

| | CONTENT | Page NO. |
|-----------------|--|-----------------|
| | LIST OF TABLES | IV |
| | LIST OF FIGURES | VII |
| | LIST OF SYMBOLS.... .. | XII |
| | ACKNOWLEDGEMENT..... | |
| 1. | INTRODUCTION | 1 |
| 2. | REVIEW OF LITERATURE..... | 4 |
| 2.1 | Melon seeds extraction machinery..... | 5 |
| 2.2 | Some physical and mechanical properties of melon seeds | 10 |
| 2.3. | Origin and distribution of melon seeds | 12 |
| 2.4. | Economic importance and uses of melon seeds | 14 |
| 2.5. | Seed extraction methods and equipment | 17 |
| 2.6. | Factors affecting of seed extraction equipment | 20 |
| 2.7. | Effect of drying method on seed quality of melon seeds..... | 26 |
| 2.8. | Power consumed for mechanical extraction | 28 |
| 2.9. | Cost estimation | 31 |
| 3. | MATERIALS AND METHODS..... | 36 |
| 3.1 | Materials..... | 36 |
| 3.1.1 | Manufacturing and experimental layout | 36 |
| 3.1.2. | The prototype of melon seeds extracting | 37 |
| 3.1.2.1. | Frame | 37 |
| 3.1.2.2. | Feeding hopper | 39 |
| 3.1.2.3. | Cutting drum | 40 |
| 3.1.2.4. | Crushing drum | 41 |
| 3.1.2.5. | Extraction drum | 42 |
| 3.1.2.6. | Concave | 42 |

| | | |
|-----------|--|----|
| 3.1.2.7. | Peels outlet..... | 42 |
| 3.1.2.8. | Conveying auger of seeds..... | 43 |
| 3.1.2.9. | Cleaning brushes..... | 43 |
| 3.1.2.10. | Seeds outlet..... | 44 |
| 3.1.2.11. | Transmission system..... | 44 |
| 3.2 | Measuring instruments | 45 |
| 3.2.1 | Drying oven | 45 |
| 3.2.2. | Balances | 45 |
| 3.2.3. | Stop watch | 45 |
| 3.2.4. | Canvas | 45 |
| 3.2.5. | Bags | 45 |
| 3.2.6. | Fuel consumption apparatus | 46 |
| 3.2.7. | Hardness tester | 46 |
| 3.2.8. | Vernier | 46 |
| 3.3. | Melon seeds fruit..... | 46 |
| 3.4. | Measurements | 47 |
| 3.4.1. | Performance evaluation | 47 |
| 3.4.2. | Measurement of size and mass of seeds for melon seeds..... | 49 |
| 3.4.3. | Physical properties of seeds for melon seeds | 50 |
| 3.4.4. | Mechanical properties of seeds for melon seeds..... | 52 |
| 3.4.5. | Cleaning efficiency | 56 |
| 3.4.6. | Extraction efficiency..... | 57 |
| 3.4.7. | Machine productivity | 57 |
| 3.4.8. | Seed losses | 58 |
| 3.4.9. | Seeds damage..... | 58 |
| 3.4.10. | Material discharge efficiency..... | 58 |

| | | |
|----------|--|----|
| 3.4.11. | The overall efficiency..... | 59 |
| 3.4.12. | Fuel and Power determination..... | 59 |
| 3.4.13. | Determination of specific energy..... | 61 |
| 3.4.14. | Cost analysis | 61 |
| 3.4.14.1 | Fixed costs | 61 |
| 3.4.14.2 | Variable costs | 63 |
| 3.4.14.3 | Total costs..... | 63 |
| 3.5. | Experimental layout and statistical analysis..... | 64 |
| 4. | RESULTS AND DISCUSSION..... | 65 |
| 4.1. | Experiments on seed extraction prototype..... | 65 |
| 4.1.1 | Effect of drum speed, feed rate and time span on seeds machine productivity | 66 |
| 4.1.2. | Effect of drum speed, feed rate and time span of on seed losses..... | 68 |
| 4.1.3. | Effect of drum speed, feed rate and time span on seed damage..... | 70 |
| 4.1.4. | Effect of drum speed, feed rate and time span on extraction efficiency..... | 72 |
| 4.1.5. | Effect of drum speed, feed rate and time span on machine discharge efficiency..... | 75 |
| 4.1.6. | Effect of drum speed, feed rate and time span on overall efficiency..... | 77 |
| 4.1.7. | Effect of drum speed, feed rate and time span on cleaning efficiency..... | 79 |
| 4.1.8. | Effect of drum speed, feed rate and time span on power consumption | 81 |

