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STUDY ON SOME ENGINEERING PARAMETERS AFFECTING THE PRODUCTION OF FISH PELLETING MACHINE

Morad, M. M.[1], , M. K. Afify[1], O. A. Kaddour[2], and V. M. Daood[1]
1-Agricultural Engineering Department,Fac.Agric., Zagazig University.
2-Agricultural Engineering Research Institute, (AEnRI)., Giza, Egypt

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ABSTRACT : The main experiments were carried out in a local animal feeding factory in El-Alawaia village, Sharkia Governorate to study the effect of some engineering parameters (screw speed, feeding rate, number of die holes and effective hole thickness) on the performance of fish pelleting machine to produce high quality fish pellets. Evaluation of the fish pelleting machine performance was carried out taking into consideration extruder productivity, pelleting efficiency, pellets bulk density, pellets durability, energy requirements and pelleting cost.

The obtained results revealed that pelleting machine has a high efficiency and minimum production cost under conditions of screw speed of 2.11 m/sec. and feeding rate of 432kg/hr. In order to minimize pelleting energy and high quality fish pellets, effective hole thickness of 15 mm. and 31 die holes are used.

Key words: Pelleting, machines, screw speed, durability, effective hole

INTRODUCTION

Extrusion processing is considered one of the new processes of high technology in food and feed industry, floating and sinking extruded fish feed industry is used as a new technology in a large scale all over the world to optimize the quantity of fish feed meal in agricultural farms. Both the geometrical dimensions of die and ration components are the most important parameters influencing the efficiency of extrusion machine and pellets quality .

Singh (1996) used a wheel tire as a pelleting machine , by rotating it in a vertical plane. The dry soil-seed mixture is put in the tire concave. The tire is rotated while sprinkling the water on the mixture. In this process the mixture goes up and rolls back and as a result of continued cascading action for a period, the mixture is transformed into balls.

Blass and Wisman (1998) suggested the length of pellets to be in normally between 0.8 and 1 cm. If longer, there is a higher risk of breaking during handling while losses of single pellets or parts of them are more frequent.

Jannasch *et al.* (2001) stated that a reduction in screen size from 1/8 inch to 7/64 inch for the fine grinding process appeared to produce a modest increase in pellet hardness. pellet throughput was approximately 2 ton/h. The bending quality of the feedstock and pellet durability could be improved by changes to the die configuration, steam temperature or natural additives.

Adapa *et al.* (2002) mentioned that understanding the terminology used to describe dies is important when choosing die specifications. Different feeds and ingredients require specific amounts of time in the die hole – die retention time – to be able to bind together to form a pellet. Larger die working areas provide more retention time to form pellets, reduce power consumption per ton of feed pelleted and improve production efficiencies. They found that the bulk density of a dried straw is as low as 40 kg/m^3, whereas the bulk density of palletized grasses can reach as high as 1250 kg/m3.

Booth *et al.* (2002) studied the effect of processing techniques on digestibility coefficients, three diets treatments by three processing methods (cold pelleted, steam pelleted, and extruded). They found that feed conversation and diets protein efficiency was better in fish feed extruded diets than steam-pelleted diets. The cold-pelleted diet reduced performance of fish fed.

Robutti *et al.* (2002) found that important aspect of cereal extrusion is that the extruded product properties would depend on the raw material structure characteristics. For example. Corn endosperm hardness and amylase content of rice affect both expansion and cooking degree of extruded.

Kaddour (2003) stated that when extruder screw speed increased from 1.01 to 1.4 and up to 1.81 m/s. the energy requirements decreased by 12.72 and 16.20% under fineness degree of 2 mm. and number of holes of 22 using effective hole diameter 25.5mm., also energy requirements increased by increasing the effective hole from 19.5 to 25.5 mm. by 8.89, 11.72 and 17.80% at screw speed of 1.81 m/s. and number of holes of 22 using fineness degree of 1, 2, and 3 mm., respectively. He added that increasing number of holes from 16 to 22 and up to 30 holes decreased the energy requirements by 42.37 and 75.23% at screw speed of 1.81 m/s. and effective hole of 25.5 mm. using milling fineness degree of 2 mm.

Yucheng Feng *et al* (2004) stated that there was a slight decrease in bulk density as the moisture content of the litter increased. The amount of storage space that will be required per unit mass of material will therefore increase with the increase in moisture content . In contrast , particle density of the pellets increased with increase in moisture content .

Nehru *et al.* (2005) stated that the extruders used in the feed industry can be generally divided into two types. Single screw and twin screw. There are several factors which contribute to the production of high quality feeds in the extrusion process These include various feed parameters aquaculture and extrusion processing parameters.

Kaddour *et al.*(2006) decided that both the geometrical dimensions of die and rations components are the most important parameters influencing the efficiency of extrusion machine and the quality of pellets. The extrusion machine with different dies was evaluated for the two previously kinds of ration and taken into account the effective design parameters such as; [four levels of L/D ratio (1.42, 1.67, 1.92 and 2.17), hole entry diameter (16, 18 and 20 mm), percentage of die opening area (2.66, 5.33, and 7.99 %), and thickness of die (30 and 35 mm)], while the evaluation parameters were specified into two groups such as; a) machine evaluation parameters (productivity, energy requirements and total losses), b) pellets quality parameters (pellets durability, pellets bulk density, and pellets hardness). The results indicated that the optimum conditions for producing a good quality of pellets from standard ration were 1.92 L/D ratio, 18 mm hole entry diameter, 5.33 % die opening area, and 30 mm thickness of die, when the evaluated parameters (machine productivity, energy requirements, total losses, pellets durability, pellets bulk density, and pellets hardness) were 0.399 t/ h., 114.04 kW .h. /ton, 5.21%, 86.72%, 1.190 g/cm^3, and 184.80 N, respectively.

So, the objectives of this study are:

1-Evaluate the performance of fish pelleting machine to produce high quality fish pellets.

2-Optimize some operating and engineering parameters (extruder screw speed, feeding rate, die effective hole thickness and number of die holes) affecting the performance of fish pelleting machine .

3-Evaluate the performance of fish pelleting machine from the economic point of view.

MATERIALS AND METHODS

The main experiments were carried out in a local animal feeding factory in El-Alawaia village, Sharkia Governorate to study the effect of some operating and engineering parameters on the performance of fish pelleting machine.

Materials

Experimental Ration

The experimental ration prepared by a hammer mill and mixed in forage mixer at 16% total mass moisture content for the mixture .

The composition of the experimental ration is shown in Table 1 .

Table 1. Composition of experimental ration

Composition	Percentage
Corn (yellow grain)	47.5
Soy-bean meal	27.5
Wheat bran	7.5
Fish meal	12
Fish oil	5
Premix	0.3
DL.methionine	0.2

*Taken from Amria for fish feed meal.

Extrusion Pelleting Machine

The extrusion pelleting machine it local manufactured consists of the following main parts:-

Main frame

The main frame is a the base which carrying the feeding unit, extrusion unit and main electric power motor. It was made of iron steel L-sections with 2000 mm length , 1050 mm width and 98 mm height (Fig.1) .

