossette radius. A.I. Fel'dman <i>et al.</i> (Abs.)	218
- C.M. Madrazo. (Abs.)	215	- from cane juice. C.S. Lee. (Abs.)	180	- water acidification. M. Rogowska and Z. Węgrzynowski. (Abs.)	346
- J.T. Rundell and P.R. Pottage.	28	- carbonatation. Anon. (Abs.)	184	- juice flow. S.L. Nemirovskaya <i>et al.</i>	346
- J.T. Rundell <i>et al.</i> (Abs.)	215	- K. Bara. (Abs.)	348	boiling. B.A. Eremenko <i>et al.</i> (Abs.)	87
- G.S. Shephard. (Abs.)	378	- V.P. Pasechnik <i>et al.</i> (Abs.)	218	- T. Kawamura and F. Kawata.	24
- Tate & Lyle Ltd. (Pat.)	285	- V.M. Priimak <i>et al.</i> (Abs.)	183	- G.R. Moller <i>et al.</i> (Abs.)	179
juice colour removal. J.F. Silva and F. Zarpelon. (Abs.)	179	- K.P. Zakharov <i>et al.</i> (Abs.)	313	- K. Sullivan.	259
- liming. J.A. Casey. (Pat.)	284	- ion exchange. J.H. Barrett and D.H. Clemens. (Pat.)	285	- G. Windal. (Abs.)	182
- pH control. (TN)	158	- L. González C. <i>et al.</i> (Abs.)	219	- G. Windal and A. Deleurence.	121
- settling. O.L. Crees <i>et al.</i> (Abs.)	344	- P. Hoareau <i>et al.</i> (Abs.)	122	Brix. N.F. Bondarenko and M.A. Marushchenko. (Abs.)	87
- A.C. Raha. (Abs.)	179	- V.P. Meleshko <i>et al.</i> (Abs.)	183	- V.I. Tuzhilkin <i>et al.</i> (Abs.)	346
- effect of non-sugars. S.C. Sharma. 180		- F.X. Pollio and O. Campos. (Pat.)	284	cane mill feeding. N. Chandappa <i>et al.</i> (Abs.)	119
lime effect on juice composition and scale formation. N.A. da Glória and E. da Silva. (Abs.)	180	- F.X. Pollio and F.X. McGarvey.	157	- milling. J. Abreu and V. Polonik.	216
low-grade remelt liquor. N.L.C. Suzor. (Abs.)	181	- K. Sasaki <i>et al.</i> (Abs.)	377	- train handling. R. Dipplock and K. Marshall. (Abs.)	373
with magnesium oxide. Anon.	214	- K.W.R. Schoenrock <i>et al.</i> (Abs.)	346	carbonatation juice lime salts. W. Uhlenbrock. (Abs.)	278
mud centrifuge treatment. P.N. Stewart <i>et al.</i> (Abs.)	154	- resin fouling. F. Maekawa <i>et al.</i>	377	distillery processes. V.I. Petrunya <i>et al.</i> (Abs.)	350
- filtration, effect of pumping. A.G. Noble and G.A. Brotherton.	344	- regeneration. K. Kawasaki <i>et al.</i>	377	equipment. (TN)	286
scum sugar recovery. Tate & Lyle Ltd. (Pat.)	285	- and molasses yeast fermentation. V.N. Shvets <i>et al.</i> (Abs.)	253	- for fermentation. (TN)	318
single- vs. multiple-tray clarifier performance. M. Mochtar. (Abs.)	179	- phosphatation. M. Matic <i>et al.</i>	184	evaporator juice level. D.H. Mee.	88
SRI clarifier performance. Anon.	213	- from raw sugar, effect of non-sugars zeta-potential. D.V. Freeland <i>et al.</i>	196	flow. W. Hogrefe.	323
zeta-potential of calcium phosphates. R. Fajardo G. and L.D. Bobrovnik.	216	- by remelt and syrup clarification. N.L.C. Suzor. (Abs.)	181	introduction in a sugar factory. V.A.F.I. Isoldi. (Abs.)	155
- refinery liquor non-sugars. D.V. Freeland <i>et al.</i>	196	- with sodium sulphite. L.D. Bobrovnik <i>et al.</i> (Abs.)	218	juice pH. (TN)	158
see also Clarifiers and Juice, Cane Clarifiers: M. Bosnjak. (Pat.)	61	ultrafiltration and reverse osmosis. S. Kishihara and M. Komoto.	347	low-grade sugar purity. K.F. Miller and P.G. Wright. (Abs.)	343
cane wash water. L. Engel. (Abs.)	179	sugar, effect of continuous carbonatation. S.L. Sang <i>et al.</i> (Abs.)	248	product feed. T. Kalitynski. (Abs.)	250
continuous. L.A.R. Pinto. (Abs.)	155	see also Bone char; Carbon, Active and Refining		refining. T. Ozeki and M. Ishida.	314
Enviro-Clear. (TN)	286	Commission Internationale Technique de Sucrerie 16th General Assembly 1979	95, 163, 194	sugar factory laboratory. C.C. Bleyenbergh <i>et al.</i> (Abs.)	313
plate-type settlers. S. Bednarski.	182	Computers: application to beet payment. D.F.A. Horsley and A. Williams. (Abs.)	279	- P.W. van der Poel <i>et al.</i>	168
Sucro AMS. C.M. Madrazo and E.A. Guena. (Abs.)	215	- K. Szczot and H. Jochim. (Abs.)	346	- processes. B.A. Eremenko <i>et al.</i>	183
see also Clarification		- factory maintenance. R.A. Allaway and N.H. Barnes. (Abs.)	373	- H. Kemter. (TN)	382
Colombia: alcohol fuel programme.	351	automatic control systems development in Taiwan. Anon. (NB)	90	sulphitation. J.C. Gaiofatto and A.T. Sobrinho. (Abs.)	181
cane rust. (Brev.)	288	- weighing. (TN)	30	surfactant and antifouling agent feeding. A.F. Kravchuk <i>et al.</i> (Abs.)	23
sugar exports and the International Sugar Agreement.	190, 257	beet diffusion and carbonatation control. J. Dober. (Abs.)	312	systems development in Taiwan. Anon. (NB)	90
- US import policy. (NC)	2	boiling automatic control. J. Burjane and M. Kmínek. (Abs.)	182	see also Computers	
- industry. C. Alincastre. (Abs.)	52	- H. Kemter. (TN)	382	Control, Chemical: beet brei analysis, effect of freezing. A. Arbizzani and P. Laghi. (Abs.)	220
- expansion. (Brev.)	64	- G. Windal and A. Deleurence.	121	- juice purity determination. M. Roche. (Abs.)	376
project. (Brev.)	96	- continuous analysis. A.D. Randolph and C.S. Tan. (Abs.)	216	- marc determination. H. Gruszecka.	348
Colour: beet juice, liming system comparison. I. Vigh. (Abs.)	375	cane sugar factory crushing optimization. R.G. Hoekstra. (Abs.)	374	- sampling. D. Bourdon. (Abs.)	376
- molasses colouring matter and sugar content. N.P. Silina <i>et al.</i>	346	commodity data bank. (Brev.)	255	- tarehouse data processing for beet payment. D.F.A. Horsley and A. Williams. (Abs.)	279
- thick juice, effect of carbonatation. A.F. Yakimov. (Abs.)	87	comparison with programmable calculators. J.R. Vyse and H. Morten. (Abs.)	278	- equipment. M.Z. Khelmskii <i>et al.</i>	188
- and molasses colorants fractionation. M. Wachowicz. (Abs.)	315	control systems. (TN)	286	- O. Krieger. (Abs.)	315
cane juice, effect of cane extraneous matter. R.P. Scott <i>et al.</i> (Abs.)	348	heat and mass balance calculation. E. Farwick. (Abs.)	375	- A.Y. Zagorul'ko <i>et al.</i> (Abs.)	92
- clarifier type. M. Mochtar.	179	laboratory data processing. C.C. Bleyenbergh <i>et al.</i> (Abs.)	313	cane juice additional water calculation in milling. S. Nath and S.N. Tripathi. (Abs.)	85
- harvesting delay. Anon. (Abs.)	213	- H. Rudolf <i>et al.</i> (Abs.)	313	- molasses exhaustibility determination. J. Bruijn. (Abs.)	248
colorants effect on calcium phosphate zeta-potential. R. Fajardo G. and L.D. Bobrovnik. (Abs.)	216	- P.W. van der Poel <i>et al.</i>	168	- pol and fibre determination. A.P. Gupta. (Abs.)	380
- in raw sugar. T. Yamane <i>et al.</i>	315	musseculite parameters analysis for exhaustion determination. G.R.E. Lionnet. (Abs.)	349	quality determination. V.H. Chiappino. (Abs.)	57
- fractionation by high-pressure liquid chromatography. N.H. Smith. (Abs.)	379			- sample preparation. J.F.G. Pereira.	187
content in cane juice, syrup and sugar, effect of sulphurcarbonatation. R.S. Dubey. (Abs.)	53			- sampler. R. Bodger and C.B. van der Riet. (Abs.)	374
				- sampling and analysis. N.A. da Glória <i>et al.</i> (Abs.)	380

# INDEX

	page		page		page
Control, Chemical:		Crystallizers:		Dextrose: isomerization and syrup	
cane juice sampling, A.C. Sturion, 180, 281		design, E.E.A. Rouillard, (Abs.) . . . . .	156	properties, K. Vukov <i>et al.</i> (Abs.) . . . . .	25
- soil content estimation, Anon. . . . .	213	massecuite feed flow rate.		kojic acid fermentation, P. Bajpai	
- sugar recovery calculation.		J. Gebler <i>et al.</i> (Abs.) . . . . .	251	<i>et al.</i> (Abs.) . . . . .	93
S.N. Sinha <i>et al.</i> (Abs.) . . . . .	20	Cuba: aid for Ethiopian sugar		levulose ratio changes in factory	
Codex Alimentarius sugar analysis		industry, (Brev.) . . . . .	265	products, E. Reinefeld <i>et al.</i> . . . . .	57
methods, Anon. (Abs.) . . . . .	315	bagasse paper pilot plant.		reaction with amino-acid and colour	
discrepancies between beet and		P.L. Gutiérrez and R. Molina M. . . . .	222	formation, L. González <i>et al.</i> . . . . .	219
cassette sugar contents.		bulk sugar terminal (Brev.) . . . . .	265	- dipeptides and colour formation.	
G.F. Tyazhelova, (Abs.) . . . . .	376	by-products utilization project.		L. González <i>et al.</i> (Abs.) . . . . .	219
laboratory cane mill juice analysis		O. Almazán del O. and A. Roca G. . . . .	222	recovery from bagasse pith hydro-	
for cane payment, H.G. Ayala		cane agriculture, H. Gruszecka, . . . . .	304	lysate, C.I. Nee and W.F. Yee, . . . . .	381
<i>et al.</i> (Abs.) . . . . .	26	- harvest 1978/79, (Brev.) . . . . .	383	separation from levulose.	
- data processing by computer.		- planter manufacture, (Brev.) . . . . .	255	A.J. Melaja <i>et al.</i> (Pat.) . . . . .	28
C.C. Bleyenbergh <i>et al.</i> (Abs.) . . . . .	313	- research, M. Anderez V. (NB) . . . . .	186	solution alcohol fermentation.	
--- H. Rudolf <i>et al.</i> (Abs.) . . . . .	313	- varietal trials, R. Díaz M. <i>et al.</i> . . . . .	244	W. Engelbart and H. Dellweg, . . . . .	253
--- P.W. van der Poel <i>et al.</i> . . . . .	168	nematodes, J.P. O'Reilly and		solvation saturation, A. Smelik, . . . . .	25
- programmable calculator.		J.R. Pérez M. (Abs.) . . . . .	150	utilization as sweetener and chemical	
B.L. Karren and M.K. Faviell, . . . . .	278	new sugar factories, (Brev.) . . . . .	223	feedstock, G.G. Birch and	
--- J.R. Vyse and H. Morten, (Abs.) 278		sugar expansion plans, (NC) . . . . .	66	K.J. Parker, (NB) . . . . .	185
low-grade massecuite curing efficiency		- factory plant replacement, (Brev.) . . . . .	95	<i>see also</i> Invert sugar; Reducing	
calculation, N.V. Soundarrajan <i>et al.</i> 58		- industry, H. Gruszecka, (Abs.) . . . . .	310	sugars and Sugars, . . . . .	
mass and heat balance calculation.		- production 1978/79, (NC) . . . . .	257	Dictionaries: English-Portuguese, cane	
E. Farwick, (Abs.) . . . . .	375	- statistics, (Stat.) . . . . .	256	diseases and pests.	
massecuite and molasses analysis.		yeast plant, (Brev.) . . . . .	63	M.P.S.B. Gonçalves, (NB) . . . . .	186
T.K.K. Menon and V.C. Nair, . . . . .	58	Cube sugar <i>see</i> Tablet sugar		Portuguese sugar terms.	
molasses sugar and thick juice purity		Czechoslovakia: beet varietal trials.		M.P.S.B. Gonçalves, (NB) . . . . .	186
estimation, W. Drewnowska and		L. Schmidt <i>et al.</i> (Abs.) . . . . .	309	Spanish-Russian sugar terms.	
A. Butwilowicz, (Abs.) . . . . .	345	sugar consumption, (Brev.) . . . . .	384	J. Moreno P. and J. Lodos, (NB) . . . . .	90
reduced boiling house recovery		- exports, (Stat.) . . . . .	255	Diffusers, Beet, C.H.J. Pinet, (Pat.) . . . . .	87
calculation, R.T. Patil and		- production 1978/79, (Brev.) . . . . .	224	corrosion prevention, N.P. Romenskii, . . . . .	87
J.B. Chavan, (Abs.) . . . . .	348			repair, modernization and adjust-	
sucrose vs. pol balances, Anon. . . . .	187			ment, I.O. Andrianov <i>et al.</i> (NB) . . . . .	280
--- M.A. Brokensha <i>et al.</i> (Abs.) . . . . .	349			ring, N.N. Pushanko <i>et al.</i> (Abs.) . . . . .	249
--- R. Detavernier <i>et al.</i> (Abs.) . . . . .	123			tower, Braunschweigische	
--- K.J. Schäffler and I.A. Smith, . . . . .	349			Maschinenbauanstalt, (Pat.) . . . . .	316
sugar factory balances calculation.				- A.P. Parkhod'ko, (Abs.) . . . . .	249
E. David, (Abs.) . . . . .	379			<i>see also</i> Diffusion, Beet	
- product analysis, J. Dobrzycki, . . . . .	187			Diffusers, Cane, BMA, Anon. (Abs.) . . . . .	215
- solution purity determination.				"Hi-Extractor", P. Triviz, (Abs.) . . . . .	181
J. Ponant, (Abs.) . . . . .	220			transfer efficiency, G.V. Genie, . . . . .	156
<i>see also</i> Ash; Brix; Colour; Filtra-				<i>see also</i> Diffusion, Cane	
bility; Invert sugar; Losses; Polari-				Diffusion, Beet, A.I. Feldman <i>et al.</i> . . . . .	218
metry; Reducing sugars; Sucrose;				Great Western Sugar Co. (Pat.) . . . . .	317
Sugar and Water				R. Shokrani and H.J. Delavier, . . . . .	217
Conveyors, (TN) . . . . .	286, 382			automatic control, J. Dober, (Abs.) . . . . .	312
V. Urban, (Abs.) . . . . .	278			- G. Windal, (Abs.) . . . . .	182
beet elevator, N.D. Khomenko and				cossette length optimization.	
V.G. Yarmilko, (Abs.) . . . . .	22			Y.A. Terent'ev <i>et al.</i> (Abs.) . . . . .	313
belt weighers, (Brev.) . . . . .	286			counter-current combined with direct	
bulk terminal link with deep-water				flow, N.V. Pogorelova and	
wharf, Anon. (Abs.) . . . . .	215			V.M. Lysyanskii, (Abs.) . . . . .	313
cane sampler, R. Bodger and				<i>see also</i> on pulp moisture content.	
C.B. van der Riet, (Abs.) . . . . .	374			V.N. Bazlov, (Abs.) . . . . .	89
filter-cake, Z. Kembrowski <i>et al.</i> . . . . .	312			flow measurement and control.	
rake, G.N. Stepanov, (Abs.) . . . . .	250			W. Hogrefe, . . . . .	323
refined sugar, . . . . .	347			heat and mass balance calculation	
tubular bridge housings, (TN) . . . . .	318			by computer, E. Farwick, (Abs.) . . . . .	375
<i>see also</i> Bulk handling and Mills, Cane				juice purity as performance	
Coolers: molasses, M.R. Player <i>et al.</i> . . . . .	344			indicator, M. Roche, (Abs.) . . . . .	376
sugar, V. Duhem, (Abs.) . . . . .	376			losses, M. Milic, (Abs.) . . . . .	88
white sugar, A.F. Zaborzin <i>et al.</i> . . . . .	54			- measurement, R. Detavernier <i>et al.</i> . . . . .	123
- fluidized bed, A.A. Dmytryk <i>et al.</i> . . . . .	22			midday acidification, J.F.T. Oldfield, . . . . .	279
Corrosion: boilers, B.B. Khochare, . . . . .	248			<i>et al.</i> (Abs.) . . . . .	279
effect of incondensable gases.				residence time determination.	
G. Mantovani, (Abs.) . . . . .	54			T. Cronewitz <i>et al.</i> (Abs.) . . . . .	376
prevention, L. Zamecniak, (Abs.) . . . . .	250			scroll speed fluctuation and sugar	
- in beet diffusers, N.P. Romenskii, . . . . .	87			losses, Y.P. Dobrobaba, (Abs.) . . . . .	89
- evaporators, Anon. (Abs.) . . . . .	183			steam composition optimization.	
- white sugar silo, P. Godulla <i>et al.</i> . . . . .	250			J. Ledoux, (Abs.) . . . . .	22
Costa Rica: cane mill order, (Brev.) . . . . .	95			water acidification, M. Rogowska	
sugar production 1977/78, (Brev.) . . . . .	287			and Z. Węgrzynowski, (Abs.) . . . . .	346
- vitaminization, E. Portela <i>et al.</i> . . . . .	179			<i>see also</i> Diffusers, Beet	
Crystallization, Massecuite, Anon. . . . .	214			Diffusion, Cane, B. St. C. Moor, . . . . .	310
computer simulation, S.M.R.				R. Shokrani and H.J. Delavier, . . . . .	217
Maudarobus and E.T. White, . . . . .	343			for alcohol manufacture, C. Ebeling, . . . . .	381
protein reduction, M.A. Godshall and				extraction vs. milling, P.S. Kelly and	
E.J. Roberts, (Abs.) . . . . .	379			R.G. Porter, (Abs.) . . . . .	311
Tully sugar factory, R.J. Swindells				juice Brix profiles as performance	
<i>et al.</i> (Abs.) . . . . .	311			indicators, Anon. (Abs.) . . . . .	213
<i>see also</i> Boiling and Massecuite				- flow, G.A. Matthesius, (Abs.) . . . . .	120
Crystallization, Sucrose, A. VanHook, 124				<i>see also</i> Diffusers, Cane	
in aqueous alcohol, L. Carrazana R.				Diseases, Beet: black leg control.	
<i>et al.</i> (Abs.) . . . . .	219			N. Jarowaja, (Abs.) . . . . .	276
effects of centrifugal force.				control in Poland, M. Kubacka-	
A. Voilley <i>et al.</i> (Abs.) . . . . .	315			Szmidtgal, (Abs.) . . . . .	276
- dextran, raffinose and KCl, . . . . .	58			curly top control, D.L. Mumford, . . . . .	276
G. Mantovani <i>et al.</i> (Abs.) . . . . .	58			fungi control, W.G. Miles <i>et al.</i> . . . . .	212
- kestoses, Anon. (Abs.) . . . . .	188			fungicides, V. Kovács, (Abs.) . . . . .	276
kinetics, A.I. Gromkovskii <i>et al.</i> . . . . .	220			leaf spot control, C.N. Giannopolitis, . . . . .	247
Crystallizers: BMA vertical, Anon. . . . .	218			- and leaf number effect on beet	
- performance, (TN) . . . . .	318			sugar content, J. Kralović, . . . . .	274
continuous, M. Friml and R. Stengl, . . . . .	277			- root lesions, C.N. Giannopolitis, . . . . .	247
- flow pattern and efficiency determin-				midew of seed beet in France, A.	
ation, I.K. Kirby <i>et al.</i> T. White, . . . . .	343			Lebrun, (Abs.) . . . . .	212
- pressure head loss determination.				pelleted seed fungicide effect on	
E.T. White and S.M.R.				germination, W. Hrubec and	
Maudarobus, (Abs.) . . . . .	343			F. Wieser, (Abs.) . . . . .	245



# INDEX

	page		page		page
Diseases, Beet:		Diseases, Cane:		Distillery:	
powdery mildew control. P. Meeus.	212	red rot resistant variety. K.K.P.		waste treatment. V. Hanumanulu and	
root rot and crown rot incidence, effect of herbicide, pesticide and nitrogen. R.J. Hecker and E.G. Ruppel.	276	Rao <i>et al.</i> (Abs.)	83	P.V.R. Subrahmanyam. (Abs.)	254
-- and leaf spot control.		-- transmission. V.P. Agnihotri <i>et al.</i>	263	-- S.T. Kale. (Abs.)	254
P.S. Bhatnagar and G.B. Pant.	17	-- F. Alonso. (Abs.)	341	-- V.A. Vitkovskaya <i>et al.</i> (Abs.)	254
virus yellows in Belgium. L. van Steyvoort. (Abs.)	247	-- varietal reaction. K.K. Prasad Rao <i>et al.</i> (Abs.)	116	-- by enzyme. L.H. Wang <i>et al.</i>	252
-- control in US. J.E. Duffus. (Abs.)	276	-- strip artificial inoculation.		-- utilization. W. Lewicki. (Abs.)	27
-- vector control. Anon. (Abs.)	212	A. Chinae <i>et al.</i> (Abs.)	115	see also Alcohol and Fermentation	
-- L. van Steyvoort. (Abs.)	212	research in Mauritius. Anon. (Abs.)	81	Dominican Republic: cane damage by	
Diseases, Cane: brown spot in Taiwan. H.W. Hsieh and D.S. Tseng. (Abs.)	371	rind disease. H.P. Liu <i>et al.</i> (Abs.)	115	hurricane. (Brev.)	383
cane susceptibility, effect of fertilization. Anon. (Abs.)	242	rot x borer effect on cane quality. G.M. de A. Silva and R.S. de Moraes.	209	sugar factory study. (Brev.)	290
-- varietal response differences in Brazil. Anon. (Abs.)	243	rust in Colombia. (Brev.)	288	-- situation. (Brev.)	32
control. B.T. Egan. (Abs.)	115	-- control. M.B. Bachchhav <i>et al.</i>	341	-- statistics 1978. (Stat.)	237
-- C.G. Hughes. (Abs.)	116	-- new strain in Queensland. (Brev.)	160	Drives. (TN)	286
-- by agronomic practices.		-- in Puerto Rico. (Brev.)	64, 191	cane mill turbine repairs.	
K.C. Alexander and H.C. David.	81	-- US. (Brev.)	191, 351	B.P. Barge. (Abs.)	53
-- in India. P.N. Avasthy. (Abs.)	50	smut control by sett hot water treatment. M.R. Gupta. (Abs.)	149	centrifugal motors. F. Bändel <i>et al.</i>	375
-- by seed cane programme in India. K. Singh. (Abs.)	81	-- treatment. M.R. Gupta. (Abs.)	149	-- A. Glowacki. (Abs.)	375
sett heat treatment. G.T.A. Benda and C. Ricaud. (Abs.)	150	-- emergency regulations in US.	95	masseuite mixer. Soc.D'Exploitation d'Usines Metallurgiques. (Pat.)	317
-- with moist air. N.S.L. Srivastava <i>et al.</i> (Abs.)	81	-- and grassy shoot control. V.V. Tembhekar and D.K. Patel.	50	steam and diesel engine automatic stop system. M.K. Biswas and M. Singh. (Abs.)	53
droopy top. E.A. Pembroke. (Abs.)	14	-- in Guyana. V.M. Young-Kong.	16	see also Steam turbines	
English-Portuguese dictionary. M.P.S.B. Gonçalves. (NB)	186	-- incidence, effect of treatment against ratoon stunting. R.A. Bailey. (Abs.)	115	Dryers. (TN)	318
eye spot in Australia. T.G. Willcox and C.M. McAleese. (Abs.)	371	-- inoculation of seedlings. M.L.R. Duarte and H. Tokeshi.	116	sugar. V. Duhem. (Abs.)	376
Fiji disease in Australia. B.T. Egan.	306	-- and leaf scald association. R.A. Bailey. (Abs.)	341	-- order from Mauritius. (Brev.)	30
-- breeding for resistance. Anon.	51	-- resistance ratings. A.M. Whittle.	341	tablet sugar. V.A. Zubatov <i>et al.</i>	122
-- resistance testing. R. Anon.	90	-- testing. K.C. Alexander. (Abs.)	341	white sugar. A.F. Zaborsin <i>et al.</i>	54
-- surveys in Australia. P.A. Jones.	82	-- and rust effects on sugar production in Jamaica. (Brev.)	384	-- fluidized bed. A.A. Dmytryuk <i>et al.</i> (Abs.)	22
fungi associated with weevil damage. R. Acosta B. and F.A. Rodríguez.	209	-- in St. Kitts. (Brev.)	64	Drying: bagasse. P.P. Chaturvedi.	119
fungicide effect on cane height. J.D. Nimbalkar and G.R. Naik.	15	-- spore germination. K.C. Alexander and K. Ramakrishnan. (Abs.)	149	-- R.T. Khurd. (Abs.)	53
-- protection of cane setts. S.M. Yang and H.J. Braud. (Abs.)	116	-- strains compatibility. W.H. Hsieh and C.S. Lee. (Abs.)	243	-- heat economy evaluation. S.K. Ghosh. (Abs.)	154
fungus formation on cane arrows. A.M. Whittle. (Abs.)	306	-- in Hawaii. J.C. Comstock and D.J. Heinz. (Abs.)	16	beet pulp. (TN)	318
<i>Fusarium moniliforme</i> and <i>F. tricinum</i> . H. Koike. (Abs.)	306	-- varietal resistance. S. Vir and M.S. Behniwal. (Abs.)	273	-- J. Malczewski. (Abs.)	253
leaf blight infection mechanism. Z.N. Wang and C.S. Lee. (Abs.)	243	-- rating. R.G. Singh. (Abs.)	243	-- drum inlet temperature and capacity optimization. H. Huber.	59
-- scald in Australia. I.T. Freshwater.	82	<i>Spaethotheca schweinfurthiana</i> in India. M.B. Bachchhav. (Abs.)	306	-- with gas turbine heat. W.J. Leibig.	282
-- diagnosis. Y. Masuda and H. Tokeshi. (Abs.)	306	streak virus strains. C. Ricaud and S. Félix. (Abs.)	149	excess activated sludge. J. Yamaga and S. Shirakawa. (Abs.)	282
-- A.R. Oliveira <i>et al.</i> (Abs.)	149	symptoms and control. V.P. Agnihotri and K. Singh. (Abs.)	81	Dust: fire hazards. H.E.C. Powers.	280
-- C. Ricaud <i>et al.</i> (Abs.)	149	varietal resistance trials in Uganda. M. Simbwa-Bunnya. (Abs.)	341	separators. (TN)	318
-- survival in blade grass. Anon.	82	white leaf transmission by leaf-hopper. C.T. Chen. (Abs.)	243	-- order from UK. (Brev.)	286
-- symptom development failure. Anon. (Abs.)	82	yellow spot in Mauritius. C. Ricaud <i>et al.</i> (Abs.)	341	sugar, separation. G.A. Abazyan.	313
mosaic alternative host. K.S. Bhargava <i>et al.</i> (Abs.)	306	Distillery: automation. V.I. Petrunya <i>et al.</i> (Abs.)	350	-- I.I. Prilutskii and P.A. Lyubarets.	22
-- control by heteropolyanions. V.K. Srivastava <i>et al.</i> (Abs.)	16	column tray efficiencies. R. Alemán and G. Portal. (Abs.)	222	see also Boilers and Furnaces	
-- infection of Q 83 cane. A.L. Fors.	273	erection proposals in India. P.N. Soman. (Abs.)	93	Ecuador: sugar situation. (Brev.)	95
-- inhibitor. R.D. Joshi and J. Prakash. (Abs.)	306	in Fiji. (Brev.)	128	Egypt: cane flowering and breeding. A.I. Allam <i>et al.</i> (Abs.)	244
-- resistance breeding of cane. R.D. Breaux and H. Koike. (Abs.)	149	flow regulation calculations. J. Blanc. (Abs.)	279	-- A.I. Allam <i>et al.</i> (Abs.)	152
-- virus infectivity. J.L. Dean. (Abs.)	115	in Kenya. (Brev.)	383	-- Z.A. Menshawi. (Abs.)	244
-- strain identification. A.G. Gillaspie <i>et al.</i> (Abs.)	115	Mauritius. (Brev.)	160	varieties and yield. A.I. Allam.	244
nutrient deficiency symptoms. U.S. Singh. (Abs.)	370	Philippines. (Brev.)	288, 384	pokkah boeng incidence. A.M. Higgy <i>et al.</i> (Abs.)	150
orange freckle. Anon. (Abs.)	337	power supply by external associations. L.G. de Souza <i>et al.</i> (Abs.)	310	sugar expansion plans. (Brev.)	320
in Papua-New Guinea. H. Koike.	272	-- voltages in Brazil. C. Piedade <i>et al.</i>	248	-- situation. (Brev.)	31
pineapple disease control. G.R. Bechet. (Abs.)	242	waste concentration. L.P. de Biase.	381	white sugar silo. (Brev.)	64
pokkah boeng in Egypt. A.M. Higgy <i>et al.</i> (Abs.)	150	-- as fertilizer. M.L. Agarwal and S.P. Dua. (Abs.)	254	Electrodialysis: beet juice treatment. F. Perschak. (Abs.)	279
ratoon stunting anti-serum. A.G. Gillaspie. (Abs.)	273	-- F. Brigger. (Abs.)	59	effect on syrup crystallization rate. N.S. Fedorova and L.D. Bobrovnik.	219
-- bacterium. L.J. Liu. (Abs.)	272	-- J.M. Lorenzetti and P.G.R. Freitas.	368	refinery molasses treatment. T. Hiramoto. (Abs.)	314
-- N. Rishi and P. Nath. (Abs.)	273	-- effect of nitrogen and phosphorus addition. J.A. Magro and N.A. da Glória. (Abs.)	207	Electrophoresis. Gel: colorants separation. L. González <i>et al.</i>	188
-- detection. K.E. Damann <i>et al.</i>	149	-- mixed with herbicide. A. Buss.	280	protein determination in raw and refined sugar. M.A. Godshall and E.J. Roberts. (Abs.)	379
-- diagnosis. R.W. Harris and A.G. Gillaspie. (Abs.)	242	-- fodder yeast cultivation. L.D. Il'ina <i>et al.</i> (Abs.)	222	Entrainment: continuous monitoring for sugar. K.J. Schaffler. (Abs.)	378
-- D.S. Teakle <i>et al.</i> (Abs.)	306, 371	-- mixture with beet pulp as animal fodder. R. Brierley-Tremontoise.	317	separator. R. Archibald and C. Mack. (Abs.)	374
red rot biotypes and varietal reactions. M.N. Sarma and M.A. Rao. (Abs.)	50	-- mushroom mycelium propagation. J.T. Aguinaldo. (Abs.)	59	Enzyme: activity in yeast fermentation, effect of molasses decolorization. V.N. Shvets <i>et al.</i> (Abs.)	253
-- effect on cane tissue phenol content. K.I. Wilson and D.N. Srivastava. (Abs.)	242	-- potassium fertilizer manufacture. A.C. Chatterjee <i>et al.</i> (Abs.)	252	browning compound formation in sugar. N.H. Smith. (Abs.)	379
-- infection and invertase activity. G.A. da Silva <i>et al.</i> (Abs.)	116	-- poultry feed and fertilizer production. B.B. Paul. (Abs.)	252	cane fructofuranosidase. F.E. Prado <i>et al.</i> (Abs.)	174
-- leaf sheath control. S. Matsuoka and M.M. Aguilera. (Abs.)	116	-- recycling and alcohol fermentation of beet molasses. N. Taygun <i>et al.</i> (Abs.)	282	-- invertase activity and red rot infection. G.A. da Silva <i>et al.</i>	116
-- midrib lesions. H.D. Lewin <i>et al.</i>	273	-- treatment. C.A. Accorsi and F. Zama. (Abs.)	93	-- and diastase activity, effect of ripeners. A.S. Chacravarti <i>et al.</i>	48
		-- R.S. Dubey <i>et al.</i> (Abs.)	93	-- nitrate reductase activity, effect of age and fertilization. E.L. Rosario and K. Sooksathan. (Abs.)	176
				-- nitrogenase activity. A.P. Ruschel and R. Ruschel. (Abs.)	206
				-- effect of fertilizers. A.P. Ruschel <i>et al.</i> (Abs.)	176
				-- nitrogen-fixing bacteria. A.P. Ruschel <i>et al.</i> (Abs.)	176
				-- phosphatases. A.R. Sampietro <i>et al.</i>	15

# INDEX

	page		page		page
Enzyme: determination of dextrose and levulose. W. Mauch and E. Krause. . . . .	124	Factory: applications of stainless steel. E. Hale. (Abs.) . . . . .	52	Fermentation: beet molasses ash component concentrations. V.N. Shvets <i>et al.</i> (Abs.) . . . . .	221
- sugar losses in beet diffusion and molasses. R. Detavernier <i>et al.</i> . . . . .	123	- bacteriological control. A. Simonart and J.P. Dubois. (Abs.) . . . . .	250	- dextran production from sucrose. N.M. Sheikh and M. Hossain. . . . .	125
- dextran removal from raw sugar. R.P. Fulcher and P.A. Inkerman. . . . .	348	- bagasse and trash consumption and power generation potential in Hawaii. D. Murata and W. Gibson. . . . .	21	- dextrose and cane molasses. M.A. el-Sayed and A. Abo-Shady. . . . .	27
- in sugar processing. B.T. Egan <i>et al.</i> (Pat.) . . . . .	109	- beet processing. M.G. Koukios. . . . .	182	- distillery waste treatment. V. Hanumanulu and P.V.R. Subrahmanyam. (Abs.) . . . . .	254
- dextrose isomerase. F.C. Armbruster <i>et al.</i> (Pat.) . . . . .	283	- in India. A.D. Karve. (Abs.) . . . . .	87	- V.A. Vitkovskaya <i>et al.</i> (Abs.) . . . . .	254
- isomerization to levulose. L.E. Coker and D.E. Gardner. . . . .	283	- materials flow coordination. J. Oledzki <i>et al.</i> (Abs.) . . . . .	375	- equipment. (TN) . . . . .	318
- Corning Glass Works. (Pat.) . . . . .	285	- optimization. J. Poniecki. (Abs.) . . . . .	346	- gum production from sucrose. W.P. Chen <i>et al.</i> (Abs.) . . . . .	125
- CPC International Inc. (Pat.) . . . . .	316	- research in US. Anon. (Abs.) . . . . .	91	- kojic acid manufacture from cane molasses, effect of clarification. P. Bajpai <i>et al.</i> (Abs.) . . . . .	93
- D.L. Lartigue and H.H. Weetall. . . . .	60	- cane crushing optimization by dynamic programming. R.G. Hoekstra. (Abs.) . . . . .	374	- yeast extract. P. Bajpai <i>et al.</i> . . . . .	93
- Rhone-Poulenc S.A. (Pat.) . . . . .	317	- products alcohol content. J.D. Blake and K.E. McNeil. . . . .	343	- molasses, effect of invert sugar content. E.W. Krause. (Abs.) . . . . .	281
- Standard Brands Inc. (Pat.) . . . . .	285	- E. Cerrizuela. (Abs.) . . . . .	79	- mash analysis by gas-liquid chromatography. E. Rosado and H. Batiz. (Abs.) . . . . .	57
- M. Suekane <i>et al.</i> (Pat.) . . . . .	29	- electrical equipment. (TN) . . . . .	286	- pre-treatment. M. Pietrzak. (Abs.) . . . . .	345
- M. Tamura <i>et al.</i> (Pat.) . . . . .	284	- energy consumption reduction in France. J. Ledoux. (Abs.) . . . . .	22	- protein production. L.E. Slater. . . . .	59
- distillery waste treatment. L.H. Wang <i>et al.</i> (Abs.) . . . . .	252	- equipment. (TN) . . . . .	158, 382	- mushroom mycelium propagation on vinasse and cane molasses. J.T. Aguinaldo. (Abs.) . . . . .	59
- levulose and levan production from sucrose. (Brev.) . . . . .	159	- lubrication. T.M. Karne. (Abs.) . . . . .	310	- sugar factory effluent treatment. Anon. (Abs.) . . . . .	218
- saccharification of bagasse. R.K. Andren <i>et al.</i> (Abs.) . . . . .	350	- manufacturer centenary. (TN) . . . . .	318	- K. Kaiser <i>et al.</i> (Abs.) . . . . .	282
- pith. L.H. Wang and Y.C. Kuo. . . . .	126	- fuel efficiency and steam consumption. P.J.M. Rao. (Abs.) . . . . .	311	- J.P. Lescure and P. Bourlet. . . . .	121
- starch removal from sugar factory products. S. Bose <i>et al.</i> (Abs.) . . . . .	157	- heat recovery. P.M. Rao and S.K. Ghosh. (Abs.) . . . . .	154	- D.E. Simpson and J. Hemens. . . . .	347
- Ethiopia. HVA. Anon. (NB) . . . . .	185	- loss reduction. D. Christoph and E. Manzke. (Abs.) . . . . .	249	- refinery effluent treatment. K. Akiyama and M. Okada. . . . .	377
- sugar industry aid from Cuba. . . . .	265	- and steam economy. S.K. Ghosh. . . . .	119	- tryptophan production from beet molasses. L.K. Smirnova <i>et al.</i> . . . . .	27
- Europe: beet area 1979. (NC) 131,194,288		- and mass balance calculation by computer. E. Farwick. (Abs.) . . . . .	375	- valine production from beet molasses. Z. Popova and I. Murgov. (Abs.) . . . . .	350
- sugar production 1979/80. (NC) . . . . .	321	- laboratory programmable calculator. B.L. Karren and M.K. Faviell. . . . .	278	- <i>see also</i> Micro-organisms and individual fermentation products including Alcohol, Citric acid, Yeast, etc.	
- EEC beet and sugar prices. (NC) 65, 225		- J.R. Vyse and H. Morten. . . . .	278	Fertilizers: aerial application. C.A. Lang. (Abs.) . . . . .	339
- and currencies. (NC) . . . . .	162	- location and average cane haulage distance. C.M.R. Drajier. (Abs.) . . . . .	179	- application in India. K. Singh <i>et al.</i> . . . . .	304
- Cameroun sugar production expansion. (NC) . . . . .	193	- maintenance. R.A. Allaway and N.H. Barnes. (Abs.) . . . . .	373	- irrigation water. Anon. (Abs.) . . . . .	369
- ISA membership. (NC) . . . . .	1, 225	- mathematical simulation model. H. Pérez de A. and P. Friedman. . . . .	67	- bagasse furnace ash. Y.C. Pan <i>et al.</i> . . . . .	109
- levy on high fructose corn syrup. (NC) . . . . .	194, 255	- modernization and expansion at Newark. F. Robson and M. Flack. . . . .	42, 72	- beet drilling x variety trials in Hungary. L. Lukács. (Abs.) . . . . .	308
- sugar dumping in US. (Brev.) . . . . .	159, 256	- performance in Fiji. R. Karan. . . . .	213	- nutrient requirements. R. Vanstallen and A. Jardin. . . . .	308
- exports, 1978. (NC) . . . . .	354	- improvement policy in Brazil. J.H. Payne. (Abs.) . . . . .	310	- thick juice non-sugars. S.E. Bichsel. . . . .	375
- to USSR. (Brev.) . . . . .	223	- in India. V.R. Bhosale <i>et al.</i> . . . . .	20	- calcium silicate treatment assessment. Anon. (Abs.) . . . . .	78
- import quotas for ACP countries. . . . .	193	- A.P. Gupta and S.V. Singh. . . . .	20	- cane requirements determination by soil and plant analysis. G. Price. . . . .	304
- production quotas. (NC) . . . . .	353	- UK. J.F.T. Oldfield <i>et al.</i> (Abs.) . . . . .	279	- dried activated sludge. J. Yamaga and S. Shirakawa. (Abs.) . . . . .	282
- regime. (NC) . . . . .	257	- power factor improvement calculation. J. van Dokkum. (Abs.) . . . . .	374	- effect on beet growth. W.C. von Kessel. (Abs.) . . . . .	308
- sugar production 1978/79. (NC) . . . . .	98	- generation and fuel consumption. W. Leibig. (Abs.) . . . . .	154, 216	- cane chemical composition. S.P. Dua and R.C. Singh. (Abs.) . . . . .	238
- Evaporators. (TN) . . . . .	318	- in India. P.J.M. Rao. (Abs.) . . . . .	52	- enzyme activity. E.L. Rosario and K. Sooksathan. (Abs.) . . . . .	176
- P. Christodoulou. (Abs.) . . . . .	182	- supply to public grid. P.J.M. Rao. . . . .	248	- A.P. Ruschel <i>et al.</i> (Abs.) . . . . .	176
- K. Urbaniec <i>et al.</i> (Abs.) . . . . .	250	- K.W. Watts <i>et al.</i> (Abs.) . . . . .	343	- leaf area, quality and yield. E.L. Rosario <i>et al.</i> (Abs.) . . . . .	176
- condenser. V.I. Dovgopoli <i>et al.</i> . . . . .	89	- supply by external associations. L.G. de Souza <i>et al.</i> (Abs.) . . . . .	310	- nutrient status. J. Orlando <i>et al.</i> . . . . .	112
- downflow tube evaporation of cane juice containing surfactant. O.O. Omatete and H.H. Sephton. . . . .	120	- voltage in Brazil. C. Piedade <i>et al.</i> . . . . .	248	- yield. K. Thakur <i>et al.</i> (Abs.) . . . . .	271
- evaporation coefficient calculation. B.B. Khochare. (Abs.) . . . . .	20	- and equipment performance. W. Goepen. (Abs.) . . . . .	250	- soil copper deficiency. E.A. Pembroke. (Abs.) . . . . .	14
- heat and mass balance calculation by computer. E. Farwick. (Abs.) . . . . .	375	- process automatic control. (TN) . . . . .	382	- effectivity increase. P.K. Bose. . . . .	239
- transfer and vapour circulation rate increase. L. Gulminelli. (Abs.) . . . . .	54	- introduction. V.A.F. Isoldi. . . . .	155	- filter cake. V.S. Bawasakar <i>et al.</i> . . . . .	240
- inconvertible gases. G. Mantovani. . . . .	54	- centralized control. B.A. Eremenko <i>et al.</i> (Abs.) . . . . .	183	- O.D. Curtis <i>et al.</i> (Abs.) . . . . .	207
- withdrawal. S. Basso. (Abs.) . . . . .	54	- effects on raw sugar colour. J.V. López-Ona. (Abs.) . . . . .	187	- P.K. Moberly and J.H. Meyer. . . . .	339
- S. Sacchi. (Abs.) . . . . .	54	- equipment and instrumentation in India. G.S. Varadan. (Abs.) . . . . .	248	- S.P. Patil <i>et al.</i> (Abs.) . . . . .	239
- F. Zama. (Abs.) . . . . .	54	- residence time determination. T. Cronewitz <i>et al.</i> (Abs.) . . . . .	376	- liquid application and deep cultivation effect on beet yield. T. Agosti. . . . .	245
- juice Brix measurement. V.I. Tuzhikini <i>et al.</i> (Abs.) . . . . .	346	- studies with lithium. P.G. Wright and R. Broadfoot. (Abs.) . . . . .	156	- manganese. A.P. Gupta and G.S.G. Rao. (Abs.) . . . . .	238
- regulator. N.F. Bondarenko and M.A. Maruschchenko. (Abs.) . . . . .	87	- product analysis. J. Dobrzycki. . . . .	187	- manufacture from sugar factory effluent. G. Kaiser <i>et al.</i> (Abs.) . . . . .	282
- colour, effect of 1st carbonation juice liming. A.P. Lapin <i>et al.</i> . . . . .	54	- colloid content determination. A. Rodriguez <i>et al.</i> (Abs.) . . . . .	187	- nitrogen, ammonium chloride. A.N. Singh. (Abs.) . . . . .	238
- feed and condensate flow measurement. W. Hogrefe. . . . .	323	- conveying. V. Urban. (Abs.) . . . . .	278	- anhydrous ammonia. Anon. (Abs.) . . . . .	337
- glutamine content. J. Nedelkovits and K. Fábiani. (Abs.) . . . . .	91	- research in Australia. Anon. (NB) . . . . .	56	- M.V. Dahiphale. (Abs.) . . . . .	239, 370
- level control. D.H. Mee. (Abs.) . . . . .	88	- Austria. Anon. (NB) . . . . .	56	- application rates in U.K. G. Hanslip. . . . .	18
- residence time determination. B.A. Matvienko <i>et al.</i> (Abs.) . . . . .	183	- Jamaica. Anon. (Abs.) . . . . .	310	- beet requirements. G.V. Johnson <i>et al.</i> . . . . .	307
- long-tube. Anon. (Abs.) . . . . .	214	- Mauritius. Anon. (Abs.) . . . . .	86	- cane response. S. Saldarriaga <i>et al.</i> . . . . .	145
- mathematical modelling. W. McWhinney and A.J. Pinkney. . . . .	344	- Taiwan. Anon. (NB) . . . . .	90	- variety interaction on leaf growth. E.L. Rosario <i>et al.</i> (Abs.) . . . . .	147
- operation optimization. L.I. Kornienko. (Abs.) . . . . .	278	- solid waste disposal. F. Kastner. . . . .	22	- response differences. J.P. Patil <i>et al.</i> (Abs.) . . . . .	238
- for heat economy. D. Christoph and E. Manzke. (Abs.) . . . . .	249	- quantity and treatment. F. Bellabarba. (Abs.) . . . . .	218	- crotonylidene diurea effect on cane yield. Y.Y. Chan. (Abs.) . . . . .	338
- performances. R. Espinosa P. . . . .	21	- steam balance. M.K. Hicks. (Abs.) . . . . .	120		
- pressure. T. Wardhana. (Abs.) . . . . .	310	- consumption. P. Christodoulou. . . . .	375		
- steam efficiency, effect of heat pump. A. Fényes. (Abs.) . . . . .	89	- effect of pressure evaporation. T. Wardhana. (Abs.) . . . . .	310		
- heating surface and condenser requirements for factory energy self-sufficiency. H.S. Birkett. . . . .	215	- unknown losses reduction. A.Y. Zagorul'ko <i>et al.</i> (Abs.) . . . . .	249		
- structural design. D. Macey. (Abs.) . . . . .	120	- water economy. V.G. Bahulekar. . . . .	311		
- vapour bleeding for juice heating. J.T. Jadhav. (Abs.) . . . . .	85	- V. Lochman. (Abs.) . . . . .	182		
- <i>see also</i> Control, Automatic; Corrosion; Entrainment and Scale		- working temperature minimization by roof spraying with water. . . . .	382		