Feeding unit

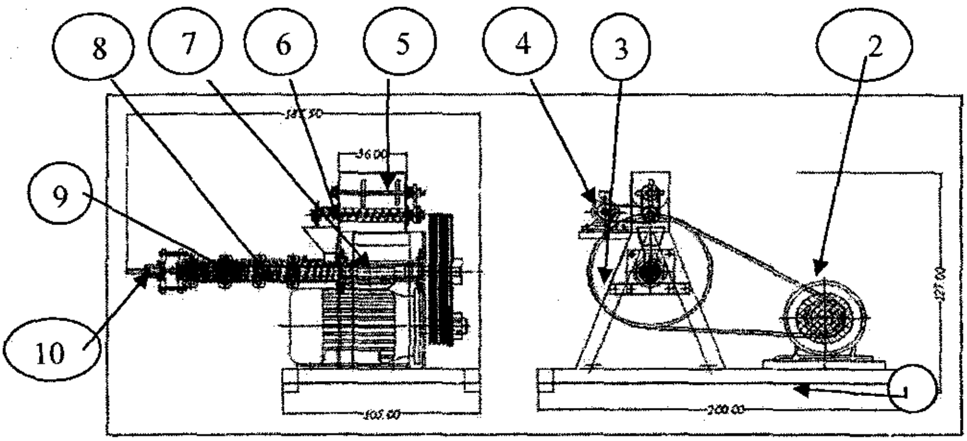
Feeding unit consists of feeding hopper, feeding screw and feeding mixer.

Feeding hopper

It is the part in which the ration prepared before extrusion stage .It constructed of iron sheet metal (2 mm. thickness), with 360 mm length,280 mm width and 620 mm height. Maximum capacity of feeding hopper is about 30 kg, There is a gate at the bottom of the hopper to allow ration to flow to the extrusion unit.

Feeding screw

A screw was fixed in the bottom of the feeding hopper to transmit ration from feeding unit to extrusion unit. The feeding screw dimensions are of550 mm length, 49 mm diameter and 35 mm pitch, feeding screw is powered by an electrical variable speed motor by means of two gears and sprocket , The motor gear is of 18 teeth, while the screw shaft gear is of 16 teeth. Feeding screw is powered by speed can be controlled by means of a key.



Scale 1 : 26.5

Side view **Elevation**

Part No.	Name	Part No.	Name
1	Main frame base	6	Feeding screw
2	Main electric motor	7	Main pressing shaft
3	Operating pulley	8	Extruder screw
4	Variable speed feeding motor	9	Cylinder clumps
5	Feeding mixer	10	Cutter shaft

Fig.1: Extruder pelleting machine

Feeding mixer

is working inside the middle of feeding hopper to mix and turn the ration. It consists of a shaft which has dimensions of 22 mm diameter and 360 mm lengths. 6 blades are fixed on the shaft to re-mix ration before feeding. Feeder shaft mixer takes the power from feeder screw shaft by two gears 1 :1 .

Extrusion unit

This unit is responsible for compressing and cooking the ration before the forming zone.

Main pressing shaft

The main shaft is carried on the machine from one end, on which all extruder units were assembled. It having made of hard steel 52 carbons. It has dimensions of 1250 mm length and 50 mm diameter. Also the main shaft is supported by two tapered bearings inside oil-house On another hand the shaft connected from behind to a drawing pulley having diameter of 660 mm, to transmit the power from main motor to main shaft by five (V) belts. There is an incision in the surface of the shaft to assemble as a keyway, to prevent slipping of extruder screw on the main shaft .

Extruder screw

The extruder screw consists of five parts . The first three parts are single screws and each part has dimensions of 150 mm length,95 mm. diameter and pitch of 35 mm, The next two parts are twin screws. Each part having dimensions of 150 mm length ,95 mm diameter and pitch of 17.5 mm .At the front of the screws there is a bolt assembled on the last screw to hold all screws parts with main shaft. Also the key on the main shaft is passing in the screws throw an internal incision. 10.4 mm diameter .There is a square hole in feeding cylinder under feeding unit to receive the ration. The internal surface has incisions throw which the mail passes through it. The next parts of the cylinder are three equal parts. Each one of them having dimensions of 159 mm length, 104 mm diameters and 12 mm thickness, the last part of extruder cylinder named die-house also there is a edge which prevent die movement during forming process, Die house has dimensions of 70 mm length,10.4 mm diameter, and 1.2 mm thickness. Each two parts of the cylinder are assembled together by a couple of clumps of 50 mm thickness, each couple is holding by two bolts.

Forming unit (die)

The forming unit is the part which blocked the last cylinder from the end of extruder screw. It is assembled in die house by screw bolt 8 mm diameter. Clearance between the die and extruder screw about 3 mm. The die dimensions are 104 and 100 mm diameter exterior and interior, respectively, and 25 mm total thicknesses. On the surface of the die there are holes on die surface having diameter of 3 mm.

Each hole consists of

-Die hole entry

The entry is of conical shape to help ration to flow easily inside the effective hole.

-Die effective hole thickness

It's a straight distance which press and form ration through the hole to get the final product (pellets). Dimensions of entry and effective hole thickness can be changed to adapt the experimental ration treatment to control specification of the obtained pellets.

Cutter knife

A cutter knife turn in a circular motion on die surface was used to cut the final product into small parts. It consists of four sharp blades, It having diameter of 95 mm. Obtained pellets length are controlled by changing knife speed by means of digital inverter, which controls cutting motor shaft speed.

Power Transmission and Electric Control

Main motor

The machine is powered by an electrical motor of 37.3 kW, 43 A, power is transmitted to the extruder shaft by a pulley (diameter of 224mm) and 5 (v) belts.

Feeder motor

Having variable mechanical gearbox is used to control motor shaft speed ,having output power 1.5 KW and 18 A., it is operated by a manual key to change feeding rate. Motor shaft Speed ranged from 28 rpm to 160 rpm Power transmitted to feeder screw shaft and feeder mixer shaft by gears and sprockets.

Cutter motor

Cutter motor connected to cutter knife by a shaft having dimensions of 180 mm length and 15 mm diameter .The motor is of output power 0.746 kW , 12 A . The cutting speed can be controlled by inverter which change motor shaft speed from zero to 28 rpm.

Methods

Experiments were conducted to optimize some operating and engineering parameters affecting the performance of fish pelleting machine.

Three experimental groups namely A , B and C were carried out and replicated three times in a completely randomized block design .

The first group of tests were run under four different extruder screw speeds of 325, 375, 425 and 450 rpm (Corresponding to 1.62, 1. 86, 2.11 and 2.36m/s) with three different feeding rates of 6000, 7200 and 9000 g/min.

The second group of tests were carried out under three different effective holes of 10, 15 and 20 mm with three different feeding rates of 6000 , 7200 and 9000 g/min (Corresponding to 360,432 and 540 kg/h)

The third group of tests were conducted under four different die hole numbers of 19, 24, 31 and 36 hole/die with three different feeding rates of 6000, 7200 and 9000 g/min.

Evaluation of the above mentioned treatments was carried out taking into consideration the following indicators:-

Extruder Productivity

It was calculated from the following relation:

$$\textbf{Extruder productivity (kg/h)} = W_p \div T \times 3.6$$

Where:

W_p: pellets mass (g).

T: consumed time (sec).

Pelleting Efficiency

It was calculated from the following relation:

$$\textbf{Pelleting efficiency (\%)} = W_p \div W_m \times 100$$

Where:

W_p: pellets mass (g).

W_m: ration sample mass (g).

Pellets Bulk Density

It was calculated using the following relation:

$$\textbf{pellets bulk density (gm/cm}^3\textbf{)} = W_d \div V_d$$

Where

W_d: pellets sample mass (g).

V_d: pellets sample volume (cm^3).

Durability of Pellets

A shaker model California pellet mill (CPM). was used for measuring pellets durability. It was calculated using the following relation:

$$\textbf{Durability (\%)} = W_a \div W_b \times 100$$

Where:

W_a: Pellets mass after shaker treatment (g).

W_b: Pellets mass before shaker treatment(g).

Energy Requirements

Energy requirements were obtained using the following equation:

Energy requirements (kW.h/ton) =Power (kW)÷ Extruder productivity (ton/h)

Pelleting Cost

The machine cost was estimated according to the conventional method of estimating both fixed and variable costs. While pelleting cost was calculated using the following formula:

Pelleting cost (L.E./ton) = Machine cost (L.E/h) ÷Extruder productivity (ton/h).

RESULTS AND DISCUSSION

The discussion will cover the results obtained under the following headings :

Effect of Different Operating Parameters on Extruder Productivity

Extruder productivity is affected greatly by many factors such as: feeding rate, die effective hole thickness, number of die holes (output area) and screw speed

Results obtained in (Fig. 2) show that increasing screw speed from 1.62 to 2.36 m/s at constant feeding rate of 360 kg/h. increased the extruder productivity by 1.38, 1.29, 1.16 and 0.82% using effective hole thickness of 10mm., by 1.40 , 1.30, 1.17 and 0.83 % using effective hole thickness of 15 mm, and by 1.49, 1.48, 1.47 and 0.84% using effective hole thickness of 20mm under number of holes of 19, 24, 31 and 36 respectively.

The same trend was noticed with the feeding rate of 432kg/h, it is noticed that , increasing screw speed from 1.62 to 2.36 m/s increased the productivity by 1.49, 1.48, 1.47 and 1.46 % and by 1.50, 1.50, 1.48 and 1.48 % and by 1.52, 1.51, 1.49 and 1.49 % using effective hole thicknesses of 10, 15and 20mm, under number of holes of 19, 24, 31 and 36 holes respectively.

On another hand, when the feeding rate increased to 540

kg/h., results show that increasing screw speed from 1.62 to 2.11 m/s increased the productivity by 0.52, 0.51, 0.51 and 0.51 %, and by 0.52, 0.52, 0.51 and 0.51% ,and by 0.52, 0.52, 0.52 and 0.51% using effective hole thicknesses of 10, 15 and 20 mm and number of holes of 19, 24, 31and 36 respectively. While increasing screw speed more than 2.11 m/s up to 2.36 m/s sharply decreased the productivity by 15.45, 7.97, 3.17 and 3.16 %, and by 16.39, 10.19, 3.19 and 3.18% and by 17.47, 12.13, 3.22 and 3.20% using effective hole thicknesses of 10, 15 and 20mm and number of holes of 19, 24, 31 and 36 respectively.

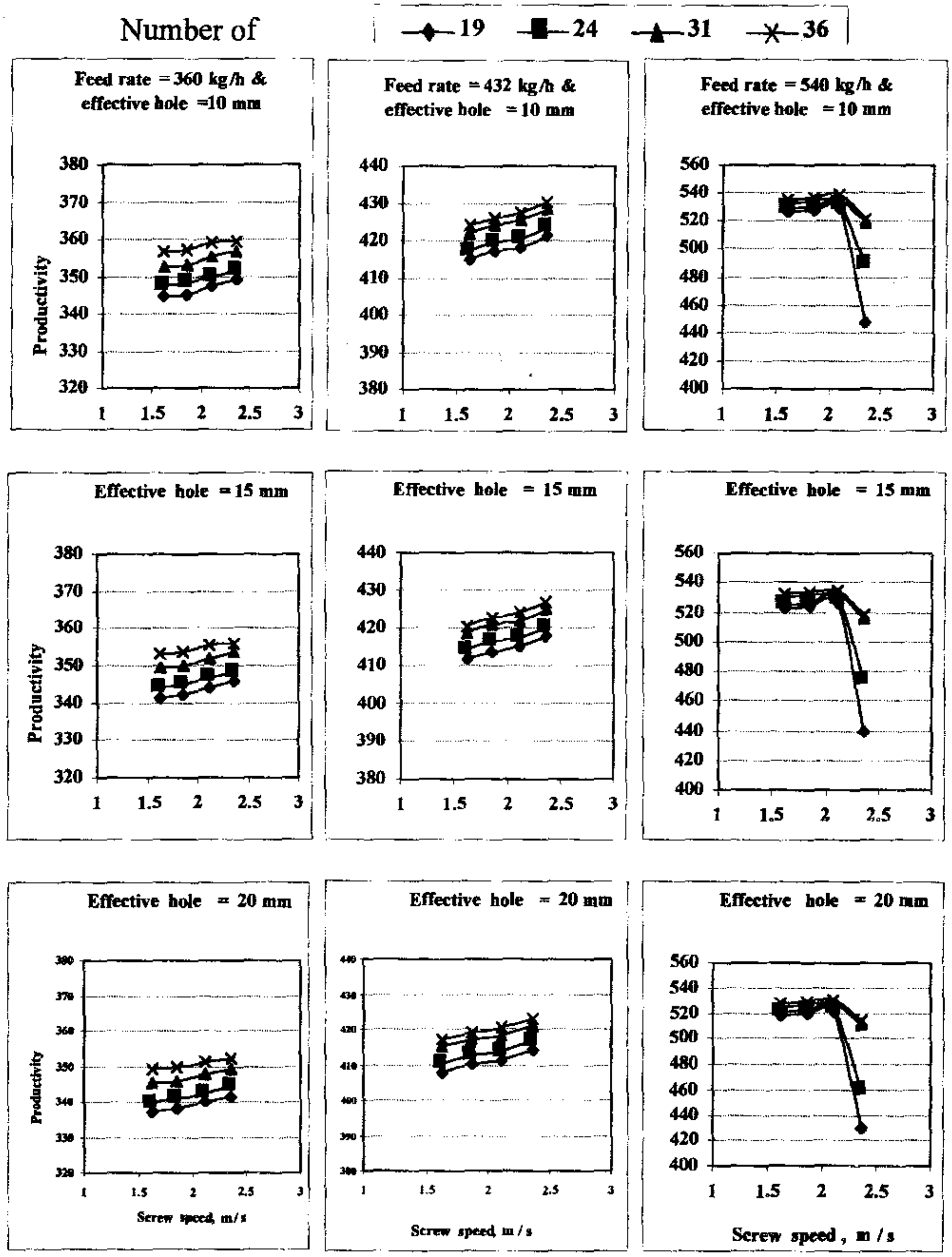


Fig.2 :Effect of screw speed on extruder productivity at different numbers of die holes ,different effecive hole thicknesses and feeding rates .

The decrease of extruder productivity by increasing the screw speed from 2.11 to 2.36 m/s using feed rate of 540 kg/h could be due to high screw speed which transfer the experimental ration from the screws feeding zone to the die zone quickly through constant output area that tend to block extruder cylinder ,resulting in over load in the extruder main motor so time is required to remove the blocked ration to reproducing the extruder .