## INDEX

xii

# INDEX

	page		page		page
Hawaii:		India:		Invert sugar:	
sugar factory bagasse and trash		beet agriculture. P.S. Arya and		degradation, liming system	
consumption and power generation		S.S. Saini. (Abs.) . . . . .	246	comparison. I. Vigh. (Abs.) . . . . .	375
potential. D. Murata and		-- N. Mukerji. (Abs.) . . . . .	84	determination. J. Dobrzycki. (Abs.) . . . . .	187
W. Gibson. (Abs.) . . . . .	21	-- M.H. Patel. (Abs.) . . . . .	246	- in cane juice and molasses.	
-- closure. (Brev.) . . . . .	192	-- economics. S.K. Tewari and		E. Krause <i>et al.</i> (Abs.) . . . . .	187
- manual. Anon. (NB) . . . . .	90	P.S. Bhatnagar. (Abs.) . . . . .	84	manufacture. A. Maly. (Abs.) . . . . .	345
weed control research. Anon. (Abs.)	370	-- for high yield. D.S. Oberoi and		see also Dextrose; Levulose; Reducing	
see also United States of America		H.G. Singh. (Abs.) . . . . .	17	sugars; Sugars and Syrup	
Heat: balance of boiling house, effect		-- and quality. P.S. Bhatnagar		Ion exchange. V. Maurandi. (Abs.) . . . . .	218
of refinery liquor pre-concentration.		and G.B. Pant. (Abs.) . . . . .	17	applications in cane sugar processing.	
R. de los Rios. (Abs.) . . . . .	314	-- drilling and harvest dates.		F.X. Pollio and F.X. McGarvey. . . . .	157
- calculation by computer.		A.D. Karve <i>et al.</i> (Abs.) . . . . .	18	beet and cane juice treatment.	
E. Farwick. (Abs.) . . . . .	375	-- processing. A.D. Karve. (Abs.) . . . . .	87	F.X. Pollio and O. Campos. (Pat.) . . . . .	284
- of lime kiln. W. Lippold. (Abs.) . . . . .	22	-- research. Anon. (Abs.) . . . . .	308	- juice treatment. Anon. (Abs.) . . . . .	217
consumption reduction, effect of		-- varietal trials. L. Bishnoi <i>et al.</i> . . . . .	246	-- J.C. Giorgi and R. Gontier. . . . .	121
optimum carbonatation pH.		cane agriculture. P.N. Rao and		-- V.P. Meleshko <i>et al.</i> (Abs.) . . . . .	183
K.E. Reznik and V.D. Vitvitskii. . . . .	218	B.R. Rao. (Abs.) . . . . .	271	-- F. Perschak. (Abs.) . . . . .	375
economic evaluation of bagasse		-- research. G.K. Zende. (Abs.) . . . . .	48	-- K.W.R. Schoenrock <i>et al.</i> (Abs.) . . . . .	346
drying. S.K. Ghosh. (Abs.) . . . . .	154	-- for increased yield. S.B. Chougule.		-- and boiling costs. V. Maurandi. . . . .	251
economy in beet sugar factories.		-- breeding. S. Krishna and		- molasses treatment. M.I. Daishev	
D. Christoph and E. Manzke. . . . .	249	R.B. Gaddagimath. (NB) . . . . .	186	and T.P. Trifonova. (Abs.) . . . . .	88
- cane sugar factories. P.N.R. Rao		-- flowering. S. Singh. (Abs.) . . . . .	174	-- J.F.T. Oldfield <i>et al.</i> . . . . .	103, 138
and S.K. Ghosh. (Abs.) . . . . .	154	-- induction. Q.Q. Khan and		-- Süddeutsche Zucker-AG. (Pat.) . . . . .	285
-- S.K. Ghosh. (Abs.) . . . . .	119	P.K. Bhatnagar. (Abs.) . . . . .	117	boiler feedwater treatment.	
---- and energy production.		- intercropping trials. J.D. Chougule		B.B. Khochare. (Abs.) . . . . .	248
W. Leibig. (Abs.) . . . . .	154	and K.U. Sanghavi. (Abs.) . . . . .	48	cane molasses and massecuite	
exchangers. M. Pietrzak. (Abs.) . . . . .	345	-- K.S. Rathii <i>et al.</i> (Abs.) . . . . .	48	analysis. T.K.K. Menon and	
- operation optimization. J. Ledoux.		- pest and disease control.		V.C. Nair. (Abs.) . . . . .	58
generation by raw sugar bacterial		P.N. Avasthy. (Abs.) . . . . .	50	colour removal. L. González <i>et al.</i> . . . . .	219
degradation. N.V. Kostenko and		-- V.V. Tembhekar and D.K. Patel. . . . .	50	- P. Hoarau <i>et al.</i> (Abs.) . . . . .	122
V.Z. Nakhodkina. (Abs.) . . . . .	347	- seed programme for disease		- K. Sasaki <i>et al.</i> (Abs.) . . . . .	377
- in stored beet. T. Baloh. (Abs.) . . . . .	23	control. K. Singh. (Abs.) . . . . .	81	effluent sulphuric acid recovery by	
juice heater steam and heating		-- varieties. (Brev.) . . . . .	383	electrodialysis. F. Perschak. (Abs.) . . . . .	279
surface requirements for factory		-- planting and harvest times.		liquid sugar manufacture from thick	
energy self-sufficiency.		K.C. Rao. (Abs.) . . . . .	304	juice. S.E. Bichsel. (Abs.) . . . . .	375
H.S. Birkett. (Abs.) . . . . .	215	- yield decline. G.R. Naik <i>et al.</i> . . . . .	15	resin fouling after sugar solution	
pan boiling thermodynamics.		continuous centrifugal components		treatment. F. Maekawa <i>et al.</i> . . . . .	377
V.I. Tuzhilkin and I.N. Kaganov.		manufacture. A. Chatterjee and		- restoration after fouling.	
pump effect on evaporator steam		B.R. Math. (Abs.) . . . . .	119	K. Kawasaki <i>et al.</i> (Abs.) . . . . .	377
efficiency. A. Fényes. (Abs.) . . . . .	57	Decan Sugar Institute. (Brev.) . . . . .	255	- synthesis. J.H. Barrett and	
recovery from flue gases.		gur production and consumption.		D.H. Clemens. (Pat.) . . . . .	285
P.P. Chaturvedi. (Abs.) . . . . .	119	S. Thangavelu and K. Sundaresan. . . . .	238	Iran: bagasse paper plant. (Brev.) . . . . .	127
sugar solution specific heat calcula-		Maharashtra sugar industry.		beet agricultural costs. M. Baghestani. . . . .	17
tion. J. Dobrzycki. (Abs.) . . . . .	315	P.N. Soman. (Abs.) . . . . .	93	irrigation x nitrogen fertilizer x	
transfer in boiling. Anon. (Abs.) . . . . .	214	new sugar factories. (Brev.) . . . . .	31, 128	harvest data trials. A. Kaschani	
-- effect of surfactants. J. Lodos		raw and refined sugar standards.		and H. Farazdaghi. (Abs.) . . . . .	17
and I. Diaz. (Abs.) . . . . .	180	A.C. Chatterjee and A.R. Bhide. . . . .	122	sugar imports. (Stat.) . . . . .	384
-- optimization. V.G. Tregub <i>et al.</i> . . . . .	122	sugar factory equipment		- industry. (Brev.) . . . . .	63
deformed tubes. R. Pons M. (Abs.) . . . . .	21	manufacturer. (TN) . . . . .	158	winter conditions and cane ripening.	
- evaporators. R. Espinosa P. (Abs.) . . . . .	21	-- modifications and performances.		D.P. Gowing and N. Baniabassi. . . . .	148
-- effect of incondensable gases.		V.R.R. Bhosale <i>et al.</i> (Abs.) . . . . .	20	Iraq: cane agriculture. M.M. Salih. . . . .	144
G. Mantovani. (Abs.) . . . . .	54	-- performances. A.P. Gupta and		Ireland: sugar imports and exports. . . . .	320
-- surfactant. O.O. Omatete and		S.V. Singh. (Abs.) . . . . .	48	see also Europe, EEC	
H.H. Sephton. (Abs.) . . . . .	120	-- power generation. P.J.M. Rao. . . . .	52	Irrigation. Anon. (Abs.) . . . . .	206
-- vapour circulation rate.		- industry. G.S. Varadan. (Abs.) . . . . .	248	L.M. Blaquier <i>et al.</i> (Abs.) . . . . .	145
V.L. Gulminelli. (Abs.) . . . . .	54	- production 1977/78. (NC) . . . . .	97	A.J. Gonzalez. (Abs.) . . . . .	206
see also Steam		- situation. (NC) . . . . .	354	application rates in South Africa.	
High fructose corn syrup see Syrup		- statistics. (Stat.) . . . . .	32, 288	D.B. Hellman <i>et al.</i> (Abs.) . . . . .	368
Holland. Amsterdam		Indonesia: HVA. Anon. (NB) . . . . .	185	- in Australia. A. Hegarty. (Abs.) . . . . .	78
CITS 16th General Assembly. . . . .	163, 194	new sugar factory. (Brev.) . . . . .	63	- P.A. Jones. (Abs.) . . . . .	240
HVA. Anon. (NB) . . . . .	185	sugar imports. (Stat.) . . . . .	351	- J. Wright. (Abs.) . . . . .	239
sugar factory laboratory automation		- production. (Brev.) . . . . .	383	beet subsurface system. G. Hanslip. . . . .	177
and data processing.		- projections. (Brev.) . . . . .	319	In Brazil. J.A.G.C. Sousa and	
C.C. Bleyenberg <i>et al.</i> (Abs.) . . . . .	313	Instruments: dissolved oxygen meter. . . . .	30	R. Scardua. (Abs.) . . . . .	112
---- P.W. van der Poel <i>et al.</i> . . . . .	168	see also Brix; Colour; Control.		canal distribution of vinasse as	
- operation resumption. (Brev.) . . . . .	31	Automatic: Flow; Level; pH;		fertilizer. J.M. Lorenzetti and	
- imports and exports. (Stat.) . . . . .	224	Polarimetry; Refractometers;		P.G.R. Freitas. (Abs.) . . . . .	368
- industry. . . . .	166	Viscosity; Water; etc.		cane evapotranspiration. G. Hunsigi	
- Anon. (NB) . . . . .	185	International: conference on		and S.C. Srivastava. (Abs.) . . . . .	148
see also Europe, EEC		effluent treatment. (Brev.) . . . . .	287	- farm waterway construction.	
Honduras: new sugar factory. (Brev.) . . . . .	223	International Society of Sugar Cane		C.D. Jones and P. Rudd. (Abs.) . . . . .	15
sugar prospects. (Brev.) . . . . .	288	Technologists: 17th Congress 1980. . . . .	352	- water requirement determination.	
- vitaminization. E. Portela <i>et al.</i> . . . . .	179	International Sugar Agreement.		N.A.V. Nova <i>et al.</i> (Abs.) . . . . .	369
Hungary: beet agriculture. P. Pintér. . . . .	308	Anon. (NB) . . . . .	90	critical application time. P.K. Bose. . . . .	239
- variety x drilling x fertilizer trials.		additional quotas. (NC) . . . . .	162	drip. B.A. McElhroe and J.G. Tabrah. . . . .	28
L. Lukács. (Abs.) . . . . .	308	Colombia sugar exports. (Brev.) . . . . .	190, 257	- E. Paz-Vergara P. (Abs.) . . . . .	368
Kaba sugar factory. A. Hanftwurcel. . . . .	345	Council meetings. (NC) 1, 33, 225, 321		- L.L.P. Shan <i>et al.</i> (Abs.) . . . . .	144
new sugar factory. (Brev.) . . . . .	223	Daily and prevailing sugar prices. . . . .	353	- in Australia. L.S. Chapman. (Abs.) . . . . .	304
sugar consumption. (Brev.) . . . . .	384	EEC membership. (NC) . . . . .	1, 225	- effect on cane and sugar yield.	
Hydrocyclones: cane juice and press		export quotas. (NC) . . . . .	258	L.S. Chapman. (Abs.) . . . . .	337
water suspended solids removal.		-- shortfalls. (Brev.) . . . . .	32	- vs. overhead and beet yield.	
Anon. (Abs.) . . . . .	213	GEPLACEA meeting topic. (NC) . . . . .	258	A. Bramm and C. Sommer. . . . .	274
sugar dust separation.		- support. (NC) . . . . .	3	---- F.J. Braun. (Abs.) . . . . .	274
G.A. Abazyan. (Abs.) . . . . .	313	membership and US imports		- research in Hawaii. Anon. (Abs.) . . . . .	369
		policy. . . . .	2, 33	effect on beet sugar yield and	
		special stocks financing. (NC) . . . . .	193, 354	quality. J. Simon. (Abs.) . . . . .	211
		US membership ratification		- cane flowering. A.I. Allam <i>et al.</i> . . . . .	109
		delays (NC) . . . . .	97, 353	- moisture and sugar production.	
		USSR sugar imports from EEC. . . . .	223	E.J. da A. Leme and R. Scardua. . . . .	175
		International Sugar Organization:		- nitrogenase activity. A.P. Ruschel	
		sugar economy studies. (Brev.) . . . . .	128, 320	<i>et al.</i> (Abs.) . . . . .	176
		- year book 1977. Anon. (NB) . . . . .	56	- yield and sugar content.	
		Invert sugar: content in beet juice,		E. Llerena <i>et al.</i> (Abs.) . . . . .	207
		effect of diffuser acidification.		- minimum temperature requirement	
		J.F.T. Oldfield <i>et al.</i> (Abs.) . . . . .	279	for cane growth. O.O.S. Bacchi	
		-- in Poland. W. Drewnowska and		and J.A.G.C. Sousa. (Abs.) . . . . .	175
		A. Butwilowicz. (Abs.) . . . . .	345	Mauritius projects. (Brev.) . . . . .	287



## INDEX

	page		page		page
Irrigation:		Juice, Beet:		Lactic acid: formation in sugar	
- nitrogen effects on beet sugar		silica determination, P. Devillers		processing, L. McMaster and	
- yield, G. Rizescu. (Abs.)	308	<i>et al.</i> (Abs.)	251	- A.B. Ravnö. (Abs.)	156
- P. Draycott and A. Messem.	246	sucrose degradation, effect of		Lebanon: sugar factory refinery	
- and harvest date trials in Iran.		potassium lactate, Z.A. Mil'kova	92	section. (Brev.)	127
A. Kaschani and H. Farazdaghi.	17	<i>et al.</i> (Abs.)		Levan: enzymatic production from	
overhead in Swaziland.		thick juice Brix measurement.		sucrose. (Brev.)	159
R.P. Humbert. (Abs.)	49	V.I. Tuzhilkin <i>et al.</i> (Abs.)	346	Level: control in evaporator, D.H. Mee.	88
reduction of cane deterioration by		-- regulator, N.F. Bondarenko and		liquor tank automatic control.	
frost, O. Singh and R.S. Kanwar.	359	M.A. Marushchenko. (Abs.)	87	G. Windal. (Abs.)	182
soil moisture level and cane yield.		-- colouring material fractionation.		switches. (TN)	382
R.D. Phulare and U.C. Upadhyaya.	240	M. Wachowicz. (Abs.)	315	Levulose: adsorption on active carbon.	
sprinkler herbicide application.		-- ion exchange treatment for liquid		A.A. Larina and V.G. Aleinikov.	314
Anon. (Abs.)	245	sugar manufacture, S.E. Bichsel.	375	content changes during beet and	
technique and beet sugar content		purity estimation, W. Drewnowska		cane studies, E.W. Krause.	281
and yield, N. Vanli and S. Kaimoglu.	177	and A. Butwilowicz. (Abs.)	345	determination, M. Shibosato. (Abs.)	315
trash management effect on cane		-- storage and processing losses.		-- in beet and cane sugar products.	
yield, J.M. Gosnell and		A.Y. Zagorul'ko <i>et al.</i> (Abs.)	375	W. Mauch and E. Krause. (Abs.)	124
J.E. Lonsdale. (Abs.)	148	-- treatment in centrifuges.		-- by gas-liquid chromatography.	
trials in Australia, N.R. Maclean.	337	W.K. Nielsen. (Abs.)	88	Anon. (Abs.)	188
water carbon dioxide addition.		see also Carbonatation; Filtration		-- P.G. Morel du Boil and	
P.N. Soman. (Abs.)	93	and Sulphitation		K.J. Schäffler. (Abs.)	378
-- fertilizer application, Anon. (Abs.)	369	Juice, Cane: acidity and frost damage		destruction, effect of time and	
-- nutrient content, J. Pinna C. and		assessment, F.A. Martin. (Abs.)	124	temperature, M.A. Clarke <i>et al.</i>	379
S. Valdivia V. (Abs.)	147	alcohol content, J.D. Blake and		dextrose ratio changes in factory	
-- salinity and cane juice ash content.		K.E. McNeil. (Abs.)	343	products, E. Reinefeld <i>et al.</i>	57
L.K. Kirby and G. Kingston.	337	manufacture, P.M.A.M. Chenu.	126	enzymatic isomerization.	
-- table depth effects on beet yield		-- W.H. Kampen. (Abs.)	253	D. Rose, F.C. Armbruster <i>et al.</i>	283
and quality, G.A. Reichman <i>et al.</i>	138	-- M.K. Patil. (Abs.)	252	-- L.E. Coker and D.E. Gardner.	283
see also Water		-- L.A.R. Pinto. (Abs.)	381	-- Corning Glass Works. (Pat.)	285
Israel: sugar factory closures. (Brev.)	190	-- K. Rudolph <i>et al.</i> (Abs.)	253	-- CPC International Inc. (Pat.)	316
Italy: sugar factory closures. (Brev.)	223	-- in Philippines. (Brev.)	255	-- D.J. Lartigue and H.H. Weetall.	60
-- production 1978/79. (Brev.)	224	colloid removal, effect of pH.		-- Rhone-Poulenc S.A. (Pat.)	317
see also Europe, EEC		M. Darias P. and M.C. Ruiz G.	215	-- Standard Brands Inc. (Pat.)	285
Ivory Coast: sugar industry.		colour reduction by sulphur-carbona-		-- M. Suekane <i>et al.</i> (Pat.)	29
R.E. Haresnape. (Abs.)	287	tion, R.S. Dubey. (Abs.)	53	-- M. Tamura <i>et al.</i> (Pat.)	284
Zuénoula sugar factory. (Brev.)	20	enzymatic starch removal, S. Bose		production from sucrose. (Brev.)	159
		<i>et al.</i> (Abs.)	157	high fructose corn syrup vs. beet	
		extraction without colour formation.		sugar. (NC)	2
		P. Grau y Triana. (Pat.)	285	-- EEC levy. (NC)	194, 255
		-- and quality, effect of extraneous		-- production quotas. (NC)	225
		matter, R.P. Scott <i>et al.</i> (Abs.)	348	-- licence for US company.	191
		heater, M. Singh <i>et al.</i> (Abs.)	52	-- plant in Canada. (Brev.)	351
		-- design, A. Valdés D. (Abs.)	154	-- US. (Brev.)	256
		-- mathematical modelling.		-- production technology.	
		W. McWhinney and A.J. Pinkney.	344	K. Vukov <i>et al.</i> (Abs.)	25
		-- tubeplate erosion prevention.		-- use in Japan. (Brev.)	288
		T.W. Gatley. (Abs.)	373	separation from dextrose.	
		heating with bleed vapour.		A.J. Melaja <i>et al.</i> (Pat.)	28
		J.T. Jadhav. (Abs.)	85	see also Invert sugar; Reducing	
		invert sugar determination.		sugars and Sugars	
		E. Krause <i>et al.</i> (Abs.)	187	Liberia: sugar factory. S.N. Wu and	
		ion exchange treatment, F.X. Pollio	284	P.W. Ho. (Abs.)	20
		and O. Campos. (Pat.)		F.O. Licht's international sugar	
		micro-organisms control, effect on		economic yearbook and directory	
		analysis, H.G. Ayala <i>et al.</i> (Abs.)	180	1978. (NB)	55
		-- effects, M.T. Hernández N. <i>et al.</i>	220	Lime: application to soil, O.D. Curtis	
		-- populations, T. Sais H. (Abs.)	188	<i>et al.</i> (Abs.)	207
		nitrogen, phosphorus and potassium			
		contents, effects of fertilizer and		- W.C. von Kessel. (Abs.)	308
		cropage, S.P. Dua and R.C. Singh.	238	applicator. Anon. (Abs.)	241
		phenolic acids identification.		bagasse mixture thermal insulation	
		N.H. Paton. (Abs.)	124	and mechanical strength.	
		phospholipids, A. Garg.	200	R. Espinosa P. (Abs.)	222
		reducing sugars determination.		balance calculation, L.M. Tuchinskii	
		L. Díaz <i>et al.</i> (Abs.)	379	and B.P. Kuz'menko. (Abs.)	249
		sand separator, P. Chenu <i>et al.</i>	310	beet wash water clarification.	
		sucrose vs. pol balances.		H. Dabrowski. (Abs.)	345
		M.A. Brokensha <i>et al.</i> (Abs.)	349	hydration plant. (Brev.)	158
		-- K.J. Schäffler and I.A. Smith.	349	kiln, A.A. Connolly and V.G. Duigan	250
		suspended solids and ash removal		- fuel and flue gas CO <sub>2</sub> content.	
		by hydrocyclone. Anon. (Abs.)	213	N. Marinetti and G. Mantovani.	88
		weight calculation, E. David. (Abs.)	379	- heat balance, W. Lippold. (Abs.)	22
		white sugar manufacture, C.S. Lee.	180	- performance, effect of coke	
		yeast effect, M.T. Hernández N.	219	properties, L. Bazynski. (Abs.)	346
		<i>et al.</i> (Abs.)		- waste quantity and treatment.	
		see also Carbonatation, Clarification,		F. Bellabarba. (Abs.)	218
		Sulphitation and Syrup		milk-of-lime metering, J. Záruba.	346
				stone mechanical handling.	
				J. Wolanski and M. Trepa. (Abs.)	182
				see also Carbonatation and	
				Clarification	
				Liquid sugar: manufacture.	
				M. Pietrzak. (Abs.)	345
				- bacteriological control.	
				A. Simonart and J.P. Dubois.	250
				- by ion exchange, S.E. Bichsel.	375
				-- F.X. Pollio and F.X. McGarvey.	157
				water determination, C.A. Accorsi	
				and G. Vaccari. (Abs.)	251
				Losses, N.R. Tagore. (Abs.)	119
				beet cleaning, J. Pichenez. (Abs.)	211
				- damage in loading/unloading	
				methods and A. Nagy <i>et al.</i> (Abs.)	89
				-- mechanical handling, A.I. Chekal'	
				and V.V. Popovich. (Abs.)	277
				-- pumping, S. Dušek and J. Dyntar.	222
				- diffusion, R. Detavernier <i>et al.</i>	123
				-- M. Milic. (Abs.)	88

# INDEX

	page		page		page
Losses:		Maintenance: cane mechanical equip-		Mechanization, Beet:	
- in beet diffusion. N.V. Pogorelova and		ment. W.W. Paty. (Abs.) . . . . .	113	seed harvesting. E. Niculescu and	
- V.M. Lysyanskii. (Abs.) . . . . .	313	centrifugals. A.C. Chatterjee. (Abs.)	52	A. Stefanescu. (Abs.) . . . . .	308
- effect of scroll speed fluctuation.		computer-based system. R.A.		seedbed preparation and drilling.	
- Y. P. Dobrobaba. (Abs.) . . . . .	89	Allaway and N.H. Barnes. (Abs.) .	373	G. Clotan and N. Bria. (Abs.) . . .	246
- juice electrolysis. F. Perschak. . .	279	cost reduction, effect of clarification		thinning. G. Brown. (Abs.) . . . . .	17
- storage. M. Lailier. (Abs.) . . . . .	121	system. J.C. Gaiofatto and A.T.		topping. Z. Stanescu and N. Bria.	
- determination. P. Devillers. . . . .	345	Sobrinho. (Abs.) . . . . .	181	- M. Umari and W. Brinkmann. . . .	307
- effect on chemical control.		diesel engine scheduling. E. Clavery		- in UK. T.P.J. Dyke. (Abs.) . . . . .	275
- G.F. Tsyzelova. (Abs.) . . . . .	376	and R.L. Kincaid. (Abs.) . . . . .	114	- Spring Demonstration 1979. . . . .	159
- of freezing. M.Z. Khelemskii		steam traps. K. Nakazato and E.		Mechanization, Cane: cleaner. L.G.	
et al. (Abs.) . . . . .	89	Fuwa. (Abs.) . . . . .	377	Fowler. (Pat.) . . . . .	60
- temperature. T. Baloh. (Abs.) . . .	23	see also Lubrication		Dedini-Toft agreement. (Brev.) . . .	287
- R.E. Wyse. (Abs.) . . . . .	307	Malawi: centrifugal order. (Brev.)	30	diesel engine oil analysis. E. Clavery	
- weight. J. Zahradnický et al. . . . .	277	Nchalo sugar factory. A.		and R.L. Kincaid. (Abs.) . . . . .	114
- thick juice storage and processing.		McMartin. (Abs.) . . . . .	20	harvested cane trash content. N.	
- A.Y. Zagorul'ko et al. (Abs.) . . . .	375	- performance. J.P. Lamusse. . . .	374	Tambosco et al. (Abs.) . . . . .	113
- washing. H. Dabrowski. (Abs.) . . .	345	smallholder cane project. (Brev.)	351	harvester. (Brev.) . . . . .	32
boiling, effect of surfactants.		Malaysia: refining. A.C. Chatterjee		- Anon. (Abs.) . . . . .	79, 241, 305
- J. Lodos and I. Díaz. (Abs.) . . . .	180	and A.R. Bhide. (Abs.) . . . . .	122	- D.J. Quick. (Pat.) . . . . .	60
- temperature fluctuation.		Mannitol: occurrence in beet. J. Cap-		- D.A. Scott and J.C. Hudson. (Pat.)	60
- L.I. Trebin et al. (Abs.) . . . . .	89	lovic and F. Rendos. (Abs.) . . . .	57	- O. Shunichi. (Pat.) . . . . .	28
calculation by programmable		Masseuiter: analysis. T.K.K. Menon		- Sugar Cane Growers Cooperative	
calculator. B.L. Karen and		and V.C. Nair. (Abs.) . . . . .	58	of Florida. (Pat.) . . . . .	285
- M.K. Faviell. (Abs.) . . . . .	278	consistency measurement. F. Pantuso		- base cutter standards. G. Rivas N.	113
- J.R. Vyse and H. Morten. (Abs.)	278	N. (Abs.) . . . . .	216	- billet elevator. D.J. Quick. (Pat.)	60
cane deterioration after burning		conveying. V. Urban. (Abs.) . . . .	278	- blockage warning system. Anon.	80
and harvesting. B.T. Egan et al. . .	109	cooling and reheating. E.E.A. Rouil-		- comparison. E. Zamorano. C. . . .	113
- harvesting. J.E. Irvine et al.		ard. (Abs.) . . . . .	156	- performances. T.G. Fuelle et al.	340
- B.L. Legendre. (Abs.) . . . . .	110	crystal content determination. F.		- C.R. Henkel et al. (Abs.) . . . . .	340
- J.D. Miller et al. (Abs.) . . . . .	176	Pantuso N. and V.S. Polonik. . . .	219	- V. Mason et al. (Abs.) . . . . .	340
- dextran occurrence. S.E. Ferrari		exhaustion. G.R.E. Lionnet. (Abs.)	349	- topper. D.J. Brassette. (Pat.) . . .	29
and A.A. Rodella. (Abs.) . . . . .	52	filtration. Y. Thirel. . . . .	293	- D.J. Brassette and R.A. Duncan.	60
- effect of billet length and		flow rate. J. Gebler et al. (Abs.)	251	- trash separation. J. Brito M. and J.	
burning. P.C. Ivin and D.H.		mixer drive. Soc. d'Exploitation		Abreu C. (Abs.) . . . . .	113
Foster. (Abs.) . . . . .	157	d'Usines Metallurgiques. (Pat.)	317	- separator. D.J. Quick. (Pat.) . . .	28
- ripener. M. St. J. Clowes and		pH calculation. N.A. Arkhipovich		- trials in Brazil. N. Tambosco et al.	305
- R.A. Wood. (Abs.) . . . . .	339	et al. (Abs.) . . . . .	188	harvesting. Anon. (Abs.) . . . . .	80
- juice degradation by micro-		pump. (TN) . . . . .	318	- L.A.R. Pinto. (Abs.) . . . . .	340
organisms. M.T. Hernández		reheater. J.C. Giorgi and B. Richard	89	- analysis and calculation. L.V.B.	
et al. (Abs.) . . . . .	220	- N.A. Ramaiah and H.N. Gupta.	120	Gentil and T.C. Ripoli. (Abs.) . . .	114
- yeast. M.T. Hernández et al. . . .	219	- R.C. Sharma. (Abs.) . . . . .	20	- cane stalk cutting resistance measure-	
- milling, effect of cane burning.		residence time determination. T.		ment. C.S. Chang. (Abs.) . . . . .	241
- J.P. Lamusse. . . . .	231	Cronewitz et al. (Abs.) . . . . .	376	- effect of cane growth factors. E.	
- harvesting delay after burning.		sugar determination by polarimetry		Casanova and I. Robella. (Abs.)	241
- G. El-K. Sayed et al. (Abs.) . . . .	156	after active carbon treatment. A.Y.		- on soil properties and cane ratoon-	
- micro-organisms. E. Duarte P.		Zagorul'ko et al. (Abs.) . . . . .	26	ing. S.J. Yang. (Abs.) . . . . .	109
and J.L. Pérez. (Abs.) . . . . .	248	viscosity, effect of dextran. G.L.		- efficiency in French West Indies. J.	
- R.P. Mittal. (Abs.) . . . . .	119	Geronimos and P.F. Greenfield.	348	Dutarte. (Abs.) . . . . .	113
- trash. W.F. Allins. (Abs.) . . . . .	119	- temperature and time. R.C.		- green cane. Anon. (Abs.) . . . . .	241
- F.A. Fogliata et al. (Abs.) . . . .	180	Sharma. (Abs.) . . . . .	311	- and loading effect on cane trash.	
- reduction by bacteriological		washing in centrifugals and molasses		Anon. (Abs.) . . . . .	305
control. R.H. Tilbury et al. . . . .	157	sugar content. Y.D. Kot and L.N.		- A.C. Fernandes and E.R. de	
determination, pol balance errors.		Binevskaya. (Abs.) . . . . .	346	Oliveira. (Abs.) . . . . .	305
- K.J. Schaffter and I.A. Smith.	349	see also Boiling; Centrifugals;		- and transport. E. Cerzuelia. . . .	79
effect of beet nitrogen over-		Crystallization and Pans, Vacuum		- losses. A.G. De Beer and T.C.	
application. G. Hanslip. (Abs.) . . .	18	Materials grinding, batching and blend-		Boevey. (Abs.) . . . . .	114
filter cake, effect of low-pressure		ing equipment. (Brev.) . . . . .	158	- lost time analysis. L.V.B. Gentil.	241
filtration. S.P. Mishra. (Abs.) . . . .	53	Mauritius: bagasse paper study . . .	223	- in narrow rows. W. Jackson. (Abs.)	305
lactic acid formation in sugar		bulk sugar termite. (Brev.) . . . .	311	- whole-stick cane. J.C. Hudson.	113
processing. L. McMaster and		- silos. G. Beaubois. (Abs.) . . . .	311	lime applicator. Anon. (Abs.) . . .	241
A.B. Ravnó. (Abs.) . . . . .	156	by-products research. Anon. (Abs.)	93	loading hopper. Anon. (Abs.) . . .	79
mechanical cane harvesting.		cane agricultural research. Anon.	77	machinery effect on cane root	
- A.G. De Beer and T.C. Boevey.	114	- breeding and varieties. Anon. . .	117	development. M. Fonseca and M.	
raw sugar degradation in storage.		- mechanization research. Anon.	79	Dominguez. (Abs.) . . . . .	241
- N.V. Kostenko and		- pest and disease research. Anon.	81	personnel training. W.W. Paty. . . .	113
- V.Z. Nakhodkina. (Abs.) . . . . .	347	distillery. (Brev.) . . . . .	160	planter. Anon. (Abs.) . . . . .	241, 305
- A.Y. Zagorul'ko et al. (Abs.) . . .	249	irrigation projects. (Brev.) . . . .	287	- C.V. Allain. (Pat.) . . . . .	60
- carbonation. V.A. Kolesnikov		raw sugar grain size analysis. E.C.		- L.G. Fowler. (Pat.) . . . . .	284
et al. (Abs.) . . . . .	87	Vignes. (Abs.) . . . . .	124	- C.M. McAleese. (Abs.) . . . . .	80
- Y.F. Tsyukalo et al. (Abs.) . . . .	313	sugar dryer order. (Brev.) . . . .	30	- L.G. Mialhe. (Abs.) . . . . .	305
- filtration. M.I. Zhenchuk et al.	346	- factory strike. (Brev.) . . . . .	351	- P. Populin et al. (Pat.) . . . . .	60
sucrose inversion determination		- technology research. Anon. . . .	86	- manufacture in Cuba. (Brev.) . .	255
by high pressure liquid		- production 1978. (NC) . . . . .	161	planting. C. Morton. (Abs.) . . . .	79
chromatography. M.A. Clarke		- statistics. (Stat.) . . . . .	190	research in Mauritius. Anon. (Abs.)	79
et al. (Abs.) . . . . .	379	weed control. Anon. (Abs.) . . . .	49	soil cultivation. S.W.D. Baxter. . .	114
- in sulphitation juice, effect of		yellow spot. C. Ricard et al. (Abs.)	341	- estimation in harvested cane. T.C.	
potassium lactate.		Mechanization, Beet: drill. E.A.H.		Ripoli et al. (Abs.) . . . . .	281
- Z.A. Mil'kova et al. (Abs.) . . . .	92	Ribouleau. (Pat.) . . . . .	317	stubble shaver. N.S.L. Srivastava.	340
see also Bagasse; Diseases; Filter		- G. Spee. (Abs.) . . . . .	177	tractor tyres vs. tracks.	
cake; Molasses; Pests;		drilling to stand. S. Krasucki and		W.W. Brixius. (Abs.) . . . . .	113, 305
Pulp, Beet and Weather		S. Siwicki. (Abs.) . . . . .	246	Metering feeder. (TN) . . . . .	30
Lubrication. T.M. Karne. (Abs.) . . .	310	- in US. Anon. (Abs.) . . . . .	274	Mexico: fertilizer trials. M. Torres	
automatic low oil pressure alarm.		- x variety x fertilizer trials in Hun-		B. (Abs.) . . . . .	112
- M.K. Biswas and M. Singh. . . . .	53	gary. L. Lukács. (Abs.) . . . . .	308	irrigation. A.J. Gonzalez. (Abs.)	206
cane mill gears. J.R. Partridge. . . .	374	harvesters. Comhlucht Siuicre Eire.		sugar expansion. (Brev.) . . . . .	31
- journals. I.D. Blackburne et al.	373	ann Teo. (Pat.) . . . . .	285, 317	- industry recovery. (NC) . . . . .	35
- and steam turbine. Anon. (Abs.) . .	21	- Ransomes Sims & Jefferies Ltd.		- problems. (NC) . . . . .	322
diesel engine oil analysis and		(Pat.) . . . . .	285, 316	- statistics. . . . .	258, 288
maintenance scheduling.		- W.C. von Kessel. (Abs.) . . . . .	274	Micro-organisms: activity deter-	
- E. Clavery and R.L. Kincaid. . . .	114	harvesting and cleaning. J.		mination in cane mills. M.T.	
		Pichenez. (Abs.) . . . . .	211	Hernández et al. (Abs.) . . . . .	52
		- in Poland. C. Zolnierczyk. (Abs.)	308	- in stored raw sugar. N.V. Kostenko	
		in Hungary. P. Pintér. (Abs.) . . .	308	et al. (Abs.) . . . . .	24
		loading/unloading losses. P. Soós and		Azotobacter culture effect on cane	
		A. Lengyel. (Abs.) . . . . .	89	yield. M.L. Agarwal et al. (Abs.)	304
		machinery and beet row width dis-		bacterial biomass production from	
		crepancies. J. von Alten. (Abs.) . .	308	beet molasses. L.E. Slater. (Abs.)	59