The increase of extruder productivity by increasing feeding rate may be due to the increase of ration quantities which passed through the extrusion unit and expelled from the die holes at the same time .

The increase in extruder productivity by increasing the number of holes on the die surface could be due to the increase of the output area that help the ration to move out the die holes quickly, resulting in remarkable decrease in treatment consumed time.

While the decrease in extruder productivity by increasing the die hole thickness could be due to the increase in treatment consumed time as the ration passed a long distance inside the die hole.

Effect of Different Operating Parameters on Extruder Pelleting Efficiency

Pelleting efficiency is affected by many factors such as screw speed, number of die holes, feeding rate, and die effective hole thickness (Fig.3).

Regarding the effect of screw speed on pelleting efficiency result show that increasing screw speed from 1.62 to 2.36 m/sec, with number of holes of 19 increased pelleting efficiency by 14.99%, 13.59% and 12.60% at feeding rate of 360kg/h, and by 14.66 %, 13.16% and 12.46% at feeding rate of 432 kg/h, and by13.90 %, 12.68% and 11.93 % at feeding rate of 540 kg/h, under die effective hole thicknesses of 10,15 and 20 mm, respectively .

The increase of pelleting efficiency by increasing screw speed could be due to the increase in both compressing pressure and temperature, that is make the granules mixture in high bulking, and coming out the extruder as good pellets, without any cracking.

The slow increase of pelleting efficiency by increasing feeding rates could be due to the increase in the quantities of mixture resulting in more compression that increased the ration temperature that is enough to change the moisture profile from water into

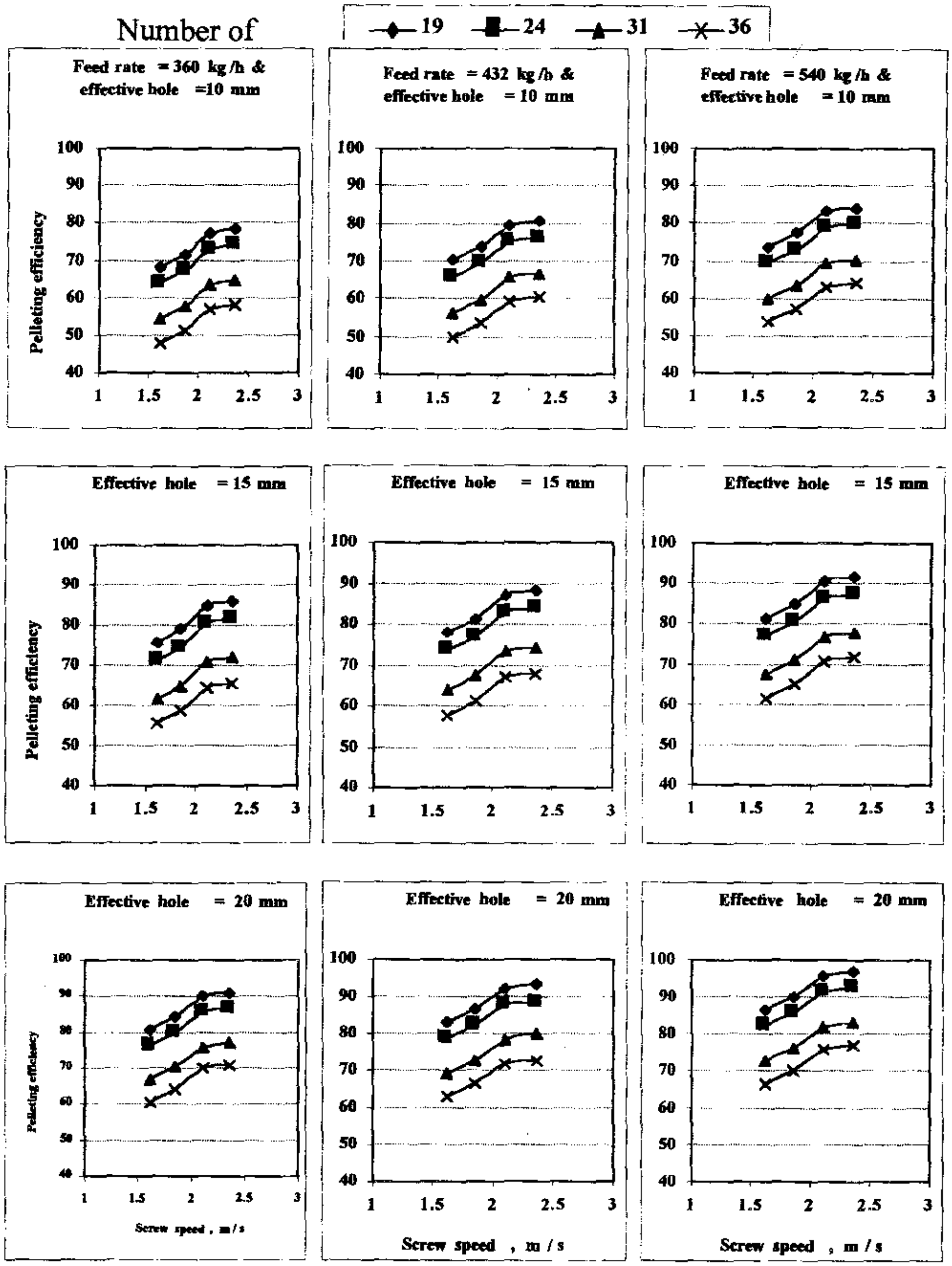


Fig.3:Effect of screw speed on pelleting efficiency at different numbers of die holes ,different effective hole thicknesses and feeding rates .

steam to make the mixture has bulking structure.

As to the effect of die hole number on pelleting efficiency ,data show that increasing die hole numbers from 19 to 36 at screw speed of 2.36 m/s, the pelleting efficiency decreased by 25.76% , 23.48%, and 22.16 % at feeding rate of 360kg/h., and by 24.96 %, 22.84%, and 21.11% at feeding rate of 432 kg/h, and by 23.82 %, 21.86% ,and 20.69% at feeding rate of 540 kg/h, under effective hole thickness of10,15 and 20 mm, respectively.

The reason of decreasing the pelleting efficiency by increasing numbers of die hole, can be due to the increase of the die output area that tend to decrease pressure in extrusion unit, which caused decreasing in granules bulking. So a high percentage of broken pellets are expected.

Increasing the working thickness of die hole forced the mixture to st more time in die zone which is the hottest zone in extrusion unit, added to that the effective hole thickness has a less diameter than the hole entry diameter that tend to increase temperature to 140C, it caused burning by plastic film on the pellets surface, that decreased the mash mixture and broken pellets were expected.

Effect of Different Operating Parameters on Pellets Bulk Density

Pellets bulk density is the major aquatic feed pellets quality controller, it attending the kind of producing aquatic feed. There is a lot of factors affecting the bulk density, such as screw speed, feeding rate, die holes number (opening area) and die effective hole thickness (Fig. 4) .

Referring to the effect of screw speed on pellets bulk density, results show that increasing screw speed from 1.62 to 2.11 m/sec with number of holes 19, increased bulk density by 10.61%, 12.60 % ,and 12.15 % at feeding rate of 360 kg/h, and by 12.39 %, 12.40 % ,and 12.56 % at feeding rate of 432 kg/h, and by 12.31%, 12.09 %,and 12.23 % at feeding rate of 540kg/h, under effective hole thicknesses of 10,15,and 20mm, respectively.