Madagascar: sugar statistics. (Stat) 287

# INDEX

	page		page		page
<b>Micro-organisms:</b>		<b>Molasses:</b>		<b>Molasses, Beet:</b>	
bactericide effects on cane juice		alcohol fermentation automatic		sugar recovery by liquid distribution	
analysis. H.G. Ayala <i>et al.</i> . . . . .	180	control. V.I. Petrunya <i>et al.</i> (Abs.)	350	chromatography. M. Munir. (Abs.)	345
- evaluation. R.H. Tilbury <i>et al.</i> . . . . .	157	-- plant. (Tilbury <i>et al.</i> ) . . . . .	318	-- Quentin process. J.F.T. Oldfield	
in bagasse. T. Sais H. <i>et al.</i> (Abs.)	219	-- under vacuum vs. atmospheric		<i>et al.</i> . . . . .	103, 138
beet diffusion losses. M. Milic. . . . .	88	pressure. A. Ramalingam. . . . .	27	tryptophane production. L.K.	
in cane mills. R.P. Mittal. (Abs.)	119	animal fodder. C.O. McKenzie. . . . .	284	Smirnova <i>et al.</i> (Abs.) . . . . .	27
control. F. Hollaus. (Abs.) . . . . .	23	-- F.M. Snyder. (Pat.) . . . . .	29	valine production. Z. Popova and	
- in beet sugar factory. A. Simonart		-- J.F. Wilson and R.S. Parish.	60	I. Murgov. (Abs.) . . . . .	350
and J.P. Dubois. (Abs.) . . . . .	250	exhaustion, effect of viscosity. P.		volatile fatty acids determination.	
- cane milling. M.T. Hernández N.		Devillers <i>et al.</i> (Abs.) . . . . .	26	J. Hrivnák and M. Medved. (Abs.)	188
. . . . .	266, 291	optimum potassium ferrocyanide		washing of low-grade sugar in centri-	
-- M.T. Hernández <i>et al.</i> (Abs.)	215	dose determination for citric acid		fugals. A.P. Kozayvkin <i>et al.</i> . . . . .	89
effect on cane juice. M.T. Hernández		fermentation. W. Leśniak. (Abs.)	94	water determination. C.A. Accorsi	
<i>et al.</i> (Abs.) . . . . .	220	pre-treatment for fermentation.		and G. Vaccari. (Abs.) . . . . .	251
lactic acid formation in sugar process-		M. Pietrzak. (Abs.) . . . . .	345	-- R. Detavernier <i>et al.</i> (Abs.) . . . . .	123
ing. L. McMaster and A.B. Ravnö. 156		pump. (TN) . . . . .	318	yeast fermentation, changes in ash	
<i>Leuconostoc</i> deterioration of burnt		sucrose determination by gas-liquid		components concentration. V.N.	
and harvested cane. B.T. Egan <i>et al.</i>	109	chromatography. D. Nurok and		Shvets <i>et al.</i> (Abs.) . . . . .	221
nitrogen-fixing bacteria and cane		T.J. Reardon. (Abs.) . . . . .	58	-- effect of colour removal. V.N.	
root nitrogenase activity. A.P.		sugar recovery by ion exchange.		Shvets <i>et al.</i> (Abs.) . . . . .	253
Ruschel <i>et al.</i> (Abs.) . . . . .	176	Süddeutsche Zucker AG. (Pat.)		<b>Molasses, Cane: addition to cane for</b>	
populations in cane juice and imbibition		sugars determination. H. Janshekar		alcohol fermentation. K. Rudolph	
water. T. Sais H. (Abs.) . . . . .	188	and J.R. Mor. (Abs.) . . . . .	26	<i>et al.</i> (Abs.) . . . . .	253
in raw sugar. R.D. Skole. (Abs.) . . . . .	380	sulphur dioxide determination. C.		- effect on citric acid fermentation.	
-- during storage. N.V. Kostenko		Christiane. (Abs.) . . . . .	220	D.V. Vadehra <i>et al.</i> (Abs.) . . . . .	94
and V.Z. Nakhodkina. (Abs.)	347	water determination. H. Schiweck		alcohol fermentation. H.S. Birkett	
<i>see also</i> Diseases; Fermentation;		<i>et al.</i> (Abs.) . . . . .	91	and J.A. Polack. (Abs.) . . . . .	254
Losses; Water, Waste and		yeast manufacture, effect of dis-		-- K. Hokama <i>et al.</i> (Abs.) . . . . .	221
individual Fermentation		solved oxygen concentration. T.		-- M.K. Patil. (Abs.) . . . . .	252
products		Miskiewicz <i>et al.</i> (Abs.) . . . . .	94	-- L.A.R. Pinto. (Abs.) . . . . .	381
<b>Milling, Cane: cane preparation. H.N.</b>		<b>Molasses, Beet: addition to cane for</b>		-- L.H. Wang <i>et al.</i> (Abs.) . . . . .	251
Gupta. (Abs.) . . . . .	53	effluent for fermentation treatment.		-- costs. P.B. Neto. (Abs.) . . . . .	381
effect of delay with burnt cane. G.		G. Kaiser <i>et al.</i> (Abs.) . . . . .	282	-- in Hawaii. (Brev.) . . . . .	256
El-K. Sayed <i>et al.</i> (Abs.) . . . . .	156	alcohol fermentation, effect of re-		-- Kenya. (Brev.) . . . . .	383
- trash W.F. Allison. (Abs.) . . . . .	119	cycled vinasse. N. Taygun <i>et al.</i>	282	- and yeast fermentation. K. Manni-	
-- F.A. Fogliata <i>et al.</i> (Abs.) . . . . .	180	-- ultrasonics. J. le Mao and R.O.		vannan. (Abs.) . . . . .	252
-- S. El-N.A. Hemaida <i>et al.</i> (Abs.)	155	Prudhomme. (Abs.) . . . . .	350	analysis. T.K.K. Menon and V.C.	
efficiency, effect of cane burning.		animal fodder. N.B. Davis and P.		Nair. (Abs.) . . . . .	58
J.P. Lamuse. . . . .	231	Tory. (Abs.) . . . . .	282	- by gas-liquid chromatography. E.	
-- setting. J.S. Huja. (Abs.) . . . . .	85	-- A. Giouzelyanne. (Abs.) . . . . .	282	Rosado and H. Batiz. (Abs.) . . . . .	57
extraction vs. diffusion. P.S. Kelly		-- R. Teissier <i>et al.</i> (Pat.) . . . . .	29	animal fodder. C.M. Geerken. . . . .	27
and R.G. Porter. (Abs.) . . . . .	311	betaine determination. G. Steinle		- P. Lezcano <i>et al.</i> (Abs.) . . . . .	27
imbibition and juice extraction. F.		and E. Fischer. (Abs.) . . . . .	91	-- A. Molina. (Abs.) . . . . .	27
Serna S. (Abs.) . . . . .	155	citric acid manufacture. H. Hustede		-- P.N. Soman. (Abs.) . . . . .	93
- water micro-organism populations.		and H. Rudy. (Pat.) . . . . .	60	ash determination. G. Núñez T. and	
T. Sais H. (Abs.) . . . . .	188	-- yeast activity measurement. V.M.		C. Díaz de A. (Abs.) . . . . .	58
juice additional water calculation.		Golubtsova. (Abs.) . . . . .	222	Azotobacter cultivation. M.A. el-	
S. Nath and S.N. Tripathi. (Abs.)	85	colloid particle size determination.		Sayed and A. Abo-Shady. (Abs.)	27
laboratory mill juice extraction.		S.T. Krylov <i>et al.</i> (Abs.) . . . . .	92	Brix optimization. Anon. (Abs.)	214
H.G. Ayala <i>et al.</i> (Abs.) . . . . .	26	colorants fractionation. M. Wach-		citric acid manufacture. H. Hustede	
losses, effect of micro-organisms. E.		wicz. (Abs.) . . . . .	315	and H. Rudy. (Pat.) . . . . .	60
Duarte P. and J.L. Pérez. (Abs.)	248	enzymatic sucrose vs. pol. R. Deta-		composition, effect of lime. N.A. da	
- reduction by micro-organism con-		vernier <i>et al.</i> (Abs.) . . . . .	123	Glória and E. da Silva. (Abs.) . . . . .	180
control. R.H. Tilbury <i>et al.</i> (Abs.)	157	exhaustion. R.A. McGinnis. (Abs.)	250	cooler. M.R. Player <i>et al.</i> (Abs.)	344
mathematical modelling. J. Abreu G.		- formula. R. Detavernier and J.		dextrose and levulose content. W.	
and V. Polonik. (Abs.) . . . . .	216	Roger. (Abs.) . . . . .	123	Mauch and E. Krause. (Abs.) . . . . .	124
micro-organisms. R.P. Mittal. (Abs.)	119	fluorine determination. P.B. Koster		exhaustibility determination. J.	
- activity determination. M.T.		<i>et al.</i> . . . . .	4	Bruijn. (Abs.) . . . . .	248
Hernández <i>et al.</i> (Abs.) . . . . .	52	formation and viscosity, effect of		exhaustion, effect of viscosity.	
- control. M.T. Hernández N. 266, 291		nucleosides. N.V. Remeslo <i>et al.</i>	281	Anon. (Abs.) . . . . .	188
-- M.T. Hernández <i>et al.</i> (Abs.) . . . . .	215	food ingredient product. Food Tech-		food ingredient product. Food Tech-	
El Potrero sugar factory. F.J.		nology Inc. (Pat.) . . . . .	317	nology Inc. (Pat.) . . . . .	317
Medina. (Abs.) . . . . .	213	glutamic acid content. Nedelko-		incorporation in cane tops silage.	
shredder performance. S.M. Alam.	85	vs. K. Fábán. (Abs.) . . . . .	91	J. Deville and Y. Wong You	
-- L.B. Rodríguez <i>et al.</i> (Abs.) . . . . .	52	-- lysine and bacterial biomass		Cheong. (Abs.) . . . . .	126
<i>see also</i> Mills, Cane		production. L.E. Slater. (Abs.)	59	invert sugar degradation, effect of	
<b>Mills, Cane. (TN)</b>		invert sugar degradation, effect of		temperature. E.W. Krause. (Abs.)	281
carrier durability improvement.	158	temperature. E.W. Krause. (Abs.)	281	kojic acid manufacture. P. Bajpai	
- shaft breakage. V.M. Murugkar		lysine manufacture in		<i>et al.</i> (Abs.) . . . . .	93
and J. Lakshminarayan. (Abs.)	53	Yugoslavia. (Brev.) . . . . .	351	mushroom mycelium propagation.	
feeder. D.S. Shann. (Abs.) . . . . .	154	pesticide residue determination.		J.T. Aguinaldo. (Abs.) . . . . .	59
feeding. J.R. Abreu G. (Abs.) . . . . .	215	P.B. Koster. (Abs.) . . . . .	91	reducing sugars determination. I. Díaz	
- J.R. Abreu G. <i>et al.</i> (Abs.) . . . . .	216	pH calculation. N.A. Arkhipovich		<i>et al.</i> (Abs.) . . . . .	379
- automatic control. N. Chandappa		<i>et al.</i> (Abs.) . . . . .	188	-- E. Krause <i>et al.</i> (Abs.) . . . . .	187
<i>et al.</i> (Abs.) . . . . .	119	sugar content. A.Y. Zagorul'ko		-- instrument failure. Anon. . . . .	187
flangeless tool rollers. J.A.P.		<i>et al.</i> (Abs.) . . . . .	375	sucrose, dextrose and levulose de-	
Jacquin. (Abs.) . . . . .	119	-- determination, effect of active		termination. P.G. Morel du Boil and	
gears. J.R. Partridge. (Abs.) . . . . .	374	carbon. A.Y. Zagorul'ko <i>et al.</i>		K.J. Schäffler. (Abs.) . . . . .	378
- reducer lubricant. Anon. (Abs.)	21	-- effect of colloids. N.P. Silina		sugar content determination. E.	
journal lubricants. I.D. Blackburne		<i>et al.</i> (Abs.) . . . . .	346	David. (Abs.) . . . . .	379
<i>et al.</i> (Abs.) . . . . .	373	-- filtration. M.I. Zhenchuk <i>et al.</i>	346	-- by alcohol treatment. A.D.	
order from Costa Rica. (Brev.) . . . . .	95	-- soil salinity. C. Mathieu and		Robertson. (Abs.) . . . . .	349
roller bearings. G.D. Jacklin <i>et al.</i>	119	F.W. Hesse. (Abs.) . . . . .	211	- loss reduction. A.P. Chinnaswamy	311
rollers. R.P. de Ramalho. (Abs.) . . . . .	310	-- prediction. W. Drewnowska and		-- melt liquor clarification. L.L.C.	
- grooving and juice extraction. F.		A. Butwilowicz. (Abs.) . . . . .	345	Suzor. (Abs.) . . . . .	181
Serna S. (Abs.) . . . . .	155	-- M.Z. Khelemskii <i>et al.</i> (Abs.)	388	-- Sucro "AMS" clarifier. C.M.	
shredder. I.G. Flanders <i>et al.</i> (Abs.)	373	- reduction by carbonation pH		Madrazo and E.A. Guena. . . . .	215
-- L.B. Rodríguez <i>et al.</i> (Abs.) . . . . .	311	optimization. K.E. Reznik and		- recovery by ion exchange chromato-	
toothed roller pressure feeder. N.C.		V.D. Vitvitskii. (Abs.) . . . . .	218	graphy. H. Hongisto and H.	
Farmer. (Abs.) . . . . .	120	-- ion exchange. M.I. Daishev and		Heikkilä. (Abs.) . . . . .	181, 248
turbine drive repairs. B.P. Bargaje.	53, 85	T.P. Trifonova. (Abs.) . . . . .	88	utilization. J.M. Paturau. (Abs.)	59, 252
<i>see also</i> Milling, Cane		-- in USSR. Y. D. Kot and L.N.		vinasse mixture for animal fodder	
<b>Mixers. (TN)</b>		Binevskaya. (Abs.) . . . . .	346	production. J.T. Aguinaldo. . . . .	59
massecuite, drive. Soc. d'Exploitation		-- and yield, effect of juice ion		viscosity. E.R. Fleites and C.	
d'Usines Metallurgiques. (Pat.)	317	exchange treatment. V.P. Meleshko		González. (Abs.) . . . . .	219
<b>Molasses: alcohol fermentation. W.</b>		<i>et al.</i> (Abs.) . . . . .	183	- effect of dextran. G.L. Geronimos	
Engelbart and H. Dellweg. (Abs.)	253	- recovery. A. Kubasiewicz. (Abs.)	346	and P.F. Greenfield. (Abs.) . . . . .	348

# INDEX

	page		page		page
Molasses, Cane:		Paper Bagasse:		Pests, Cane:	
viscosity, effect of massecuite surfactants, J. Lodos and I. Díaz. (Abs.) . . . . .	180	pilot plant in Cuba. P.L. Gutiérrez and R. Molina M. (Abs.) . . . . .	222	borer damage and sugar loss estimation. G. Arceneaux. (Abs.) . . . . .	369
- temperature and time. R.C. Sharma. (Abs.) . . . . .	311	study in Mauritius. (Brev.) . . . . .	71	- effect on cane and juice quality. G. Valsechi <i>et al.</i> (Abs.) . . . . .	242
- water determination. C.A. Accorsi and G. Vaccari. (Abs.) . . . . .	251	see also Pulp, Bagasse		- yield. R. Pérez G. <i>et al.</i> (Abs.) . . . . .	151
- yeast cultivation. P. Hernández S. and I. Morrell F. (Abs.) . . . . .	222	Papua-New Guinea: cane by-products project. (Brev.) . . . . .	287	- and quality. P.R. Moholkar <i>et al.</i> (Abs.) . . . . .	16
- P. Hernández S. <i>et al.</i> (Abs.) . . . . .	59	payment, Beet: computerized calculation. D.F.A. Horsley and A. Williams. 279		- incidence in South Africa. R.J. Smail. (Abs.) . . . . .	371
- A. Madi <i>et al.</i> (Abs.) . . . . .	27	in EEC. (NC) . . . . .	65, 225	- leafhopper and scale insect control. V.V. Tembhekar and D.K. Patel. 50	
- and oxalic acid manufacture. M.S. Iyengar. (Abs.) . . . . .	222	Iran. M. Baghestani. (Abs.) . . . . .	17	- and white grub control. D.S. Ajrl. (Abs.) . . . . .	50
- yield and purity, effect of continuous centrifugals. A.P. Chinnaswamy <i>et al.</i> (Abs.) . . . . .	85	Poland. K. Szczot and H. Jochim. 346		- mass rearing and artificial infestation in South Africa. P.R. Atkinson. (Abs.) . . . . .	371
- dolomitic lime. J.M. Zuazua N. 181		USSR. G. I. Bereshchuk. (Abs.) . . . . .	313	- morphology. E.E. Carbonell. . . . .	371
see also By-products		-S.R. Bostanov. (Abs.) . . . . .	277	- moth rearing and trapping Y. Ito and M. Kinjo. (Abs.) . . . . .	209
Molasses, Refinery: loss reduction by electro dialysis. T. Hiramoto. (Abs.) 314		-A.I. Chekal' and V.V. Popovich. 277		- oviposition on cane varieties. G.T. Lim and Y.C. Pan. (Abs.) . . . . .	151
Morocco: sugar factory orders . . . . .	96	-V.M. Karasik <i>et al.</i> (Abs.) . . . . .	277	- parasites. F.D. Bennett. (Abs.) . . . . .	150
- production 1978/79. (Brev.) . . . . .	255	-M.N. Kozlenko. (Abs.) . . . . .	313	- M. Daniali <i>et al.</i> (Abs.) . . . . .	242
Mozambique: sugar export quota shortfall. (Brev.) . . . . .	32	see also Beet and Polarimetry		- A.F.H. El-Sherif and M.T. Kira. 242	
- factory performances. J.P. Lamusse 374		Payment, Cane. W.F. Allison. (Abs.) 119		- T. Falloon. (Abs.) . . . . .	151
Nepal: sugar factory. (Brev.) . . . . .	32	E.J. Buchanan. (Abs.) . . . . .	157	- A.F. Mendonça <i>et al.</i> (Abs.) . . . . .	208
New Zealand: refined sugar production. (Brev.) . . . . .	256	A.C. Sturion. (Abs.) . . . . .	281	- breeding. N.G. Saraceni and C.A. Mourao. (Abs.) . . . . .	151
- sugar economy study. (Brev.) . . . . .	128	in Argentina, effect on topping. C. Hofmann. (Abs.) . . . . .	15	- characteristics. E.G. King <i>et al.</i> 116	
Nicaragua: sugar factory destruction. 237		calculation from laboratory mill juice analysis. H.G. Ayala <i>et al.</i> 26		- distribution. A.F.H. El-Sherif <i>et al.</i> (Abs.) . . . . .	242
Niger: sugar complex. (Brev.) . . . . .	32	research in Brazil. N.A. da Glória <i>et al.</i> 380		- larviposition. J.P. Roth and E.G. King. (Abs.) . . . . .	150
Nigeria: Numan sugar factory. (TN) 318		see also Cane analysis; Cane sampling and Polarimetry		- release in Taiwan. W.Y. Cheng and T.H. Su. (Abs.) . . . . .	272
- sugar expansion plans. (Brev.) . . . . .	127	Pectin: determination. H. Andres <i>et al.</i> (Abs.) . . . . .	91	- size relationships. R.M. McPherson and S.D. Hensley. (Abs.) . . . . .	151
- project study. (Brev.) . . . . .	224	Peru: fertilizer trials. S. Saldarriaga <i>et al.</i> (Abs.) . . . . .	145	- population, effect of weather. P.S.M. Botelho <i>et al.</i> (Abs.) . . . . .	208
Nitrogen: amino-nitrogen content in beet, effect of irrigation. J. Simon. 211		-S. Valdivia V. (Abs.) . . . . .	368	- x rot effect on cane quality. G.M. de A. Silva and R.S. de Moraes. 209	
- juice and molasses. J. Nedelkovits and K. Fabian. (Abs.) . . . . .	91	irrigation. A.J. Gonzalez. (Abs.) . . . . .	206	- sampling and control. W.G. des Vignes. (Abs.) . . . . .	209
- removal by affination. A.P. Kozjavkin and N.I. Oodorod'ko. 24		- water nutrient contents. J. Pinna C. and S. Valdivia V. (Abs.) . . . . .	147	- varietal resistance. S.D. Hensley <i>et al.</i> (Abs.) . . . . .	150
- ammonia determination in condensate. H. Zaorska <i>et al.</i> (Abs.) . . . . .	312	- nematodes. E.E. Carbonell. (Abs.) 150		- Y.S. Pan and S.L. Yang. (Abs.) . . . . .	150
- ammonium carbonate recovery from beet juice. S. Zagrodzki <i>et al.</i> 312		soil texture and salinity. J.C. Sevilla G. (Abs.) . . . . .	368	- in Venezuela. E.N. Morales and N. Falcon C. (Abs.) . . . . .	209
- compounds in beet. M. Lailier. 121		sugar exports . . . . .	191, 256	- and white grub control. A.S. Patil <i>et al.</i> (Abs.) . . . . .	16
- effect on quality. M. O'Sullivan. 218		- industry difficulties. (Brev.) . . . . .	71	cane sett protection. K. Singh. 81	
- content in cane, effect of ripeners. A.S. Chacaravarti <i>et al.</i> (Abs.) . . . . .	48	Pests, Beet: aphid control. Anon. 212		control by agronomic practices. K.C. Alexander and H.C. David. 81	
- leaf and nitrogenase activity. A.P. Ruschel and R. Ruschel. (Abs.) 206		- L. van Steyvoort. (Abs.) . . . . .	212	- in India. P.N. Avasthy. (Abs.) . . . . .	50
see also Amino-acids; Fertilizers and Soil		in Belgium. L. van Steyvoort. 247		English-Portuguese dictionary. M.P.S.B. Gonçalves. (NB) . . . . .	186
Norway: sugar imports 1978. (Stat.) 127		control chemicals. V. Kovács. 276		frog hopper biology. E.J. Marques. 151	
Oxalic acid: manufacture from cane molasses. M.S. Iyengar. (Abs.) . . . . .	222	- application rate determination. A. Vigoureaux and R. Vanstallen. 19		- population, effect of weather. M.K. El-Kadi. (Abs.) . . . . .	208
Packaging: company division formed. 30		- effect on beet root and crown rot incidence. R.J. Hecker and E.G. Ruppel. (Abs.) . . . . .	276	- A. de C. Mendes <i>et al.</i> (Abs.) 208	
Pakistan: Deh Bitora sugar factory. 286		- interactions. K.N. Giannopolite. 19		incidence in plant cane and ratoons. M.L. Agrawal and B.N. Pandey. 243	
- new sugar factories. (Brev.) . . . . .	255	- miscibility with herbicides. M. Kubacka-Szmidtgal. (Abs.) . . . . .	276	leafhopper control. S.K. Sharma. 16	
- sugar production 1977/78. (Brev.) 95		- residues in beet pulp and molasses. P.B. Koster. (Abs.) . . . . .	91	- pesticide toxicity determination. K.K. Nirula. (Abs.) . . . . .	50
Panama: sugar exports 1978. (Brev.) 224		- spraying. G. Becker. (Abs.) . . . . .	247	- as white leaf vector. C.T. Chen. 243	
- vitaminization. E. Portela <i>et al.</i> 179		- in Poland. M. Kubacka-Szmidtgal. 276		moth and caterpillar activity. A.J.M. Carnegie. (Abs.) . . . . .	209
Pans, Vacuum. (TN) . . . . .	318	insect control. L. van Steyvoort and E. Seutin. (Abs.) . . . . .	212	nematodes, cane varietal tolerance. M.M. Aguilera and S. Matsuoaka. 273	
- condenser. V.I. Dovgopool <i>et al.</i> 89		leafhopper as curly top vector. D.L. Mumford. (Abs.) . . . . .	276	- control. K.J. Chandler. (Abs.) . . . . .	371
- continuous. C.J. Abraham. (Abs.) 85		mice. Anon. (Abs.) . . . . .	276	- in Cuba. J.P. O'Reilly and J.R. Pérez M. (Abs.) . . . . .	150
- W.S. Graham and D.J. Radford. 20		moth trapping. G.L. Ayre and R.B. Semple. (Abs.) . . . . .	276	- Mauritius. J.R. Williams and M. Luc. 242	
- F. Langreny. (Abs.) . . . . .	155	nematodes. D.A. Cooke. (Abs.) . . . . .	247	- Peru. E.E. Carbonell. (Abs.) . . . . .	150
Copersucar. Divisão Industrial do Departamento Técnico da Copersucar. (Abs.) . . . . .	310	- control. Anon. (Abs.) . . . . .	19	- population seasonal fluctuation and control. K. Singh and S.R. Misra. (Abs.) . . . . .	208
- dimensions and incondensable gas trapping. F. Zama. (Abs.) . . . . .	54	- D.G. Kontaxis and I.J. Thomason. 212		pesticide interaction with nitrogen. P.P. Singh and K. Kumar. . . . .	329
- feed automatic control. T. Kalitynski. 250		- R. Smith <i>et al.</i> (Abs.) . . . . .	276	rat control. B.E. Hitchcock and R.E. Kerkwyk. (Abs.) . . . . .	371
- steam and power consumption. effect of refinery computer control. T. Ozeki and M. Ishida. (Abs.) 314		- W.C. von Kessel. (Abs.) . . . . .	212	research in Jamaica. Anon. (Abs.) . . . . .	272
- requirement and factory energy self-sufficiency. H.S. Birkett. 215		- G. Wiebe. (Abs.) . . . . .	212	- Mauritius. Anon. (Abs.) . . . . .	81
- structural design. D. Macey. (Abs.) 120		- in U.K. R.A. Dunning and T.P.J. Dyke. (Abs.) . . . . .	19	- scale insect. J. Etienne. (Abs.) . . . . .	209
see also Boiling; Crystallization; Entrainment; Heat; Massecuite and Scale		- cyst counting in soil. . . . .	19	- damage to cane. A.V. Rao and M.S. Murty. (Abs.) . . . . .	50
Paper, Bagasse: factory in Argentina. 255		- determination in soil. C. Winner. 84		- and control. B.H.K. Rao . . . . .	50
- India. (Brev.) . . . . .	288	- hatching agent. J.D. Willett and L.M. Cheek. (Pat.) . . . . .	283	- and mealy bug control. A.H. Shah <i>et al.</i> (Abs.) . . . . .	50
- Iran. (Brev.) . . . . .	127	root aphid in Rumania. V. Ciochia <i>et al.</i> (Abs.) . . . . .	19	- weevil damage and fungal disease. R. Acosta B. and F.A. Rodriguez. 209	
- manufacture. P.L. Gutiérrez. (Abs.) 252		soil pests control. V. Ciochia and M. Ionescu. (Abs.) . . . . .	247	white grub control. P.R. Moholkar <i>et al.</i> (Abs.) . . . . .	16
- in India, government incentives. 288		Pests, Cane: aphid trapping and flight activity. G.T. Lim <i>et al.</i> (Abs.) . . . . .	151	- distribution damage to cane and control. G.K. Veeresh. (Abs.) 50	
- mini-plants. P.J.M. Rao. (Abs.) . . . . .	126	in Australia. B.E. Hitchcock. 341			
		borer alternative host. P.R. Atkinson. (Abs.) . . . . .	371		
		- control. J.S. Sandhu and M.S. Duhra. (Abs.) . . . . .	50		
		- O.P. Singh. (Abs.) . . . . .	50		
		- in Brazil. D. Gallo <i>et al.</i> (Abs.) . . . . .	151		
		- S.H. Risco B. (Abs.) . . . . .	209		
		- F.O. Teran and W.R. Novaretti. 208			
		- by infested shoot excision. B. Wiriatomodjo and D. Samoeidi. 151			
		- trash mulching. A. Subramanian <i>et al.</i> (Abs.) . . . . .	243		
		- damage and red rot infection. F. Alonso. (Abs.) . . . . .	341		



## INDEX

**Pests, Cane:**  
white grub and grey back grub control. W.A.C. Webb. (Abs.) . . . 243  
-- wireworm resistance to pesticide. S.A. Hsieh. (Abs.) . . . 371  
-- in Taiwan. M.Y. Chen and S.T. Tseng. (Abs.) . . . 272  
wireworm damage and control. A.A. Marwaha. (Abs.) . . . 243  
pH: automatic control. (TN) . . . 158  
-- diffusion water. M. Rogowska and Z. Węgrzynowski. (Abs.) . . . 346  
beet juice, effect of invert sugar degradation. W. Drewnowska and A. Butwiliowicz. (Abs.) . . . 345  
calculation of sugar, massecuite and molasses. N.A. Arkhipovich *et al.* cane juice, effect of bactericides. H.G. Ayala *et al.* (Abs.) . . . 180  
-- cane extraneous matter. R.P. Scott *et al.* (Abs.) . . . 348  
-- clarification system. J.C. Gaiofatto and A.T. Sobrinho. (Abs.) . . . 181  
-- clarifier type. M. Mochtar. . . 179  
-- frost. O. Singh and R.S. Kanwar. 359  
carbonation juice optimum, determination. F.A. Baczek and V.M. Jesic. (Abs.) . . . 182  
-- N. Sendokmen and O.C. Akyar. 182  
-- effect on heat and cost savings. K.E. Reznik and V.D. Vitvitskii. (Abs.) . . . 218  
decrease in chopped cane. J.E. Irvine and B.L. Legendre. (Abs.) . . . 110  
effect on beet juice glutamine content in evaporation. J. Nedelkovits and K. Fábiani. (Abs.) . . . 91  
calcium phosphates zeta-potential. R. Fajardo G. and L.D. Bobrovnik. 216  
cane juice colloid removal. M. Date and M.C. Ruiz G. (Abs.) 215  
raw sugar zeta-potential. D.V. Freeland *et al.* (Abs.) . . . 196  
-- yeast cultivation on cane molasses. P. Hernández S. and I. Morrell F. flocculant solution, effect on clarification. G.S. Shephard. (Abs.) . . . 378  
harvested cane juice. J.D. Miller *et al.* (Abs.) . . . 176  
sulphitation. Z.A. Mil'kova *et al.* 92  
*see also* Carbonation; Clarification and Sulphitation  
**Philippines: alcohol manufacture**  
(Brev.) . . . 255, 288, 384  
cane crop damage by storm. (Brev.) 64  
germplasm collection. A.T. Barredo and T.R. Escobar. (Abs.) . . . 83  
varieties morphology and cytology. N.S. Divinigracia and D.A. Ramirez. (Abs.) . . . 210  
-- trials. V. Y. G. and A. (Abs.) . . . 51  
Fletcher and Stewart sugar projects. 194  
International Society of Sugar Cane Technologists, 17th Congress 1980 352  
soil magnesium release. R.N. Nartea and V.G. Castro. (Abs.) . . . 144  
sugar statistics. (Stat.) . . . 320  
trade agreement with China. (Brev.) 319  
**Phosphatation.** S.P. Mishra. (Abs.) 85  
Rotation of cane syrup. C.M. Madrazo *et al.* . . . 215  
polysaccharide removal. E.J. Roberts *et al.* (Abs.) . . . 314  
refinery melt liquor. M. Matic *et al.* 184  
**Pipeline:** fittings. (TN) . . . 30  
**Poland:** beet campaign starting and finishing dates. G. Sobczyk. (Abs.) 182  
-- payment. K. Szczot and H. Jochim. 346  
-- pests and diseases. M. Kubacka-Szmigda. (Abs.) . . . 276  
sugar beet production. (Brev.) . . . 384  
exports. (Stat.) . . . 223  
-- industry decline. (Brev.) . . . 94  
-- expansion. (Brev.) . . . 65  
**Polarimetry:** automatic saccharimeters. E. David. (Abs.) . . . 379  
Codex Alimentarius method. Anon. 315  
comparison with gas-liquid chromatography for sucrose determination. Anon. (Abs.) . . . 187  
-- M.A. Brokensha *et al.* (Abs.) 349  
-- Schieber and I.A. Smith. effects of clarifying agent and polysaccharides. B. Guzmán. (Abs.) 124  
-- temperature. A. Emmerich. (Abs.) 25  
high-colour products. A.Y. Zagorulkov *et al.* (Abs.) . . . 26  
**Polarimetry:**  
sugars detection in high-pressure liquid chromatographic systems. G.B. Cox and I.K.O'Neill. . . . 378  
*see also* Control, Chemical  
Polarization measurement *see* Polarimetry  
Polyelectrolytes *see* Carbonation; Clarification and Filtration  
Polysaccharides: contained in cane juice, effect of flowering. J.C. Salata and L.J. Ferreira. (Abs.) . . . 207  
-- frost. O. Singh and R.S. Kanwar. 359  
-- harvesting delay. Anon. (Abs.) 213  
-- J.E. Irvine and B.L. Legendre. (Abs.) . . . 110  
-- in raw sugar, determination. I.F. Bugaenko and A.I. Lapkin. . . . 347  
-- seasonal effects. Anon. (Abs.) 188  
effect on cane juice settling. S.C. Sharma. (Abs.) . . . 180  
-- molasses viscosity. Anon. (Abs.) 188  
-- polarimetry. B. Guzmán. (Abs.) 124  
floc formation in refined sugar. E.J. Roberts and M.A. Godshall. . . . 379  
-- sugar solution, effect of proteins. M.A. Godshall and E.J. Roberts. 379  
formation in cane juice, effect of micro-organisms. M.T. Hernández *et al.* (Abs.) . . . 220  
-- yeast. M.T. Hernández *et al.* gum fermentation of sugar. W.P. Chen *et al.* (Abs.) . . . 125  
removal from cane juice. M. Darias P. and M.C. Ruiz G. (Abs.) . . . 215  
by melt phosphatation. M. Matic *et al.* (Abs.) . . . 184  
-- in refining. E.J. Roberts *et al.* . . . 314  
*see also* Dextran and Starch  
Portugal: beet sugar factory plans. 194  
Powdered sugar. Iceing sugar  
**Power:** consumption by cane mills, effect of cane burning. J.P. Lamusse. 231  
-- trash. F.A. Fogliata *et al.* . . . 180  
-- vacuum pans, effect of refinery computer control. T. Ozeki and M. Ishida. (Abs.) . . . 314  
factor improvement calculation. J. van Dokkum. (Abs.) . . . 374  
generation, effect of high-pressure steam utilization. T. Wardhana. 310  
-- and fuel consumption. H. Hattori. D. Murata and W. Gibson. (Abs.) 21  
-- heat economy in cane sugar factories. W. Leibig. (Abs.) . . . 154, 216  
-- for supply to the public grid. P.J.M. Rao. (Abs.) . . . 52, 248  
-- K.W. Watts *et al.* (Abs.) . . . 343  
soil drainage pump requirement calculation. C. Henkel. (Abs.) . . . 15  
supply to sugar factories by external associations. G. de Souza *et al.* 310  
voltage in Brazil. C. Piedade *et al.* 248  
-- and factory equipment performance. W. Goepen. (Abs.) . . . 250  
Prices: computer storage bank. . . . 255  
EEC green currencies. (NC) . . . 162  
-- sugar. (NC) . . . 65  
-- and beet. (NC) . . . 225  
International Sugar Agreement daily and prevailing prices. (NC) . . . 353  
New York spot price resumption. 1, 290  
raw sugar hedging. E.P. Roy *et al.* . . . 55  
world sugar. (NC) 2, 33, 66, 98, 131, 162, 193, 225, 257, 289, 322  
*see also* Payment  
Puerto Rico: cane rust. (Brev.) 64, 191  
irrigation. A. J. Gonzalez. (Abs.) 206  
Pulp, Bagasse: bleaching. Z. Herrera *et al.* (Abs.) . . . 222  
hemicellulose quality. A.E. el-Ash-mawi *et al.* (Abs.) . . . 94  
manufacture. A.J. Ernst and T.F. Clark. (Abs.) . . . 254  
-- P.L. Gutiérrez. (Abs.) . . . 252  
-- J.J. Hough and J.S.M. Venter. 126  
-- S.C. Lin. (Abs.) . . . 221  
-- E.A. Villavicencio. (Pat.) . . . 28  
black liquor recovery. M. Castellanos C. *et al.* (Abs.) . . . 93  
-- mathematical model. R. Suárez R. and L. González P. (Abs.) . . . 93  
*see also* Paper, Bagasse  
Pulp, Toilet: animal fodder. N.B. Davis and P. Tory. (Abs.) . . . 282  
-- B. Frank. (Abs.) . . . 221  
-- A. Giouzelyanne. (Abs.) . . . 282  
-- A.M. Paulais. (Abs.) . . . 252  
Pulp, Beet: animal fodder. E. Pfeffer. 125  
-- Raffinerie Tirlenmontoise. (Pat.) 317  
-- R. Teissier *et al.* (Pat.) . . . 29  
betaine determination. G. Steinle and E. Fischer. (Abs.) . . . 91  
drying. J. Malczewski. (Abs.) . . . 253  
-- drum inlet temperature and capacity optimization. H. Huber. . . . 59  
-- with gas turbine heat. W.J. Leibig. fluorine determination. P.B. Koster *et al.* . . . 4  
mannitol occurrence. J. Caplovic and F. Rendos. (Abs.) . . . 57  
pesticide residue determination. P.B. Koster. (Abs.) . . . 91  
presses. (TN) . . . 318  
-- G. Katics. (Abs.) . . . 381  
pressing and drying. (TN) . . . 318  
effect of diffuser acidification. J.F. Oldfield *et al.* (Abs.) . . . 279  
quantity determination. V.N. Bazlov. 350  
texture measurement. R. Vanstellen. 350  
Pumps. (TN) . . . 30, 318  
M. Pietrzak. (Abs.) . . . 345  
beet. S. Dusek and J. Dytar. . . . 22  
-- N.D. Khomenko and V.G. Yarmilko. 22  
-- N.D. Khomenko *et al.* (Abs.) . . . 277  
carbonatation mud. Z. Kembrowski *et al.* (Abs.) . . . 312  
power requirements for land drainage. C. Henkel. (Abs.) . . . 15  
type and clarification mud filtration. A.G. Noble and G.A. Brotherton. 344  
**Raffinose:** determination. J. Dobrzycki. (Abs.) . . . 187  
effect on sucrose crystallization. G. Mantovani *et al.* (Abs.) . . . 58  
*see also* Sugars  
Raw sugar: colorants. T. Yamane *et al.* 315  
-- determination by high-pressure liquid chromatography. N.H. Smith. (Abs.) . . . 379  
colour determination and payment. J.V. López-Oña. (Abs.) . . . 187  
-- and polysaccharide content, seasonal effects. Anon. (Abs.) . . . 188  
dextrose and levulose contents. W. Mauch and E. Krause. (Abs.) . . . 124  
enzymatic removal of starch. S. Bose *et al.* (Abs.) . . . 157  
filtrability, effect of dextran. R.P. Fulcher and P.A. Inkerman. (Abs.) 348  
grain size analysis in Mauritius. E.C. Vignes. (Abs.) . . . 124  
hedging. E.P. Roy *et al.* (NB) . . . 55  
high polymers determination and removal. I.F. Bugaenko and A.I. Lapkin. (Abs.) . . . 347  
Indian standards. A.C. Chatterjee and A.R. Bhidi. (Abs.) . . . 122  
microorganisms. A.K. Kulkarni. (Abs.) 380  
moisture and centrifugal efficiency. E. Svoboda and J. Klepal. (Abs.) 217  
new London contract. (NC) 289, 354  
York spot price resumption. . . . 1, 290  
non-sugars zeta-potential and colour removal. D.V. Freeland *et al.* . . . 196  
phenolic acids identification. N.H. Paton. (Abs.) . . . 124  
protein determination. M.A. Godshall and E.J. Roberts. (Abs.) . . . 379  
reducing sugars determination. I. Diaz *et al.* (Abs.) . . . 379  
refining quality. Anon. (Abs.) . . . 380  
-- W. Altenburg. (Abs.) . . . 380  
-- J.V. López-Oña. (Abs.) . . . 380  
storage and bacterial development. N.V. Kostenko and V.Z. Nakhodkina. (Abs.) . . . 347  
-- colour increase. N.V. Kostenko *et al.* (Abs.) . . . 24  
trace metals determination. K. Tomobe and T. Nagasaka. (Abs.) . . . 315  
world markets in 1979. (NC) . . . 1

# INDEX

	page		page		page
Reducing sugars: content in stored beet, effect of temperature. R.E. Wyse. (Abs.) . . . . .	307	Refining: colour removal, active carbon consumption determination. A. Curbelo S. (Abs.) . . . . .	184	Soil: analysis for nutrients, and nematode counts. C. Winner. (Abs.) . . . . .	84
- cane juice, effect of bactericides. H.G. Ayala <i>et al.</i> (Abs.) . . . . .	180	--- fixed vs. moving bed. E. Krauss P. (Abs.) . . . . .	184	--- requirements assessment. G. Price. 304	
--- borer and rot. G.M. da Silva and R.S. de Moraes. (Abs.) . . . . .	209	--- effect of non-sugars zeta-potential. D.V. Freeland <i>et al.</i> (Abs.) . . . . .	196	--- and texture. K.V. Joshi. (Abs.) . . . . .	15
--- extraneous matter. R.P. Scott <i>et al.</i> (Abs.) . . . . .	348	--- ion exchange resin. P. Hoareau <i>et al.</i> (Abs.) . . . . .	122	--- potassium deficiency diagnosis. R.P. Humbert. (Abs.) . . . . .	304
--- frost. O. Singh and R.S. Kanwar. 359		--- F.X. Pollio and F.X. McGarvey. (Abs.) . . . . .	157	--- beet seedbed preparation. G. Spoor. 178	
--- ripeners. A.S. Chacravarti <i>et al.</i> 48		--- K. Sasaki <i>et al.</i> (Abs.) . . . . .	377	--- K. Thompson. (Abs.) . . . . .	178
--- J. Fernandes <i>et al.</i> (Abs.) . . . . .	206	--- effect of raw sugar high polymers. I.F. Bugaenko and A.I. Lapkin. 347		--- and fertilization effects on beet growth. W.C. von Kessel. 308	
--- carbonatation juice. K.P. Zakharov <i>et al.</i> (Abs.) . . . . .	313	--- Japan industry capacity. (Brev.) . . . . .	63	--- boron determination. M.M. Kao and T.C. Juang. (Abs.) . . . . .	338
--- effect of intermediate liming. A.P. Lapin <i>et al.</i> (Abs.) . . . . .	54	--- liquor carbonatation with flocculants. Anon. (Abs.) . . . . .	184	--- cane growth on calcareous soils. H. Evans. . . . .	38
decrease in growing cane. T.T. Yang and T.S. Hsieh. (Abs.) . . . . .	238	--- F.M. Runggas. (Abs.) . . . . .	377	--- trash incorporation. C.M. McAleese. 14	
determination. B. Slutsky and A. Lara. (Abs.) . . . . .	220	--- clarification with flocculants. J.T. Rundell and P.R. Pottage. (Pat.) . . . . .	28	--- for borer control. A. Subramanian <i>et al.</i> (Abs.) . . . . .	243
- in cane juice, molasses and raw sugar. I. Diaz <i>et al.</i> (Abs.) . . . . .	379	--- J.T. Rundell <i>et al.</i> (Abs.) . . . . .	215	carbonatation mud application. Anon. (Abs.) . . . . .	252
- molasses, instrument failure. Anon. (Abs.) . . . . .	187	--- Tate & Lyle Ltd. (Pat.) . . . . .	285	--- G. Vaccari and C.A. Accorsi. 222	
formation in cane milling, effect of micro-organisms. E. Duarte P. and J.L. Pérez. (Abs.) . . . . .	248	--- filtration, effect of raw sugar components. E. Whayman and T.W. Meredith. (Abs.) . . . . .	184	--- chemical weed control in beet on light soils. F. Maykuhs. (Abs.) . . . . .	177
ratio to ash in cane molasses, effect of alcohol. A.D. Robertson. (Abs.) . . . . .	349	--- ion exchange treatment and resin fouling. F. Maekawa <i>et al.</i> (Abs.) . . . . .	377	compaction and cane yield. R. Ricaud. (Abs.) . . . . .	111
- sucrose in cane, effect of ripening. E.J. de A. Leme and R. Scardua. 175		--- regeneration. K. Kawasaki <i>et al.</i> (Abs.) . . . . .	377	--- wheel vs. crawler tractors. W.W. Brixius. (Abs.) . . . . .	113
removal by affination. A.P. Kozaykin and N.I. Odorod'ko. (Abs.) . . . . .	24	--- phosphatation. M. Matic <i>et al.</i> . . . . .	184	condition and herbicide effect on beet. E. Dalleinne. (Abs.) . . . . .	18
see also Dextrose; Invert sugar; Levulose and Sugars		--- preconcentration and boiling house heat balance. R. de los Rios. . . . .	314	conservation. C.T. Wise. (Abs.) . . . . .	338
Refined sugar: colorants determination by high-pressure liquid chromatography. N.H. Smith. (Abs.) . . . . .	379	polysaccharide removal. E.J. Roberts <i>et al.</i> (Abs.) . . . . .	314	copper deficiency. E.A. Pembroke. 14	
- filtrability, effect of dextran. R.P. Fulcher and P.A. Inkerman. (Abs.) . . . . .	348	protein removal. M.A. Godshall and E.J. Roberts. (Abs.) . . . . .	379	cultivation, effect on cane yield. J. Fernandes <i>et al.</i> (Abs.) . . . . .	112
Indian standards. A.C. Chatterjee and A.R. Bhide. (Abs.) . . . . .	122	quality of raw sugar. W. Altenburg. 380		machines efficiency. S.W.D. Baxter. 114	
manufacture in Australia and New Zealand. (Brev.) . . . . .	256	--- J.V. López-Oña. (Abs.) . . . . .	380	minimum tillage system. W. Hadlow and E.W. Millard. (Abs.) . . . . .	109
- USSR. (Brev.) . . . . .	127	Technical Session on Cane Sugar Refining Research. . . . .	13	--- P.K. Moberly and P.E.T. Turner. 146	
metals determination. R. Cormier <i>et al.</i> (Abs.) . . . . .	380	see also Affination; Bone char; Carbon; Active; Ion exchange; Raw sugar and Syrup		tillage method effect on cane yield and soil properties. A.A. Casagrande and O.P. Godoy. (Abs.) . . . . .	147
moisture and centrifugal efficiency. E. Svoboda and J. Klepal. (Abs.) . . . . .	217	Refractometers. Anon. (Abs.) . . . . .	187	disinfectant effect on beet. G. Pritoni <i>et al.</i> (Abs.) . . . . .	245
proteins determination. M.A. Godshall and E.J. Roberts. (Abs.) . . . . .	379	beet diffusion automatic control. G. Windal. (Abs.) . . . . .	182	drain construction aids. A.I. Linedale. 78	
solution floc formation. M.A. Clarke <i>et al.</i> (Abs.) . . . . .	184	sugars detection in high pressure liquid chromatography systems. G.B. Cox and I.K.O'Neill. (Abs.) . . . . .	378	D.W. Beattie. (Abs.) . . . . .	78
--- effect of polysaccharides and proteins. E.J. Roberts and M.A. Godshall. (Abs.) . . . . .	379	Réunion: ARTAS 2nd International Congress. . . . .	8	--- C.W. Chardon and A.V. Rudd. 337	
--- prevention. Anon. (Abs.) . . . . .	184	cane breeding. Anon. (NB) . . . . .	90	--- A.V. Rudd. (Abs.) . . . . .	15
synthetic medium for yeast activity measurement. V.M. Golubtsova. 222		Reverse osmosis: decolorizing resin effluent treatment. S. Kishihara and M. Komoto. (Abs.) . . . . .	347	--- and irrigation in Argentina. L.M. Blaquiere <i>et al.</i> (Abs.) . . . . .	145
see also Icing sugar; Liquid sugar; Sugar; Tablet sugar and White sugar		Rum: fermented mash analysis by gas-liquid chromatography. E. Rosado and H. Batiz. (Abs.) . . . . .	57	--- pump power requirements calculation. C. Henkel. (Abs.) . . . . .	15
Refinery: Amstar Corporation, Boston. . . . .	137	Rumania: beet harvesters. Z. Stanescu and N. Bria. (Abs.) . . . . .	17	--- with underground tubing. G. Gallarate. (Abs.) . . . . .	275
- bagged sugar conveyors. . . . .	347	- root aphid. V. Cicchia <i>et al.</i> (Abs.) . . . . .	19	--- L.K. Izatt. (Abs.) . . . . .	338
- in Belgium. Anon. (Abs.) . . . . .	184	- varieties. Z. Stanescu <i>et al.</i> (Abs.) . . . . .	309	effect on cane yield turbidity. Anon. 213	
- closure in UK. (Brev.) . . . . .	320	Saint Kitts: cane smut. (Brev.) . . . . .	64	- leaf Cu, Fe, Mn and Zn. J. Orlando and E. Zambello. (Abs.) . . . . .	14
decolorizing resin effluent treatment. S. Kishihara and M. Komoto. . . . .	347	sugar production 1978. (Brev.) . . . . .	31	--- nutrient composition. J. Orlando <i>et al.</i> (Abs.) . . . . .	112
effluent pollution limitations in US. R. Dellinger. (Abs.) . . . . .	122	St. Vincent: sugar factory. (Brev.) . . . . .	71	elements, effect on cane yield. E.R. Beaufils and M.E. Sumner. (Abs.) . . . . .	110
- treatment. K. Akiyama and M. Okada. (Abs.) . . . . .	377	Salvador: Central American Sugar Technologists meeting. (Brev.) . . . . .	287	erosion prevention. G. Spee. (Abs.) . . . . .	177
- sludge drying. J. Yamaga and S. Shirakawa. (Abs.) . . . . .	282	Jiboa sugar factory. . . . .	227	- in Trinidad. J.E.W. Georges. (Abs.) . . . . .	147
- in Lebanon. (Brev.) . . . . .	127	Sampling. (Brev.) . . . . .	158	estimation in cane by ashing. Anon. 213	
products pH calculation. N.A. Arkhipovich <i>et al.</i> (Abs.) . . . . .	188	see also Control, Chemical		factors and cane yield decline in India. G.R. Naik <i>et al.</i> (Abs.) . . . . .	15
raw sugar colour determination and payment. J.V. López-Oña. (Abs.) . . . . .	187	Saponin determination in sugar. A. Kurkowska-Mielczarek. (Abs.) . . . . .	281	herbicide residues and degradation. B.J. Eaton <i>et al.</i> (Abs.) . . . . .	111
Reverse Sugar Corporation. . . . .	135	Scale: formation in boilers. B.B. Khochare. (Abs.) . . . . .	248	injection with ethylene, effect on beet yield and sugar content. L.J. Franci <i>et al.</i> (Abs.) . . . . .	84
steam trap inspection and maintenance. K. Nakazato and E. Fuwa. 377		- effect of lime. N.A. da Glória and E. da Silva. (Abs.) . . . . .	180	land utilization in Australia. A. Hegarty. 78	
- in Sudan. . . . .	355	prevention in boilers. E. Fröchlich. 248		lime application. Anon. (Abs.) . . . . .	241
symp stainless steel tanks. (Brev.) . . . . .	30	removal from juice heaters, effect of clarification. J.C. Gaiofatto and A.T. Sobrinho. (Abs.) . . . . .	181	--- and potassium availability. D.A. Cordeiro <i>et al.</i> (Abs.) . . . . .	111
Refining. A.C. Chatterjee and A.R. Bhide. (Abs.) . . . . .	122	Scale, Evaporator: formation monitoring. R. Detavernier <i>et al.</i> (Abs.) . . . . .	123	filter-cake and gypsum application. O.D. Curtis <i>et al.</i> (Abs.) . . . . .	207
- acid floc precursor removal. Anon. 184		- reduction. N.E. Chiang <i>et al.</i> . . . . .	215	magnesium release. R.N. Nartea and V.G. Castro. (Abs.) . . . . .	144
--- M.A. Clarke <i>et al.</i> (Abs.) . . . . .	184	- by carbonatation juice lime salts control. W. Uhlenbrock. (Abs.) . . . . .	278	manganese availability in Hawaii and Florida. G.J. Gascho <i>et al.</i> . . . . .	110
aids manufacturer receives Queen's Award to Industry. (Brev.) . . . . .	382	--- pH optimization. K.E. Reznik and V.D. Vitvitskii. (Abs.) . . . . .	218	- effect on cane leaf amino-acids. G.S.C. Rao and A.P. Gupta. . . . .	99
- new UK company formed. (Brev.) . . . . .	96	--- clarification with dolomitic lime. J.M. Zuazua N. (Abs.) . . . . .	181	nitrogen uptake, distribution and metabolism in beet. K. Koch. . . . .	245
automatic control. T. Ozeki and M. Ishida. (Abs.) . . . . .	314	removal. P.C. Ivin. (Abs.) . . . . .	373	oxygen content and cane growth. Y.S. Sheu <i>et al.</i> (Abs.) . . . . .	369
carbo-phosphatation vs. carbon sulphitation. K.K. Gupta <i>et al.</i> 122		- J.W.V. Lewis <i>et al.</i> (Abs.) . . . . .	374	parameters effect on cane yield and sugar content. A.A. Tomaneng. 206	
clarification scum sugar recovery. Tate & Lyle Ltd. (Pat.) . . . . .	285	Shredders see Mills, Cane		phosphate analysis. V.C. de Bittencourt <i>et al.</i> (Abs.) . . . . .	112
colour removal with active carbon. S. Sakamaki and T. Onishi. (Abs.) . . . . .	122	Soil: analysis. G. Ramchandran. . . . .	338	--- in Brazil. M.L. Marinho and G.A.C. Albuquerque. (Abs.) . . . . .	145

# INDEX

	page		page		page
Soil:		Starch:		Storage, Beet:	
salinity effect on beet quality. C.		effect on refinery liquor filtration.		losses. M. Loilier. (Abs.) . . . . .	121
Mathieu and F.W. Hesse. (Abs.) . . .	211	E. Whayman and T.W. Meredith.	184	G.F. Tyazheleva. (Abs.) . . . . .	376
-- cane sett germination. S. Valdivia		removal by enzymes from sugar		determination. P. Devillers. (Abs.) .	345
V. and J. Pinna C. (Abs.) . . . . .	368	factory products. S. Bose <i>et al.</i> . .	157	effect of beet weight. J. Zahradnický	
-- yield and photosynthesis. G.V.		melt phosphatation. M. Matić <i>et al.</i> .	184	<i>et al.</i> (Abs.) . . . . .	277
Joshi and G.R. Naik. (Abs.) . . . . .	48	Statistics: Algeria sugar imports . . .	31	-- temperature. R.E. Wyse. (Abs.) .	307
-- reduction with calcium chloride.		Argentina sugar exports . . . . .	127	pile air flow. V.T. Serkin <i>et al.</i> (Abs.)	345
J.A.C. Gonçalves and A.G. Santos. 112		Australia sugar exports . . . . .	223	-- forced ventilation. T. Baloh. (Abs.)	88
-- by drainage. S.J. Yang and P.L.		Belgium sugar imports and exports .	192	S. Vajna. (Abs.) . . . . .	88
Wang. (Abs.) . . . . .	110	Brazil sugar exports . . . . .	128	-- with freezing air. M.Z. Khelemskii	
-- and texture in Peru. J.C. Sevilla G.	368	Canada sugar imports . . . . .	237	<i>et al.</i> (Abs.) . . . . .	89
sodium content, effect on cane yield.		Chile sugar . . . . .	319	-- thermodynamics. T. Baloh. . . . .	23
S. Valdivia V. (Abs.) . . . . .	109	Cuba sugar . . . . .	256	-- fungicide treatment. W.G. Miles	
toxicity. P.K. Makepeace. (Abs.) . .	240	Czechoslovakia sugar exports . . . .	255	<i>et al.</i> (Abs.) . . . . .	212
type effect on beet sugar content.		Dominican Republic sugar . . . . .	237	polar silo. (TN) . . . . .	318
D. Bourdon. (Abs.) . . . . .	376	Guatemala sugar . . . . .	351	in USSR. V.S. Vyshak and A.I.	
water content and cane guttation.		Holland sugar imports and exports .	224	Sidorenko. (Abs.) . . . . .	277
T.T. Yang and C.T. Chen. (Abs.) . .	176	India sugar . . . . .	32	Sucrose: derivatives. Tate & Lyle Ltd.	285
depletion and cane water utilization.		Indonesia sugar imports . . . . .	258	determination. J. Dobrzycki. (Abs.) .	187
M.R. Reddy <i>et al.</i> . . . . .	239, 240	International Sugar Organization		-- by gas-liquid chromatography.	
effect on cane varietal yield. D.B.		yearbook 1977 (NB) . . . . .	56	Anon. (Abs.) . . . . .	188
Hellmann. (Abs.) . . . . .	146	Iran sugar imports . . . . .	384	-- P.G. Morel du Boil and K.J.	
-- management in Florida. S.F. Shith		Japan sugar imports . . . . .	191	Schäffler. (Abs.) . . . . .	378
<i>et al.</i> (Abs.) . . . . .	111	Madagascar sugar . . . . .	287	-- D. Nurok and T.J. Reardon. . . . .	58
-- and nitrogen effect on cane flower-		Mauritius sugar . . . . .	190	-- vs. polarization. Anon. (Abs.) . .	187
ing. A.I. Allam <i>et al.</i> (Abs.) . . . .	109	Mexico sugar . . . . .	288	-- M.A. Brokensha <i>et al.</i> (Abs.) .	349
-- source location. L.K. Iza. (Abs.) .	109	Norway sugar imports . . . . .	127	K.J. Schäffler and I.A. Smith. . .	349
-- stress effect on smut disease . . .		Peru sugar exports . . . . .	256	-- by polarization vs. enzymatic	
incidence. R.A. Bailey. (Abs.) . . .	115	Philippines sugar . . . . .	320	method. R. Detavernier <i>et al.</i> . .	123
-- table depth and beet yield and		Poland sugar . . . . .	223	esters analysis. R. Cormier <i>et al.</i> .	381
quality. G.A. Reichman <i>et al.</i> . . . .	18	South Africa sugar exports . . . . .	192	-- synthesis. G.P. Rizzi and H.M.	
-- uptake by cane roots. G. Kingston.	144	South Korea sugar imports and		Taylor. (Pat.) . . . . .	284
waterlogging and fertilizer foliar		exports . . . . .	383	hydroxyalkyl ether preparation. D.	
application. P.K. Bose. (Abs.) . . .	239	Sudan sugar imports . . . . .	287, 384	Maassen <i>et al.</i> (Pat.) . . . . .	60
zinc effect on cane yield. T.C. Juang		Swaziland sugar . . . . .	224	incorporation in resins. C.H. Lin	
<i>et al.</i> (Abs.) . . . . .	110	Taiwan sugar exports . . . . .	159	<i>et al.</i> (Abs.) . . . . .	125
see also Fertilizers; Irrigation and		Tanzania sugar . . . . .	255	interaction with metal ions. L.	
Pests		Thailand sugar exports . . . . .	128	Poncin. . . . .	36
Somalia: sugar expansion plans.	95	UK sugar imports and exports . . .	160	-- surfactants. N.S. D'yachenko.	380
-- project. (NC) . . . . .	194	US sugar imports . . . . .	190	inversion catalysis by oxidized	
Sorghum: syrup manufacture and		USSR sugar imports and exports .	270	carbons. A.A. Larina and V.G.	
properties. K. Vukov <i>et al.</i> (Abs.) .	25	West Indies sugar . . . . .	191	Aleinikov. (Abs.) . . . . .	314
South Africa: activated sludge treat-		world sugar production 1978/79 .	62, 189	-- determination by high pressure	
ment of waste water. J. Bruijn. . . .	154	Steam: balance in a sugar factory.		liquid chromatography. M.A.	
bagasse board factory closure. . . .	64	M.K. Hicks. (Abs.) . . . . .	120	Clarke <i>et al.</i> (Abs.) . . . . .	379
by-products utilization. R.J. Andrews.	125	consumption, effect of evaporator		-- in syrup ion exchange treatment.	
cane agriculture. Anon. (NB) . . . .	55	vapour bleeding. B.B. Khochare . .	20	V. Maurandi. (Abs.) . . . . .	218
-- research. Anon. (NB) . . . . .	80	-- pressure evaporation. T. Wardhana.	310	-- kojic acid fermentation. P. Bajpai	
-- mechanization developments. Anon.	80	in French sugar factories. J. . . .	22	<i>et al.</i> (Abs.) . . . . .	93
-- study group recommendations.		Leduc. (Abs.) . . . . .	22	solution boiling point elevation.	
Anon. (Abs.) . . . . .	241	-- reduction. S.K. Ghosh. (Abs.) . .	119	E. Sárka <i>et al.</i> (Abs.) . . . . .	251
-- payment. E.J. Buchanan. (Abs.) . .	157	-- W. Leibig. (Abs.) . . . . .	154, 216	-- vapour pressure. V.I. Tuzhilkin	
-- smut control. R.A. Bailey. (Abs.) .	149	-- P.J.M. Rao. (Abs.) . . . . .	311	and I.N. Kaganov. (Abs.) . . . .	57
<i>Eldana saccharina</i> incidence. R.J.		-- by use of heat pump. A. Fényes. . .	89	-- viscosities. effect of temperature and	
Small. (Abs.) . . . . .	371	-- vapour compression. P. Christod-		concentration. K. Koziol <i>et al.</i> .	281
-- mass rearing and artificial infest-		oulou. (Abs.) . . . . .	375	see also Crystallization; Fermentation;	
ation. P.R. Atkinson. (Abs.) . . . .	90	-- by vacuum pans, effects of refinery		Sugar and Sugars	
herbicide guide. Anon. (NB) . . . . .	371	computer control. T. Ozeki and		Sudan: Kenana sugar project. . . . .	355
irrigation application rates. D.B.		M. Ishida. (Abs.) . . . . .	314	sugar imports. (Stat.) . . . . .	287, 384
Hellmann. (Abs.) . . . . .	368	ejectors. (TN) . . . . .	286	-- project. (NC) . . . . .	96
rainfall. T.G.J. Dyer and J.M.		for vapour-gas mixture recirculation		-- scheme difficulties. (Brev.) . . . .	96
Gosnell. (Abs.) . . . . .	368	in carbonation. N. Marignetti		Sugar: alcohol fermentation. H.S.	
soil phosphate fixation and cane		and G. Mantovani. (Abs.) . . . . .	88	Birkett and J.A. Polack. (Abs.) . .	254
fertilization. J.H. Meyer. (Abs.) . .	146	engine automatic stoppage system.		analysis. Anon. (Abs.) . . . . .	315
sugar exports. (Stat.) . . . . .	192	M.K. Biswas and M. Singh. (Abs.) .	53	as chemical feedstock. (TN) . . . .	318
-- factory performances. J.P. Lamusse.	374	flow regulation, parameters calculation.		citric acid fermentation. P.K. Agrawal	
-- research. Anon. (Abs.) . . . . .	213	J. Blanc. (Abs.) . . . . .	279	<i>et al.</i> (Abs.) . . . . .	94, 381
-- production 1978/79. (NC) . . . . .	226	pressure optimization in boiling.		Codex Alimentarius standards for	
-- year book 1977-78. Anon. (NB) . .	185	Anon. (Abs.) . . . . .	214	soft sugar. J.A. Hupfer. (Abs.) . .	380
Tongat Group Ltd. annual report		requirements and factory energy		colorants fractionation by high	
1979. (Brev.) . . . . .	384	self-sufficiency. H.S. Birkett. . . .	215	pressure liquid chromatography.	
Spain: beet area. (Brev.) . . . . .	223	trap inspection and maintenance in		N.H. Smith. (Abs.) . . . . .	379
-- and cane growing. E. Lorduy. . . .	206	a refinery. K. Nakazato and E.		colour and ash content, effect of	
sugar factory closures. (Brev.) . . .	63	Fuwa. (Abs.) . . . . .	377	boiling system. J.F. Silva and F.	
-- industry. F. Lozano B. (Abs.) . . .	376	turbines. (TN) . . . . .	286	Zarpelon. (Abs.) . . . . .	179
-- production 1978/79. (Brev.) . . . .	319	-- and compressors. (TN) . . . . .	318	-- effect of continuous vs. batch	
Sri Lanka: cane development schemes.	287	-- lubricant. Anon. (Abs.) . . . . .	21	carbonation. S.L. Sang <i>et al.</i> . . .	248
sugar project. (Brev.) . . . . .	191	-- repairs to cane mill drive. P.B.		sulphate-carbonation. R.S. Dubey. .	53
-- situation. (Brev.) . . . . .	320	Bargate. (Abs.) . . . . .	53, 85	conveying. V. Urban. (Abs.) . . . .	278
Stainless steel: applications in sugar		see also Boilers; Furnaces, Bagasse;		crystal shape, effect of dextran.	
factories. E. Hale. (Abs.) . . . . .	52	Heat and Power		M.T. Covacevich <i>et al.</i> (Abs.) . .	123
products. (TN) . . . . .	30	Storage: bagasse. J.E. Atchison. . . .	252	-- kestoses. Anon. (Abs.) . . . . .	188
tanks for refinery syrup. (Brev.) . .	30	-- R. Hesch. (Pat.) . . . . .	285	crystallization. H.E.C. Powers. (NB)	280
Starch: content in cane, effect of		-- P. López G. (Abs.) . . . . .	253	determination in condensate. H.	
ripeners. A.S. Chacravarti <i>et al.</i> . .	48	beet thick juice losses. A.Y. Zagorul'		Zaorska <i>et al.</i> (Abs.) . . . . .	312
-- juice, effect of harvesting delay.		ko <i>et al.</i> (Abs.) . . . . .	375	dextran fermentation. N.M. Sheikh	
Anon. (Abs.) . . . . .	213	fuel and solid waste space require-		and M. Hossain. (Abs.) . . . . .	125
-- stored raw sugar, effect of micro-		ments. F. Kastner. (Abs.) . . . . .	22	dust separation. I.I. Prilutskii and	
organisms. N.V. Kostenko <i>et al.</i> . .	24	icing sugar conditioning. D. Nahler.	88	P.A. Lyubarets. (Abs.) . . . . .	22
determination in raw sugar. I.F. Bug-		molasses invert sugar degradation.		economic pocket book 1978/79. K.	
aenko and A.I. Lapkin. (Abs.) . . .	347	E.W. Krause. (Abs.) . . . . .	281	Dankowski <i>et al.</i> (NB) . . . . .	55
effect on cane juice clarification.		raw sugar colour increase. N.V.		entrainment detection. K.J. Schäffler.	378
S.C. Sharma. (Abs.) . . . . .	180	Kostenko <i>et al.</i> (Abs.) . . . . .	24	flow from storage bins. R.J. Swindells	
-- and refinery liquor phosphata-		sugar caking and moisture migration.		<i>et al.</i> (Abs.) . . . . .	344
tion. Anon. (Abs.) . . . . .	213	C.J. Lu <i>et al.</i> (Abs.) . . . . .	156	future, UK conference. . . . .	320
-- turbidity. Anon. (Abs.) . . . . .	213	see also Bulk storage		gum production by fermentation.	
-- refinery liquor clarification. D.V.		Storage, Beet: at Aarberg sugar		W.P. Chen <i>et al.</i> (Abs.) . . . . .	125
Freeland <i>et al.</i> . . . . .	196	factory. Anon. (Abs.) . . . . .	217	industrial utilization. M.J. Kort. (NB)	56

# INDEX

	page		page		page
Sugar:		Sulphitation: burnt and unburnt cane		Tanzania: sugar expansion programme	34
Industry Technologists Inc., 1978		juice, A.A. Delgado. (Abs.)	181	- factory destroyed. (Brev.)	190
meeting Proceedings. (Brev.)	3	cane juice colour removal. C.S. Lee.	180	- project. (Brev.)	352
--- 1979 meeting	132	carbonatation process. R.S. Dubey.	53	- statistics. (Stat.)	255
international economic yearbook		efficiency and white sugar ash		Thailand: drought and sugar product-	
and directory, 1978. Anon. (NB)	55	content. N.A. da Glória <i>et al.</i>	187	- ion, 1978/79. (Brev.)	237
levulose and levan enzymatic prod-		juice flow simulation by computer.		raw sugar bulk handling. (Brev.)	96
uction. (Brev.)	159	C.H. Chen <i>et al.</i> (Abs.)	180	sugar exports 1978. (Stat.)	128
low-grade sugar affination, effect of		large-grained sugar manufacture. S.		- situation. (Brev.)	64
crystal size and purity. A.P. Kozya-		Srinivasan and K.N. Pandey. (Abs.)	85	Togo: sugar complex. (Brev.)	31
vkina and N.I. Odorod'ko. (Abs.)	24	Sulphur dioxide: determination in		Trade Notices:	
manufacture. S. Nikiel. (NB)	280	- molasses. C. Christiane. (Abs.)	220	Actuated Controls Ltd.	30
- economics in US. D.L. Brooke.	119	- white sugar. M. Prasad <i>et al.</i> (Abs.)	58	A.P.V. Co. Ltd.	318
- effect of cane trash. W.F. Allison.	119	Swaziland: centrifugals order. (Brev.)	30	Booker Agriculture International	
packet palletizer. T.A. Field. (Abs.)	278	overhead irrigation. R.P. Humbert.	49	Ltd.	382
pH calculation. N.A. Arkhipovich		sugar factory performances. J.P.		Bowerhill Engineering Ltd.	382
<i>et al.</i> (Abs.)	188	Lamusse. (Abs.)	374	Braunschweigische Maschinenbauan-	
Portuguese dictionary. M.P.S.B.		- project. (Brev.)	265	stalt	318
Gonçalves. (NB)	186	- statistics. (Stat.)	224	Peter Brotherhood Ltd.	318
research in Taiwan. Anon. (NB)	280	Sweden: sugar factory closure.	32	Chemap AG.	318
saponin determination. A. Kurk-		- production 1978/79. (Brev.)	190	VEB Chemieanlagenbau Stassfurt/	
owska-Mielczarek. (Abs.)	281	Switzerland: beet area. (Brev.)	224	Kombinat.	382
science and technology. G.G. Birch		- reception at Aarberg sugar factory.		Cockedge & Co. Ltd.	318
and K.J. Parker. (NB)	185	Anon. (Abs.)	217	Delaval Turbine GmbH.	382
small-scale production. (Brev.)	236	sugar imports, 1978. (Brev.)	191	Electronic Instruments Ltd.	30
soft drink turbidity prevention.		- production 1978/79. (Brev.)	96	Enviro-Clear Division, Amstar Corpor-	
Naarden International N.V. (Pat.)	317	Syrup: Brix measurement. G.F.		ation.	286
solution boiling point elevation. E.		Heffelfinger. (Abs.)	92	Ewart Chainbelt Co. Ltd.	158, 286
Sarka <i>et al.</i> (Abs.)	251	- regulation. N.F. Bondarenko and		Farrel Machinery Group.	382
- carbonatation. K. Bara. (Abs.)	348	M.A. Marushchenko. (Abs.)	87	Fischer & Porter GmbH.	382
- changes in dextrose:levulose con-		clarification. N.L.C. Suzor. (Abs.)	181	Fives-Cail Babcock.	286
centration ratio. E. Reinefeld		- by centrifuge. W.K. Nielsen. (Abs.)	88	Humphreys & Glasgow Ltd.	318
<i>et al.</i> (Abs.)	57	- with flocculants. M.C. Bennett		Korting International Ltd.	286
- decolorization with adsorbent resin.		<i>et al.</i> (Abs.)	179	Mechanical Handling Engineers'	
J.H. Barrett and D.D. Clements.	285	- C.M. Madrazo. (Abs.)	215	Association.	158
- sodium sulphite. L.H. Bobrovnik		- J.T. Rundell and P.R. Pottage.	28	Neptune Chemical Pump Co.	30
<i>et al.</i> (Abs.)	218	- J.T. Rundell <i>et al.</i> (Abs.)	215	Netzsich Mohno-Pumpen GmbH.	318
- polysaccharide flocculation by proteins.		colloid particle size determination.		Pegler & Loudon Ltd.	30
M.A. Godshall and E.J. Roberts.	379	S.T. Krylov <i>et al.</i> (Abs.)	92	Reckon Inc.	382
- purity determination. J. Ponant.	220	colour content, effect of sulphur-car-		Richard Simon & Sons.	30, 382
- specific heat calculation. J. Dobrzy-		bonatation. R.S. Dubey. (Abs.)	53	Simon-Solite Ltd.	30
cki. (Abs.)	315	composition, effect of lime quantity		SPP Group Ltd.	30
- viscosity and refractive index, effect		and type. N.A. da Glória and E. da		Starcosa GmbH.	318
of dextran. L. Carrazana <i>et al.</i>	57	Silva. (Abs.)	180	Stord Bartz A/S	318
Spanish-Russian dictionary. J. Moreno		conveying. V. Urban. (Abs.)	278	Tate & Lyle Process Technology Ltd.	
P. and J. Lodos. (NB)	90	electrodialysis and crystallization		158, 318	
trap iron separation by magnet.		rate. N.S. Fedorova and L.D.		Trocknungsanlagen-GmbH.	318
D.B. Chinchwade. (Abs.)	53	Bobrovnik. (Abs.)	219	United Erectors.	158
vitamin A addition. E. Portela <i>et al.</i>	179	enzymatic starch removal. S. Bose		Transport: bagasse. P. López G.	253
water content, effect of affination tem-		<i>et al.</i> (Abs.)	157	beet. Z. Stanescu and N. Bria.	17
perature and crystal size. E. Svoboda		high fructose corn syrup vs. beet		Transport, cane: analysis and calcula-	
and J. Klepal. (Abs.)	23	sugar. (NC)	2	tion. L.V.B. Gentil and T.C. Ripoli.	114
- migration and caking. C.J. Lu <i>et al.</i>	156	--- EEC levy. (NC)	194, 255	in Australia. T.G. Fuelling. (Abs.)	340
world balance 1978/79. (NC)	34, 161, 225, 290	--- production quotas. (NC)	225	bin trailer. Anon. (Abs.)	79, 80
--- 1979/80. (NC)	321	--- licence for US company.	191	- R.B. Newton. (Abs.)	80
- markets in 1979. (NC)	129	--- plant in Canada. (Brev.)	351	computer simulation. O.S. Libunao.	114
production 1978/79.	33, 62, 162, 189, 289	--- US. (Brev.)	256	O.S. Libunao and R.M. Lantini.	281
--- prospects. (NC)	289	--- sugars determination. I.R. West		Dedini-Toft equipment agreement.	287
- supply and demand. (NC)	3, 130	and G.J. Moskowit. (Abs.)	123	economics. A.B. Santos. (Abs.)	305
year book 1977. Anon. (Abs.)	56	--- use in Japan. (Brev.)	288	factory location and average hauling	
see also Bulk handling; Crystallization;		invert syrup manufacture. A. Malý.	345	distance. C.M.R. Draijer. (Abs.)	179
Liquid sugar; Polarization; Prices; Raw		- and properties. K. Vukov <i>et al.</i>	25	new railway system in Australia.	63
sugar; Refined sugar; Sucrose and		ion exchange treatment. V. Mau-		rail truck loading. Anon. (Abs.)	79
White sugar		randi. (Abs.)	218	systems. E. Cerrizuela. (Abs.)	79
Sugars: detection in high pressure		preparation. D.R. White. (Pat.)	60	- design. B.J. Cochran and R.W.	
liquid chromatographic systems.		silica determination. P. Devillers		Whitney. (Abs.)	114
G.B. Cox and I.K. O'Neill. (Abs.)	378	<i>et al.</i> (Abs.)	251	trailer load, effect of cane burning.	
determination. J. Dobrzycki. (Abs.)	187	stainless steel tanks. (Brev.)	30	J.P. Lamusse.	231
- by gas-liquid chromatography. H.		sucrose, dextrose and levulose deter-		train dynamics investigation. R.J.	
Schwinn <i>et al.</i> (Abs.)	379	mination. P.G. Morel du Boil and		Dullow <i>et al.</i> (Abs.)	340
--- J.E. Sullivan and L.R. Schewe.	58	K.J. Schäffler. (Abs.)	378	- handling automatic control. R.	
- high pressure liquid chromatography.		sugars determination by gas-liquid		Diplock and K. Marshall. (Abs.)	373
D.C. Hunt <i>et al.</i> (Abs.)	25	chromatography. J.E. Sullivan and		- proximity sensor. G.F. Pukallus and	
--- H.D. Scobell <i>et al.</i> (Abs.)	26	L.R. Schewe. (Abs.)	58	A.K. Roseler. (Abs.)	340
- levulose syrups. I.R. West and G.J.		viscosity, effect of temperature and		in Trinidad. L.P. Donawa. (Abs.)	114
Moskowit. (Abs.)	123	time. R.C. Sharma. (Abs.)	311	weight transfer tractor system. H.G.	
- molasses. H. Janshekar and J.R.		water determination. H. Schiwek		Poole. (Abs.)	241
Mor. (Abs.)	26	<i>et al.</i> (Abs.)	91	Trinidad: cane transport. L.P.	
- by paper chromatography and den-		see also Evaporators; Invert sugar;		Donawa. (Abs.)	114
sitometry. S.N. Karchik <i>et al.</i>	26	Juice, Beet; Liquid sugar and Refining		soil erosion. J.E.W. Georges. (Abs.)	147
enzymatic production from bagasse.		Tablet sugar: dryer. V.A. Zubatov		sugar export quota shortfall. (Brev.)	32
R.K. Andren <i>et al.</i> (Abs.)	350	<i>et al.</i> (Abs.)	122	- production 1978. (Brev.)	31
--- pith. L.H. Wang and Y.C. Kuo.	126	wrapping unit. M.E. Balyasny and		Tubing: stainless steel. (TN)	30
esters preparation. V. Prev. (Pat.)	283	A.F. Livshits. (Abs.)	24	Tunisia: sugar expansion. (Brev.)	31
iron determination. Korenaga and		Taiwan: cane breeding. C.C. Lo.	244	Turbidity: cane juice, effect of cane	
Takashi. (Abs.)	348	- with <i>Miscanthus</i> germplasm.		extraneous matter. R.P. Scott <i>et al.</i>	348
kestose isomers and sugar crystal		C.C. Lo <i>et al.</i> (Abs.)	118	- clarification flocculants. G.S.	
elongation. Anon. (Abs.)	188	- brown spot disease. W.H. Hsieh		Shepard. (Abs.)	378
solution thermodynamics. A.V.		and D.S. Tseng. (Abs.)	371	--- clarifier type. M. Mochtar.	179
Zubchenko <i>et al.</i> (Abs.)	251	pan boiling practices. S.Y. Hsiung.	20	- starch and soil and filtrate recycl-	
- vapour pressure and hydration.		sugar exports 1978. (Stat.)	159	ing. Anon. (Abs.)	213
V.I. Buravleva <i>et al.</i> (Abs.)	25	- production 1978/79. (Brev.)	320	carbonatation juice, effect of filter	
as sweeteners and chemical feed-		research. Anon. (NB)	90, 280	cloth. Y.F. Tsyukalo <i>et al.</i> (Abs.)	376
stocks. G.G. Birch and K.J. Parker.	185	Tanks: cleaning equipment. (TN)	30	prevention in soft drinks. Naarden	
see also Dextrose; Fermentation; Invert		stainless steel, for refinery syrup.	30	International N.V. (Pat.)	317
sugar; Levulose; Polysaccharides; Raffi-				refinery liquor, reduction by melt	
nose; Refined sugar and Sucrose				phosphatation. M. Matic <i>et al.</i>	184
				sugar factory products. A. Rodríguez	
				<i>et al.</i> (Abs.)	187



# INDEX

	page		page		page
Turbidity: syrup, reduction by C-melt clarification. N.L.C. Suzor. (Abs.) . . . . .	181	United States of America: cane varieties. (Brev.) . . . . .	32	Varieties, Cane: in Brazil. F. Brieger. - J.Y.J. Micoque and G.R. Machado. brown spot reactions. W.H. Hsieh and D.S. Tseng. (Abs.) . . . . .	372 117 371
Turkey: sugar expansion. (Brev.) . . . . .	224	Colorado, high fructose corn syrup plant. (Brev.) . . . . .	256	cane cultivation requirements. C.L. Toohy. (Abs.) . . . . .	117
- production 1978/79. (Brev.) . . . . .	319	Commodity Futures Trading Comm- mission proposals. (NC) . . . . .	322	character inheritance in <i>Saccharum</i> <i>robustum</i> hybrids. T.C.R. Rao and J.T. Rao. (Abs.) . . . . .	153
Uganda: cane disease resistance trials. M. Simbwa-Bunnya. (Abs.) . . . . .	341	corn sweetener consumption. (NC) 2 EEC sugar dumping. (Brev.) . . . . .	159, 256	chemical ripener effects. G.M. Azzi et al. (Abs.) . . . . .	174
sugar factory reconstruction. (Brev.) 336		Florida, cane growing and sugar production economics. D.L. Brooke. (Abs.) . . . . .	119	- J. Fernandes et al. (Abs.) . . . . .	207
Union of Soviet Socialist Republics: beet molasses sugar content. Y.D. Kot and L.N. Binevskaya. (Abs.) . . . . .	346	-- rust. (Brev.) . . . . .	191	- R.A. Sharma et al. (Abs.) . . . . .	14
- payment. G.I. Bereschuk. (Abs.) 313		-- varieties. G. Kidder and E.R. Rice. - soil manganese availability. G.J. Gascho et al. (Abs.) . . . . .	342 110	clonal competition and selection. A.M. Galvez and L.T. Empig. . . . .	153
- S.R. Bostanov. (Abs.) . . . . .	277	-- water management. S.F. Shih et al. (Abs.) . . . . .	111	CoA 7602. K.K.P. Rao et al. (Abs.) 83 CoA 7701. K.K.P. Rao et al. (Abs.) 83 CoC 671. A.K. Kadirvel and G. Devaraj. (Abs.) . . . . .	83 83 83
- A.I. Chekal' and V.V. Popovich. 277		forfeited loan programme sugar sales. 290, 322, 354		CoS 758. B.K. Mathur and A. Nath. 372 CP 70-321 and CP 70-330. C. Ricaud. 372 - C.A. Richard. (Abs.) . . . . .	342 243 342
- V.M. Karasik et al. (Abs.) . . . . .	277	Gilmore Louisiana-Florida-Texas- Hawaii sugar manual 1978. C.M. McKay. (NB) . . . . .	90	disease responses in Brazil. Anon. 243 - resistance trials in Uganda. M. Simbwa-Bunnya. (Abs.) . . . . .	341
- M.N. Kozlenko. (Abs.) . . . . .	313	high fucose corn syrup licensee. 191		dry matter partitioning, effect of harvest date. M.H.R. Julien and P. Delaveau. (Abs.) . . . . .	175
- production 1978. (Brev.) . . . . .	31	Louisiana, cane breeding. P.H. Dun- ckelman and S. Nagatomi. (Abs.) 51		- in Egypt. A.I. Alam. (Abs.) . . . . .	244
- reception and storage. V.S. Vyshtak and A.I. Sidorenko. (Abs.) . . . . .	227	-- rust outbreak. (Brev.) . . . . .	351	environment interaction and perfor- mance. J.S. Pollock. (Abs.) . . . . .	342
new sugar factories. (Brev.) . . . . .	273	-- varieties borer resistance. S.D. Hensley et al. (Abs.) . . . . .	150	frost resistance. O. Brinholi et al. 372 - R. Cesnik et al. (Abs.) . . . . .	16, 210
raw sugar storage and deterioration. N.V. Kostenko et al. (Abs.) . . . . .	24	- frost and cane quality. G.J. Durbin. 21 - sugar factory closures. (Brev.) 63, 190 Massachusetts, Amstar Boston refinery. . . . .	137	- S.D. Fasih et al. (Abs.) . . . . .	244
refined sugar production. (Brev.) 127		- Reverse sugar refinery. . . . .	135	- J.E. Irvine. (Abs.) . . . . .	152
sugar consumption. (Brev.) . . . . .	384	- Sugar Industry Technologists Inc. 1979 meeting. . . . .	132	- R.E. Sloan and R.H. Farquhar. 342 germplasm collection in the Philip- pines. A.T. Barredo and T.R. Escobar. 83 growth parameter differences. P.R.C. Castro et al. (Abs.) . . . . .	207
- dust separation. I.I. Prilutskii and P.A. Lyubarets. (Abs.) . . . . .	22	New York, spot price resumption. 1,290		herbicide tolerance. R.P. Cossio et al. (Abs.) . . . . .	111
- imports from the EEC. (Brev.) . . . . .	223	-- Sugar Trade Laboratory raw sugar analyses. W. Altenburg. (Abs.) 380		- H.J. Yeh. (Abs.) . . . . .	238
- and exports. (Stat.) . . . . .	270	raw sugar imports. (Stat.) . . . . .	190	- in India. (Brev.) . . . . .	383
- production 1978. (Brev.) . . . . .	128	refinery effluent pollution limita- tions. R. Dellinger. (Abs.) . . . . .	122	- K.C. Rao. (Abs.) . . . . .	304
United Kingdom: ACP sugar supply consultations. 131		renewable sources of energy confer- ence. . . . .	319	- in Jamaica. Anon. (Abs.) . . . . .	372
beet agriculture. W. Hollowell and D. Charlesworth. (Abs.) . . . . .	274	sugar economy study. (Brev.) . . . . .	320	juice volume reduction, effect of flowering. J.C. Salata and L.J. Ferreira. (Abs.) . . . . .	207
- conference. . . . .	102	- import fee. (NC) 33, 66, 131, 226, 290, 322		leaf Cu, Fe, Mn and Zn, effect of soil type. J. Orlando and E. Za bello. 14 - nutrient status and fertilizers. J. Orlando et al. (Abs.) . . . . .	112
- mechanization. T.P.J. Dyke. . . . .	275	- imports policy. (NC) 2		in Mauritius. Anon. (Abs.) . . . . .	117
- sugar production 1978/79. (NC) 97		- industry and legislation. Anon. 90		N 11. Anon. (Abs.) . . . . .	372
- varietal trials. D. Kimber and S. McCullagh. (Abs.) . . . . .	309	- restructure possibility. (NC) 65		nematode tolerance. M.M. Aguilera and S. Matsuoaka. (Abs.) . . . . .	273
Booker Agriculture International Ltd. activities. (TN) . . . . .	382	- legislation. (NC) 33, 66, 130, 162, 226, 257, 290, 321, 353		nitrogen interaction on leaf growth. E.L. Rosario et al. (Abs.) . . . . .	147
- project in Papua-New Guinea. 384		-- and the International Sugar Agree- ment. (NC) . . . . .	97	- response differences. J.P. Patil et al. 238 nitrogenase activity. A.P. Ruschel and R. Ruschel. (Abs.) . . . . .	206
Booker McConnell Ltd. 1978 report. 194		- loan period extensions. . . . .	63, 354	phenotypic stability in Brazil. R. Ruschel. (Abs.) . . . . .	210
British Sugar Corporation Ltd. computer data handling. D.F.A. Horsley and A. Williams. (Abs.) 279		- programme for 1979. (NC) 162, 226		- effect on yield. J.A. Mariotti et al. 83 Philippines, cytology and morphology. N.S. Diviniagracia and D.A. Ram- irez. (Abs.) . . . . .	210
---- molassed pulp marketing. N.B. Davis and P. Tory. (Abs.) . . . . .	282	- production 1978. (NC) . . . . .	98	post-harvest deterioration. J.D. Miller et al. (Abs.) . . . . .	176
---- Quentin plant. J.F.T. Oldfield et al. . . . .	103, 138	- cost calculation doubts. (Brev.) 190		proline content and drought resist- ance. K.C. Rao and S. Asokan. 244 Q 83 infection by mosaic. A.L. Fors. 273 Q 96. H.L. Boyle. (Abs.) . . . . .	244
---- sugar factory performances. J.F.T. Oldfield et al. (Abs.) 279		- prospects. (NC) . . . . .	34	red rot reactions. K.K. Prasadarao et al. (Abs.) . . . . .	116
Cocksedge & Co. Ltd. centenary. 318		Technical Session on Cane Sugar Refining Research. . . . .	13	- M.N. Sarma and M.A. Rao. . . . .	50
companies and China sugar industry. 127		Texas, cane burning. N. Rozeff. . . . .	296	rind disease resistance. H.P. Liu et al. 115 <i>Saccharum</i> and <i>Miscanthus</i> species cytology. L.M. Engle et al. (Abs.) 153 smut resistance. K.C. Alexander. 341 - M.L.R. Duarte and H. Tokeshi. 116 - G.R. Singh. (Abs.) . . . . .	243
company packaging division. (Brev.) 30		-- varietal trials. S.A. Reeves. (Abs.) 51		- S. Vir and M.S. Behniwal. (Abs.) 273 - A.M. Whittle. (Abs.) . . . . .	341
computerized commodity data bank. 255		- sugar production 1978/79. (Brev.) 191		sugar recovery estimation by small- scale milling. G. Arceneaux. . . . .	369
dust separator order. (Brev.) . . . . .	287	see also Hawaii		suitability for gur production. S. Thangavelu and K. Sundaresan. 238 sunlight utilization efficiency and yield. N. Shimabuku and K. Higa. trials in Cuba. R. Diaz M. et al. 244 - Philippines. E.V. Vergara et al. 51 - U.S. S.A. Reeves. (Abs.) . . . . .	51 51 342
effluent treatment conference. . . . .	287	Valves: (TN) . . . . .	30	- C.A. Richard et al. (Abs.) . . . . .	32
Fletcher and Stewart Ltd. diversifi- cation. (Brev.) . . . . .	158	diaphragm. A.F. Kravchuk et al. 23		- in US. (Brev.) . . . . .	342
National Spring Beet Demonstration, 1979. . . . .	159	flow regulation. J. Blanc. (Abs.) 279		- G. Kidder and E.R. Rice. (Abs.) 342 yellow spot susceptibility. C. Ricaud et al. (Abs.) . . . . .	341
nematode control. R.A. Dunning and T.P.J. Dyke. (Abs.) . . . . .	19	incondensable gas removal from evaporators. F. Zama. (Abs.) . . . . .	54		
new London raw sugar contract. 354, 289		Varieties, Beet: crown and root composition. R. Miletic. (Abs.) . . . . .	92		
Newark sugar factory modernization and expansion. F. Robson and M. Flack. . . . .	42, 72	drilling x fertilizer trials in Hungary. L. Lukacs. (Abs.) . . . . .	308		
nitrogen fertilizer dosage rates. G. Hanslip. (Abs.) . . . . .	18	harvest date effect on yield and quality. R.F. Oldemeyer et al. 18			
Renold Group centenary. (Brev.) 158		seed beet susceptibility to mildew in France. A. Lebrun. (Abs.) . . . . .	19		
sugar future, conference. . . . .	320	- spacing and yield. A. Suzuki et al. 84			
- imports and exports . . . . .	130, 160	trials in Belgium. N. Roussel et al. 309			
- industry expansion. (NC) . . . . .	130	- Czechoslovakia. L. Schmidt et al. 309			
Tate & Lyle company's Queen's Award to Industry. (Brev.) . . . . .	382	- Hungary. L. Lukacs and J. Zana. 309			
- new company. (Brev.) . . . . .	96	- India. L. Bishnoi et al. (Abs.) . . . . .	246		
- refinery closure. (Brev.) . . . . .	320	- Rumania. Z. Stancescu et al. (Abs.) 309			
- conveyors. . . . .	347	- UK. D. Kimber and S. McCullagh. 309			
- syrup tanks. (Brev.) . . . . .	30	- West Germany. A. von Müller. 309			
- sugar project consultancy con- tract. (Brev.) . . . . .	286	see also Beet breeding			
weed control herbicides. N.V. Turner. (Abs.) . . . . .	19	Varieties, Cane: adoption in Australia. C.W. Chardon et al. (Abs.) . . . . .	342		
see also Europe, EEC		bibliography. M.P.S.B. Gonçalves. 186			
United Nations Conference on Trade and Development: Common Fund for Commodities. (NC) . . . . .	161	borer oviposition. G.T. Lim and Y.C. Pan. (Abs.) . . . . .	151		
United States of America: alcohol production from bagasse. 159		- resistance. N. Macedo et al. (Abs.) 208			
beet area reduction. (Brev.) . . . . .	160	- Y.S. Pan and S.L. Yang. (Abs.) 150			
- research centre. Anon. (Abs.) . . . . .	91	- in Louisiana. S.D. Hensley et al. 150			
- sugar factories for sale. (Brev.) 160					
cane smut emergency regulations. 95					