The increase in bulk density by increasing screw speed from 1.62 to 2.11m/sec, attributed to be due to the increase in homogeneity of ration granules with moisture and steam, causing more compaction to the raw materials in the die zone, that means increasing in granules mass in the same volume of die holes for the obtained pellets.

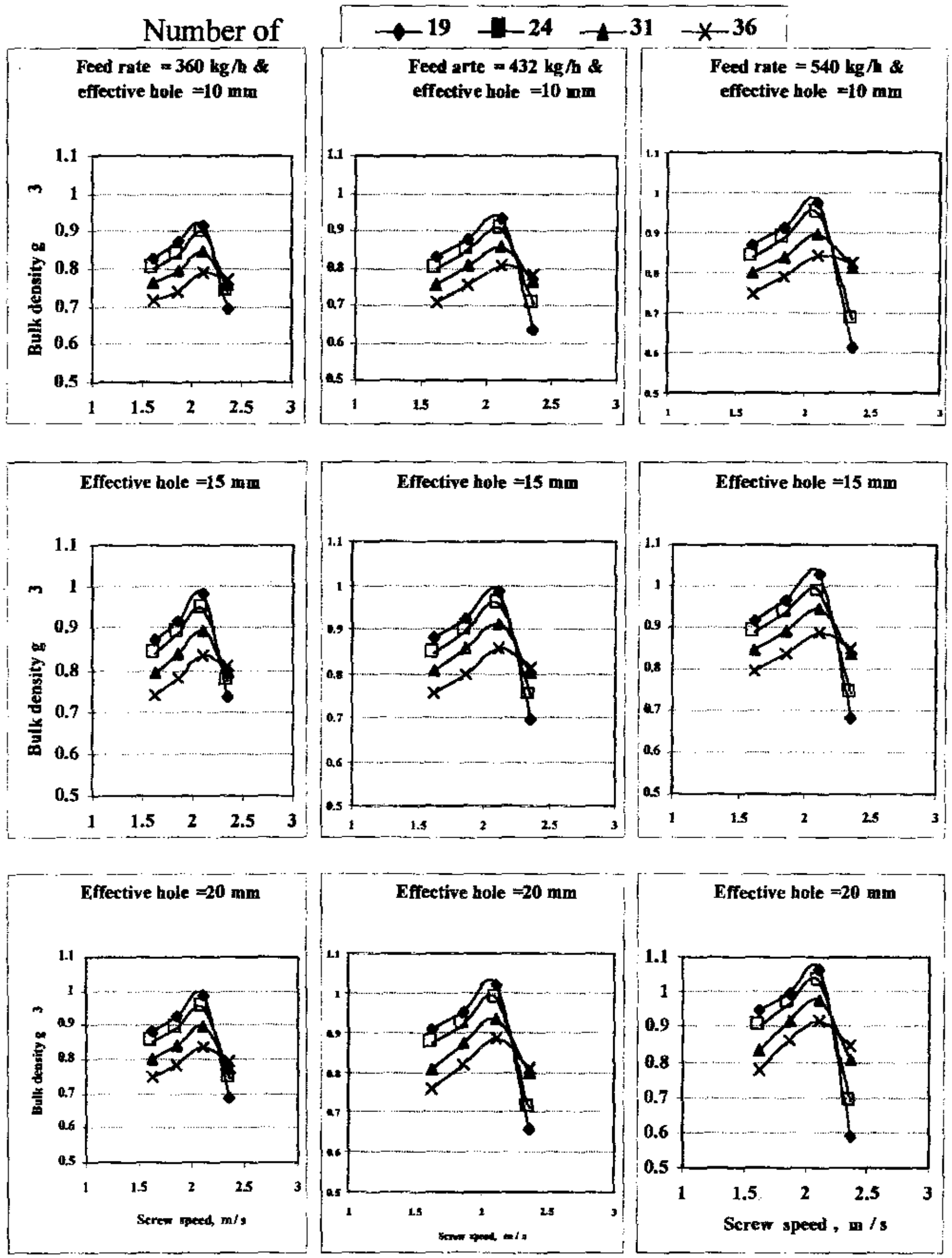


Fig.4 :Effect of screw speed on pellet bulk density at different numbers of die holes , different effective hole thicknesses and feeding rates .

While increasing screw speed more than 2.11 up to 2.36m/sec., with number of holes 19 decreased bulk density by 24.20 %, 25.33 %,and 30.29 % at feeding rate of 360 kg/h, by 32.11 %, 29.35 %,and 35.45 % at feeding rate of 432 kg/h, and by 37.29 %, 33.43 %,and 44.73 % at feeding rate of 540 kg/h, under effective hole thicknesses of 10,15,and 20 mm respectively.

The significant decrease in bulk density by increasing the screw speed from 2.11 to 2.36m/s, due to the high increase in mechanical energy inside the extruder barrel, by the fraction, pressure and temperature, that caused high cooking of the raw materials and increase in starch gelatinization by the high temperature around (150C^o), all of this reasons make the produced pellets to be expanded, that is mean increasing of pellets volume with constant mass.

Feeding rate affects positively pellets bulk density at limit of screw speed around 2.11m/s that may be due to the more quantity of raw materials on the die zone which increase the compaction of materials granules and fore sure increase the ration mass in the constant volume of die holes.

The different effect of increasing feeding rate from 360 to 540 kg/h on pellets bulk density at screw speed of 2.36m/s could be due to the differences in die opening area, using die holes number of 19 and 24 the output area decreased with high feeding rate and high screw speed . That means high raw materials pressure on the die surface causing to high of increase in ration temperature, That causes the expansion of ration starch and increases the pellets volume at the same pellets mass. While increasing feeding rate using die holes number of 31and 36 holes increases the pellets bulk density by increasing the output area cause of decreasing the pressure .

Referring to the effect of number of holes on pellets bulk density, data show that increasing number of holes on the die surface (opening area) from 19 to 36 at screw speed of 2.11 m/s decreased the pellets bulk density by 13.74 %, 13.70 % and 13.52 % at die effective hole thickness of 10 mm, and by 15.15 %, 13.36 % and 13.70 % at die effective hole thickness of 15 mm ,and by 15.09 %, 13.41 % and 14.00 % at die effective hole thickness of 20 mm under feeding rates of 360, 432 and 540 kg/h. respectively .

The reason of negative effect of increasing die output area on pellets bulk density could be due to the decrease in raw materials compacted inside the die zone caused by the low compacting pressure .

Meanwhile there is a different effect of increasing the die number of holes on pellets bulk density at a speed of 2.36 m/s, the same figures showed that there is positive effect of increasing die opening area from 19 to 36 it increased the pellets bulk density by 11.36 % , 23.81 % and 35.29 % at die effective hole thickness of 10 mm, and by 10.49 % , 16.61 % and 24.37% at die effective hole thickness of 15mm and by 15.69%, 22.91 % and 43.87 % at die effective hole thickness of 20mm using feeding rates of 360, 432 and 540 kg/h respectively .

Theoretically the increase in opening area decreased the pellets bulk density, but practically with the high screw speed of 2.36m/s it increased the pellets bulk density, which could be due to the decrease in mechanical energy less than the expanding limit .