# INDEX

	page		page		page
Varieties, Cane:		Water, Waste:		Weeds: abandoned cane. J. Wright. . .	78
yields, effect of soil moisture. D.B.		beet trash press water analysis		blady grass as leaf scald host. Anon.	82
Hellmann. (Abs.) . . . . .	146	and disposal. P. Mathismoen. . . . .	221	bolted beet elimination. W. Perowne	and P. Longden. (Abs.) . . . . . 178, 274
-- wide furrow planting. C. Richard.	368	cane cleaning effluent and boiler ash		-- A. Vigoureux. (Abs.) . . . . .	245
see also Cane breeding		water treatment. L. Engel. (Abs.)	179	chemical control. Anon. (Abs.) . . . . .	177
Venezuela: sugar expansion plans.	319	chemical oxygen demand determina-		-- J.M. Belien and J.F. Salembier.	18, 211
-- imports. (Brev.) . . . . .	64	tion. A.P. Parkhomets <i>et al.</i> (Abs.)	92	-- A.C. Bhalarao <i>et al.</i> (Abs.) . . . . .	18
Vinasse see Distillery waste		decolorizing resin effluent treatment.		-- W. Bray. (Abs.) . . . . .	178
Viscosity: beet molasses, effect of		S. Kishihara and M. Komoto. (Abs.)	347	-- J.D. Chougule <i>et al.</i> (Abs.) . . . . .	238
nucleosides. N.V. Remeslo <i>et al.</i>	281	dissolved oxygen meter. (TN) . . . . .	30	-- G. Ebers and R. Wüstemann. . . . .	17
cane molasses. E.R. Fleites and C.		-- as quality indicator. J.C.P. Chen.	21	-- D. Kirsten. (Abs.) . . . . .	17
González. (Abs.) . . . . .	219	flume-wash water losses. G.F. Tyazh-		-- V.I. Kolesnikov <i>et al.</i> (Abs.) . . . . .	238
-- effect of massecuite surface-		elova. (Abs.) . . . . .	376	-- L.F.G. McIntyre. (Abs.) . . . . .	144
active additives. J. Lodos and		-- pH and soil sedimentation. H.		-- S.A. Reeves. (Abs.) . . . . .	146
I. Diaz. (Abs.) . . . . .	180	Dabrowski. (Abs.) . . . . .	345	-- F.E. Richardson. (Abs.) . . . . .	145
-- and massecuite, effect of dextran.		pond loss reduction. J.P. Lescure		-- W.R. Schaufele and C. Wimmer.	245
G.L. Geronimos and P.F. Green-		and P. Bourlet. (Abs.) . . . . .	121	-- E.F. Sullivan and L.K. Fagala.	84
field. (Abs.) . . . . .	348	press water quantity calculation.		-- P.E.T. Turner. (Abs.) . . . . .	146, 339
-- and syrup, effect of temperature		V.N. Bazlov. (Abs.) . . . . .	89	-- D.P. Yamit and J.J. Rizo. (Abs.)	207
and time. R.C. Sharma. (Abs.)	311	-- suspended solids removal by hydro-		-- in Argentina. R.A. Arévalo. . . . .	207
effect -- molasses exhaustion. Anon.	188	cyclone. Anon. (Abs.) . . . . .	213	-- Hawaii. Anon. (Abs.) . . . . .	370
-- P. Devillers <i>et al.</i> (Abs.) . . . . .	26	solids separation. S. Marie-Jeanne.		-- herbicide. Bayer AG. (Pat.) . . . . .	317
reduction in boiling. R. Sivaraman		treatment with activated sludge. K.		-- G. Becker. (Abs.) . . . . .	177
and S.C. Ray. (Abs.) . . . . .	52	Akiyama and M. Okada. (Abs.) . . . . .	377	-- M.Y. Chen and Y.T. Hsu. (Abs.)	271
sucrose solution, effect of tempera-		J. Bijl. (Abs.) . . . . .	154	-- J. Everitt and J. Louw. (Abs.)	369
ture and concentration. K. Koziol		-- D.E. Simpson and J. Hemens.	374	-- J. van der W. Jooste <i>et al.</i> (Abs.)	339
<i>et al.</i> (Abs.) . . . . .	281	-- in Australia. R.R. Bathgate <i>et al.</i>	156	-- activity, effect of surfactants.	
sugar solution, effect of dextran. L.		by fermentation. Anon. (Abs.)	218	H.J. Yeh. (Abs.) . . . . .	206
Carrazana <i>et al.</i> (Abs.) . . . . .	57	-- G. Kaiser <i>et al.</i> (Abs.) . . . . .	282	-- aerial application. C.A. Lang.	339
		-- J.P. Lescure and P. Bourlet.	121	-- application by irrigation sprinkler.	
		-- in France. J.P. Vellaud. (Abs.)	249	Anon. (Abs.) . . . . .	245
		-- international conference. (Brev.)	287	-- degradation. B.J. Eaton <i>et al.</i>	111
		-- study award. (Brev.) . . . . .	384	-- effect on beet. E. Dalleinne. . . . .	18
Water: beet diffuser feed acidification.		US refinery pollution limitations.		-- W. Haquenne. (Abs.) . . . . .	211
M. Rogowska and Z. Wegrowski.	346	R. Dellinger. (Abs.) . . . . .	122	-- G. Pritoni <i>et al.</i> (Abs.) . . . . .	211
boiler feed alcohol content. J.D.		Wax, Can. analysis. B.Y. Rao <i>et al.</i>	254	-- composition. T. Banaszkiwicz	
Blake and K.E. McNeil. (Abs.) . . . . .	343	determination in raw sugar. I.F.		and H. Kozaczek. (Abs.) . . . . .	211
-- treatment. B.B. Khochare. (Abs.)	248	Bugenko and A.I. Lapkin. (Abs.)	347	-- root and crown rot incidence.	
-- K.S. Ramamani. (Abs.) . . . . .	53	hydrogenation. S.C. Ray and P.F.		R.J. Hecker and E.G.	
-- for scaling reduction. E. Froch-		Jain. (Abs.) . . . . .	93	Ruppel. (Abs.) . . . . .	276
lich. (Abs.) . . . . .	248	recovery from filter cake. Anon.	125	-- on cane. H.J. Yeh. (Abs.) . . . . .	238
cane uptake from soil. G. Kingston.	144	-- A.W. Lake. (Pat.) . . . . .	29	-- guide. Anon. (NB) . . . . .	90
-- utilization, effect of soil water		Weather: drought effect on beet weed		-- miscibility. M. Kubacka-Szmidt-	
depletion and nitrogen. M.R.		control on light soils. F. Maykuhs.	177	(Abs.) . . . . .	276
Reddy <i>et al.</i> (Abs.) . . . . .	239, 240	-- resistance and cane proline content.		-- mixed with vinasse. . . . .	280
boiler feed alcohol content. J.D.		K.C. Rao and S. Askan. (Abs.)	244	-- tolerance of cane varieties. R.P.	
Blake and K.E. McNeil. (Abs.)	343	-- resistant variety. K.K.P. Rao <i>et al.</i>	83	Cossio <i>et al.</i> (Abs.) . . . . .	111
-- ammonia and sugar determination.		-- in Thailand. (Brev.) . . . . .	237	-- T. Kuntahartono <i>et al.</i> . . . . .	145
H. Zaorska <i>et al.</i> (Abs.) . . . . .	312	effect on beet sugar content. P.S.		-- in Hungary. A. Kádár. (Abs.)	308
-- flow measurement. W. Hogrefe.	323	Bhatnagar and B. Raj. (Abs.) . . . . .	84	-- P. Pinter. (Abs.) . . . . .	308
content in cane, effect of ripening.		-- D. Bourdon. (Abs.) . . . . .	376	-- Jamaica. Anon. (Abs.) . . . . .	271
E.J. de A. Leme and R. Scardua.	175	-- A.I. Chekal' and V.V. Popovich.	277	-- light soils. F. Maykuhs. (Abs.)	177
-- raw sugar. W. Altenburg. (Abs.)	380	-- cane borer population. P.S.M.		-- Mauritania. Anon. (Abs.) . . . . .	49
-- stored raw sugar and colour increase.		Botelho <i>et al.</i> (Abs.) . . . . .	208	-- Rumania. A. Clorlaus. (Abs.)	24
N.V. Kostenko <i>et al.</i> (Abs.) . . . . .	24	-- growth and photosynthesis. U.S.		-- U.K. N.V. Turner. (Abs.) . . . . .	19
-- sugar, effect of crystal size and		Singh. (Abs.) . . . . .	338	-- U.S. D.T. Loupe <i>et al.</i> (Abs.)	207
temperature rise during centrifugal-		-- Kadi. (Abs.) . . . . .	208	-- E.E. Schweizer. (Abs.) . . . . .	275
ling. E. Svoboda and J. Klepal.	23	-- A. de C. Mendes <i>et al.</i> (Abs.)	208	control energy inputs. P.A. Donovan.	368
determination in bagasse. R.W.A.		-- herbicide effectiveness. W.R.		<i>Cyperus immensus</i> as borer host. P.R.	
Luxford. (Abs.) . . . . .	348	Schaufele and C. Wimmer. (Abs.)	245	Atkinson. (Abs.) . . . . .	371
-- beet molasses. R. Detavernier <i>et al.</i>	123	-- ripening. D.P. Gowing and N.		effects on cane yield. R.A. Arévalo	
-- syrup and white sugar. H. Schi-		Baniabassi. (Abs.) . . . . .	148	<i>et al.</i> (Abs.) . . . . .	144
weck <i>et al.</i> (Abs.) . . . . .	91	-- yellow spot incidence. C. Ricaud.	341	Johnson grass chemical control.	
-- cane molasses and massecuite. T.K.K.		flood damage in Jamaica. (Brev.)	287	R.W. Millhollon. (Abs.) . . . . .	145
Menon and V.C. Nair. (Abs.) . . . . .	58	-- effect on cane. D.W. Beattie.	78	reed control. A.I. Linedale. . . . .	240, 337
-- molasses and liquid sugar. C.A.		frost, cane damage effect assessment		<i>Rotthoeilla exaltata</i> germination	
Accorsi and G. Vaccari. (Abs.)	251	by juice acidity measurement. F.A.		R.W. Millhollon. (Abs.) . . . . .	111
effect on bagasse fuel properties.		Martin. (Abs.) . . . . .	124	Weighers. . . . .	286
Anon. (Abs.) . . . . .	214	-- protection. R.S. Kanwar. (Abs.)	369	automatic. (TN) . . . . .	30
-- cane flowering. A.I. Allam <i>et al.</i>	109	-- fibre effects. V.H. Chiappino.	281	-- correction unit. (TN) . . . . .	382
migration and sugar caking. C.J. Lu		-- juice constituents changes. O.		field cane. J.R. Reghenzani. (Abs.)	340
<i>et al.</i> (Abs.) . . . . .	156	Singh and R.S. Kanwar . . . . .	359	Weighing: bagasse, cane, maceration	
nutrient contents in Peru. J. Pinna C.		-- quality effects in the U.S. G.J.		water and juice. E. David. (Abs.)	379
and S. Valdivia V. (Abs.) . . . . .	147	Durbin. (Abs.) . . . . .	21	West Indies: cane breeding. D.I.T.	
raw sugar safety factor. J.V. López-		-- varietal resistance. O. Brinholi		Walker <i>et al.</i> (Abs.) . . . . .	210
Ofia. (Abs.) . . . . .	380	<i>et al.</i> (Abs.) . . . . .	372	sugar factory working temperature	
separation from carbonatation mud.		-- R. Cesnik <i>et al.</i> (Abs.) . . . . .	16, 210	reduction. (Brev.) . . . . .	382
H. Zoidl. (Abs.) . . . . .	313	-- S.D. Fasih <i>et al.</i> (Abs.) . . . . .	244	-- statistics. (Stat.) . . . . .	191
separator for beet. N.G. Lila. (Abs.)	249	-- J.E. Irvine. (Abs.) . . . . .	152	-- Technologists meeting 1979. . . . .	95
soil moisture effect on cane yield.		-- R.E. Sloan and R.H. Farquhar.	342	White sugar: ash analysis. N.A. da	
D.B. Hellmann. (Abs.) . . . . .	146	-- effect on beet quality. M. Lohier.	121	Glória <i>et al.</i> (Abs.) . . . . .	187
-- management in Florida. S.F.		hailstorm defoliation and nitrogen		-- distribution and Crystal Regularity	
Shih <i>et al.</i> (Abs.) . . . . .	111	effects on beet yield. D.J. Traveller		Index. D. Hibbert <i>et al.</i> (Abs.)	25
-- source location. L.K. Izatt. (Abs.)	109	and S.M. Bosma. (Abs.) . . . . .	307	betaine determination. G. Steimle and	
sugar content and centrifugal effici-		hurricane damage in Dominican		E. Fischer. (Abs.) . . . . .	91
ency. E. Svoboda and J. Klepal.	217	Republic. (Brev.) . . . . .	383	boiling systems. J.F. Silva and	
-- factory consumption and conden-		rainfall and cane evapotranspiration		Zarpelon. (Abs.) . . . . .	179
sate reutilization. V.G. Bahulekar.	311	mathematical modelling. A.C. Early.	146	Codex Alimentarius standards. A.C.	
-- economy. V. Lochman. (Abs.)	182	-- effect on cane yield. F.A. Fogliata		Chatterjee and A.R. Bhide. (Abs.)	122
sugars hydration in solution. V.I.		and C.A. Gargiulo. (Abs.) . . . . .	146	-- J.A. Hupfer. (Abs.) . . . . .	380
Buravleva <i>et al.</i> (Abs.) . . . . .	25	-- nitrogen influence on beet yield.		continuous centrifugal. D. Hoks.	157
treatment with plate-type settlers.		H.J. Müller. (Abs.) . . . . .	246	dextrose and levulose contents. W.	
S. Bednarski. (Abs.) . . . . .	182	-- sugar production in Ja aica.	384	Mauch and E. Krause. (Abs.) . . . . .	124
see also Brix; Centrifugals; Drying;		-- in South Africa. T.G.J. Dyer and		dryer/cooler. A.A. Dmytryuk <i>et al.</i>	22
Irrigation; Milling; Cane; Soil; Water,		J.M. Gosnell. (Abs.) . . . . .	368	-- A.F. Zaborin <i>et al.</i> (Abs.) . . . . .	54
Waste and Weather		storm damage in the Philippines.	64	electrical resistance measurement.	
Water, Waste: alcohol content. J.D.		wind erosion prevention in beet		A.M. Kostenyuk <i>et al.</i> (Abs.) . . . . .	281
Blake and K.E. McNeil. (Abs.)	343	soils. G. Hanslip. (Abs.) . . . . .	177		
beet leaf separation. F. Hruska.	218				

# INDEX

	page		page		page
White sugar:		World:		Yeast, cultivation on cane molasses.	
evaluation. J. Dobrzycki. (Abs.)	187	sugar market, effect of HFCS. (NC)	2	M.S. Iyengar. (Abs.)	222
grist determination. G. Rens. (Abs.)	251	effect of HFCS. (NC)	2	K. Mannivannan. (Abs.)	252
large grain production. S. Srinivasan		prices. (NC)	2, 33, 66, 98, 131, 162,	L.H. Wang <i>et al.</i> (Abs.)	252
and K.N. Pandey. (Abs.)	85	193, 225, 257, 289, 322, 353		Kenya project. (Brev.)	383
quality, effect of cane juice treat-		production 1978/79.	33, 62, 162, 189, 289	extract kojic acid fermentation. P.	
ment. C.S. Lee. (Abs.)	180	prospects. (NC)	289	Bajpai <i>et al.</i> (Abs.)	93
silica determination. P. Devillers		supply and demand. (NC)	3	plant in Cuba. (Brev.)	63
<i>et al.</i> (Abs.)	251	balance. (NC)	130	operation economics. I. Morrell F.	
storage, effect of boiling. V. Maur-		see also International		<i>et al.</i> (Abs.)	222
and I. (Abs.)	251	Yeast: animal fodder. L.D. Il'ina <i>et al.</i>	222	ribonucleic acid and nicotinamide	
silo in Egypt. (Brev.)	64	S.T. Kale. (Abs.)	254	adenine dinucleotide production.	
wall protective lining. P. Godulla		A. Madi <i>et al.</i> (Abs.)	27	M.C. Hsie. (Abs.)	125
<i>et al.</i> (Abs.)	250	project in Cuba. O. Almazán del O.		sugar loss in cane juice. M.T. Hern-	
sulphur dioxide determination. M.		and A. Roca G. (Abs.)	222	ández <i>et al.</i> (Abs.)	219
Prasad <i>et al.</i> (Abs.)	58	ash determination. G. Núñez T. and		see also Alcohol; Animal fodder	
water determination. H. Schiweck		C. Díaz de A. (Abs.)	58	and Micro-organisms	
<i>et al.</i> (Abs.)	91	cultivation on beet molasses. V.N.		Yugoslavia: lysine plant. (Brev.)	351
world markets in 1979. (NC)	129	Shvets <i>et al.</i> (Abs.)	282	new sugar factory. (Brev.)	223
prices. (NC)	2, 33, 66, 98, 131, 162,	effect of decolorization. V.N.		Osijek sugar factory carbonation	
193, 225, 257, 289, 322, 353		Shvets <i>et al.</i> (Abs.)	253	process. K. Vojin. (Abs.)	23
see also Icing sugar; Refined sugar;		dissolved oxygen concentration.		sugar exports possibility. (Brev.)	96
Sugar and Tablet sugar		T. Miśkiewicz and W. Leśniak.	94	industry expansion. (Brev.)	288
World: sugar balance 1978/79. (NC)		T. Miśkiewicz <i>et al.</i> (Abs.)	94	Zaire: sugar project. (Brev.)	237
Sugar and Tablet sugar	34, 161, 225, 290	cane molasses. P. Hernández S.		Zambia: sugar export plans postponed.	63
1979/80. (NC)	321	and I. Morrell F. (Abs.)	222	Zuckerwirtschaftliches Taschenbuch	
industry expansion plans. H.		P. Hernández S. <i>et al.</i> (Abs.)	59	1978/79. K. Dankowski <i>et al.</i> (NB)	55
Ahlfeld. (NB)	55				
market, 1979. (NC)	129				

# INDEX NAMES

	page		page		page
Abazyán, G.A. Sugar dust separator.	313	Almada, G.H., <i>see</i> Mariotti, J.A.		Baczek, F.A. and Jesic, V.M.	
Abbott, J.L., <i>see</i> Johnson, C.V.		Almazán del O., O. Cane by-products utilization as animal fodder.	252	Optimum carbonation alkalinity and pH determination. (Abs.)	182
Abd-Elrazik, A.A., <i>see</i> Higgy, A.M.		and Roca G., A. Animal fodder project in Cuba. (Abs.)	222	Baghestani, M. Beet agriculture culture in Iran. (Abs.)	17
Abdykerimov, A.O., <i>see</i> Shvets, V.N.		Alonso, F. Red rot transmission.	341	Bahulekar, V.G. Sugar factory condensate reutilization and water consumption. (Abs.)	311
Abo-Shady, A., <i>see</i> El-Sayed, M.A.		Alonso, O., <i>see</i> Tambosco, N.		Bailey, R.A. Cane smut control in South Africa. (Abs.)	149
Abraham, C.J. Vacuum pan. (Abs.)	85	Altengrub, W. Raw sugar analyses at New York Sugar Trade Laboratory. (Abs.)	380	Effect of ratoon stunting treatment on cane smut incidence.	115
Abram, J.C. and Bennett, M.C.		Alves, A.S. <i>et al.</i> Chemical weed control. (Abs.)	112	Leaf scald and smut association.	341
Temperature effect on bone char structure and decolorizing capacity.	377	— Ripener effect on cane juice quality. (Abs.)	174	Bains, B.S., <i>see</i> Sharma, H.L.	
Abreu, C., J., <i>see</i> Brito M., J.		<i>see also</i> Azzi, G.M.		Baizhenov, E.G., <i>see</i> Serkin, V.T.	
Abreu, G., J.R. Cane mill feeding.	215	Alves, E., <i>see</i> Castro, P.R.C.		Bajpai, P., <i>et al.</i> Clarification effect on kojic acid manufacture from cane molasses. (Abs.)	93
and Polonik V. Dynamic modeling of a cane mill. (Abs.)	216	Ames, R.R., <i>see</i> Miles, W.G.		— Kojic acid manufacture from yeast extract. (Abs.)	93
<i>et al.</i> Cane mill feeding. (Abs.)	216	Amin, M.H., <i>see</i> El-Sherif, A.F.H.		Balachandran, G., <i>see</i> Chandappa, N.	
Abu-Zeid, M.O. and Mansi, M.G.		Anderez V., M. Cane research in Cuba. (NB)	186	Ballesteros H., R., <i>see</i> Abreu G., J.	
Optimum plot size for cane yield trials. (Abs.)	148	Anderson, F.N. and Peterson, G.A.		Baloh, T. Beet storage thermodynamics. (Abs.)	23, 88
Accorsi, C.A. and Vaccari, G. Water determination in molasses and liquid sugar. (Abs.)	251	Phosphate placement and beet uptake. (Abs.)	275	Balyasny, M.E. and Livshits, A.F.	
and Zama, F. Distillery waste treatment. (Abs.)	93	Anderson, R., <i>see</i> Nossier, M.		Tablet sugar wrapping machine.	24
<i>see also</i> Mantovani, G. and Vaccari, G.		Andren, R.K. <i>et al.</i> Enzymatic saccharification of bagasse. (Abs.)	350	Banasiewicz, T. and Kozaczenco, H. Herbicide effect on beet composition. (Abs.)	211
Acosta B., R. and Rodríguez, F.A.		Andres, H. <i>et al.</i> Pectin determination. (Abs.)	91	Bändel, F. <i>et al.</i> Centrifugal motors.	375
Cane weevil damage and fungal diseases. (Abs.)	209	Andrews, R.J. By-products utilization in South Africa. (Abs.)	125	Banibhassani, N., <i>see</i> Daniali, M.	
Adamenko, E.S., <i>see</i> Vitkovskaya, V.A.		Andrianov, I.O. <i>et al.</i> Beet diffuser repair, modernization and adjustment. (NB)	280	and Gowing, D.P.	
Agarwal, M.L. Cane production cost minimization. (Abs.)	15	Andrzejewski, A., <i>see</i> Cisak, R.		Bara, K. Sugar solution carbonation. (Abs.)	348
and Dua, S.P. Distillery waste as fertilizer. (Abs.)	254	Anikeev, Y.V., <i>see</i> Tsyukalo, Y.F.		Barba, R.C. <i>et al.</i> Cane tissue culture. (Abs.)	244
<i>et al.</i> Azotobacter culture effect on cane yield. (Abs.)	204	Anthoniswamy, A., <i>see</i> Chinnaswamy, A.P.		Barbin, D., <i>see</i> Valsechi, O.	
Agnihotri, V.P. and Singh, K. Cane disease symptoms and control.	81	Appleton, J.M., <i>see</i> Teakle, D.S.		Bargaje, P.B. Cane mill turbine repairs. (Abs.)	53, 85
<i>et al.</i> Red rot transmission.	263	Arbizzani, A. and Laghi, P. Freezing effect on beet brei analysis. (Abs.)	220	Barke, P.E. <i>et al.</i> Dextran hydrolysate continuous fractionation.	282
Agosti, T. Deep cultivation and liquid fertilizer effect on beet yield.	245	Arceaux, G. Cane breeding. (Abs.)	83	Barnes, M.G., <i>see</i> Westfall, D.G.	
Agrawal, G.D. Furfural and protein manufacture from bagasse. (Abs.)	94	Estimation of cane sugar recovery and losses caused by cane borers.	369	Barnes, N.H., <i>see</i> Allaway, R.A.	
Agrawal, M.L. and Pandey, B.N. Pest incidence in plant cane and ratoons.	243	Archibald, R. and Mack, C.		Barredo, A.T. and Escobier, T.R.	
Agrawal, N., <i>see</i> Srivastava, V.K.		Entrainment separator. (Abs.)	374	Cane germplasm collection in the Philippines. (Abs.)	83
Agrawal, P.K. and Viswanathan, L.		<i>see also</i> Lewis, J.W.V.		Barrett, J.H. and Clemens, D.H.	
Citric acid fermentation. (Abs.)	93	Ardashv, V.A., <i>see</i> Matvienko, B.A.		Sugar solution decolorization. (Pat.)	285
<i>et al.</i> Citric acid fermentation.	94, 381	Arevalo, C.G., <i>see</i> Mariotti, J.A.		Barth, R., <i>see</i> Dankowski, K.	
<i>see also</i> Bajpai, P.		Arévalo, R.A. Chemical weed control in Argentina. (Abs.)	207	Bassinello, A.I., <i>see</i> Cesnik, R.	
Aguiar, J., <i>see</i> Portela, E.		<i>et al.</i> Weed competition for cane in Argentina. (Abs.)	144	Basso, S. Evaporator incondensable gas withdrawal. (Abs.)	54
Aguilera, M.M. and Matsuo, S.		Arias de F., E., <i>see</i> Sampietro, A.R.		Batcha, M.B.G.R. and Palanichamy, K. Character inheritance in cane.	153
Cane varietal tolerance of nematodes.	273	Arkhipovich, N.A. <i>et al.</i> Factory and refinery products pH calculation.	188	Bathgate, R.R. <i>et al.</i> Waste water purification. (Abs.)	156
<i>see also</i> Matsuo, S.		— Processing of beet pieces. (Abs.)	313	Batista, L.F., <i>see</i> Gordo, D.A.	
Aguinaldo, J.T. Mushroom mycelium propagation on vinasse and cane molasses. (Abs.)	59	<i>see also</i> Remeslo, N.V.		Batz, R., <i>see</i> Rosado, E.	
Ahlfeld, H. World sugar industry expansion plans. (B)	55	Armbruster, F.C. <i>et al.</i> Dextrose isomerase. (Pat.)	283	Bavaskar, V.S., <i>see</i> Patil, J.P.	
Ajri, D.S. Early shoot borer, leaf hopper, scale insect and white grub control. (Abs.)	50	Arnold, M.H. Beet breeding.	195	Bawaskar, V.S. <i>et al.</i> Filter cake application as fertilizer. (Abs.)	240
Akiyama, K. and Okada, M. Refinery effluent treatment. (Abs.)	377	Arnove, G., <i>see</i> Portela, E.		<i>see also</i> Patil, S.P.	
Akyar, O.C., <i>see</i> Sendokmen, N.		Artiles S., J., <i>see</i> Morrell F., I.		Baxter, S.W.D. Mechanical soil cultivation efficiency. (Abs.)	114
Alam, S.M. "Unigrator" performance.	85	Arya, P.S. and Saini, S.S. Beet cultivation in India. (Abs.)	246	Bayer AG. Herbicide. (Pat.)	317
Alba, A.C., <i>see</i> Rodriguez, L.B.		Asai, H., <i>see</i> Yamane, T.		<i>see also</i> Maassen, D.	
Albuquerque, G.A.C., <i>see</i> Marinho, M.L.		Asokan, S., <i>see</i> Rao, K.C.		Bazhal, I.G., <i>see</i> Trebin, L.I.	
Alegret R., M., <i>see</i> González C., L.		Aspillaga, J., <i>see</i> Saldarriaga A., S.		Bazlov, V.N. Beet pulp and press water quantities determination.	89
Aleijnikov, V.G. <i>see</i> Larina, A.A.		Atchison, J.E. Fuel value of bagasse. (Abs.)	125, 252	Bazyński, L. Coke quality effect on lime kiln performance. (Abs.)	346
Alemán, R. and Portal, G.		Atchutaramarao, M., <i>see</i> Prasadarao, K.K.		Beattie, D.W. Flooding and drainage inadequacy effects on cane. (Abs.)	78
Distillation column tray efficiencies. (Abs.)	222	Atkinson, P.R. Mass rearing and artificial infestation of <i>Eldana saccharina</i> . (Abs.)	371	Beaubois, G. Bulk sugar silos. (Abs.)	311
Alexander, A.G. and Biddulph, O.		Sedge as borer host. (Abs.)	371	Beaufils, E.R. and Sumner, M.E.	
Cane photosynthesis at different wavelengths. (Abs.)	148	Autrey, J.C., <i>see</i> Ricaud, C.		Effect of soil elements on cane yield. (Abs.)	110
Alexander, K.C. Cane smut resistance testing. (Abs.)	341	Avasthy, P.N. Cane pests and disease control in India. (Abs.)	50	Bechet, G.R. Pineapple disease control. (Abs.)	242
and David, H.C. Cane pest and disease control by agronomic practices. (Abs.)	81	Ayala, H.G. <i>et al.</i> Bactericides and cane juice quality. (Abs.)	180	Becker, G. Beet spraying with insecticides. (Abs.)	247
and Ramakrishnan, K. Cane smut spore germination. (Abs.)	149	— Bagasse pellets as animal fodder.	27	"Goltix" herbicide. (Abs.)	177
Alincastre, C. Colombia sugar industry. (Abs.)	52	— Cane juice extraction in laboratory mill. (Abs.)	26	Becker & van Hullen Nieder-rheinische Maschinenfabrik, <i>see</i> Hesch, R.	
Alison, M., <i>see</i> Chardon, C.W.		<i>see also</i> Fogliati, F.A.		Bednarski, S. Plate-type settlers.	182
Allain, C.V. Cane planter. (Pat.)	60	Ayre, G.L. and Semple, R.B.		Behl, K.L., <i>see</i> Bishnoi, L.N., Narwal, S.S. and Singh, K.	
Allam, A.I. Cane varieties and yield in Egypt. (Abs.)	244	<i>Tetanops myopaeformis</i> trapping.	276	Behniwal, M.S., <i>see</i> Vir, S.	
<i>et al.</i> Cane flowering and breeding in Egypt. (Abs.)	244	Azeredo, D.F., <i>see</i> Manhães, K.S.		Beiss, U., <i>see</i> Bürcky, K.	
— Soil nitrogen and water effect on cane flowering. (Abs.)	109	Azzi, G.M. <i>et al.</i> Cane ripening with "Polaris". (Abs.)	174	Bekker, A.M., <i>see</i> Zubatov, V.A.	
Allaway, R.A. and Barnes, N.H.		<i>see also</i> Alves, A.S. and Fernandes, J.		Belenko, A.P., <i>see</i> Tsyukalo, Y.F.	
Factory maintenance. (Abs.)	373	Bacchi, O.O.S. and Sousa, J.A.G.C.		Belien, J.M. and Salembier, J.F.	
Allan, J.R., <i>see</i> Broadfoot, R.		Minutem temperature requirement for cane growth. (Abs.)	175	Chemical weed control. (Abs.)	18, 211
Allison, W.F. Cane payment. (Abs.)	119	<i>see also</i> Nova, N.A.V.		Belik, V.G. and Scherbakov, A.M.	
Effect of cane trash on sugar recovery. (Abs.)	119	Bachchhav, M.B. <i>Sphacelotheca schweinfurthiana</i> in India. (Abs.)	306	Beet slicer speed optimization.	23
		<i>et al.</i> Cane rust control. (Abs.)	341	Bellabarba, F. Factory solid waste quantity and treatment. (Abs.)	218



# INDEX

	page		page		page
Belolipetskii, B.I. <i>see</i> Mil'kova, Z.A.		Botelho, P.S.M. <i>et al.</i> Weather effect on moth borer population. (Abs.)	208	Cafada, A., <i>see</i> China, A.	
Joh. A. Benckiser GmbH, <i>see</i> Husted, H.		<i>see also</i> Macedo, N. and Mendes, A. de C.		Caplovic, J. and Rendos, F. Mannitol occurrence in beet pulp. (Abs.)	57
Benda, G.T.A. Cane bud germination inhibition by leaf sheaths. (Abs.)	148	Bötger, -. Nematode cyst counting in soil. (Abs.)	19	Carbonell T., E.E. <i>Elasmopalpus lignosellus</i> morphology. (Abs.)	371
and Ricaud, C. Cane disease control by sett heat treatment . . .	150	Bourdon, D. Beet sampling. (Abs.)	376	Nematodes in Peru. (Abs.)	150
Benez, S.F., <i>see</i> de Souza, L.G. and Fiedade, A.		Bourlet, P., <i>see</i> Lescure, J.P.		Cardoso M., R., <i>see</i> Pérez G., R.	
Bennett, F.D. Cane borer parasites.	150	Boyle, H.L. Q 96 cane variety. (Abs.)	244	Carnegie, A.J.M. Moth and caterpillar activity in cane fields. (Abs.)	209
Bennett, M.C. <i>et al.</i> Syrup clarification with flocculant. (Abs.)	179	Bramm, A. and Sommer, C. Drip vs. overhead irrigation and beet yield. (Abs.)	274	Carpenter, F.G., <i>see</i> Clarke, M.A. and Roberts, E.J.	
<i>see also</i> Abram, J.C.		Brannan, M.A., <i>see</i> Clarke, M.A.		Carranza R., L. Massecuite super-saturation tables. (Abs.)	57
Benz, L.C. <i>see</i> Reichman, G.A.		Braslette, D.J. Cane harvester toppler. (Pat.)	29	<i>et al.</i> Dextran effect on sugar solution viscosity and refractive index. (Abs.)	57
Bereshchuk, G.I. Beet payment in USSR. (Abs.)	313	and Duncan, R.A. Cane harvester toppler. (Pat.)	60	- Physical chemistry of sucrose-ethanol-water system. (Abs.)	219
Beringer, G., <i>see</i> Bändel, F.		Braud, H.J., <i>see</i> Yang, S.M.		Carter, J.N. <i>et al.</i> Hailstorm defoliation and nitrogen effects on beet yield. (Abs.)	307
Berti-Filho, E., <i>see</i> Gallo, D.		Braun, F.J. Drip vs. overhead irrigation and beet yield. (Abs.)	274	Carville, L., <i>see</i> Roy, E.P.	
Bhalero, A.C. <i>et al.</i> Weed control with "Nitrofen". (Abs.)	18	Braunschweigische Maschinenbauanstalt. Continuous centrifugal. Tower diffuser. (Pat.)	317	Casagrande, A.A. and Godoy, O.P. Effect of soil tillage method on cane yield and soil properties.	147
<i>see also</i> Karve, A.D. and Singh, O.P.		<i>see also</i> Schaper, H.	316	Casanova, E. and Robella, I. Cane growth factors and mechanical harvesting. (Abs.)	241
Bhargava, K.S. <i>et al.</i> Alternative mosaic host. (Abs.)	306	Bravo L., D., <i>see</i> Ayala, H.G. and Fogliata, F.A.		Casey, J.A. Cane juice liming tank.	284
Bhatia, N.L., <i>see</i> Bishnoi, L. and Singh, K.		Bray, W. Chemical weed control.	178	Casastellanos C., M. <i>et al.</i> Black liquor recovery from bagasse pulp manufacture. (Abs.)	93
Bhatnagar, P.K. <i>see</i> Khan, Q.O.		Breaux, R.D. and Koike, H. Cane breeding for mosaic resistance.	149	Castilho, H.C. <i>see</i> Gallo, D.	
Bhatnagar, P.S. and Pant, G.B. Agronomic practices for high beet yield and quality. (Abs.)	17	Brennan, S.A., <i>see</i> Kostenko, N.V.		Castro, P.R.C. <i>et al.</i> Cane varietal growth parameter differences.	207
and Raj, B. Gibberellin acid effect on beet yield and sugar content. . .	18	Bria, N., <i>see</i> Clotan, G. and Stanesco, Z.		Castro, V.G., <i>see</i> Nartea, R.N.	
- Weather and agronomy effects on beet quality. (Abs.)	84	Brieger, F. Cane varieties in Brazil. Vinasse utilization as fertilizer.	371	Carizone, P., <i>see</i> Britoni, G.	
<i>see also</i> Tewari, S.K.		Brinholi, O. <i>et al.</i> Cane varietal frost resistance. (Abs.)	371	Cepelak, J. and Oswald, R. Filtration coefficient calculation. (Abs.)	217
Bhatt, C.S., <i>see</i> Agrawal, P.K.		Brinkmann, W., <i>see</i> Umari, M.		Cerrizuela, E.A. Mechanical cane harvesting. (Abs.)	79
Bhatt, J.P., <i>see</i> Shah, A.H.		Britto M., J. and Abreu C., J. Cane harvester trash separation. (Abs.)	113	<i>see also</i> Arévalo, R.A.	
Bhaskar, V.R. <i>et al.</i> Indian factory equipment modifications and performance. (Abs.)	20	Brixius, W.W. Wheel vs. crawler tractor comparison. (Abs.)	305	Cesnik, R. <i>et al.</i> Cane seedling potting compound trials. (Abs.)	51
Bhushan, T.A., <i>see</i> Khan, A.M.H.R.		Broadfoot, R. and Allen, J.R. Continuous boiling. (Abs.)	156	- Frost resistance of cane varieties. (Abs.)	16, 210
Bichsel, S.E. Liquid sugar manufacture by thick juice ion exchange treatment.	375	and Wright, P.G. Low-grade continuous boiling. (Abs.)	344	Chacravarti, A.S. <i>et al.</i> Chemical ripening effect on cane composition and enzyme activity. (Abs.)	48
Bickle, R.E. and Moir, M.K. Bagasse furnace operation problems. (Abs.)	373	<i>see also</i> Wright, P.G.		Chan, P., <i>see</i> Shan, L.L.P.	
Biddulph, O., <i>see</i> Alexander, A.G.		Brobst, K.M., <i>see</i> Scobell, H.D.		Chan, Y.Y. Slow release CDU nitrogen fertilizer. (Abs.)	338
Binevskaya, L.N., <i>see</i> Kot, Y.D.		Brokensha, M.A. <i>et al.</i> Cane juice sucrose vs. pol balances. (Abs.)	349	and Juang, T.C. Trials with CDU nitrogen fertilizer. (Abs.)	147
Birch, G.G. and Parker, K.J. Sugar: science and technology. (NB)	185	Broniarz, L., <i>see</i> Kozioł, K.		Chandappa, N. <i>et al.</i> Automatic control of mill feeding. (Abs.)	119
Birkett, H.S. Evaporator, juice heater and pan dimensions. (Abs.)	215	Brooke, D.L. Cane growing and sugar production economics in Florida. (Abs.)	119	Chandler, K.J. Nematode control.	371
and Polack, J.A. Alcohol fermentation. (Abs.)	254	Brotherton, G.A., <i>see</i> Noble, A.G., Stewart, P.N. and Swindells, R.J.		Chang, C.H., <i>see</i> Juang, T.C.	
Bishnoi, L. <i>et al.</i> Beet varietal trials in India. (Abs.)	246	Broughton, N.W., <i>see</i> Oldfield, J.F.T.		Chang, C.S. Cane stalk cutting resistance measurement. (Abs.)	241
Biswas, M.K. <i>et al.</i> Sugar: Automatic engine stoppage system. (Abs.)	53	Brown, G. Mechanical beet thinning.	178	Chang, C.Y., <i>see</i> Wang, L.H.	
Bittencourt, V.C., <i>see</i> Cordeiro, D.A.		Brunhs, G., <i>see</i> Dankowski, K.		Chantha, N., <i>see</i> Rosario, E.L.	
Blackburne, I.D. <i>et al.</i> Cane mill journal lubricants. (Abs.)	373	Bruin, J. Activated sludge treatment of waste water in South Africa. (Abs.)	154	Chapman, L.S. Drip irrigation in Australia. (Abs.)	304, 337
Blake, J.D. and McNeil, K.E. Alcohol content in cane sugar factory products. (Abs.)	343	cane molasses exhaustibility determination. (Abs.)	248	<i>see also</i> Kingston, G.	
Blanc, J. Parameters calculation for flow regulation. (Abs.)	279	Brunelli, S., <i>see</i> Chenu, P.		Chardon, C.W. and Rudd, A.V. Soil drainage inadequacy and cane yield. (Abs.)	337
Blanco C., G., <i>see</i> Ocampo S., G.		Bruschke, H. Alcohol fermentation of cane. (Abs.)	253	<i>et al.</i> Cane variety adoption in Australia. (Abs.)	342
Blaquier, L.M. <i>et al.</i> Irrigation. (Abs.)	145	Bryant, B.S. Corrugated board manufacture from bagasse. (Abs.)	350	Charlesworth, D. Beet pulp and tops as animal fodder. (Abs.)	221
Bleijenberg, C.C., <i>see</i> van der Poel, P.W.		Buchanan, E.J. Cane payment. (Abs.)	157	Beet seed pelleting. (Abs.)	178
Bleyenbergh, C.C. <i>et al.</i> Sugar factory laboratory computer application.	313	Buckau R. Wolf AG. Continuous centrifugal. (Pat.)	316, 317	Beet tops as animal fodder. (Abs.)	27
<i>see also</i> Bleijenberg, C.C.		Budharaja, T.R., <i>see</i> Agnihotri, V.P.		<i>see also</i> Hollowell, W.	
Bliessen, K.M., <i>see</i> Reinefeld, E.		Bugaenko, I.F. and Lapkin, A.I. Cane raw sugar high polymers.	347	Charnyakhovskii, I.B., <i>see</i> Dovgopoli, V.I.	
Bobrovnik, L.D. <i>et al.</i> Decolorization by sodium sulphite. (Abs.)	218	Buge, K., <i>see</i> Werner, W.		Chatterjee, A. and Math, B.R. Manufacture of continuous centrifugal components in India. (Abs.)	119
<i>see also</i> Fajardo, G., R. Fedorova, N.S. and González C., L.		Buika, F. Carbonatation. (Abs.)	312	Chatterjee, A.C. Centrifugals. (Abs.)	52
Bodger, R. and van der Riet, C.B. Cane sampler. (Abs.)	374	Bukhar, B.A., <i>see</i> Fasih, S.D.		and Bhidi, A.R. Refining. (Abs.)	122
Boevoy, T.C., <i>see</i> De Beer, A.G.		Bulacio, A.N.R., <i>see</i> Mariotti, J.A.		<i>et al.</i> Potash manufacture from vinasse. (Abs.)	252
Bogdanichikova, V.S., <i>see</i> Gromkovskii, A.I.		Buravleva, V.I. <i>et al.</i> Sugars hydration. (Abs.)	25	Chaturvedi, P.P. Heat recovery from flue gases. (Abs.)	119
Boiko, E.S., <i>see</i> Zagorul'ko, A.Y.		<i>see also</i> Zubchenko, A.V.		Chavan, J.B., <i>see</i> Patil, R.T.	
Bond, R.S. Cane seedling yield as a selection guide. (Abs.)	118	Bürckky, K. <i>et al.</i> Nitrogen and potassium effects on beet sugar content and quality. (Abs.)	177	Chekal', A.I. and Popovich, V.V. Beet payment in USSR. (Abs.)	277
Bondarenko, N.F. and Marushchenko, M.A. Evaporator juice Brix regulator.	87	Buriánek, J. and Kmínek, M. Automatic boiling control. (Abs.)	182	Chemical Services (Pty.) Ltd., <i>see</i> Lake, A.W.	
Bormann, H., <i>see</i> Maassen, D.		Burlyay, T.F., <i>see</i> Zagorul'ko, A.Y.		Chen, C.H. <i>et al.</i> Carbonation and sulphitation juice flow pattern simulation by computer. (Abs.)	180
Bose, P.K. Increasing fertilizer effectiveness. (Abs.)	239	Burrows, J.R. Available phosphorus determination in soil. (Abs.)	378	<i>see also</i> Sang, S.L.	
<i>see also</i> Thakur, K.		Burtch, L.M., <i>see</i> Smith, R.		Chen, C.T. White leaf transmission by leafhopper. (Abs.)	243
Bose, S. <i>et al.</i> Enzymatic starch removal from sugar factory products. (Abs.)	157	Buss, A. Herbicide-vinasse mixture for weed control and fertilization.	280	<i>see also</i> Yang, T.T.	
Bosma, S.M., <i>see</i> Carter, J.N.		<i>see also</i> Alves, A.S.			
Bosnjak, M. Clarifier. (Pat.)	61	Butwilowicz, A., <i>see</i> Drewnowska, W.			
Bostanov, S.R. Beet payment in USSR. (Abs.)	277				
		Campos, O., <i>see</i> Pollio, F.X.			
		Camposilvan, D., <i>see</i> Fernandes, J.			

# INDEX

	page		page		page
Chen, J.C.P. Clarification with flocculants. (Abs.)	21	Cormier, R. <i>et al.</i> Metals determination in refined sugar. (Abs.)	380	Delavier, H.J., <i>see</i> Shokrani, R.	
Dissolved oxygen as effluent quality indicator. (Abs.)	21	— Sucrose esters analysis by high-pressure liquid chromatography.	381	Deleurence, A., <i>see</i> Windal, G.	
Chen, M.Y. and Hsu, Y.T.		Corning Glass Works. Dextrose isomerization to levulose. (Pat.)	285	Delfini, A.A., <i>see</i> Ayala, H.G. and Fogliata, F.A.	
Herbicides. (Abs.)	271	Costa, W.J., <i>see</i> Tambosco, N.		Delgado, A.A. Sulphitation of juice from burnt and unburnt cane.	181
and Tseng, S.T. Wireworm and white grub in Taiwan. (Abs.)	272	Cory, R.P., <i>see</i> Armbruster, F.C.		Dellinger, R. US refinery effluent pollution limitations. (Abs.)	122
Chen, W.H., <i>see</i> Liu, M.C. and Lo, C.C.		Cossio, R.P. <i>et al.</i> Herbicide tolerance of cane varieties. (Abs.)	111	Dellweg, H., <i>see</i> Engelbart, W.	
Chen, W.P. <i>et al.</i> Fermentation gum production from sucrose. (Abs.)	125	Costa, J.D., <i>see</i> Frazão, D.A.C.		de los Rios, R. Refinery liquor preconcentration and boiling house heat balance. (Abs.)	314
Cheng, S.L., <i>see</i> Chen, W.P.		Costa, J.M.B., <i>see</i> Mendonça, A.F.		de Moraes, R.S., <i>see</i> Silva, G.M. de A.	
Cheng, W.Y. and Su, T.H. Borer parasite release in Taiwan. (Abs.)	272	Covacevich, M.T. <i>et al.</i> Effect of dextran on crystal shape. (Abs.)	123	de Moraes, G.J., <i>see</i> Gallo, D.	
Cheng, Y.C., <i>see</i> Chen, C.H.		Cox, G.B. and O'Neill, I.K. Sugars detection in high-pressure liquid chromatographic systems. (Abs.)	378	Dennis, R.E., <i>see</i> Franci, L.J.	
Chenu, P.M.A.M. Alcohol from cane juice. (Abs.)	126	CPC International Inc. Dextrose isomerization to levulose. (Pat.)	316	de Novais, H.P., <i>see</i> Ripoli, T.C.	
<i>et al.</i> Juice sand separator. (Abs.)	310	— <i>see</i> Armbruster, F.C., Suekane, M. and Tamura, M.		Deol, D.S., <i>see</i> Sharma, H.L.	
Chernenko, V.A., <i>see</i> Tsyukalo, Y.F.		Crees, O.L. <i>et al.</i> Cane juice settling.	344	de Oliveira, E.R., <i>see</i> Fernandes, A.C.	
Chernikina, V.G., <i>see</i> Silina, N.P.		Crema, J.A., <i>see</i> Rodriguez, A.		and Valsechi, O.	
Chia, Y.H., <i>see</i> Lo, C.C.		Cronevitz, T. <i>et al.</i> Residence time determination. (Abs.)	376	de Queiroz, L., <i>see</i> Fernandes, A.C.	
Chiang, N.E. <i>et al.</i> Evaporator scale prevention. (Abs.)	215	— <i>see</i> Schiweck, H.		de Ramalho, R.P. Cane mill rollers. (Abs.)	310
Chiappino, V.H. Cane quality determination. (Abs.)	57	Cuer, M. Beet extraneous matter separation and treatment. (Abs.)	376	de Ramalho, N.V., <i>see</i> Cossio, R.P.	
Frost effect on cane fibre. (Abs.)	281	Cullen, G.R. Straight fertilizers vs. mixtures. (Abs.)	78	Derrick, K.S., <i>see</i> Damann, K.E.	
Chinchwade, D.B. Tramp iron separation by magnet. (Abs.)	53	Cullen, R.N., <i>see</i> Mason, V., Sawyer, G.M. and Watts, K.W.		de Souza, L.G. and Lloft, A.M.S.	
Chinea, A. <i>et al.</i> Artificial inoculation of red stripe cane disease. (Abs.)	115	Curbelo S., A. Active carbon consumption determination. (Abs.)	184	Cane alcohol composition. (Abs.)	282
Chinnaswamy, A.P. Cane molasses loss reduction. (Abs.)	311	Curdts, U. Appeldorn sugar factory.	279	<i>et al.</i> Factory power supply by external associations. (Abs.)	310
<i>et al.</i> Continuous centrifugal effect on molasses yield and purity. (Abs.)	85	Curtis, O.D. <i>et al.</i> Fertilizer recommendations for Louisiana.	207	<i>see also</i> Piedade, C.	
Chougule, J.D. Fertilizer application rate and cane yield. (Abs.)	14	Dabrowski, H. Beet washing. (Abs.)	345	des Vignes, W.G. Borer sampling and control. (Abs.)	209
and Patil, K.D. Soil cultivation and cane yield. (Abs.)	14	da Glória, N.A. and Da Silva, E.		Detavernier, R. and Roger, J. Beet molasses exhaustion formulae.	123
and Sanghavi, K.U. Cane inter-cropping effect on growth and yield. (Abs.)	48	Lime effect on scale formation and juice, syrup and molasses composition.	180	<i>et al.</i> Analytical methods. (Abs.)	123
<i>et al.</i> Chemical weed control. (Abs.)	238	<i>et al.</i> Ash constituents determination in white sugar. (Abs.)	187	de Ullivarri, R.F., <i>see</i> Blaquier, L.M.	
Chougule, S.B. Cane agronomic programme to raise yield in Maharashtra. (Abs.)	48	— Cane payment research in Brazil.	380	Devaraj, G., <i>see</i> Kadivel, A.K.	
Christiane, C. Sulphur dioxide determination. (Abs.)	220	— <i>see also</i> Magro, J.A.		Devil, J. and Wong Yoo Cheong, Y.	
Christodoulou, P. Boiler efficiency determination. (Abs.)	22	Dahiphale, M.V. Anhydrous ammonia as fertilizer. (Abs.)	239, 370	Cane tops silage. (Abs.)	126
Evaporator. (Abs.)	182	Daishev, M.I. and Trifonova, T.P.		Devillers, P. Stored beet sugar loss determination. (Abs.)	345
Steam consumption reduction by vapour compression. (Abs.)	375	Beet molasses ion exchange treatment. (Abs.)	88	<i>et al.</i> Silica determination. (Abs.)	251
Christoph, D. and Manzke, E.		Dakhindas, D.G. Cane agriculture development. (Abs.)	109	— Viscosity effect on molasses exhaustion. (Abs.)	26
Factory heat loss reduction. (Abs.)	249	Cane sampling and Brix measurement for maturity testing. (Abs.)	338	de Visser, N.H.M., <i>see</i> Bleyenbergh, C.C. and van der Poel, P.W.M.	
Chugunova, T.I., <i>see</i> Nemirovskaya, S.I.		Dalleinne, E. Herbicide effect on beet. (Abs.)	18	Dhukar, R.S., <i>see</i> Bishnoi, L.	
Chui, F. and Samuels, G. Nitrogen fertilizer efficiency in plant and ratoon cane. (Abs.)	144	Damann, K.E. <i>et al.</i> Cane ratoon stunting disease bacterium detection.	149	Diaz, I. <i>et al.</i> Reducing sugars determination. (Abs.)	379
Cienfuegos I., F., <i>see</i> Martinez G., A.		Damián, Y., <i>see</i> Kolesnikov, V.I.		<i>see also</i> Lodos, J.	
Ciochia, V. and Ionescu, M. Soil pests control in beet. (Abs.)	247	Damodar, K., <i>see</i> Chandappa, N.		Diaz de A, C. <i>see</i> Nunez T., G.	
<i>et al.</i> Root aphid in Rumania.	19	Daniail, M. <i>et al.</i> Cane borer parasite.	242	Diaz M., R. <i>et al.</i> Cane varietal trials in Cuba. (Abs.)	244
Ciolaus, A. Herbicide trials in Rumania. (Abs.)	246	Daniels, J. <i>et al.</i> Taxonomy of <i>Saccharum robustum</i> . (Abs.)	118	Dikshit, R.K., <i>see</i> Gupta, K.K.	
Cisak, R. and Andrejewski, A. Beet slicer. (Abs.)	345	Dankowski, K. <i>et al.</i> Zuckerwirtschaftliches Taschenbuch 1978/79.	55	Diplock, R. and Marshall, K. Automatic cane train handling. (Abs.)	373
Ciz, K., <i>see</i> Gebler, J.		D'Antico, A., <i>see</i> Cormier, R.		Divinagracia, N.S. and Ramirez, D.A.	
Clark, T.F., <i>see</i> Ernst, A.J.		Darias P., M. and Martin B., J.		Cane variety morphology in the Philippines. (Abs.)	210
Clarke, M.A. <i>et al.</i> Cane raw sugar and acid beverage floc. (Abs.)	184	Colloid effects on clarification.	52	Divisão Industrial do Departamento Técnico da Copersucar. Vacuum pan. (Abs.)	310
— Sucrose inversion determination by high pressure liquid chromatography. (Abs.)	379	and Ruiz G., M.C. Cane juice colloid removal. (Abs.)	215	Dmitrash, A.S., <i>see</i> Pushanko, N.N.	
<i>see also</i> Roberts, E.J.		da Silva, E., <i>see</i> da Glória, N.A.		Dmytryuk, A.A. <i>et al.</i> White sugar fluidized bed dryer/cooler. (Abs.)	22
Clavery, E. and Kead, R.L. Diesel engine oil analysis. (Abs.)	114	da Silva, G.A. <i>et al.</i> Red rot and cane invertase activity. (Abs.)	116	Dober, J. Automatic beet diffusion and carbonation control. (Abs.)	312
Clayton, J.E., <i>see</i> Miller, J.D.		da Silva, M.A.A., <i>see</i> da Silva, G.A.		Dobrobraba, Y.P. Diffuser scroll speed fluctuation and sugar losses.	89
Clemens, D.H., <i>see</i> Barrett, J.H.		da Silva, W.M. Cane seedling production from fuzz. (Abs.)	152	Dobrzycki, J. Factory products analysis. (Abs.)	187
Clot, A. and Briat, N. Beet seedbed preparation and drilling. (Abs.)	246	Dauval, C., <i>see</i> Hernandez, M.T.		Sugar solution specific heat calculation. (Abs.)	315
Cloves, M.St.J. Cane ripening with chemicals. (Abs.)	339	David, E. Laboratory equipment and sugar balance calculation. (Abs.)	379	Doering, E.J., <i>see</i> Reichman, G.A.	
Cochran, B.J. and Whitney, R.W.		David, H.C., <i>see</i> Alexander, K.C.		Dominguez, A.R. and Hyndshaw, A.Y. Active carbon. (Abs.)	122
Cane transport system design.	114	Dávila I., <i>see</i> Diaz M., R.		Dominguez, M., <i>see</i> Fonseca, M.	
Codrescu, V., <i>see</i> Stancu, Z.		Davis, N.B. and Torg, P. Molassed beet pulp production and marketing. (Abs.)	282	Donavan, L.P. Cane transport in Trinidad. (Abs.)	114
Coker, I.E. and Gardner, D.E.		Dayal, R., <i>see</i> Agarwal, M.L.		Donovan, P.A. Cane agronomy energy inputs. (Abs.)	368
Dextrose isomerization to levulose.	283	Dean, J.L. Cane mosaic virus infectivity. (Abs.)	115	Doolan, B.J., <i>see</i> Jacklin, G.D.	
Colas, J.L., <i>see</i> Teissier, R.		de Beer, A.G. and Boevy, T.C.		Dosado, V., <i>see</i> Rosario, E.L.	
Comhlucht Siuicre Eireann Teo.		Mechanical cane harvesting losses.	114	Dovgopol, V.I. <i>et al.</i> Condenser.	89
Comstock, J.C. and Heinz, D.J. Cane smut strains in Hawaii. (Abs.)	16	de Biase, L.P. Vinasse concentration.	381	Draier, C.M.R. Factory location Drath, L., <i>see</i> Bucky, K.	
Connolly, A.A. and Duigan, V.G.		de Bittencourt, V.C. <i>et al.</i> Soil phosphate analysis. (Abs.)	112	Draycott, P. and Messen, A. Irrigation and nitrogen effects on beet yield. (Abs.)	246
Lime kiln. (Abs.)	250	<i>see also</i> Ruschel, A.P.		Drewnowska, W. and Butwilowicz, A.	
Cooke, D.A. Beet cyst nematode.	247	de Boer, A.J., <i>see</i> Chardon, C.W.		Molasses sugar and beet thick juice purity estimation. (Abs.)	345
Cordeiro, D.A. <i>et al.</i> Soil liming and potassium availability. (Abs.)	111	de Carvalho, P.C.T., <i>see</i> da Silva, G.A.		Dua, S.P. and Singh, R.C. Fertilization and crop age effects on cane juice nitrogen, phosphorus and potassium. (Abs.)	238
		Delaveau, P., <i>see</i> Julien, M.H.R.		<i>see also</i> Agarwal, M.	
				Duarte, M.L.R. and Tokeshi, H.	
				Smut inoculation of cane seedlings.	116



# INDEX

	page		page		page
Gillaspie, A.G. Ratoon stunting disease anti-serum. (Abs.) . . . . .	273	Gupta, A.P. and Singh, S.V. Factory performances in India. (Abs.) . . . .	48	Hernández N., M.T. <i>et al.</i> Yeasts metabolism of sucrose in juice and sugar solutions. . . . .	219
<i>et al.</i> Mosaic virus strain identification. (Abs.) . . . . .	115	<i>see also</i> Rao, G.S.C.		Hernández S., P. and Morrell F., I. Yeast cultivation on cane molasses. <i>et al.</i> Yeast cultivation on cane molasses. (Abs.) . . . . .	59
<i>see also</i> Damann, K.E. and Harris, R.W.		Gupta, H.N. Cane preparation. . . . .	53	<i>see also</i> Morrell F., I.	
Giménez, O., <i>see</i> Mariotti, J.A.		Gupta, J.K., <i>see</i> Vadehra, D.V.		Herrera, N., <i>see</i> Hernández N., M.T.	
Giordano, G. Carbonatation. (Abs.)	312	Gupta, K.K. <i>et al.</i> Carbo-phosphatation v. carbo-sulphatation in refining. (Abs.) . . . . .	122	Herrera, Z. <i>et al.</i> Bagasse pulp bleaching. (Abs.) . . . . .	222
Giorgi, J.C. and Gontier, R. Ion exchange treatment of beet juice. and Richard, B. Masseculite reheater. . . . .	89	Gurgel, M.N., <i>see</i> Cordeiro, D.A.	149	Hesch, R. Bagasse storage. (Pat.)	285
Giouzelyanne, A. Beet pulp and molasses as animal fodder. (Abs.)	282	Gutierrez, P.L. Bagasse paper pilot plant in Cuba. (Abs.) . . . . .	222	Hesse, F.W., <i>see</i> Mathieu, C.	
Gladkii, V.N., <i>see</i> Pasechnik, V.P.		Guzmán, B. Effect of clarifying agent and polysaccharides on polarization. (Abs.) . . . . .	124	Hibbert, D. <i>et al.</i> White sugar ash distribution and Crystal Regularity Index. (Abs.) . . . . .	25
Glass, J.S., <i>see</i> Flanders, I.G.	375	Gyte, D.W., <i>see</i> Oldfield, J.F.T.		<i>see also</i> Koster, P.B.	
Glozman, I.M., <i>see</i> Petrunya, V.I.				Hicks, M.K. Sugar factory steam balance. (Abs.) . . . . .	120
Godoy, O.P., <i>see</i> Gasagrande, A.A. and Frazão, D.A.C.				Higa, K., <i>see</i> Shimabuku, M.	
Godshall, M.A. and Roberts, E.J. Proteins determination by gel electrophoresis. (Abs.) . . . . .	379	Haag, H.P., <i>see</i> Orlando, J.		Higgy, A.M. <i>et al.</i> Pokkah boeng cane disease in Egypt. (Abs.) . . . . .	150
<i>see also</i> Clarke, M.A. and Roberts, E.J.		Hadlow, W. and Millard, E.W. Minimum tillage. (Abs.) . . . . .	109	Hiramoto, T. Refinery molasses electrodiolysis. (Abs.) . . . . .	314
Godulla, P. <i>et al.</i> White sugar silo internal wall treatment. (Abs.) . . . .	250	Haefner, R.G., <i>see</i> Blackburne, I.D.		Hitchcock, B.E. Cane pests in Australia. (Abs.) . . . . .	341
Goel, S.K., <i>see</i> Joshi, N.N.		Hagemann, R.W., <i>see</i> Ehlig, C.F.		and Kerkwyk, R.E. Rat control. . . . .	371
Goepen, W. Factory power supply voltage and losses. (Abs.) . . . . .	250	Hagihara, H. H., <i>see</i> Gascho, G.J.		Hluzé, J., <i>see</i> Ružická, J.	
Gogia, V., <i>see</i> Vadehra, D.V.		Hale, D.J., <i>see</i> Crees, O.L.		Ho, F.W., <i>see</i> Yang, P.C.	
Gokhale, M.N. Cane propagation with bud chips. (Abs.) . . . . .	117	Hale, E. Stainless steel applications in sugar factories. (Abs.) . . . . .	52	Ho, P.W., <i>see</i> Wu, S.N.	
Golden, L.N., <i>see</i> Curtis, O.D.		Ham, G.J., <i>see</i> Leverington, K.C.		Hoareau, P. <i>et al.</i> Colour removal by ion exchange. (Abs.) . . . . .	122
Goldnik, V.E., <i>see</i> Kravchuk, A.F.		Hämäläinen, L., <i>see</i> Melaja, A.J.		Hobková, V., <i>see</i> Gebler, J.	
Golubtsova, V.M. Determination of yeast activity in citric acid fermentation of molasses. (Abs.)	222	Hanftwurcel, A. Kaba sugar factory. . . . .	345	Hockstra, R.G. Cane sugar factory crushing optimization. (Abs.) . . . . .	374
Gomkale, S.D., <i>see</i> Mehta, V.C.		Hanslip, G. Beet irrigation. (Abs.) . . . .	177	Value of cane maturity testing. . . . .	111
Gonçalves, J.A.C. and Santos, A.G. Soil salinity reduction with calcium chloride. (Abs.) . . . . .	112	Beet nitrogen fertilization and profitability in the UK. (Abs.) . . . .	18	Hoffmann, C. Topping effect on cane value. (Abs.) . . . . .	15
Gonçalves, M.P.S.B. Alcohol bibliography. (NB)	186	Hanumanulu, V. and Subrahmanyam, P.V.R. Distillery waste treatment. . . . .	254	Hogarth, D.M., <i>see</i> Leverington, K.C.	
Cane varieties bibliography. (NB)	186	Hapase, D.G., <i>see</i> Bachchhav, M.B. and Moholkar, P.R.		Hogrefe, W. Flow meters. . . . .	323
English-Portuguese dictionary of cane diseases and pests. (NB)	186	Haquenne, W. Herbicide effects on beet. (Abs.) . . . . .	211	Hogu, J.N., <i>see</i> Skole, R.D.	
Portuguese sugar dictionary. (NB)	186	Hardy, C., <i>see</i> Lezcano, P.		Hokama, K. <i>et al.</i> Fusel oil production from cane molasses. . . . .	221
Gontier, R., <i>see</i> Giorgi, J.C.		Hardy, M., <i>see</i> Shan, L.L.P.		Hoks, D. Continuous centrifugal for white sugar. (Abs.) . . . . .	157
Gonzalez, A.J. Cane irrigation. (Abs.)	206	Haresnape, R.E. Ivory Coast sugar industry. (Abs.) . . . . .	20	Hollaus, F. Bacteriological control. . . . .	23
González, C., <i>see</i> Fleites, E.R.		Hariharan, P.K. Bagasse furnace combustion efficiency. (Abs.) . . . . .	248	Hollingsworth, B.S., <i>see</i> Tilbury, R.H.	
González, R., <i>see</i> Llerena, E.		Harris, R.W. and Gillaspie, A.G. Ratoon stunting disease diagnosis. . . .	242	Hollowell, W. and Charlesworth, D. Beet agricultural practices in the UK. (Abs.) . . . . .	274
González C., L. <i>et al.</i> Colour formation in amino-carbonyl reactions. Colour formation in dextrose-dipeptide reaction. (Abs.) . . . . .	219	Harvey, C.W., <i>see</i> Oldfield, J.F.T.		Honda, T., <i>see</i> Alves, A.S.	
Colour removal by synthetic resin. . . .	219	Hasagawa, S., <i>see</i> Tamura, M.		Hongisto, H. and Heikkilä, H. Cane molasses treatment by ion exchange chromatography. (Abs.) . . . . .	181, 248
Maillard reaction products separation. (Abs.) . . . . .	188	Hasagawa, S., <i>see</i> Suekane, M.		Horiki, Y., <i>see</i> Kawasaki, K. and Maekawa, F.	
González P., L., <i>see</i> Suárez, R.R.		Hatchett, J.H., <i>see</i> King, E.G.		Horsley, D.F.A. and Williams, A. Beet payment calculation by computer. (Abs.) . . . . .	279
Gopalnam, <i>see</i> Rao, K.K.P.		Hatt, B.W., <i>see</i> Barker, P.E.		Hossain, M., <i>see</i> Sheikh, N.M.	
Gosnell, J.M. and Lonsdale, J.E. Irrigation and trash management effects on cane yield. (Abs.) . . . . .	148	Hawaiian Sugar Planters Association, <i>see</i> McElhoo, B.A.		Hough, J.J. and Venter, J.S.M. Bagasse pulp production. (Abs.) . . . .	126
<i>see also</i> Dyer, T.G.J.		Heady, R.E., <i>see</i> Armbruster, F.C.	245	Hristodoulou, P., <i>see</i> Christodoulou, P.	
Gowing, D.P. and Baniabbassi, N. Cane ripening in Iran in winter. . . . .	148	Heber, R.J. and Rupell, E.G. Herbicide, pesticide and nitrogen effects on beet root and crown rot. . . .	276	Hrivnák, J. and Medved, M. Beet molasses volatile fatty acids determination. (Abs.) . . . . .	188
<i>see also</i> Daniali, M.		Heffelfinger, G.P. Brix meter. (Abs.)	92	Hrubesch, W. and Wieser, F. Pelleted beet seed fungicide effect on germination. (Abs.) . . . . .	245
Gradowczyk, M.H., <i>see</i> Blaquier, L.M.		Hegarty, A. Land utilization in Australia. (Abs.) . . . . .	78	Hruška, F. Beet leaf catcher. (Abs.)	218
Graham, S.D., <i>see</i> Tilbury, R.H.		Heikkilä, H., <i>see</i> Hongisto, H.		Hsie, M.C. Ribonucleic acid and nicotinamide adenine dinucleotide production from yeast. (Abs.) . . . . .	125
Graham, W.S. and Radford, D.J. Continuous boiling. (Abs.) . . . . .	20, 181	Heinemann, H.W.B., <i>see</i> Bennett, M.C. and Rundell, J.T.		Hsieh, S.A. White grub and wire-worm resistance to "Heptachlor". . . .	371
<i>see also</i> Matthies, G.A.		Heinz, D.J., <i>see</i> Comstock, J.C.		Hsieh, T.S., <i>see</i> Yang, T.T.	
Grau y Triana, P. Cane juice extraction without colour formation. . .	285	Hellmann, D.B. Effect of soil water on cane varietal yields. (Abs.) . . . . .	146	Hsieh, W.C., <i>see</i> Lin, C.H.	
Great Western Sugar Co. Beet diffusion. (Pat.) . . . . .	317	Irrigation application rates in South Africa. (Abs.) . . . . .	368	Hsieh, W.H. and Lee, C.S. Smut strains compatibility. (Abs.) . . . . .	243
Greenfield, P.F., <i>see</i> Geronimos, G.L.		Hemaida, S. El-N. A. <i>et al.</i> Effect of trash on cane milling. (Abs.) . . . . .	155	and Tseng, D.S. Brown spot in Taiwan. (Abs.) . . . . .	371
Gristveia, E.A., <i>see</i> Arkhipovich, N.A. and Shina, N.P.		<i>see also</i> Sayed, G. El-K.		Hsiung, S.Y. Taiwan boiling practices. . .	20
Gromkovskii, A.I. <i>et al.</i> Sucrose crystallization kinetics. (Abs.) . . . .	220	Hemens, J., <i>see</i> Simpson, D.E.		Hsu, E.H., <i>see</i> Lu, C.J.	
Groult, M., <i>see</i> Devillers, P. and Detavernier, R.		Henis, Y., <i>see</i> Ruschel, A.P.		Hsu, Y.T., <i>see</i> Chen, M.Y.	
Gruszecka, H. Beet marc determination. (Abs.) . . . . .	348	Henkel, C. R. Drainage pump power requirements calculation. (Abs.) . . . .	15	Huber, H. Beet pulp drying. (Abs.)	59
Cane agriculture in Cuba. (Abs.)	304	<i>et al.</i> Cane harvester performances. . .	340	Huberlant, J., <i>see</i> Loop, W.	
Cuban sugar industry. (Abs.) . . . . .	310	<i>see also</i> Fuelling, T.G.		Hudson, J.C. Whole-stick mechanical harvesting. (Abs.) . . . . .	113
Gubanova, L.L., <i>see</i> Smirnova, L.K.		Henrique, J.L. de P., <i>see</i> Tambosco, N.		<i>see also</i> Scott, D.A.	
Guena, E.A., <i>see</i> Madrazo, C.M.		Hensley, S.D. <i>et al.</i> Louisiana cane varieties borer resistance. (Abs.) . . . .	150	Hughes, C.G. Eradication of cane disease. (Abs.) . . . . .	116
Gulminelli, L. Evaporator heat transfer and vapour circulation rate increase. (Abs.) . . . . .	54	Hernández N., M.T. Cane milling bacteriological control. . . . .	266, 291	Huia, J.S. Cane mill setting and performance. (Abs.) . . . . .	85
Gulya, O.I., <i>see</i> Dymko, M.A.		<i>et al.</i> Bacterial activity determination in cane mills. (Abs.) . . . .	52	Humbert, R.P. Alcohol manufacture from cane and bagasse. (Abs.) . . . . .	282
Gulyi, I.S., <i>see</i> Trebin, L.I.		— Cane juice degradation by bacteria. (Abs.) . . . . .	220	Cane potassium deficiency. (Abs.)	304
Gupta, A., <i>see</i> Schoenrock, K.W.R.		— Microbiological control of cane milling. (Abs.) . . . . .	215	Fertilizer placement effect on cane uptake and yield. (Abs.) . . . . .	49
Gupta, A.P. Cane pol and fibre determination. (Abs.) . . . . .	380			Overhead irrigation in Swaziland. . . .	49
and Rao, G.S.G. Manganese application to cane. (Abs.) . . . . .	238				



## INDEX

	page		page		page
Hunsgi, G. and Srivastava, S.C. Cane evapotranspiration and irrigation. (Abs.) . . . . .	148	Joshi, G.V. and Naik, G.R. Soil salinity effect on cane yield. (Abs.) <i>see also</i> Naik, G.R.	48	Khan, A.M.H.R. <i>et al.</i> Active carbon from bagasse. (Abs.) . . . . .	124
Hunt, D.C. <i>et al.</i> Sugars determina- tion by high-performance liquid chromatography. (Abs.) . . . . .	25	Joshi, K.V. Soil testing and evaluation. (Abs.) . . . . .	15	Khan, Q.Q. and Bhatnagar, P.K. Cane flowering induction in India. Khan, Z.A. <i>see</i> Agarwal, M.L.	117
Hupfer, J.A. Codex Alimentarius standards for sugar. (Abs.) . . . . .	380	Joshi, N.N. <i>et al.</i> Continuous clarification and filtration. (Abs.)	154	Khankhaski, M.Z. <i>et al.</i> Automatic beet tarehouse line. (Abs.) . . . . .	188
Hurney, A.P. and Schmalz, K. Cane ripening with "Polaris". (Abs.) <i>see also</i> Kingston, G.	337	Joshi, R.D. and Prakash, J. Mosaic inhibitor. (Abs.) . . . . .	306	— Freezing of stored beet. (Abs.) . . . . .	89
Hurst, K.B., <i>see</i> Blackburne, I.D.		<i>see also</i> Bhargava, K.S.		Khochare, B.B. Boiler feedwater treatment. (Abs.) . . . . .	248
Hustede, H. and Rudy, H. Citric acid manufacture from molasses. (Pat.)	60	Joshi, S.B., <i>see</i> Rao, B.Y.		Evaporation coefficient calculation.	20
Hyndshaw, A.Y., <i>see</i> Dominguez, A.R.		Jozefy, V., <i>see</i> Ružička, J.		Khomenko, N.D. and Yarmilko, V.G. Beet elevator. (Abs.) . . . . .	22
		Juanes, M., <i>see</i> Diaz, I.		<i>et al.</i> Beet lift. (Abs.) . . . . .	277
		Juang, T.C. <i>et al.</i> Effect of zinc on cane yield. (Abs.) . . . . .	110	Khurd, R.T. Bagasse drying. (Abs.)	53
		<i>see also</i> Chan, Y.Y. and Kao, M.M.		Kidder, G. and Rice, E.R. Cane varieties in Florida. (Abs.) . . . . .	342
		Julien, M.H.R. Cane ripening with chemicals. (Abs.) . . . . .	175	<i>see also</i> Shih, F.	
		and Delaveau, P. Harvest date effect on cane dry matter. (Abs.)	175	Kimber, D. and McCullagh, S. Beet varietal trials in the UK. (Abs.) . . . . .	309
		<i>see also</i> Chan, Y.Y. and Kao, M.M.		Kincaid, R.L., <i>see</i> Clavery, E.	
		AG Jungbunzlauer Spiritus- und Chemische Fabrik. <i>see</i> Kabil, A.J.		King, E.G. <i>et al.</i> Cane borer parasite characteristics. (Abs.) . . . . .	116
				<i>see also</i> Roth, J.P.	
		Kabil, A.J. Citric acid manufacture.	29	Kingston, G. Soil water uptake by cane roots. (Abs.) . . . . .	144
		Kaczmarek, E., <i>see</i> Urbaniec, K.		<i>et al.</i> Cane ripener trials. (Abs.)	337
		Kádár, A. Chemical weed control, in Hungary. (Abs.) . . . . .	308	<i>see also</i> Kirby, L.K.	
		Kadirvel, A.K. and Devaraj, G. CoC 671 cane variety. (Abs.) . . . . .	83	Kirby, L., <i>see</i> El-Sherif, A.F.H.	
		Kadlec, P., <i>see</i> Sárka, E.		Kirby, L.K. and Kingston, G. Cane topping height and juice ash content and White, E.T. Continuous crystal- lizer performance evaluation.	337
		Kaganov, I.N., <i>see</i> Tuzhilin, V.I.		<i>see also</i> Egan, B.T.	343
		Kaimoglu, S., <i>see</i> Vanli, N.		Kirk, R.S., <i>see</i> Hunt, D.C.	
		Kaiser, G. <i>et al.</i> Sugar factory effluent treatment by fermentation. (Abs.)	282	Kirsten, D. Weed control with "Fervin". (Abs.) . . . . .	17
		Kakiya, K., <i>see</i> Saiga, K.		Kishihara, S. and Kishimoto, M. Deodorized resin effluent treatment. (Abs.) . . . . .	347
		Kale, S.T. Distillery waste treatment.	254	Kisiel, Z., <i>see</i> Urbaniec, K.	
		Kalitsyni, T. Automatic product feed control. (Abs.) . . . . .	250	Klepaj, J., <i>see</i> Svoboda, E.	
		Kampen, W.H. Alcohol fermentation of cane juice. (Abs.) . . . . .	253	Klochkova, T.A., <i>see</i> Meleshko, V.P.	
		Kan, Z.G., <i>see</i> Zubatov, V.A.		Kmínek, M., <i>see</i> Buriánek, J.	
		Kandasami, P.A. Cane character inheritance. (Abs.) . . . . .	153	Knogotkova, E.I., <i>see</i> Shvets, V.N.	
		Cytogenetics of cane hybrids.	210	Knovi, E., <i>see</i> Moller, G.R.	
		<i>et al.</i> Cane intercropping with wheat. (Abs.) . . . . .	145	Koch, K. Beet nitrogen uptake, assimilation and metabolism.	245
		Kaniboloktili, V.A., <i>see</i> Ivanuk, A.A.		Koch, K. Cane diseases in Papua- New Guinea. (Abs.) . . . . .	272
		Kanwar, R.S. Effects on cane.	369	<i>Fusarium moniliforme</i> and <i>F. trituncum</i> pathogenicity. . . . .	306
		Kaur, H. Cane ratoon crop treatment. (Abs.) . . . . .	145	<i>see also</i> Breaux, R.D.	
		<i>see also</i> Singh, O.		Kolesnikov, B.F., <i>see</i> Kolesnikov, V.A.	
		Kao, J., <i>see</i> Damann, K.E.		Kolesnikov, V.A. <i>et al.</i> Carbonation.	87
		Kao, M.M. and Juang, T.C. Boron determination in soil. (Abs.) . . . . .	338	Kolesnikov, V.I. <i>et al.</i> Chemical weed control. (Abs.) . . . . .	238
		<i>see also</i> Juang, T.C.		Komerc, J. and Valter, V. Flow meter. (Abs.) . . . . .	250
		Karan, R. Factory performance in Fiji. (Abs.) . . . . .	213	Konars, M., <i>see</i> Kishihara, S.	
		Karasik, V.M. <i>et al.</i> Beet payment on sucrose basis in the USSR. . . . .	277	Konings, J. <i>et al.</i> Bleyenbergh, C.C. and van der Poel, P.W.	
		Karchik, S.N. <i>et al.</i> Sugar deter- mination by paper chromatography and densitometry. (Abs.) . . . . .	26	Kontaxis, D.G. and Thomason, I.J. Nematode control. (Abs.) . . . . .	212
		Karne, T.M. Lubrication. (Abs.) . . . . .	310	Kopkova, L.V., <i>see</i> Gromkovskii, A.I.	
		Karpenko, V.A., <i>see</i> Eremenko, B.A.		Korenaga, . and Takashi, . Iron determination in sugars. (Abs.) . . . . .	348
		Karren, B.L. and Faviell, M.K. Laboratory programmable computer.	278	Kornfeld, F., <i>see</i> Andres, H.	
		Karve, A.D. Beet processing in India. <i>et al.</i> Beet drilling and harvesting dates in India. (Abs.) . . . . .	87	Kornienko, L.I. Evaporation optimization. (Abs.) . . . . .	278
		<i>see also</i> Bhalarao, A.C.	18	Korobeikova, L.A., <i>see</i> Zagorulk, A.Y.	
		Karve, R.C., <i>see</i> Kanwar, B.B.		Korolev, A.E. <i>see</i> Karchik, S.N.	
		Kaschani, A. and Farazdaghi, H. Irrigation x nitrogen fertilizer x harvest date trials in Iran. (Abs.) . . . . .	17	Korol'kov, A.S., <i>see</i> Meleshko, V.P.	
		Kastner, F. Solid waste disposal. . . . .	22	Kort, M.J. Sugar and by-products utilization. (NB) . . . . .	56
		Katics, G. Beet pulp presses. (Abs.)	381	Korzun, A.A., <i>see</i> Fedotkin, I.M.	
		Kattermann, R., <i>see</i> Schwind, H.		Kostenko, N.V. and Nakhodkina, V.Z. Bacterial degradation of stored raw sugar. (Abs.) . . . . .	347
		Kaur, H., <i>see</i> Kanwar, R.S.		<i>et al.</i> colour increase in stored raw sugar. (Abs.) . . . . .	24
		Kavun, N.A. FILS-60 filter-thickener performance. (Abs.) . . . . .	313	Kostenyuk, A.M. <i>et al.</i> White sugar electrical resistance measurement.	281
		Kawamura, T. and Kawata, F. Automatic control of ATPN. (Abs.)	24	Koster, P.B. Pesticide residue deter- mination in beet pulp and molasses. <i>et al.</i> Fluorine determination in beet pulp and molasses. . . . .	4
		Kawasaki, K. <i>et al.</i> Restoration of fouled ion exchange resin. (Abs.) . . . . .	377	Kot, Y.D. and Binevskaya, L.N. Molasses sugar content. (Abs.) . . . . .	346
		<i>see also</i> Maekawa, F.		Kotlyarov, V.I. <i>see</i> Polishchko, R.P.	
		Kawata, F., <i>see</i> Kawamura, T.		Koukios, M.G. Beet processing and by-products utilization. (Abs.) . . . . .	182
		Kec, V., <i>see</i> Schmidt, L.		Kovács, F. Fungicides and pesticides.	276
		Kelly, P.S. and Porter, R.G. Cane diffusion vs. milling at Inkerman.	311	Kovalenko, B.D., <i>see</i> Pushnako, N.N.	
		Kemblowski, Z. <i>et al.</i> Filter cake conveying. (Abs.) . . . . .	312	Kozaczkenko, H., <i>see</i> Banaszkievicz, T.	
		Kemter, H. Sugar factory process automation. (ATN) . . . . .	382		
		Keniry, P.S., <i>see</i> Bathgate, R.R.			
		Kenning, V. G. Cane research in Bolivia. (NB) . . . . .	186		
		Kerkvijk, R.E., <i>see</i> Hitchcock, B.E.			