The increase in extruded pellets bulk density by increasing die effective hole thickness from 10 to 20 mm, could be due to the increase in raw materials retention time in die holes that means more compaction to the ration granules, caused increase in materials mass in the constant die holes volume.

This effect of die effective hole thickness is not constant with all the screw speeds, actually at 2.36m/s screw speed the increase of die effective hole thickness from 15 to 20 mm decreased slowly the extruded pellets bulk density by 6.26%, 3.75 %, 2.26 % and 1.84% at feeding rate of 360 kg/h, and by 5.58 %, 5.19 %, 0.24 % and 0.49 % at feeding rate of 432 kg/h ,and by 14.61 %, 7.28 %, 3.34% and 0.70 % at feeding rate of 540 kg/h, using die holes number of 19,24,31, and 36 respectively .

The little decrease in extruded pellets bulk density by increasing the die effective hole from15 to 20 mm, using screw speed of 2.36m/s could be due to the increase in retention time of raw materials in die holes which increased the temperature of die zone more than starch expansion limit, and that caused increase in pellets dimensions and volume with constant material mass flow through the die holes.

Effect of Different Operating Parameters on Pellets Durability

Pellets durability is considered one of the most important indicators of pellets quality. All the operation parameters such as, screw speed , number of holes on the die surface ,feeding rate ,and die effective hole thickness have a great influence on pellets durability (Fig. 5).

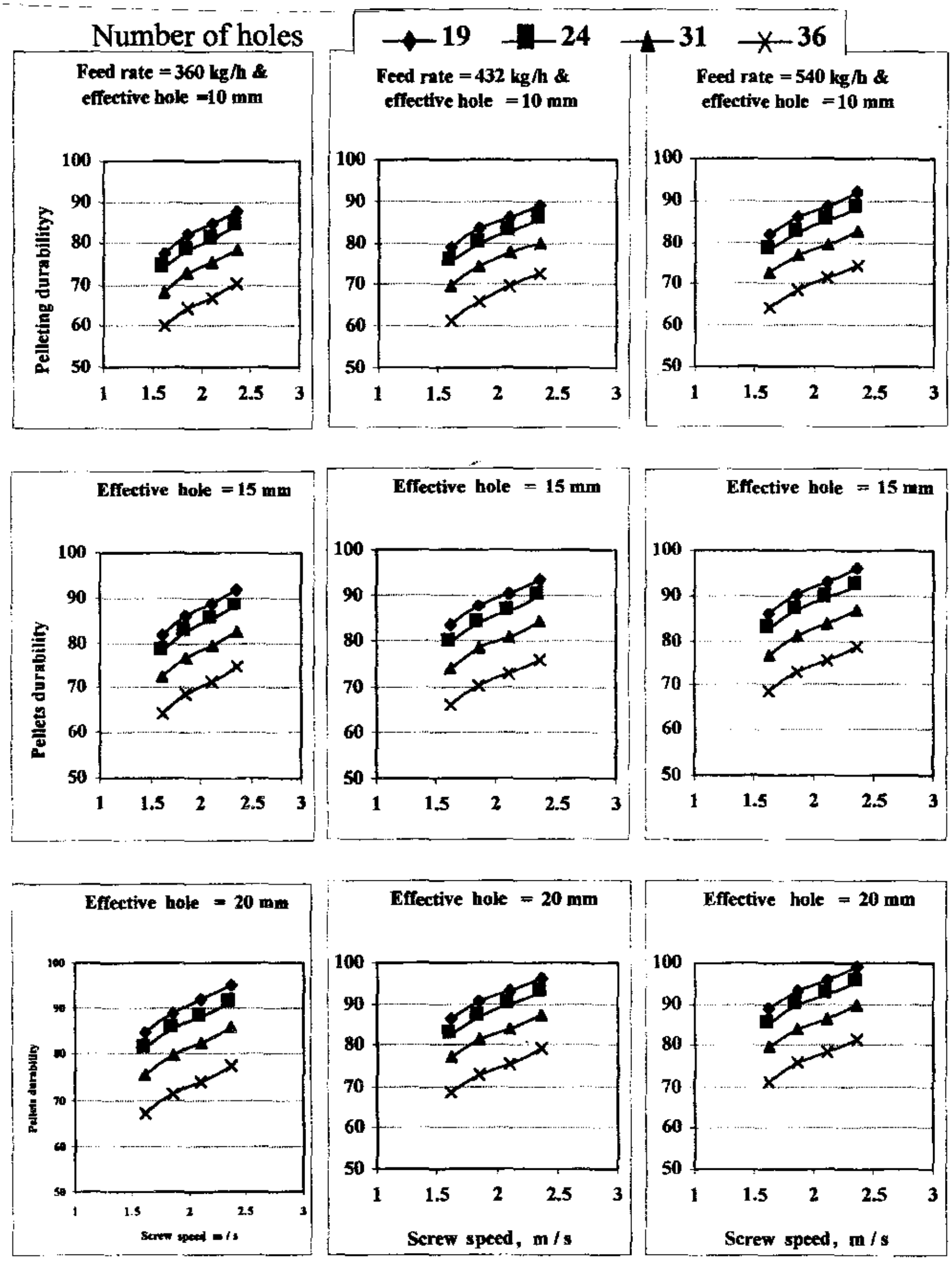


Fig.5:Effect of screw speed on pellets durability at different numbers of die holes ,different effective hole thicknesses and feeding rates .

Considering the effect of screw speed on pellets durability, results show that increasing screw speed from 1.62 to 2.36 m/sec with number of holes of 19, increased pellets durability by 12.98%, 12.31% and 11.90% at feeding rate of 360 kg/h, and by 12.81%, 12.00% and 11.73% at feeding rate of 432 kg/h., and by 12.36%, 11.67%, and 11.39% at feeding rate of 540 kg/h, under effective hole thicknesses of 10,15, and 20 mm respectively.

The increase of pellets durability by increasing screw speed could be due to the increase in pellets compression in the die zone, as well as increasing the temperature ,which remove the moisture from the cells between the granules, that make the pellets too hard with high resistance against cracking and breakage.

The increase in durability by increasing feeding rate could be due to increasing quantity of the ration which reaches the die zone in the same time unit, it means increasing pressure and temperature inside the die and more compaction for the pellets is expected.

Referring to the effect of number of holes on pellets durability, results show that ,increasing number of holes from 19 to 36 cause a decrease in pellets durability by 29.15%, 27.26%, and 26.21% at feeding rate of 360kg/h., and by 28.61 %, 26.66 % and 25.62 % at feeding rate of 432 kg/h, and by 27.29 % ,25.29 % and24.60% at feeding rate of 540 kg/h under effective hole thicknesses of 10,15, and 20 mm respectively.

This decrease of pellets durability by increasing number of holes from 19 to 36 holes/die could be due to increasing the out put area which decreases pressure in die zone extrusion, it means low level of pellets compaction and high amount of air between the ration granules.

While increasing pellets durability by increasing effective hole thickness could be due to increasing the retention time of the ration in the effective hole thickness which form hard pellets and increase the pellets resistance for durability test.

Effect of Different Operating Parameters on Extruder Energy Requirements

The extruded aquatic feed pellets energy requirements depend theoretically on consumed power and productivity ,also depend practically on the effect of the different operating parameters such as, screw speed, effective hole thickness, die hole numbers ,and feeding rate (Fig. 6).