## INDEX

Koziaikin, A.P., see Carrazana, L. and Kozayavkin, A.P.		Lara, A., see Slutsky, B.		Logan, J.T. and Fitzmaurice, A.L.	
Kozioł, K., <i>et al.</i> Temperature and concentration effects on sucrose solution viscosity. (Abs.) . . . . .	281	Larina, A.A. and Aleinikov, V.G. Sucrose inversion catalysis by oxidized carbons. (Abs.) . . . . .	314	Furnace ash removal. (Abs.) . . . . .	374
Kozlenko, M.N. Beet payment in USSR. (Abs.) . . . . .	313	Lartigue, D.J. and Weatall, H.H. Dextrose isomerization to levulose. 60		Logvin, V.M., see Fedotkin, I.M.	
Kozayavkin, A.P. and Odorod'ko, N.I. Non-sugars removal by affination. (Abs.) . . . . .	24	Lauden, L.L. Flat planting of cane. 207		Loilier, M. Beet quality effects of nitrogen, frost, etc. (Abs.) . . . . .	121
<i>et al.</i> Centrifugal nozzle location for low-grade sugar washing. see also Bobrovnik, L.D. and Koziaikin, A.P.	89	Lazhe, Y.Y., see Zaborin, A.F.		Lois C., J. Bagasse depithing equipment. (Abs.) . . . . .	93
Kraft, K.J., see Maassen, D.		Lebrun, A. Seed beet mildew in France. 19		Lokan, R., see Chinnawasamy, A.P.	
Kralović, J. Leaf growth and photosynthetic assimilation effects on beet yield and sugar content. 274		Ledesma, F.I., see Escobar, T.R.		Lokeshwarappa, G.V., see Nadagoudar, B.S.	
Krasucki, S. and Siwicki, S. Beet drilling to stand. (Abs.) . . . . .	246	Ledoux, J. Energy consumption in French sugar factories. (Abs.) . . . . .	22	Long, E. Barley effect on beet growth. (Abs.) . . . . .	177
Krause, E.W. Molasses invert sugar degradation and determination value. 281		Lee, C.S. Cane juice treatment for white sugar manufacture. (Abs.) . . . . .	180	Longden, P., see Perowne, W.	
<i>et al.</i> Invert sugar determination. see also Mauch, W.	187	see also Hsieh, W.H. and Wang, Z.N.		Lonsdale, J.E. Cane planting depth and sett germination. (Abs.) . . . . .	110
Krauss P., E. Fixed vs. moving active carbon bed. (Abs.) . . . . .	184	Lee, Y.P., see Pan, Y.C.		see also Gossnell, J.M.	
Kravchuk, A.F. <i>et al.</i> Diaphragm valve. (Abs.) . . . . .	23	see also Hsieh, W.H. and Wang, Z.N.		Loop, W. and Huberland, J. Beet extraneous matter pressing. (Abs.) . . . . .	222
<i>et al.</i> Eremenko, B.A.		Legendre, B.L., see Irvine, J.E.		Lopez, M.B., see Rosario, E.L.	
Kravets, Y.M., see Vitkovskaya, V.A.		Lee, Y.P., see Pan, Y.C.		López G., P. Bagasse utilization . . . . .	253
Krems-Chemie Ges. m.b.H., see Prey, V.		Legendre, B.O., see Irvine, J.E.		Luc, M., see Williams, J.R.	
Krieger, O. Beet tarehouse equipment. (Abs.) . . . . .	315	Leibig, W. Heat economy and power production in cane sugar factories. (Abs.) . . . . .	154, 216	Luchesi, A.A., see Castro, P.R.C.	
Krishna, S. and Gaddagih, R.B. Cane breeding in India. (NB) . . . . .	186	Leibig, W.J. Beet pulp drying with gas turbine heat. (Abs.) . . . . .	282	Ludwicki, M., see Zaorska, H.	
Krishnamurthi, M. Cane breeding by tissue culture. (Abs.) . . . . .	117	Leibovich, D.M., see Kolesnikov, V.A.		Lukács, L. Beet drilling x variety x fertilizer trials in Hungary. (Abs.) . . . . .	308
Cane pollen. (Abs.) . . . . .	152	le Mao, J. and Prudhomme, R.O. Ultrasonics effect on alcohol fermentation of molasses. (Abs.) . . . . .	350	and Zana, J. Beet varietal trials in Hungary. (Abs.) . . . . .	309
Krishnamurthy, N., see Soundarajan, N.V.		Leme, E.J. de A. and Scardua, R. Cane ripening. (Abs.) . . . . .	175	Luxford, R.W.A. Bagasse sampling and moisture determination. (Abs.) . . . . .	348
Kruglova, V.I., see Zaborin, A.F.		Lenyel, A., see Soos, P.		Lucy, P.M. Single stalk selection in cane breeding. (Abs.) . . . . .	152
Krukova, V.E., see Kostenyuk, A.M.		Lescure, J.P. and Bourlet, P. Anaerobic fermentation of beet waste waters. (Abs.) . . . . .	121	Lysanskii, V.M., see Fel'dman, A.I.	
Krylov, S.T. <i>et al.</i> Colloid particle size determination in juice, syrup and molasses. (Abs.) . . . . .	92	Leśniak, W. Molasses optimum potassium ferrocyanide dose for citric acid fermentation. (Abs.) . . . . .	94	and Pogorelov, N.V.	
Kubacki, S. Beet pest and disease control in Poland. (Abs.) . . . . .	276	see also Miśkiewicz, T.		Lyubarets, P.A., see Prilutskii, I.I.	
Herbicide miscibility. (Abs.) . . . . .	276	Leverington, K.C. <i>et al.</i> Harvest and ratooning data effects on cane fibre content and yield. (Abs.) . . . . .	337		
Kubasiewicz, A. Beet molasses sugar recovery. (Abs.) . . . . .	376	see also Fuelling, T.G.		Maassen, D. <i>et al.</i> Sucrose hydroxy-alkyl ether preparation. (Pat.) . . . . .	60
Kubiak, J., see Zagrodzki, S.		Levi, C., see Mariotti, J.A.		McAleese, C.D. Cane planter. (Abs.) . . . . .	80
Kugo, M., see Saiga, K.		Levin, H.D. <i>et al.</i> Root midrib lesions on cane. (Abs.) . . . . .	273	Cane trash incorporation in soil. 14	
Kulasekaran, K., see Subramanian, A.		Lewis, J.W.V. <i>et al.</i> Evaporator scale removal. (Abs.) . . . . .	374	see also Wilcox, T.G.	
Kulig, M., see Urbaniec, K.		Lezcano, P. <i>et al.</i> Cane molasses as animal fodder. (Abs.) . . . . .	27	MacColl, D. Cane yield and quality. 111	
Kumagai, M., see Yamane, T.		Lí de A., A., see González C., L.		see also Walker, D.I.T.	
Kumar, A. and Nateshan, R. Cane ripening with chemicals. (Abs.) . . . . .	112	Libunao, O.S. Cane transport computer simulation. (Abs.) . . . . .	114	F.W. McCormick Ltd., see Scott, D.A.	
see also Alves, A.S., Azzi, G.M. and Fernandes, J.		and Lantini, R.M. Computer simulation of cane transport. (Abs.) . . . . .	241	McCormick, L.L., see Loupe, D.T.	
Kumar, K., see Singh, P.P.		Lila, B.G. Water separator. . . . .	249	McCullagh, S., see Kimber, D.	
Kuntohartono, T. <i>et al.</i> Herbicide tolerance inheritance in cane varieties. (Abs.) . . . . .	145	<i>et al.</i> B-40 filter modifications. . . . .	183	Macedo, N. <i>et al.</i> Cane varietal susceptibility to moth borer. (Abs.) . . . . .	208
Kunz, M., see Reinefeld, E.		Lim, G.T. and Pan, Y.C. Borer oviposition on cane varieties. (Abs.) . . . . .	151	see also Botelho, P.S.M. and Mendes, A. de C.	
Kuo, C.C., see Lin, C.H.		<i>et al.</i> Cane aphid trapping and flight activity. (Abs.) . . . . .	151	Machado, G.R., see Micoque, J.Y.J.	
Kuo, Y.C., see Wang, L.H.		Limanskaya, A.Y., see Zakharov, K.P.		Machado, J.R., see Brinholi, O.	
Kurikawa, O.D., see Eremenko, B.A.		Lin, C.H. <i>et al.</i> Sucrose incorporation in resins. (Abs.) . . . . .	125	Machkovskii, A.A., see Terent'ev, Y.A.	
Kurkin, B.I., see Khenko, N.D.		Lin, S.C. Bagasse pulp manufacture. 221		McIntyre, L.F.G. Chemical weed control. (Abs.) . . . . .	144
Kurkowska-Mielczarek, A. Saponin determination in sugar. (Abs.) . . . . .	281	Lin, T.L. and Tung, W.H. Cane sugar content prediction. (Abs.) . . . . .	238	McIntyre, R.J., see Watts, K.W.	
Kuz'menko, B.P. see Tsuchinskii, L.M.		Linedale, A.I. Drain construction aids. 78		Mack, G., see Archibald, R. and Lewis, J.W.V.	
		Reed control. (Abs.) . . . . .	240, 337	McKay, C.M. Gilmore Louisiana Florida-Texas-Hawaii sugar manual 1978 (NB) . . . . .	90
		Ling, S.H., see Pan, Y.C.		McKenzie, C.O. Molasses feed block. 284	
		Linga, C.K., see Barba, R.C.		Maclean, N.R. Irrigation trials in Australia. (Abs.) . . . . .	337
		Lionnet, G.R.E. Massecuite exhaustion. (Abs.) . . . . .	349	McLucas, G.N., see Flanders, I.G.	
		see also Scott, R.P.		McMartin, A. Malawi sugar factory. 20	
		Lipai, L.V., see Tsyukalo, Y.F.		McMaster, L. and Rayno, A.B.	
		Lipetsker, E.G., see Nemirovskaya, S.L.		Lactic acid fermentation in sugar processing. (Abs.) . . . . .	156
		Lippold, W. Lime kiln heat balance. 22		McNeil, K.E., see Blake, J.D.	
		Lisak, H.P., see Zagrodzki, S.		McPherson, R.M. and Hensley, S.D.	
		Liu, H.P. <i>et al.</i> Cane rind disease. 115		Cane borer:parasite size relationships. (Abs.) . . . . .	151
		see also Oliveira, A.R.			
		Liu, L.R. Ratoon stunting disease bacterium. (Abs.) . . . . .	272		
		Liu, M.C. <i>et al.</i> Cane breeding by cell culture. (Abs.) . . . . .	118		
		Livshits, A.F., see Balyasnyi, M.E.			
		Llerena, E. <i>et al.</i> Irrigation effect on cane yield and sugar content. (Abs.) . . . . .	207		
		Listó, A.M.S., see de Souza, L.G.			
		Lo, C.C. Cane mutation breeding in Taiwan. (Abs.) . . . . .	244		
		Louis, A. <i>et al.</i> <i>Miscanthus</i> germplasm for cane breeding in Taiwan. (Abs.) . . . . .	118		
		Lochman, V. Factory water economy. 182			
		Lodos, J. and Díaz, I. Boiling with surface-active agents. (Abs.) . . . . .	180		
		see also Moreno P., J.			

# INDEX

	page		page		page
McWhinney, W. and Pinkney, A.J.		Matsuoka, S. and Aguilera, M.M.		Mock, R.G., see Gillaspie, A.G.	
Mathematical modelling of		Red rot of cane leaf sheath control.	16	Mogueira, M.C.S., see Cernik, R.	
evaporator and juice heater. (Abs.)	344	see also Aguilera, M.M.		Moholkar, P.R. <i>et al.</i> Borer effect on	
Madi, A. <i>et al.</i> Fodder yeast		Matthesius, G.A. Juice flow in cane		cane yield and quality. (Abs.)	16
manufacture from cane molasses.	27	diffusers. (Abs.)	120	see also Patil, A.S.	
Madrazo, C.M. Cane syrup phosphat-		<i>et al.</i> Continuous boiling	349	Moir, M.K., see Bickle, R.E.	
ation-flotation. (Abs.)	215	Matthews, A.A. Wireworm damage		Molina, A. Cane molasses as animal	
and Guena, E.A. Sucro AMS		and control. (Abs.)	243	fodder. (Abs.)	27
clarifier. (Abs.)	215	Matvienko, B.A. <i>et al.</i> Evaporator		Molina M., R., see Gutiérrez, P.L.	
Madsen, R.F., see Moller, G.R. and		juice retention time determination.	183	Moller, G.R. <i>et al.</i> Automatic	
Winstrom-Olsen, B.		Mauch, W. and Krause, E.W. Dextrose		boiling control. (Abs.)	179
Maekawa, F. <i>et al.</i> Ion exchange resin		and levulose determination in		Monsanto Co., see Ratts, K.W.	
fouling. (Abs.)	377	sugar products. (Abs.)	124	Monspart-Sényi, J., see Vukov, K.	
see also Kawasaki, K.		see also Kaiser, G. and Krause, E.W.		Montano, R., see Triana F., C.J.	
Maevskii, V.R. and Semeniso, V.M.		Maudarbocus, S.M.R. and White, E.T.		Moor, B. St. C. Cane diffusion. (Abs.)	310
BOU-40 filter modifications. (Abs.)	183	Crystallization simulation by		Mor, J.R., see Janshekar, H.	
Magro, J.A. and da Glória, N.A.		computer. (Abs.)	343	Morales, E.N. and Falcon, C. N.	
Vinasse application as fertilizer.	207	see also White, E.T.		Borers in Venezuela. (Abs.)	209
Mai, L.H., see Cormier, R.		Maurandi, V. Boiling. (Abs.)	251	Morales, G., A., see Sais, H.T.	
Makepeace, P.K. Soil sodium toxicity.	240	Ion exchange. (Abs.)	218	Morel du Boil, P.G. and Schäffler, K.J.	
Makysutov, V.A., see Kolesnikov,		Mayer, J.H. Soil phosphate fixation		Sucrose, dextrose and levulose	
V.A.		and cane fertilization. (Abs.)	146	determination by gas-liquid	
Malczewski, J. Beet pulp drying.	253	Maykuhs, F. Chemical weed control		chromatography. (Abs.)	378
Malik, K.B., see Fashi, S.D.		in beet on light soils. (Abs.)	177	Moreno P., J. and Lodos, J. Spanish-	
Mallion, A.K., see Barba, R.C.		Mazur, O.I., see Silina, N.P.		Russian dictionary for the sugar	
Malý, A. Invert sugar and syrup		Medeiros, J.E., see Andren, R.K.		industry. (NB)	90
manufacture. (Abs.)	345	Medina, F.J. Cane milling at El		Morrell, F., I. <i>et al.</i> Yeast plant	
Malyuk, V.F., see Zakharov, K.P.		Potrero factory. (Abs.)	213	operation economics. (Abs.)	222
Mandel'shtein, M.L., see Petrunya,		Medved, M., see Hrivniak, J.		see also Hernández, S., P.	
V.I.		Mee, D.H. Juice level control in an		Morten, H., see Vyse, J.	
Manhães, M.S. <i>et al.</i> Fertilizer trials		evaporator. (Abs.)	88	Mortlock, R.E., see Hunt, D.C.	
in Brazil. (Abs.)	369	Meeus, P. Powdery mildew control.	212	Morton, C. Mechanical cane planting.	79
Mannivannan, K. Bagasse and cane		Mehta, V.C. and Gomkale, S.D.		Moskalev, B.N., see Dovgopol, V.I.	
molasses fermentation. (Abs.)	252	Calcium carbonate recovery from		Moskowitz, G.J., see West, I.R.	
Mansi, M.G., see Abu-Zeid, M.O.		filter cake. (Abs.)	350	Mourão, C.A., see Saraceni, N.G.	
Mantovani, G. Evaporator		Melaja, A.J. <i>et al.</i> Dextrose and		Mukerji, N. Beet agriculture in	
crystallization. (Abs.)	54	levulose separation. (Pat.)	28	Rajasthan. (Abs.)	84
<i>et al.</i> Impurities effects on sucrose		Meleshko, V.P. <i>et al.</i> Beet juice ion		Mukherjee, K.C., see Bose, S.	
crystallization. (Abs.)	58	exchange treatment. (Abs.)	183	Müller, G., see Cronewitz, T. and	
see also Marignetti, N.		Mel'nikov, E.M., see Karchik, S.N.		Schweck, H.	
Manzke, E., see Christoph, D.		Mendes, A. de C. <i>et al.</i> Weather effect		Müller, H.J. Rainfall effect on	
Marchenko, O.P. Disc filter seal.	249	on froghopper population. (Abs.)	208	nitrogen influence on beet yield.	246
Marcondes, D.A.S., see Brinholi, O.		see also Botelho, P.S.M. and		Mumford, D.L. Curly top control.	276
Marie-Jeanne, S. Waste water solids		Macedo, N.		Munir, M. Sugar recovery from	
separation. (Abs.)	155	Mendonça, A.F. <i>et al.</i> Borer parasite.	208	molasses by liquid distribution	
Marignetti, N. and Mantovani, G.		Mendoza, P.C., see Mariotti, J.A.		chromatography. (Abs.)	345
Carbonatation gas utilization		Meng, K.J., see Mason, V.		Murashko, E.I., see Eremenko, B.A.	
efficiency. (Abs.)	88	Menon, T.K.K. and Nair, V.C. Cane		Murata, D. and Gibson, W. Factory	
Marimuthu, P., see Chinnaaswamy, A.P.		molasses and masscuite analysis.	58	bagasse and trash consumption in	
Marín, P., A., see Díaz M., R.		Menshaw, Z.A. Cane flowering and		Hawaii and power generation	
Marinho, M.L. and Albuquerque,		apex chemical composition. (Abs.)	176	potential. (Abs.)	21
G.A.C. Extractable phosphorus in		Cane flowering control. (Abs.)	148	Murgov, I., see Popova, Z.	
Brazil soils. (Abs.)	145	Cane flowering induction in Egypt.	152	Murry, C.R., see Dullow, R.J.	
Mariotti, J.A. Cane breeding research		Mercier, A. Continuous centrifugal.	61	Murty, M.S., see Rao, A.V.	
in Argentina. (Abs.)	152	Meredith, T.W., see Whayman, E.		Murugar, V.M. and Lakshminarayan,	
<i>et al.</i> Cane breeding in Argentina.	51	Messem, A., see Draycott, P.		J. Intermediate carrier shaft	
— Varietal 'stability' and cane yield	51	Meyer, J.H., see Moberly, P.K.		breakage. (Abs.)	53
— Visual selection of cane clones.	51	Mialhe, L.G. Cane planter. (Abs.)	305	Muthusamy, S., see Lewin, H.D.	
Markitan, S.V., see Dovgopol, V.I.		see also Ripoli, T.C.		Myhre, D.L., see Shih, S.F.	
Markes, E.J. Cane leaf froghopper		Miles, W.G. <i>et al.</i> Beet rotting fungi			
biology. (Abs.)	151	control. (Abs.)	212		
Márquez, F.R., see Chinaea, A.		Miletic, R. Beet crown and root			
Marshall, K., see Diplock, R.		composition. (Abs.)	92		
Martens, M. Beet sampling for yield		Milic, M. Beet diffusion losses caused			
prediction. (Abs.)	246	by micro-organisms. (Abs.)	88		
Martin, D.F., see King, E.G.		Mil'kova, Z.A. <i>et al.</i> Potassium lactate			
Martin, F.A. Cane frost damage assess-		effect on sulphitation juice. (Abs.)	92		
ment by juice acidity measurement.	124	Millard, E.W., see Hadlow, W.			
Martín B., J., see Darias P., M.		Miller, J.D. <i>et al.</i> Post-harvest cane			
Martínez, J.F., see Julien, M.H.R.		deterioration. (Abs.)	176		
Martínez G., A. and Cienfuegos I., F.		Miller, K.F. and Wright, P.G. C-sugar			
Cane cultivation experimental		purity control. (Abs.)	343		
analysis. (Abs.)	145	Millhollon, R.W. Chemical control of			
Martínez G., F., see Abreu G., J.		Johnson grass. (Abs.)	145		
Maruschchenko, M.A., see		Germination of <i>Rottboellia exaltata</i> .	111		
Bondarenko, N.F.		see also Loupe, D.T.			
Marchenfabrik Buckau R. Wolf AG,		Miocque, J.Y.J. and Machado, G.R.			
see Buckau R. Wolf AG.		Cane breeding and varietal in Brazil.	117		
Mason, V. <i>et al.</i> Cane harvester		Miroshnik, V.A., see Tregub, V.G.			
performances. (Abs.)	340	Mishoe, J.W., see Shih, S.F.			
Massey-Ferguson Services N.V., see		Mishra, S.P. Carbonatation vessel and			
Quick, D.J.		low-pressure filtration system.	53		
Masuda, Y. and Tokeshi, H. Leaf		Phosphatation. (Abs.)	87		
scald diagnosis. (Abs.)	306	Miskiewicz, T. and Lesniak, W.			
Math, B.R., see Chatterjee, A.		Dissolved oxygen effect on yeast			
Matherne, R.J. and Irvine, E.J.		manufacture from molasses. (Abs.)	94		
Influence of row spacing on cane		<i>et al.</i> Dissolved oxygen effect on yeast			
stalk population, sugar content		manufacture from molasses. (Abs.)	94		
and yield. (Abs.)	206	Misra, S.R., see Singh, K.			
Mathieu, C. and Hesse, F.W. Soil		Mit'kova, M.M., see Meleshko, V.P.			
salinity and beet quality. (Abs.)	211	Mittal, R.P. Micro-organisms in cane			
Mathisnoen, P. Press for beet		mills. (Abs.)	119		
extraneous matter. (Abs.)	221	Mobarak, F., see el-Ashmawy, A.E.			
Mathur, B.K. Cane agricultural		Moberly, P.K. and Meyer, J.H.			
practices. (Abs.)	239	Filter cake as fertilizer. (Abs.)	339		
and Nath, A. CoS 758 cane variety.	372	and Turner, P.E.T. Minimum			
Matic, M. <i>et al.</i> Refinery melt		tillage system of cane cultivation.	146		
phosphatation. (Abs.)	184	Mochtar, M. Single- vs. multi-tray			
Matsui, E., see Ruschel, A.P.		clarifier performance. (Abs.)	179		

# INDEX

	page		page		page
Nechitailo, V.N. and Zubchenko, V.P.		Ometto, J.C. Cane yield estimation in Brazil. (Abs.)	110	Pavlyuchenko, L.N., see Shvets, V.N.	
Cossette cross-section area calculation for ribless knives. (Abs.)	23	Onat, G., see Nuh, C.		Pawar, B.B. <i>et al.</i> Low-grade continuous centrifugal performance. (Abs.)	85
Nedelkovits, J. and Fabian, K.		Onádrák, M., see Zahradníček, J.		Payne, J.H. Factory performance improvement policy in Brazil.	310
Carbonatation and evaporation effects on beet juice glutamine.	91	O'Neill, I.K., see Cox, G.B.		Paz-Vergara P., E. Drip irrigation.	368
Nee, C.I. and Yee, W.F. Dextrose recovery from bagasse pith hydrolysate. (Abs.)	381	Onishi, T., see Sakamaki, S.		Peirce, R.D., see Dullow, R.J.	
Nelson, J.M. Nitrogen and planting and harvest date effects on beet yield and sugar content. (Abs.)	307	O'Reilly, J.P. and Pérez M., J.R.		Peixoto, A.A., see Manhães, M.S.	
Nemirovskaya, S.L. <i>et al.</i> Automatic beet juice flow control. (Abs.)	346	Nematodes in Cuba. (Abs.)	150	Pembroke, E.A. Soil copper deficiency. (Abs.)	14
Ness, J.N., see Player, M.R.		Orlando, J. and Zambello, E. Soil and variety effects on cane leaf Cu, Fe, Mn and Zn contents. (Abs.)	14	Peña, M.V., see Rodríguez, A.	
Neto, P.B. Alcohol vs. sugar production costs in Brazil. (Abs.)	381	<i>et al.</i> Effect of variety and soil on cane leaf nutrient status. (Abs.)	112	Pence, N.E., see Westfall, D.G.	
Neto, S.S., see Botelho, P.S.M. and Mendes, A. de C.		see also de Bittencourt, V.C. and Ruschel, A.P.		Peng, S.Y. and Twu, L.T. Cane growth regulator trials. (Abs.)	206
Neto, V.L.F., see Fernandes, J.		Orlov, L.A., see Zaborsin, A.F.		Penniman, J.G., see Freeland, D.V.	
Newton, R.B., Cane tipper bin trailer. (Abs.)	80	Osa, J.M., see Mariotti, J.A.		Pereira, J.F.G. Cane sample preparation. (Abs.)	187
Niculescu, E. and Stefanescu, A.		Oshiro, S., see Hokama, K.		see also da Glória, N.A.	
Mechanical beet seed harvesting.	308	O'Sullivan, M. Beet nitrogen compounds and quality. (Abs.)	218	Pereira, T.G., see Pimenta, T.G.	
Nielsen, W.K. Beet thick juice treatment in centrifuges. (Abs.)	88	Oswald, R., see Cepelák, J.		Pérez, C., see Carranza, R., L.	
see also Winström-Olsen		Owianowski, R., see Rudolph, K.		Pérez, J.L., see Duarte P., E.	
Nielson, A.K., see Miles, W.G.		Qayarbal, E.S., see Mariotti, J.A.		Pérez, M.E., see Hernández, N.M.T.	
Niemeyer, R.H., see Brokensha, M.A.		Özdemir, R., see Taygun, N.		Pérez, M.L., see Herrera, Z.	
Nikam, B.K., see Patil, J.P.		Ozeki, T. and Ishida, M. Automatic refining control. (Abs.)	314	Pérez, M.R., see González, L.	
Nikiel, S. Sugar manufacture (NB)	280	Palanchamy, K., see Batcha, M.B.G.R.		Pérez de A., H. and Friedman, P.	
Nimbalkar, J.D. and Naik, G.R.		Pan, Y.C. and Lee, Y.P. Cane ripening with "Polaris". (Abs.)	174	Sugar factory mathematical simulation. (Abs.)	67
Fungicide and growth promoters effects on cane height. (Abs.)	15	see also Baggase furnace ash as fertilizer. (Abs.)	109	Pérez G., R. <i>et al.</i> Effect of borer attack on cane yield. (Abs.)	151
see also Naik, G.R.		see also Lim, G.T.		Pérez M., J.R., see O'Reilly, J.P.	
Nirula, K.K. Leafhopper pesticide toxicity determination. (Abs.)	50	Pan, Y.S. and Yang, S.L. Cane varietal borer resistance. (Abs.)	150	Pérez M., M.R., see González C., L.	
Noa S., H. Cane by-products utilization. (Abs.)	252	Pandey, B.N., see Agrawal, M.L.		Pérez M., M.R., see González C., L.	
Noble, A.G. and Brotherton, G.A.		Pandey, K.N., see Srinivasan, S.		Pérez M., M.R., see González C., L.	
Pumping effect on clarification mud filtration. (Abs.)	344	Pang, K.S., see Lim, G.T.		Pérez M., M.R., see González C., L.	
see also Egan, B.T. and Stewart, P.N.		Pant, G.B., see Bhatnagar, P.S.		Pérez M., M.R., see González C., L.	
Nossier, M. and Anderson, R. Cane area surveying by satellite. (Abs.)	144	Pantuso N., F. Massacuite consistency measurement. (Abs.)	216	Pérez M., M.R., see González C., L.	
Nour, A.H., see Allam, A.I.		and Polonik, V.S. Massacuite crystal content determination.	219	Pérez M., M.R., see González C., L.	
Nova, N.A.V. <i>et al.</i> Cane water requirement determination. (Abs.)	369	Paranhos, S.B., see Castro, P.R.C.		Pérez M., M.R., see González C., L.	
Novaretti, W.R., see Teran, F.O.		Parish, R.S., see Wilson, J.F.		Pérez M., M.R., see González C., L.	
Novoseletska, V.D., see Zagorul'ko, A.Y.		Parker, K.J., see Birch, G.G.		Pérez M., M.R., see González C., L.	
Nowakowski, S., see Koziol, K.		Parkhod'ko, A.P. KDA-30-66 beet tower diffuser modification. (Abs.)	249	Pérez M., M.R., see González C., L.	
Nowatzky, H. Thin-film juice filter.	88	Prelimer. (Abs.)	277	Pérez M., M.R., see González C., L.	
Nuh, C. and Onat, G. Austria beet agriculture. (Abs.)	177	see also Andrianov, I.O.		Pérez M., M.R., see González C., L.	
Núñez, T., G. and Díaz de A., C.		Parkhomets, A.P. <i>et al.</i> Waste water COD determination. (Abs.)	92	Pérez M., M.R., see González C., L.	
Ash determination in cane molasses and yeast. (Abs.)	58	Parsons, D.K., see Frazer, L.J.		Pérez M., M.R., see González C., L.	
Nurok, D. and Reardon, T.J. Sucrose determination by gas-liquid chromatography. (Abs.)	58	Partridge, J.R. Cane mill gears.	374	Pérez M., M.R., see González C., L.	
Nuss, K.J. Floral induction for cane breeding. (Abs.)	152	Pasechnik, V.P. <i>et al.</i> Carbonation vessel. (Abs.)	218	Pérez M., M.R., see González C., L.	
		Pasricha, B. Cane quality effect on processing. (Abs.)	20	Pérez M., M.R., see González C., L.	
		Patel, A.J., see Shah, A.H.		Pérez M., M.R., see González C., L.	
		Patel, D.K., see Tembhekar, V.V.		Pérez M., M.R., see González C., L.	
		Patil, M.H. Beet agriculture in Gujarat. (Abs.)	246	Pérez M., M.R., see González C., L.	
		Patil, A.O., see Bachchhav, M.B.		Pérez M., M.R., see González C., L.	
		Patil, A.S. <i>et al.</i> Shoot borer and white grub control. (Abs.)	16	Pérez M., M.R., see González C., L.	
		see also Moholkar, P.R.		Pérez M., M.R., see González C., L.	
Oberoi, D.S. and Singh, H.G. Beet agronomy for high yield. (Abs.)	17	Patil, B.R., see Chougule, J.D.		Pérez M., M.R., see González C., L.	
Ocampo S., G. <i>et al.</i> Furfural manufacture from bagasse. (Abs.)	253	Patil, J.P. <i>et al.</i> Cane intercropping with maize. (Abs.)	370	Pérez M., M.R., see González C., L.	
Očenašková, J., see Schmidt, L. and Zahradníček, J.		— Cane varietal response to nitrogen.	238	Pérez M., M.R., see González C., L.	
Odorod'ko, N.I., see Bobrovnik, L.D. and Kozyavkin, A.P.		Patil, K.D., see Chougule, J.D.		Pérez M., M.R., see González C., L.	
Ogorodnikov, A.N., see Shvets, V.N.		Patil, M.K. Alcohol manufacture in India. (Abs.)	252	Pérez M., M.R., see González C., L.	
Okada, M., see Akiyama, K.		see also Dubey, R.S.		Pérez M., M.R., see González C., L.	
Oldemeyer, R.K. <i>et al.</i> Variety and harvest date effects on beet yield and quality. (Abs.)	18	Patil, R.T. and Chavan, J.B. Reduced boiling house recovery calculation.	348	Pérez M., M.R., see González C., L.	
see also Erichsen, A.W. and Suzuki, A.		Patil, S.N., see Pawar, B.B.		Pérez M., M.R., see González C., L.	
Oldfield, J.F.T. <i>et al.</i> Beet diffuser midbay acidification. (Abs.)	279	Patil, S.P. <i>et al.</i> Filter cake as fertilizer. (Abs.)	239	Pérez M., M.R., see González C., L.	
Beet juice quality and factory performances in the UK. (Abs.)	279	see also Bawasakar, V.S.		Pérez M., M.R., see González C., L.	
The Quentin process.	103, 138	Patil, S.S., see Patil, J.P.		Pérez M., M.R., see González C., L.	
Olea, I.L., see Arévalo, R.A.		Patil, V.D., see Patil, J.P.		Pérez M., M.R., see González C., L.	
Oledzki, J. <i>et al.</i> Mass flow coordination in a beet sugar factory.	375	Pitkai, G., see Vukov, K.		Pérez M., M.R., see González C., L.	
Oleinik, D.P., see Zagorul'ko, A.Y.		Paton, N.H. Phenolic acids identification in cane leaves, juice and raw sugar. (Abs.)	124	Pérez M., M.R., see González C., L.	
Oleinikova, A.Y., see Buravleva, V.I. and Zubchenko, A.V.		<i>et al.</i> Cane leaf flavonoid photography. (Abs.)	152	Pérez M., M.R., see González C., L.	
Oliveira, A.R. <i>et al.</i> Cane leaf scald detection. (Abs.)	149	see also Daniels, J.		Pérez M., M.R., see González C., L.	
Oliveira, E.R., see Fernandes, A.C.		Paturau, J.M. Bagasse and cane molasses utilization. (Abs.)	59, 252	Pérez M., M.R., see González C., L.	
Oliveira, F.F.S., see Cesnik, R.		Cane by-products utilization.	126	Pérez M., M.R., see González C., L.	
Omate, O.O. and Sephton, H.H.		Paty, W.W. Cane mechanization personnel training. (Abs.)	113	Pérez M., M.R., see González C., L.	
Evaporation of cane juice containing surfactant. (Abs.)	120	Paul, B.B. Poultry feed and fertilizer production from vinasse. (Abs.)	252	Pérez M., M.R., see González C., L.	
		Paulais, A.M. Beet pulp as animal fodder. (Abs.)	252	Pérez M., M.R., see González C., L.	



# INDEX

	page		page		page
Ponomarenko, A.A., <i>see</i> Zagorul'ko, A.Y.		Rantanen, L., <i>see</i> Melaja, A.J.		Ricaud, C. <i>et al.</i> Cane leaf scald detection. (Abs.) . . . . .	149
Pons, M., R. Heat transfer in deformed tubes. (Abs.) . . . . .	21	Rao, A.V. and Murty, M.S. Scale insect effect on cane. (Abs.) . . . . .	50	— Yellow spot in Mauritius. (Abs.) . . . . .	341
Poole, H.G. Weight transfer tractor system for cane transport. (Abs.) . . . . .	241	Rao, B.H.K. Scale insect incidence, damage to cane and control. (Abs.) . . . . .	50	<i>see also</i> Benda, G.T.A.	
Pop, E., <i>see</i> Stanescu, Z.		Rao, B.J., <i>see</i> Rao, K.K.P.		Ricaud, R. Effect of subsoiling on soil compaction and cane yield. . . . .	111
Popov, V.D., <i>see</i> Tregub, V.G.		Rao, B., <i>see</i> Rao, P.N.		<i>see also</i> Curtis, O.D.	
Popova, Z. and Murgov, I. Valine synthesis from beet molasses. (Abs.) . . . . .	350	Rao, B.V., <i>see</i> Rao, B.Y.	254	Rice, E.R., <i>see</i> Kiddier, G.	
Popovich, V.V., <i>see</i> Chekal', A.I.		Rao, G.H.P., <i>see</i> Ramaiah, B.B.		Richard, B., <i>see</i> Giorgi, J.C.	
Populin, L., <i>see</i> Populin, P.		Rao, G.N., <i>see</i> Ramaiah, B.B.		Richard, C.A. CP 70-321 and	
Portal, A., <i>see</i> Hernández N., M.T.		Rao, G.S.C. and Gupta, A.P.		CP 70-330 cane varieties. (Abs.) . . . . .	342
Portal, G., <i>see</i> Alemán, R.		Influence of manganese on cane leaf amino-acids. . . . .	99	Wide furrow planting and cane yields. (Abs.) . . . . .	368
Portela, E. <i>et al.</i> Vitamin A addition to sugar. (Abs.) . . . . .	179	Rao, G.S.G., <i>see</i> Gupta, A.P.		<i>et al.</i> Cane varietal trials in Louisiana. . . . .	342
Porter, R.G., <i>see</i> Kelly, P.S.		Rao, G.V.S., <i>see</i> Rao K.K.P.		Richards, G.N., <i>see</i> Covacevich, M.T.	
Pottage, P.R., <i>see</i> Bennett, M.C.		Rao, H.K.S. <i>et al.</i> Cane mutation breeding. (Abs.) . . . . .	117	Richardson, F.E. Chemical weed control. (Abs.) . . . . .	145
Rundell, J.T. and Tilbury, R.H.		Rao, J.P., <i>see</i> Rao, K.K.P.		Ridge, D., <i>see</i> Henkel, C.R.	
Powers, H.E.C. Sugar crystallization. . . . .	280	Rao, J.T., <i>see</i> Rao, T.C.R.		Riffer, R., <i>see</i> Freeland, D.V.	
Prado, F.E. <i>et al.</i> Cane leaf sheath enzyme. (Abs.) . . . . .	174	Rao, K.C. Cane varieties and harvest and planting times in India. . . . .	304	Ripoli, T.C. <i>et al.</i> Cane mineral content estimation. (Abs.) . . . . .	281
Prakash, J., <i>see</i> Joshi, R.D.		and Asokan, S. Cane proline content and drought resistance. . . . .	244	— Evaluation of cane field condition. . . . .	271
Prasad, M. <i>et al.</i> Sulphur dioxide determination in white sugar. . . . .	58	— Cane ripening with "Polaris". . . . .	48	<i>see also</i> Gentil, L.V.B.	
<i>see also</i> Sinha, S.N.		Rao, K.H., <i>see</i> Gupta, K.K.		Risco, B., S.H. Borer control in Brazil. . . . .	209
Prasadaro, K.K. <i>et al.</i> Varietal reaction to red rot. (Abs.) . . . . .	116	Rao, K.K.P. <i>et al.</i> CoA 7601 cane variety. (Abs.) . . . . .	83	<i>see also</i> Mendonça, A.F.	
<i>see also</i> Rao, K.K.P.		— CoA 7701 cane variety. (Abs.) . . . . .	83	Rishi, N. and Nath, P. Ratoon stunting disease bacterium. (Abs.) . . . . .	273
Pražák, M., <i>see</i> Šárka, E.		<i>see also</i> Prasadaro, K.K.		Rivas, N., G. Cane harvester base cutter standards. (Abs.) . . . . .	113
Prey, V. Sugars esters preparation. . . . .	283	Rao, K.L., <i>see</i> Rao, K.K.P.		Rizescu, G. Irrigation and nitrogen effects on beet sugar yield. (Abs.) . . . . .	308
<i>see also</i> Andres, H.		Rao, M.A., <i>see</i> Sarma, M.N.		Rizo, J.J., <i>see</i> Kolesnikov, V.I.	
Price, G. Cane nutrient requirement assessment by soil and plant analysis. . . . .	304	Rao, P.J.M. Improving fuel utilization efficiency. (Abs.) . . . . .	311	and Yarnit, D.P.	
Primak, V.M. <i>et al.</i> Carbonatation. . . . .	183	Mini-plants for bagasse paper production. (Abs.) . . . . .	126	Rizzi, G.P. and Taylor, H.M. Sucrose ester. (Pat.) . . . . .	284
Prikhod'ko, I.A., <i>see</i> Remeslo, N.V.		Power generation in Indian sugar factories. (Abs.) . . . . .	52, 248	Rizzuto, A.B., <i>see</i> Skole, R.D.	
Prilikho, L.T., <i>see</i> Shvets, V.N.		Rao, P.N. and Rao, B.R. Recommended cane agricultural practices for India. (Abs.) . . . . .	271	Roach, B.T. Cane breeding. (Abs.) . . . . .	342
Prilutskii, I.I. and Lyubarets, P.A.		Rao, P.N.R. and Ghosh, S.K. Heat economy in sugar factories. (Abs.) . . . . .	154	Cane nobilization with <i>Saccharum spontaneum</i> . (Abs.) . . . . .	118
Sugar dust separation. (Abs.) . . . . .	22	Rao, P.S., <i>see</i> Walker, D.I.T.		<i>see also</i> Daniels, J.	
Pritoni, G. <i>et al.</i> Herbicide and soil disinfectant effects on beet. . . . .	245	Rao, S.N.G., <i>see</i> Dubey, R.S.		Robella, I., <i>see</i> Casanova, E.	
Process Evaluation & Development Corp., <i>see</i> Villavicencio, E.J.		Rao, T.C.R. and Rao, J.T. Character inheritance in <i>Saccharum robustum</i> hybrids. (Abs.) . . . . .	153	Roberts, E.J. and Godshall, M.A. Flocculation by polysaccharide and protein. (Abs.) . . . . .	379
Procter & Gamble Co., <i>see</i> Rizzi, G.P.		Rao, T.K.G., <i>see</i> Venkatamam, K.		<i>et al.</i> Polysaccharide removal in refining. (Abs.) . . . . .	314
Produits Chimiques Ugine Kuhlmann, <i>see</i> Teissier, R.		Rastogi, K.B., <i>see</i> Saini, S.S.		<i>see also</i> Clarke, M.A. and Godshall, M.A.	
Prudhomme, R.O., <i>see</i> Le Mao, J.		Rathi, K.S. <i>et al.</i> Cane intercropping and planting effects on yield and quality. (Abs.) . . . . .	48	Robertson, A.D. Molasses loss reduction by alcohol treatment. (Abs.) . . . . .	349
Pukallus, G.F. and Roseler, A.K.		Ratts, K.W. Chemical cane ripening. . . . .	284	Robertson, L.S., <i>see</i> Wang, C.C.	
Cane train proximity sensor. (Abs.) . . . . .	340	Ravnó, A.B., <i>see</i> McMaster, L.		Robichaux, H., <i>see</i> Richard, C.A.	
Pushanko, N.N. <i>et al.</i> Ring-type beet diffuser. (Abs.) . . . . .	249	Ray, S.C. and Jain, P.F. Cane wax hydrogenation. (Abs.) . . . . .	93	Robson, F. and Flack, M. Newark factory modernization and expansion. . . . .	41, 72
Pyshnyak, V.V., <i>see</i> Reva, L.P.		<i>see also</i> Sivaraman, R.		Roca G., A., <i>see</i> Almazán del O., O.	
		Reardon, T.J., <i>see</i> Nurok, D.		Roche, M. Diffusion juice purity determination. (Abs.) . . . . .	376
		Reddy, M.R. <i>et al.</i> Nitrogen and soil water depletion effects on cane water utilization. (Abs.) . . . . .	239, 240	Rodella, A.A., <i>see</i> da Glória, N.A.	
		Reddy, S.C., <i>see</i> Reddy, M.R.		and Ferrari, S.E.	
		Reeves, S.A. Cane varietal trials in Texas. (Abs.) . . . . .	51	Rodriguez, A., <i>et al.</i> Factory product colloid content determination. . . . .	187
		Chemical weed control. (Abs.) . . . . .	146	Rodriguez, F.A., <i>see</i> Acosta, B. R.	
		Reghenzani, J.R. Cane weigher. . . . .	340	Rodriguez, L.B. <i>et al.</i> Cane preparation with the "Unigrator". (Abs.) . . . . .	52, 311
		Reichardt, K., <i>see</i> Fernandes, J.		Rodriguez, B., M. and Polonik, V.	
		Reichman, G.A. <i>et al.</i> Irrigation and water table depth effects on beet yield and quality. (Abs.) . . . . .	18	Boiling mathematical modelling. . . . .	216
		Reinefeld, E. <i>et al.</i> Changes in dextrose: levulose concentration ratio in factory products. (Abs.) . . . . .	57	Roelants, W., <i>see</i> Rousel, N.	
		Reitor, A., N., <i>see</i> Hernández S., P.		Roger, J., <i>see</i> Devillers, P. and Detavernier, R.	
		Remeslo, N.V. <i>et al.</i> Nucleoside melassigenesis. (Abs.) . . . . .	281	Rogowska, M. and Węgrzynowski, Z.	
		Rendos, I., <i>see</i> Caplovic, J.		Diffusion water acidification. (Abs.) . . . . .	346
		Rens, G. White sugar grist determination. (Abs.) . . . . .	251	Rohm & Haas Co., <i>see</i> Barrett, J.H. and Pollio, F.X.	
		Research Corporation, <i>see</i> Willett, J.D.		Romenskii, N.P. Beet diffuser corrosion prevention. (Abs.) . . . . .	87
		Reva, L.P. and Simakhina, G.A.		Rosado, E. and Batiz, H. Cane molasses and fermented mash analysis by gas-liquid chromatography. . . . .	57
		Optimum alkalinity determination in preliminary. (Abs.) . . . . .	92	Rosales, L., A., <i>see</i> Pérez, G., R.	
		<i>et al.</i> Prelim. (Abs.) . . . . .	183	Rosario, E.L. and Sooksatthan, K.	
		<i>see also</i> Fedotkin, I.M. and Silina, N.P.		Fertilizer and plant age effects on cane nitrate reductase activity. . . . .	176
		Reynoso, R.Y., <i>see</i> Ehlig, C.F.		<i>et al.</i> Fertilizer effect on cane leaf area index, quality and yield. . . . .	176
		Reznik, K.E. and Vitvitskii, V.D.		— Nitrogen x cane variety interaction on leaf growth. (Abs.) . . . . .	147
		Carbonatation pH stabilization. . . . .	218	Roseler, A.K., <i>see</i> Pukallus, G.F.	
		Rhone-Poulenc S.A. Dextrose isomerization to levulose. (Pat.) . . . . .	317	Rostron, H. Cane ripening with "Ethrel". (Abs.) . . . . .	174, 175
		Ribouleau, E.A.H. Beet drill. (Pat.) . . . . .	317	Roth, J.P. and King, E.G. Cane borer parasite larviposition. (Abs.) . . . . .	150
		Ricaud, C. Cane growth abnormality in Senegal. (Abs.) . . . . .	273	Rouillard, E.E.A. Crystallizer design for massecuite cooling and reheating. (Abs.) . . . . .	156
		CP 70-321 and CP 70-330 cane varieties. (Abs.) . . . . .	372	Roussel, N. <i>et al.</i> Beet varietal trials in Belgium. (Abs.) . . . . .	309
		and Félix, S. Cane streak virus strains . . . . .	149	Roy, E.P. <i>et al.</i> Raw cane sugar hedging. (NB) . . . . .	55
Quaquarelli, S., <i>see</i> Pritoni, G.					
Quick, D.J. Cane harvester billet elevator. (Pat.) . . . . .	60				
Cane harvester trash separator. . . . .	28				
Cane harvesters. (Pat.) . . . . .	60				
Quintero, N., <i>see</i> Hernández N., M.T.					
Quiroga, E., <i>see</i> Sampietro, A.R.					
Radford, D.J., <i>see</i> Graham, W.S.					
Radhakrishnan, C.M., <i>see</i> Kandasami, P.A.					
Rae, J.F., <i>see</i> Blackburn, I.D.					
Raffinerie Trelmontoise, Vinasse-beet pulp mixture as animal fodder. . . . .	317				
<i>see also</i> Pinet, C.H.J.					
Raha, A.C. Juice settling rates. (Abs.) . . . . .	179				
Rahul, R.M., <i>see</i> Joshi, N.N.					
Rai, Y., <i>see</i> Thakur, K.					
Rainey, D.P., <i>see</i> Eaton, B.J.					
Raj, B., <i>see</i> Bhatnagar, P.S.					
Raj, M., <i>see</i> Vadehra, D.V.					
Raju, J.S.N., <i>see</i> Rao, K.K.P.					
Ramachandra, J.T., <i>see</i> Shanappa, B.					
Ramaiah, B.B. <i>et al.</i> "Bud chip" cane sets. (Abs.) . . . . .	147				
Ramaiah, N.A. and Gupta, H.N.					
Electrical massecuite reheater. . . . .	120				
Ramakrishnan, K., <i>see</i> Alexander, K.C.					
Ramalingam, A. Vacuum vs. pressure fermentation of molasses. (Abs.) . . . . .	27				
Ramamani, K.S. Boiler feed water treatment. (Abs.) . . . . .	338				
Ramchandran, G. Cane physiology and soil analysis. (Abs.) . . . . .	338				
Ramirez, D.A., <i>see</i> Diviniagracia, N.S. and Engle, L.M.					
Ramos, E.L., <i>see</i> Rodriguez, A.					
Ranadive, S.J., <i>see</i> Bawasakar, V.S., Patil, J.P. and Patil, S.P.					
Randolph, A.D. and Tan, C.S.					
Continuous boiling. (Abs.) . . . . .	216				
Ransomes Sims & Jefferies Ltd.					
Beet harvester. (Pat.) . . . . .	285, 316				

# INDEX

	page		page		page
Rozoff, N. Cane burning in Texas. . . . .	296	Sarma, M.N. and Rao, M.A. Cane varietal reactions to red rot biotypes. (Abs.) . . . . .	50	Sharma, R.G. Clonal planting of cane. 238	
Rudolf, V.T., see Tsyukalo, Y.F.		see also Prasadarao, K.K.		Sharma, R.K., see Sharma, R.A.	
Rudd, A.V. Soil drainage inadequacy and cane yield. (Abs.) . . . . .	15	Sasaki, K. <i>et al.</i> Refinery liquor decolorization by adsorbent resin. 377		Sharma, S.C. Non-sugars effect on cane juice settling. (Abs.) . . . . .	180
see also Chardon, C.W.		Sath, M.N. "Bud chips" cane planting. 271		Sharma, S.R., see Sharma, R.A.	
Rudd, P., see Jones, C.D.		Sathyanarayana, Y., see Prasadarao, K.K. and Rao, K.K.P.		Shcherbakov, A.M., see Belik, V.G.	
Rudnichenko, L.V., see Il'ina, L.D.		Sawyer, G.M. and Cullen, R.N. Furnace ash handling systems in Queensland. (Abs.) . . . . .	120	Shehata, Y.M., see Madi, A.	
Rudolf, H. <i>et al.</i> Factory laboratory data processing by computer. (Abs.) 313		Sayed, G. El-K. <i>et al.</i> Losses from delay in milling burnt and cut cane. 156		Shrikh, N.M. and Hossain, M. Dextran fermentation of sucrose. (Abs.) . . . . .	125
Rudolph, K. <i>et al.</i> Alcohol fermentation of cane. (Abs.) . . . . .	253	see also Hemaída, S. El-N.A.		Shen, I.S., see Lo, C.C.	
Rudy, H., see Hustedé, H.		Scalia, G., see Populin, P.		Shepherd, G.S. Clarification with flocculants. (Abs.) . . . . .	378
Ruiz, J., see Llerena, E.		Scandaliaris, J., see Mariotti, J.A.		see also Matic, M.	
Ruiz G., M.C., see Darias, P., M.		Scardua, R., see Leme, E.J. de A.		Sheu, Y.S. <i>et al.</i> Soil oxygen content and cane growth. (Abs.) . . . . .	369
Rumawas, F., see Kuntoharton, T.		Nova, N.A.V. and Sousa, J.A.G.C.		Shevchenko, A., see Hernández, N., M.T.	
Rundell, J.T. and Pottage, P.R. Clarification with flocculant. (Pat.) 28		Schäffler, K.J. Continuous entrainment monitoring. (Abs.) . . . . .	378	Shewale, B.S., see Moholkar, P.R. and Patil, A.S.	
et al. Clarification with flocculants. 215		and Smith, I.A. Sucrose vs. pol. balances. (Abs.) . . . . .	349	Shibosato, M. Levulose determination. 315	
see also Bennett, M.C.		see also Brokensha, M.A. and Morel du Boil, P.G.		Shih, S.C., see Liu, M.C. and Lo, C.C.	
Rungkas, F.M. Flocculant application. (Abs.) . . . . .	377	Schaper, H. Continuous centrifugal. 61		Shih, S.F. <i>et al.</i> Soil water management in Florida. (Abs.) . . . . .	111
see also Matic, M.		Scharbert, F., see Schwind, H.		Shilova, M.A., see Smirnova, L.K.	
Ruppel, A.G., see Hecker, R.J.		Scharpf, H.C. and Wehrmann, J. Nitrogen application rate optimization. (Abs.) . . . . .	211	Shimabuku, M. and Higa, K. Varietal sunlight utilization efficiency and cane yield. (Abs.) . . . . .	153
Ruschel, A.P. and Ruschel, R. Cane nitrogenase activity. (Abs.) . . . . .	206	Schaufele, W.R. and Winner, C. Chemical weed control. (Abs.) . . . . .	245	Shingur, A.G., see Kozaykin, A.P.	
et al. Cane nitrogen fixation and fertilizer uptake. (Abs.) . . . . .	148	Schewe, L.R., see Sullivan, J.E.		Shirakawa, S., see Yamaga, J.	
– Effect of N-fixing bacteria on cane root nitrogenase activity. . . . .	176	Schiweck, H. <i>et al.</i> Water determination in molasses, syrup and white sugar. (Abs.) . . . . .	91	Shishoda, O.P.S., see Agarwal, M.L.	
– Fertilizer and irrigation effects on cane root nitrogenase activity. 176		see also Burcky, K. and Cronewitz, T.		Shokrani, R. and Delavier, H.J.	
Ruschel, R. Phenotypic stability of Brazil cane varieties. (Abs.) . . . . .	210	Schmalz, K., see Hurney, A.P.		Beet and cane diffusion. (Abs.) . . . . .	217
see also Pimenta, T.G. and Ruschel, A.P.		Schmidt, L. <i>et al.</i> Beet varietal trials in Czechoslovakia. (Abs.) . . . . .	309	Shore, M., see Oldfield, J.F.T.	
Rushdi, M.H., see Higgy, A.M.		Schmidt, R., see Schwind, H.		Shstageev, V.O., see Trebin, L.I.	
Ruzicka, J. <i>et al.</i> Beet dirt and stone separators. (Abs.) . . . . .	277	Schoenrock, K.W.R. <i>et al.</i> Beet juice ion exchange treatment. (Abs.) 346		Shukla, K., see Srivastava, V.K.	
		Schuite-maker, F., see Jaramillo, H.		Shunichi, O. Cane harvester. (Pat.) . . . . .	28
		Schweizer, E.E. Herbicide trials in the U.S. (Abs.) . . . . .	275	Shuraeva, K.D., see Serkin, V.T.	
		Schwind, H. <i>et al.</i> Sugars determination by gas-liquid chromatography. 379		Shut, N.A., see Iremenko, B.A.	
		Scobell, H.D. <i>et al.</i> Sugars determination by high-pressure liquid chromatography. (Abs.) . . . . .	26	Shvets, V.N. <i>et al.</i> Yeast fermentation of molasses. (Abs.) . . . . .	221, 253, 282
		Scott, D.A. and Hudson, J.C. Cane harvester. (Pat.) . . . . .	60	Sidorenko, A.I., see Vyshtak, V.S.	
		Scott, R.P. <i>et al.</i> Effect of cane extraneous matter on juice extraction, quality and clarification. . . . .	348	Silina, N.P. <i>et al.</i> Molasses colloids and sugar content. (Abs.) . . . . .	346
		Sek, J., see Kembrowski, Z.		Silva, G.M. de A. and de Moraes, R.S. Borer and rot effects on cane quality. (Abs.) . . . . .	209
		Selyagina, N.A., see Arkhipovich, N.A.		Silva, J.F. and Zarpelon, F. Boiling and clarification effects on sugar colour and ash content. (Abs.) . . . . .	179
		Semenko, V.Z., see Lapin, A.P.		Silva, S.A., see Alves, A.S.	
		Semenisova, V.M., see Maevskii, V.R.		Simakhina, G.A., see Reva, L.P.	
		Semple, R.B., see Ayre, G.L.		Simbwa-Bunnya, M. Cane disease resistance trials in Uganda. (Abs.) . . . . .	341
		Senba, Y., see Saiga, K.		Simon, J. Irrigation effect on beet sugar yields and quality. (Abs.) . . . . .	211
		Sendokmen, N. and Akyar, O.C. Optimum carbonation alkalinity and pH determination. (Abs.) . . . . .	182	Simonart, A. and Dubois, J.P. Infection prevention in a sugar factory. (Abs.) . . . . .	250
		Septon, H.H., see Omatete, O.O.		Simpson, D.E. and Hemens, J. Activated sludge treatment of effluent. (Abs.) . . . . .	374
		Serkin, V.T., <i>et al.</i> Air flow in beet piles. (Abs.) . . . . .	345	Singh, A.N. Ammonium chloride as fertilizer. (Abs.) . . . . .	238
		Serna, S., F. Mill growing and imbibition effects on juice extraction. (Abs.) . . . . .	155	Singh, G.R. Cane smut infection. 243	
		Serra, G.E., see Tambosco, N.		Singh, H.G., see Oberoi, D.S.	
		Sers, M., see Voilley, A.		Singh, K. Seed cane programme for disease control. (Abs.) . . . . .	81
		Seutin, E., see van Steyvoort, L.		and Misra, S.R. Seasonal fluctuations of nematode population and control. (Abs.) . . . . .	208
		Sevilla, G., J.C. Soil texture and salinity in Peru. (Abs.) . . . . .	368	et al. Fertilization in India. (Abs.) 304	
		Shah, A.H. <i>et al.</i> Scale insect and mealy bug control. (Abs.) . . . . .	50	see also Agnihotri, V.P. and Srivastava, N.S.L.	
		Shahine, S., <i>et al.</i> Cellulose manufacture from bagasse. (Abs.) . . . . .	59	Singh, L., see Bose, S.	
		Shaker, F.M., see Miles, W.G.		Singh, M. <i>et al.</i> Cane juice reheat. 52	
		Shan, L.L.P. <i>et al.</i> Drip irrigation of cane. (Abs.) . . . . .	144	Singh, O. and Kanwar, R.S. Irrigation and cane deterioration by frost. 359	
		Shang, K.C., see Liu, M.C. and Lo, C.C.		Singh, O.P. Stalk borer control. . . . .	50
		Shann, D.S. Cane mill feeder. (Abs.) 154		et al. Maleic hydrazide effect on beet sugar content. (Abs.) . . . . .	18
		Shannon, R., see Paton, N.H.		see also Balerao, A.C. and Karve, A.D.	
		Sharanappa, B. <i>et al.</i> Phosphorus and potassium effects on cane yield and quality. (Abs.) . . . . .	48	Singh, P.P. and Kumar, K. Gamma-BHC interaction with nitrogen. . . . .	329
		Sharma, H.L. <i>et al.</i> Beet genetic parameter variability and correlation. 309		– Vertical and horizontal cane planting. (Abs.) . . . . .	109
		Sharma, M.P., see Srivastava, N.S.L.		Singh, R.A., see Rathi, K.S.	
		Sharma, P.P., see Saini, S.S.		Singh, R.C., see Dua, S.P.	
		Sharma, R.A. <i>et al.</i> Cane ripening with chemicals. (Abs.) . . . . .	14	Singh, S. Cane flowering. (Abs.) . . . . .	174
		Sharma, R.C. Masseculite reheaters. 20		Singh, S.V., see Gupta, A.P.	
		Temperature and time effects on viscosity. (Abs.) . . . . .	311	Singh, U.S. Cane growth and photosynthesis. (Abs.) . . . . .	338
				Cane leaf area estimation. (Abs.) . . . . .	239
				Cane leaf nitrogen and tillering. . . . .	109
				Cane nitrogen content during growth. (Abs.) . . . . .	239
				Nitrogen metabolism in cane. . . . .	370
				Nutrient effects on cane. (Abs.) . . . . .	370

# INDEX

	page		page		page
Singh, V.P., <i>see</i> Rathi, K.S.		Stewart, E.J., <i>see</i> Swindells, R.J.		Teixeira, J.P.B., <i>see</i> Tambosco, N.	
Sinha, K.P., <i>see</i> Gupta, K.K.		Stewart, P.N., <i>et al.</i> Centrifuge treatment of clarifier mud. (Abs.)	154	Tello, A. H., <i>see</i> Saldarriaga, A. S.	
Sinha, S.N., <i>et al.</i> Cane sugar recovery calculation. (Abs.)	20	Stöckman, R., <i>see</i> Bändel, F.		Tembhekar, V.V., and Patel, D.K.	
Sitnik, N.G., <i>see</i> Il'ina, L.D.		Stokke, G., <i>see</i> Covacevich, M.T.		Cane disease and pest control in India. (Abs.)	50
Sivaraman, R. and Ray, S.C. Masse-cute viscosity reduction in boiling.	52	Stratienko, O.V., <i>see</i> Fel'dman, A.I.		Tentscher, W., <i>see</i> Rudolph, K.	
Siwicki, S., <i>see</i> Krasucki, S.		Stroehlein, J.L., <i>see</i> Johnson, G.V.		Teran, F.O. and Novaretti, W.R.	
Sklyarenko, V.D., <i>see</i> Andrianov, I.O.		Strong, A.W., <i>see</i> Bathgate, R.R.		Borer control in Brazil. (Abs.)	208
Skole, R.D., <i>et al.</i> Raw sugar micro-organisms. (Abs.)	380	Sturion, A.C. Cane sampling and analysis. (Abs.)	180, 281	Terent'ev, Y.A., <i>et al.</i> Optimum cossette length. (Abs.)	313
Slater, L.E. Protein production from beet molasses. (Abs.)	59	Su, T.H., <i>see</i> Cheng, W.Y.		Tewari, S.K. and Bhatnagar, P.S.	
Sloan, R.E. and Farquhar, R.H.		Suárez, R., and González, P., L.		Beet agriculture economics in Rajasthan. (Abs.)	84
Cane varietal frost resistance. (Abs.)	342	Mathematical model of bagasse pulp manufacture. (Abs.)	93	Thakur, A.K., <i>see</i> Chacravarti, A.S.	
Slutzky, B. and Lara, A. Reducing sugars determination. (Abs.)	220	<i>see also</i> Ocampo, S., G.		Thakur, K., <i>et al.</i> Fertilizer effect on cane yield. (Abs.)	271
Slyusarenko, T.P., <i>see</i> Shvets, V.N.		Subbarao, V.V., <i>see</i> Singh, M.		Thangavelu, S. and Sundaresan, K.	
Small, R.J. Borer infestations in South Africa. (Abs.)	371	Subrahmanyam, P.V.R., <i>see</i> Hanumanulu, V.		Gur production and consumption in India. (Abs.)	238
Smelfk, A. Dextrose solvation saturation. (Abs.)	25	Subramanian, A., <i>et al.</i> Borer control by cane trash mulching. (Abs.)	243	Thippeswamy, M.K., <i>see</i> Soundararajan, N.V.	
Smirnova, L.K., <i>et al.</i> Tryptophane production from beet molasses. . . .	27	Süddeutsche Zucker-AG. Molasses sugar recovery. (Pat.)	285	Thirel, Y. Continuous massecuite filtration. . . . .	293
Smith, E.A., <i>see</i> Player, M.R.		Suekane, M., <i>et al.</i> Dextrose isomerization to levulose. (Pat.)	29	Thomas, D.W. Field survival of above- and below-ground parts of potted seedlings. (Abs.)	372
Smith, F.F., <i>see</i> Gillaspie, A.G.		Sugar Cane Growers Cooperative of Florida. Cane harvester. (Pat.)	285	Thomason, I.J., <i>see</i> Kontaxis, D.G. and Smith, R.	
Smith, I.A., <i>see</i> Schaffler, K.J.		<i>see also</i> Fowler, L.G.		Thompson, G.D. Cane biomass production. (Abs.)	339
Smith, N.H. Sugar colorants fractionation by high-pressure liquid chromatography. (Abs.)	379	Sugawara, M., <i>see</i> Saiga, K.		Thompson, K. Beet seedbed preparation. (Abs.)	178
Smith, P., <i>see</i> Daniels, J. and Paton, N.H.		Sugimori, M.H., <i>see</i> Oliveira, A.R.		Thomson International Co., <i>see</i> Brassette, D.J.	
Smith, R., <i>et al.</i> Nematode control.	276	Sullivan, E.F. and Fagala, L.K.		Tilbury, R.H., <i>et al.</i> Mill sanitation and losses. (Abs.)	157
Snyder, F.M. Molasses-containing animal fodder. (Pat.)	29	Chemical weed control in beet. . . .	84	Tilley, L.G.W. Cane farm records system. (Abs.)	240
Sobczyk, G. Beet campaign starting and finishing dates in Poland. (Abs.)	182	Sullivan, J.E. and Schewe, L.R.		Timonin, A.N., <i>see</i> Pasechnik, V.P.	
Sobrinho, A.T., <i>see</i> Giaiofatto, J.C.		Sugars determination by gas-liquid chromatography. (Abs.)	58	Toblelich, N.Y., <i>see</i> Matvienko, B.A.	
Société d'Exploitation d'Usines Métallurgiques. Masseccuite mixer drive. (Pat.)	317	Sullivan, K. Automatic boiling control. . . . .	259	Tódt, F., <i>see</i> Kravt, E.W.	
Société de Promotion et d'Exploitation Industrielle de Procédés de Brevets S.A., <i>see</i> Fogarassy, A.		Sullivan, S., <i>see</i> Ricaud, C.		Toguchi, M., <i>see</i> Hama, K.	
Soman, P.N. Maharashtra sugar industry. (Abs.)	93	Sumner, M.E., <i>see</i> Beaufils, E.R.		Tokeshi, H., <i>see</i> Duarte, M.L.R. and Masuda, Y.	
Sommer, C., <i>see</i> Bramm, A.		Sundaresan, K., <i>see</i> Thangavelu, S.		Tomaneng, A.A. Soil factors affecting cane yield and sugar content. . . .	206
Sooksathan, R., <i>see</i> Rosario, E.L.		Suomen Sokeri Oy., <i>see</i> Melaja, A.J.		Tomobe, K. and Nagasaka, T. Raw sugar trace metals determination.	315
Soopramanien, G.C., <i>see</i> Julien, M.H.R.		Suzor, N.L.C. C-melt clarification.	181	Tong, J.F., <i>see</i> Chen, C.H. and Sang, S.L.	
Sood, P. and Lengyel, A. Beet losses in loading/unloading. (Abs.)	89	Suzuki, A., <i>et al.</i> Beet spacing effect on yield and sugar content. (Abs.)	84	Tooney, C.L. Effect of variety on cane cultivation. (Abs.)	117
Sorokin, A.I., <i>see</i> Parkhomets, A.P.		<i>see also</i> Erichen, A.W. and Oldemeyer, R.K.		Torres, B. M. Fertilizer trials in Mexico. (Abs.)	112
Sousa, J.A.G.C. and Scardua, R.		Svoboda, E. and Klepal, J. Affination temperature and crystal size effect on sugar moisture content. (Abs.)	23	Tory, P., <i>see</i> Davis, N.B.	
Irrigation in Brazil. (Abs.)	112	Centrifugal performance determination. (Abs.)	217	Tovstenko, Y.V., <i>see</i> Zagorul'ko, A.Y.	
<i>see also</i> Bacchi, O.O.S.		Sweet, C.P.M. Cane ripening with "Ethrel". (Abs.)	174	Toyama, N. Bagasse saccharification.	282
Soundararajan, N.V., <i>et al.</i> Low-grade massecuite curing efficiency calculation. (Abs.)	58	Swindells, R.J., <i>et al.</i> Crystallizer performance at Tully. (Abs.)	311	Traveller, D.J., <i>see</i> Carter, J.N.	
Spee, G. Beet drill and soil erosion prevention. (Abs.)	177	— Sugar flow from storage bins. . . .	344	Trebin, L.I., <i>et al.</i> Low-grade massecuite boiling with temperature fluctuation. (Abs.)	89
Spoor, G. Beet seedbed preparation.	178	Symington, W.M. Cane nobilization with <i>Saccharum officinarum</i> . . . . .	117	Tregub, V.G., <i>et al.</i> Heat transfer optimization in boiling. (Abs.)	122
Srinivasan, S. and Pandey, K.N.		Cane varietal selection. (Abs.)	342	Trepka, M., <i>see</i> Wolanski, J.	
Large-grained sugar manufacture.	85	Szczeniowski, M., <i>see</i> Oledzki, J.		Triana F., C.J., <i>et al.</i> Bagasse lignin chemical composition. (Abs.)	221
Srinivasan, T.R., <i>see</i> Venkatamaran, K.		Szcut, K. and Jochim, H. Computer application to beet payment. (Abs.)	346	Trifonova, T.P., <i>see</i> Daishev, M.I.	
Srivastava, D.N., <i>see</i> Wilson, K.I.		Tabrah, J.G., <i>see</i> McElhoe, B.A.		Trinchuk, G.S., <i>see</i> Petrunya, V.I.	
Srivastava, J.K., <i>see</i> Prasad, M.		Tagore, N.R. Losses. (Abs.)	119	Tripathi, A.M., <i>see</i> Srivastava, V.K.	
Srivastava, N.S.L. Stubble shaver. . . .	340	Taisne, D., <i>see</i> Teissier, R.		Tripathi, S.N., <i>see</i> Nath, S.	
<i>et al.</i> Seed cane treatment with moist hot air. (Abs.)	81	Takashi, ., <i>see</i> Korenaga, .		Triviz, P. "Hi-Extractor". (Abs.)	181
Srivastava, S.C., <i>see</i> Hunsigi, C.		Takeda, R., <i>see</i> Saiga, K.		Trubenko, V.N., <i>see</i> Terent'ev, Y.A.	
Srivastava, S.K., <i>see</i> Sinha, S.N.		Tambosco, N., <i>et al.</i> Cane harvester trials in Brazil. (Abs.)	305	Tsung, D.S., <i>see</i> Hsieh, W.H.	
Srivastava, V.K., <i>et al.</i> Heteropoly-anion effect on cane mosaic. (Abs.)	16	— Machine harvested cane trash content. (Abs.)	113	Tsung, H.C., <i>see</i> Lu, C.J.	
Srzednicki, Z. Winter beet cultivation. (Abs.)	275	Tamura, M., <i>et al.</i> Dextrose isomerization to levulose. (Pat.)	284	Tsung, S.T., <i>see</i> Chen, M.Y.	
Stacey, D. Beet tops as animal fodder.	253	<i>see also</i> Suekane, M.		Tsukui, K., <i>see</i> Sasaki, K.	
A.E. Staley Mfg. Co., <i>see</i> Coker, L.E.		Tamusch, A., <i>see</i> Blaquier, L.M.		Tsygura, V.G., <i>see</i> Ivanyuk, A.A.	
Stamper, E.R., <i>see</i> Loupe, D.T.		Tan, C.S., <i>see</i> Randolph, A.D.		Tsyukalo, Y.F., <i>et al.</i> Carbonatation at No. 2 Petrovskii sugar factory. . . .	313
Standard Brands Inc. Dextrose isomerization to levulose. (Pat.)	285	Taneja, A.D., <i>see</i> Bishnoi, L.		— Filter cloth sleeves. (Abs.)	376
Stanescu, Z. and Bria, N. Beet harvesting and transport. (Abs.)	17	Tang, K.H. Effect of inter-row spacing on cane yield. (Abs.)	109	Tubol'tsev, V.K., <i>see</i> Tuzhilkin, V.I.	
<i>et al.</i> Beet varieties in Rumania. . . .	309	Tantsyura, L.V., <i>see</i> Arkhipovich, N.A.		Tuchinskii, L.M. and Kuz'menko, B.P.	
<i>see also</i> Ciocchia, V.		Tapay, R.E., <i>see</i> Rosario, E.L.		Lime balance calculation. (Abs.)	249
Starke, H.D., <i>see</i> Godulla, P.		Tarabuta, T., <i>see</i> Ciocchia, V.		Tung, W.H., <i>see</i> Lin, T.L.	
Steele, E.M., <i>see</i> Scobell, H.D.		Taranenko, L.S., <i>see</i> Kozyavkin, A.P.		Turner, N.V. Chemical weed control in the UK. (Abs.)	19
Stefan, G., <i>see</i> Stanescu, Z.		Tate & Lyle Ltd. Clarification with flocculants. (Pat.)	285	Turner, P.E.T. Chemical weed control. (Abs.)	146, 339
Stefanescu, A., <i>see</i> Niculescu, E.		Sucrose derivatives. (Pat.)	285	<i>see also</i> Moberly, P.K.	
Stefanescu, P., <i>see</i> Stanescu, Z.		Sugar recovery from clarification scums. (Pat.)	285	Tuzhilkin, V.I. and Kaganov, I.N.	
Stegnii, N.G., <i>see</i> Kravchuk, A.F.		<i>see also</i> Rundell, J.T.		Vapour pressure in boiling. (Abs.)	57
Steinbauer, E., <i>see</i> Rudolf, H.		Taygun, N., <i>et al.</i> Vinasse recycling and alcohol fermentation of molasses. (Abs.)	282	<i>et al.</i> Brix measurement. (Abs.)	346
Steinle, G. and Fischer, E. Betaine determination by high-pressure liquid chromatography. (Abs.)	91	Taylor, H.M., <i>see</i> Rizzi, G.P.		Twu, L.T., <i>see</i> Peng, S.Y.	
<i>see also</i> Koster, P.B.		Teague, H.J., <i>see</i> Oldfield, J.F.T.		Tyazhelova, G.F. Discrepancy between beet and cossette sugar contents. . . .	376
Stengl, R., <i>see</i> Friml, M.		Teakle, D.S., <i>et al.</i> Rattoon stunting disease diagnosis. (Abs.)	306, 371	Uhlenbrock, W. Carbonatation juice lime salts determination and control.	278
Stepanov, G.N. Rake conveyor modifications. (Abs.)	250	Teissier, R., <i>et al.</i> Beet pulp and molasses as animal fodder. (Pat.)	29	Ulku, G., <i>see</i> Taygun, N.	

# INDEX

	page		page		page
Umar, M. and Brinkmann, W. Beet topping. (Abs.) . . . . .	307	Vivier, M., <i>see</i> Geoffroy, F.		Wilson, K.I. and Srivastava, D.N. Red root effect on cane tissue phenol content. (Abs.) . . . . .	242
Upadhyay, S.K., <i>see</i> Prasad, M.		Vlitos, A.J. Cane agronomy and sugar use as a chemical feedstock. (Abs.)	304	Windal, G. Automatic boiling control. 182	
Urban, V. Factory product conveying	278	Voile, A. <i>et al.</i> Centrifuging and dextrose crystallization. (Abs.)	315	Automatic water-cossette control in beet diffusion. (Abs.) . . . . .	182
Urbaniec, K. and Kulig, M. Juice heater. (Abs.) . . . . .	312	Vojin, K. Carbonatation at Osijek factory. (Abs.) . . . . .	23	and Deleurance, A. Computer control of boiling. (Abs.) . . . . .	121
<i>et al.</i> Evaporators. (Abs.) . . . . .	250	Voloshanenko, G.P., <i>see</i> Remeslo, N.V.		Winner, C. Agronomic factors and beet quality. (Abs.) . . . . .	84
Ushiro, S., <i>see</i> Tamura, M.		von Alten, J. Machinery and beet row width discrepancies. (Abs.) . . . . .	308	<i>see also</i> Bürcky, K. and Schäufele, W.R.	
Utulin, E.J., <i>see</i> Tambosco, N.		von Kessel, W.C. Beet agriculture costs in West Germany. (Abs.) . . . . .	17	Winstrom-Olsen, B. <i>et al.</i> Beet phenols investigations. . . . .	322,362
Vaccari, G. and Accorsi, C.A. Carbonatation mud application to soil. (Abs.) . . . . .	222	Beet agricultural practices and crop profitability. (Abs.) . . . . .	177	Wiriatmodjo, B. and Samoedi, D. Cane borer control. (Abs.) . . . . .	151
<i>see also</i> Accorsi, C.A. and Mantovani, G.		Beet harvesters. (Abs.) . . . . .	274	Wise, C.T. Soil conservation. (Abs.)	338
Vadehra, D.V. <i>et al.</i> Molasses effect on citric acid fermentation. (Abs.) . . . . .	94	Nematode control. (Abs.) . . . . .	212	Wisner, C.A., <i>see</i> Liu, H.P.	
Vaghela, N.V., <i>see</i> Shah, A.H.		Sodium and magnesium fertilizer trials in West Germany. (Abs.) . . . . .	17	Wójcikowski, K., <i>see</i> Urbaniec, K.	
Vajna, S. Air flow in artificially ventilated beet piles. (Abs.) . . . . .	88	Soil preparation and fertilization effects on beet crop. (Abs.) . . . . .	308	Wolański, J. and Treпка, M. Limestone mechanical handling. . . . .	182
Valdés B., E., <i>see</i> Gonzalez, C. L.		von Müller, A. Beet varietal trials in West Germany. (Abs.) . . . . .	309	Wong You Cheong, Y., <i>see</i> Deville, J.	
Valdés D., A. Juice heater design. . . . .	154	Vreven, T., <i>see</i> Roussel, N.		Wood, R.A., <i>see</i> Clowes, M.St.J.	
Valdivia V., S. Effect of excess soil sodium on cane yield. (Abs.) . . . . .	109	Vukov, K. <i>et al.</i> High invert syrup manufacture and properties. (Abs.)	25	Woodward, W., <i>see</i> Hibbert, D.	
Fertilizer trials in Peru. (Abs.) . . . . .	368	Vyse, J.R. and Morten, H. Laboratory programmable calculator. . . . .	278	Wright, J. Abandoned cane dangers and elimination. (Abs.) . . . . .	78
and Pinna C., J. Soil salinity and cane sett germination. (Abs.) . . . . .	368	Vyshtak, V.S. and Sidorenko, A.I. Beet reception and storage. (Abs.)	277	Wright, P.G. and Broadfoot, R. Factory equipment residence time studies with lithium. (Abs.) . . . . .	156
<i>see also</i> Pinna C., J.		Vyskrebtsov, V.B., <i>see</i> Pasechnik, V.P.		<i>see also</i> Broadfoot, R. and Miller, K.F.	
Valsechi, O. <i>et al.</i> Borer effect on cane and juice quality. (Abs.) . . . . .	242	Wachowicz, M. Colouring matter fractionation by gel filtration. . . . .	315	Wu, S.N. and Ho, P.W. Liberia sugar factory. (Abs.) . . . . .	20
Valter, V., <i>see</i> Komerec, J.		Wagner, P., <i>see</i> Rudolf, H.		Wysemann, R., <i>see</i> Ebers, G.	
van Biljon, J.J., <i>see</i> Jooste, J.		Walker, D.I.T. <i>et al.</i> Cane breeding in the West Indies. (Abs.) . . . . .	210	Wyse, R.E. Temperature effect on stored beet. (Abs.) . . . . .	307
van der W.		Wandre, S.S., <i>see</i> Chougule, J.D.			
van Blommestein, P.C., <i>see</i> Jooste, J.		Wang, C.C. <i>et al.</i> Soil phosphorus availability. (Abs.) . . . . .	147	Yakimov, A.F. Carbonatation with mud separation. (Abs.) . . . . .	87
van der Poel, P.W. <i>et al.</i> Sugar factory laboratory automation and data processing. . . . .	168	Wang, L.H. and Kuo, Y.C. Enzymatic saccharification of bagasse pith. . . . .	126	Yamaga, J. and Shirakawa, S. Refinery sludge drying. (Abs.) . . . . .	282
<i>see also</i> Bleyberg, C.		<i>et al.</i> Cane molasses alcohol and yeast fermentation. (Abs.) . . . . .	252	Yamane, T. <i>et al.</i> Raw sugar colorants. . . . .	315
van der Riet, C.B., <i>see</i> Bodger, R.		Wang, P.L., <i>see</i> Yang, S.J.		Yamit, D.P. and Rizo, J.J. Chemical weed control. (Abs.) . . . . .	207
van der Schans, C., <i>see</i> Alves, A.S.		Wang, S.L., <i>see</i> Liu, H.P.		Yang, J.P.W., <i>see</i> Lin, C.H.	
and Eaton, B.J.		Wang, Z.N. and Lee, C.S. Leaf blight infection mechanism. (Abs.) . . . . .	243	Yang, P.C. and Ho, F.W. Cane ripening with "Polaris". (Abs.) . . . . .	174
van Dokkum, J. Power factor improvement calculation. (Abs.) . . . . .	374	Wardhana, T. Pressure evaporation. . . . .	310	Yang, S.J. Effect of mechanical cane harvesting on soil properties and ratoonings. (Abs.) . . . . .	109
VanHook, A. Sucrose crystal growth and dissolution. (Abs.) . . . . .	124	Watts, K.W. <i>et al.</i> Factory power supply to public grid. (Abs.) . . . . .	343	and Wang, P.L. Soil salinity correction by drainage. (Abs.) . . . . .	110
Vanli, N. and Kaimoglu, S. Irrigation effect on beet sugar content and yield. (Abs.) . . . . .	177	Wawro, S., <i>see</i> Zagrodzki, S.		<i>see also</i> Sheu, Y.S.	
Vanstallen, R. Beet pulp texture measurement. (Abs.) . . . . .	350	Webb, J. and Jaggard, K. Sowing date and beet yield. (Abs.) . . . . .	178	Yang, S.L., <i>see</i> Pan, Y.S.	
Beet seed spacing and population. . . . .	177	Webb, W.A.C. Grub control. (Abs.)	243	Yang, S.M. and Braud, H.J. Cane sett protection with fungicide. (Abs.)	116
and Jardin, A. Beet fertilization. . . . .	308	Weattall, H.H., <i>see</i> Lartigue, D.J.		Yang, T.C., <i>see</i> Sheu, Y.S.	
<i>see also</i> Roussel, N. and Vigoureux, A.		Wegenhoft, K., <i>see</i> Roy, E.P.		Yang, T.H. and Chen, C.T. Cane guttation. (Abs.) . . . . .	176
van Steyvoort, L. Beet pests and diseases in Belgium. (Abs.) . . . . .	247	Wegzynowski, Z., <i>see</i> Rogowska, M.		and Hsieh, T.S. Reducing sugars decrease in growing cane. (Abs.)	238
Beet virus yellow vector control. . . . .	212	Wehrmann, J., <i>see</i> Scharpf, H.C.		Yaremchuk, I.G., <i>see</i> Dymko, M.A.	
and Seutin, E. Insect control in beet. . . . .	212	Weidner, H. Automatic filter press. . . . .	217	Yarmilko, V.G., <i>see</i> Khomenko, N.D.	
Varadan, G.S. Sugar industry in India. . . . .	248	Werner, W. and Buge, K. Centrifugal. . . . .	283	Yee, W.F., <i>see</i> Nee, C.I.	
Varma, N.C., <i>see</i> Dubey, R.S.		West, I.R. and Moskowitz, G.J. Sugars determination in high fructose corn syrup. (Abs.) . . . . .	123	Yeh, H.J. Herbicide tolerance of cane varieties. (Abs.) . . . . .	238
Vattuone, M.A., <i>see</i> Prado, F.E.		Westfall, D.G. <i>et al.</i> Beet brei nitrate and sugar content. (Abs.) . . . . .	84	Surfactant effect on herbicide activity. (Abs.) . . . . .	206
Vaughan, J.G. Food microscopy. . . . .	280	Whayman, E. and Meredith, T.W. Raw sugar components and refinery liquor filtration. (Abs.) . . . . .	184	Young, M.A., <i>see</i> Ocampo, S. G.	
Veeres, G.K. White grub distribution, damage to cane and control. (Abs.)	50	<i>see also</i> Crees, O.L.		Young-Kong, V.M. Cane smut in Guyana. (Abs.) . . . . .	16
Vega, R., I., <i>see</i> Hernández, S. P.		White, D.R. Syrup preparation. (Pat.)	60	Yuzefchuk, K.I., <i>see</i> Karasik, V.M.	
Velayutham, B., <i>see</i> Subramanian, A.S.		White, E.T. and Maudarobocus, S.M.R. Head loss determination in continuous crystallizers. (Abs.) . . . . .	343		
Vellaud, J.P. Waste water treatment and disposal in France. (Abs.) . . . . .	249	<i>see also</i> Kirby, L.K., Maudarobocus, S.M.R. and Swindells, R.J.		Zaborsin, A.F. <i>et al.</i> White sugar dryer/coolers. (Abs.) . . . . .	54
Venkatachary, A., <i>see</i> Reddy, M.R.		Whittle, R.W., <i>see</i> Cochran, B.J.		<i>see also</i> Kostenko, N.V.	
Venkatachary, A., <i>see</i> Reddy, M.R.		Whittle, A.M. Cane smut resistance ratings. (Abs.) . . . . .	341	Zabuga, F.F., <i>see</i> Zakharov, K.P.	
Venkatamaran, K. <i>et al.</i> Cane ripening with chemicals. (Abs.) . . . . .	338	Fungus formation on cane arrows. . . . .	306	Zagorul'ko, A.Y. <i>et al.</i> Active carbon effect on sugar determination in high-colour products. (Abs.) . . . . .	26
Venter, J.S.M., <i>see</i> Hough, J.J.		Wiebe, G. Nematode control. (Abs.)	212	- Beet tarehouse line. (Abs.) . . . . .	92
Venturi, G., <i>see</i> Pritoni, G.		Wieser, F., <i>see</i> Hrubesch, W.		- Losses in thick juice storage and processing. (Abs.) . . . . .	375
Vergara, E.V. <i>et al.</i> Cane varietal trials in the Philippines. (Abs.)	51	Willcox, T.G. Cane crop forward planning. (Abs.) . . . . .	14	- Unknown losses reduction. (Abs.)	249
Veurman, J.D. Contour farming. . . . .	15	Cane standing-over. (Abs.) . . . . .	240	Zagrodzki, S. <i>et al.</i> Active carbon regeneration kiln. (Abs.) . . . . .	314
Vigh, I. Liming vessel. (Abs.) . . . . .	375	and McAleese, C.M. Eye spot in Australia. (Abs.) . . . . .	371	- Ammonium carbonate recovery from beet juice. (Abs.) . . . . .	312
Vignes, E.C. Raw sugar grain size analysis in Mauritius. (Abs.) . . . . .	124	Willett, J.D. and Cheek, L.M. Nematode hatching agent. (Pat.)	283	<i>see also</i> Zaorska, H.	
Vigoureux, A. Bolted beet elimination. (Abs.) . . . . .	245	Williams, A., <i>see</i> Horsley, D.F.A.		Zagrodzki, S.M., <i>see</i> Zagrodzki, S. and Zaorska, H.	
and Vanstallen, R. Pesticide application rate determination. . . . .	19	Williams, J.R. and Luc, M. Nematodes in Mauritius. (Abs.) . . . . .	242	Zahradnick, J. <i>et al.</i> Stored beet weight and sugar losses. (Abs.) . . . . .	277
Villasanta, S.M., <i>see</i> Vergara, E.V.		Wilson, B. Cane agricultural practices for increased yield. (Abs.) . . . . .	239		
Villavicencio, E.J. Bagasse prehydrolysis and digestion. (Pat.)	28	Wilson, J.F. and Parish, R.S.			
Viotti, A.V., <i>see</i> Chenu, P.M.A.M.		Molasses-containing animal fodder. . . . .	60		
Vir, S. and Behniwal, M.S. Cane varietal resistance to smut. (Abs.)	273				
Viswanathan, L., <i>see</i> Agrawal, P.K. and Bajpai, P.					
Vitkovskaya, V.A. <i>et al.</i> Distillery waste treatment. (Abs.) . . . . .	254				
Vitvitskii, V.D., <i>see</i> Reznik, K.E.					



# INDEX

	page		page		page
Zakharov, K.P. <i>et al.</i> Carbonatation at Sambor sugar factory. (Abs.) . . .	313	Zarpelon, F., <i>see</i> Chenu, P.M.A.M. and Silva, J.R.		Zhizhina, R.G., <i>see</i> Ivanyuk, A.A.	
<i>see also</i> Lapin, A.P.		Záruba, J. Milk-of-lime metering system. (Abs.) . . . . .	346	Ziegler, J. Boiling. (Abs.) . . . . .	213
Zama, F. Juice heater and evaporator incondensable gas withdrawal. (Abs.)	54	Zdikhovskii, O.B., <i>see</i> Kostenyuk, A.M.		Zoidl, H. Carbonatation mud dewatering. (Abs.) . . . . .	313
<i>see also</i> Accorsi, C.A.		Zende, G.K. Agronomic factors and cane quality. (Abs.) . . . . .	370	Zolnierczyk, C. Mechanical beet harvesting in Poland. (Abs.) . . . . .	308
Zambello, E., <i>see de</i> Bittencourt, V.C., Orlando, J. and Ruschel, A.P.		Cane research in India. (Abs.) . . . .	48	Zotkina, L.V., <i>see</i> Fel'dman, A.I.	
Zamecnik, L. Corrosion prevention.	250	<i>see also</i> Bawasakar, V.S. and Patil, S.P.		Zuazua N., J.M. Clarification with dolomitic lime. (Abs.) . . . . .	181
Zamora, A.B., <i>see</i> Barba, R.C.		Zharinov, N.I., <i>see</i> Zakharov, K.P.		Zubatov, V.A. <i>et al.</i> Tablet sugar dryer. (Abs.) . . . . .	122
Zamorano C., E. Cane harvester comparison. (Abs.) . . . . .	113	Zhenchuk, M.I. <i>et al.</i> Carbonatation juice filtration. (Abs.) . . . . .	346	Zubchenko, A.V. <i>et al.</i> Sugars solutions thermodynamics. (Abs.)	251
Zana, J., <i>see</i> Lukacs, L.		<i>see also</i> Reva, L.P. and Zakharov, K.P.		<i>see also</i> Buravleva, V.I.	
Zaorska, H. Beet juice treatment with active carbon. (Abs.) . . . . .	250			Zubchenko, V.P., <i>see</i> Nechitailo, V.N.	
<i>et al.</i> Ammonia and sugar determination in condensate. (Abs.) . .	312				

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