Recording the effect of screw speed on the energy requirements ,

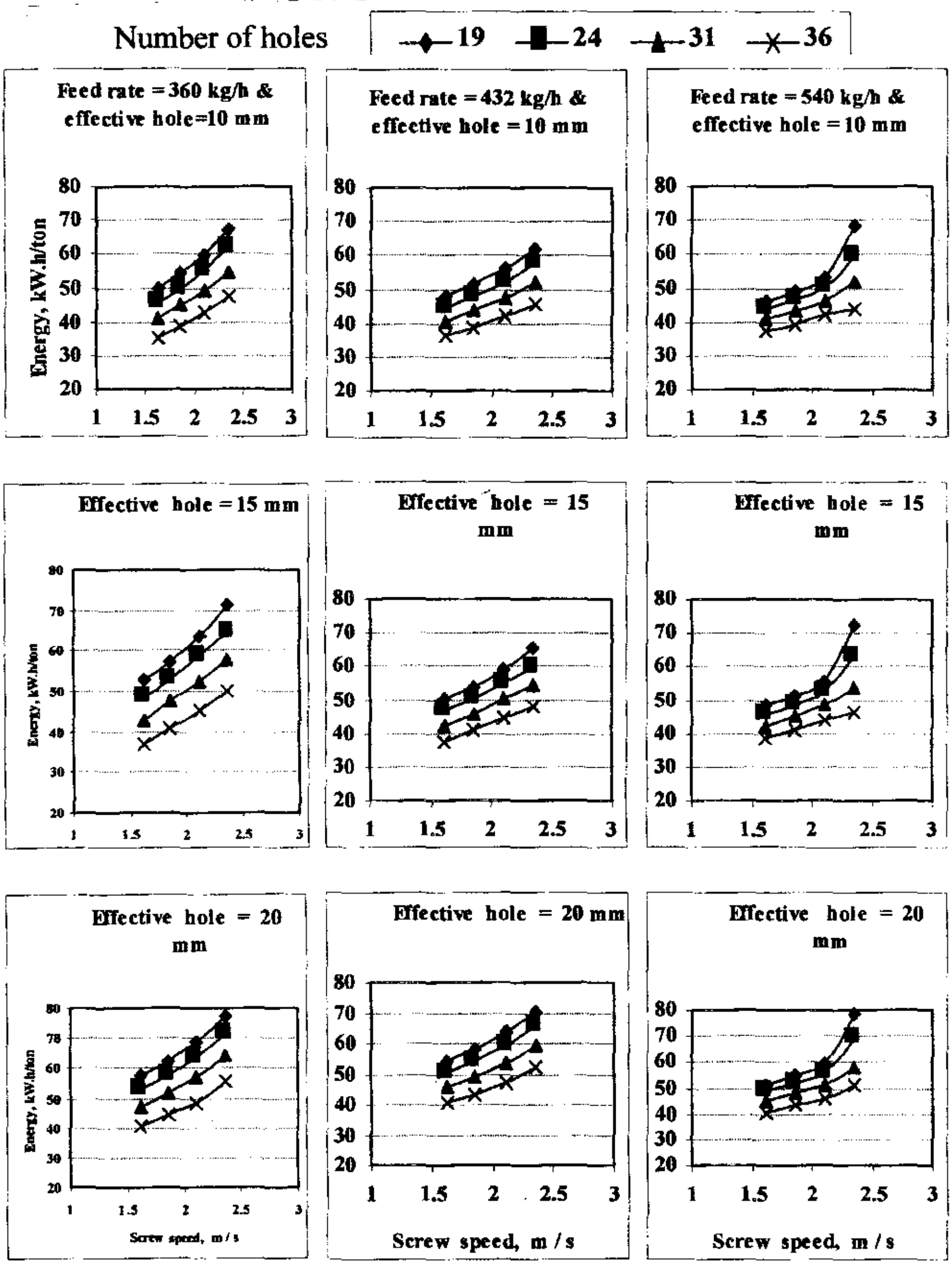


Fig.6:Effect of screw speed on consumed energy at different numbers of die holes , different effective hole thicknesses and feeding rates .

results show that increasing screw speed from 1.62 to 2.36 m/sec, increased the energy requirements by 34.02 %, 34.54%, and 36.70 % at feeding rate of 360 kg/h, and by 27.70 %, 27.67 %,and 29.88 % at feeding rate of 432 kg/h, and by 18.40 %, 20.99 %,and 28.38 %at feeding rate of 540 kg/h and under die hole number of 36 and effective hole thicknesses of 10,15 and 20 mm respectively.

The increase in energy requirements by increasing screw speed could be due to the high increase in the required power and at the same time insignificant increase in production rate was occurred.

While the decrease in energy requirements by increasing feeding rate, could be due to the increase in extruder productivity in the same time unit more than the increase of the required power.

On the other hand increase in energy requirements by increasing the feeding rate more than 432 kg/h up to 540 kg/h could be due to the sharply decrease in extruder productivity addition to the high increase of power consumed in this treatment. That means high power consumed with low production rate at the same time.

Regarding the effect of increasing the die holes number on energy requirements, results show that increasing die holes number from 19 to 36 at screw speed of 2.11 m/s it decreased the energy requirements by 28.68%, 28.62 %, and 29.52 % at feeding rate of 360 kg/h, by 24.98%, 25.04%, and 26.03% at feeding rate of 432 kg/h, and by 20.78%, 21.62% ,and 22.00% at feeding rate of 540 kg/h, at effective hole thicknesses of 10,15, and 20 mm respectively .

The decrease of energy requirements by increasing number of holes could be due to the increase in output area that caused a decrease in the pressure load and the required power, and increases the treatment production rate in the same time.

While the increase of energy requirement by increasing the effective hole thickness could be due to the decrease in extruder production rate by the increase in treatment consumed time .

Effect of different operating parameters on extruder pelleting cost

Decreasing the industrial cost is considered one of the most important aims of any company. The selection of operating parameters which decreases operating cost with high quality product still very difficult question in animals feed industry field. In this study the effect of some operating parameters on pelleting costs of extruded aquatic feed pellets were described (Fig. 7).

Concerning the effect of screw speed on pelleting cost . The data show that increasing the screw speed from 1.62 to 2.36m/s with die hole number of 19, increased the pelleting cost by 0.86%, 0.92%, and 1.01 % at feeding rate of 360 kg/h, and by 0.96%, 0.78 %,and 0.85 % at feeding rate of 432 kg/h, and by 1.39 %, 1.51 %, and 1.69 % at feeding rate of 540 kg/h under effective hole thicknesses of 10,15,and 20 mm respectively.

Pelleting cost increased by increasing the screw speed because of increase in power consumed is accompanied by insignificant increase in extruder productivity.

While the high decrease of pelleting costs by increasing feeding rate could be due to the high increase in extruder productivity with low increase in extruder power consumed.

Referring to the effect of number of die holes on pelleting cost, it is noticed that, increasing the die holes number from 19 to 36 at screw speed of 2.11 m/s, decreased the pelleting cost by 0.95 % , 1.01 % and 1.12 % at feeding rate of 360 kg/h, by 1.04 %, 0.79 %, and 0.89 % at feeding rate of 432 kg/h, and by 0.63 %, 0.66 %, and 0.72 % at feeding rate of 540 kg/h, under effective hole thickness of 10,15,and 20 mm respectively.

The sharply decrease in pelleting costs by increasing the number of die holes from 19 to 36 holes could be due to the increase in die opening area, it caused more increase in extruder productivity and decreased the load on extruder motor caused high decrease in extruder power consumed .

While the insignificant increase in pelleting costs by increasing the die effective hole thickness could be due to the low decrease in extruder productivity caused by increasing the raw materials retention time in die holes, and the low increase in the required power , caused by increasing the load on the extruder main motor.

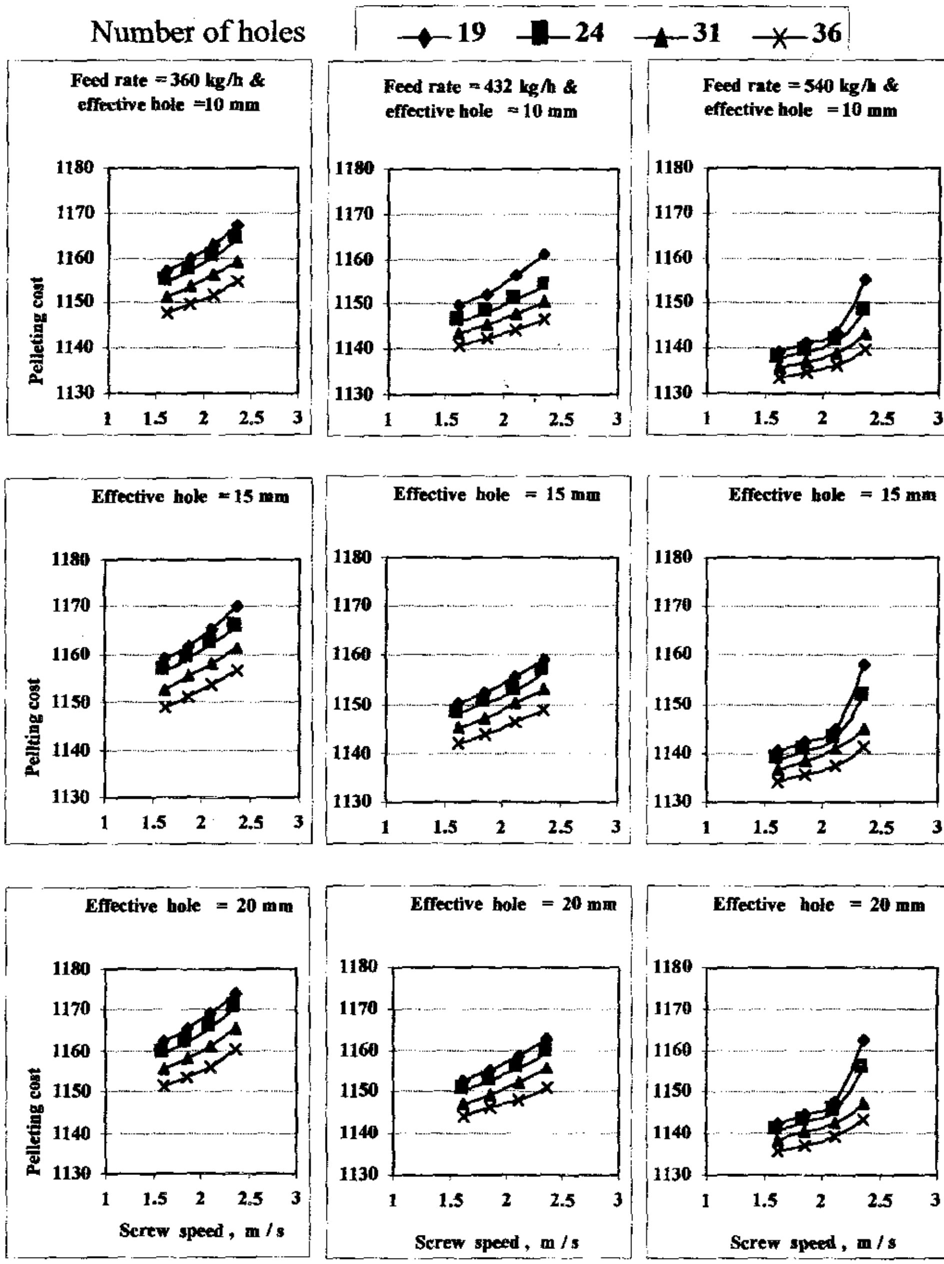


Fig.7:Effect of screw speed on pelleting cost at different numbers of die holes , different effective hole thicknesses and feeding rates

CONCLUSION

1. The extrusion pelleting machine is recommended to be used for producing fish pellets because of its maximum efficiency and minimum production costs .
2. Its recommended to operate the extrusion pelleting machine of screw speed of 2.11 m/sec. with feeding rate of432 kg/hr in order to minimize pelleting energy .
3. It is recommended to adjust the effective hole thickness at 15mm and number of die holes a 31 in order to produce high quality fish pellets .

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دراسة بعض العوامل الهندسية المؤثرة على إنتاج ماكينة تصنيع علف الأسماك

محمد محمد مراد [1] - محمود خطاب عفيفى [1]
أسامة احمد خليل قدور [2] - فيكتور ميخائيل داود [1]
١- قسم الهندسة الزراعية – كلية الزراعة – جامعة الزقازيق - مصر
٢- معهد بحوث الهندسة الزراعية – مركز البحوث الزراعية - الدقي – الجيزة – مصر

تعتبر الأسماك من أهم مصادر البروتين اللازمة لسد الفجوة الغذائية في البروتين الحيواني ،و من أهم الصعوبات التي تواجه التوسع في مجال الثروة السمكية التغذية و ارتفاع أسعار ماكينات تصنيع الأعلاف السمكية لذلك أجريت الدراسة على ماكينة أعلاف محلية الصنع تعمل بنظام بريمة الضغط لتصنيع المصبعات و دراسة العوامل الهندسية المؤثرة على تشغيلها و هى :

١ - سرعة بريمة الضغط
٢ - معدل التغذية
٣ - عدد ثقوب مشكل العلف (الداى)
٤ - السمك الفعال لمشكل العلف

و قد تم تقييم أداء الماكينة المستخدمة أخذا في الاعتبار كل من إنتاجية الآلة و كفاءة تكعيب الآلة وكثافة العلف و مقاومة العلف للنقل و الصدمات و كذلك كل من الطاقة اللازمة و تكاليف الإنتاج .

و قد تم تحديد أفضل نسب للعوامل الهندسية التي تم فحصها و هى استخدام السرعة ٢,١١ م/ث مع معدل تغذية ٤٣٢ كجم /ساعة و عدد ثقوب مشكل العلف ٣١ مع سمك فعال قدرة ١٥ مم حيث أوضحت النتائج أنه عند هذه القيم تكون أعلى إنتاجية و هى ٤٢٢ كجم /ساعة مع أفضل مقاومة علفية للنقل و الصدمات بنسبة ٨١,٠٨% ،و تكون كفاءة التكعيب ٧٣,١٥% ،وكثافة العلف ٠,٩١١ كجم/سم٣، و تكون احتياجات الطاقة اللازمة لعملية التكعيب تساوى ٥٠,٠٣ كيلووات/طن ، و اقل تكلفة إنتاج و هى ١١٥٠ جنية للطن.