| | | |
|---------------|---|------------|
| 4.1.9. | Effect of drum speed, feed rate and time on total cost..... | 84 |
| 5. | SUMMARY AND CONCLUSION..... | 86 |
| 6. | REFERENCES..... | 92 |
| 7. | APENDIX | 102 |
| 8. | ARABIC SUMMARY..... | |

LIST OF TABLES

| Table No. | | Page No. |
|------------------|--|-----------------|
| 1 | The technical specifications of manufactured melon seeds extraction machine prototype..... | 39 |
| 2 | Physical and mechanical properties of melon seeds..... | 56 |
| 3 | Manufacture price, economic life and hour per year of extraction operation in the study..... | 62 |
| 4 | Effect of drum speed, feed rate and time span of melon seeds on total cost..... | 85 |
| 5 | Multiple regression coefficients for the output parameters of the extraction machine during experiments..... | 90 |
| 6 | Effect of drum speed, feed rate and time span of melon seeds on seeds machine productivity | 102 |
| 7 | Effect of drum speed, feed rate and time span of melon seeds on seed losses | 103 |
| 8 | Effect of drum speed, feed rate and time span of melon seeds on seed damage..... | 104 |
| 9 | Effect of drum speed, feed rate and time span of melon seeds on extraction efficiency..... | 105 |
| 10 | Effect of drum speed, feed rate and time span of melon seeds on machine discharge efficiency | 106 |
| 11 | Effect of drum speed, feed rate and time span of melon seeds on overall efficiency | 107 |
| 12 | Effect of drum speed, feed rate and time span of melon seeds on machine discharge efficiency | 108 |

| | | |
|----|---|-----|
| 13 | Effect of drum speed, feed rate and time span of melon seeds on cleaning efficiency..... | 109 |
| 14 | Effect of drum speed, feed rate and time span of melon seeds on power consumption | 110 |
| 15 | Effect of drum speed, feed rate and time span of melon seeds on specific energy..... | 111 |
| 16 | Type III sum of square analysis and summary statistical according to analysis of variance (ANOVA) for seeds machine productivity with 2 levels of interaction | 112 |
| 17 | Type III sum of square analysis and summary statistical according to analysis of variance (ANOVA) for seed losses with 2 levels of interaction | 113 |
| 18 | Type III sum of square analysis and summary statistical according to analysis of variance (ANOVA) for extraction efficiency with 2 levels of interaction | 114 |
| 19 | Type III sum of square analysis and summary statistical according to analysis of variance (ANOVA) for machine discharge efficiency with 2 levels of interaction | 115 |
| 20 | Type III sum of square analysis and summary statistical according to analysis of variance (ANOVA) for overall efficiency with 2 levels of interaction | 116 |
| 21 | Type III sum of square analysis and summary statistical according to analysis of variance (ANOVA) for cleaning efficiency with 2 levels of interaction | 117 |
| 22 | Type III sum of square analysis and summary statistical according to analysis of variance (ANOVA) for power consumption with 2 levels of interaction..... | 118 |

LIST OF FIGURES

| Table NO. | | Page NO. |
|------------------|---|-----------------|
| 1 | Schematic flow diagram of a seed extractor (Todd et al., 1983)..... | 5 |
| 2 | Schematic flow diagram of melon seeds depodding machine..... | 8 |
| 3 | Transverse and longitudinal section of melon seeds fruit (Akubuo and Odigboh, 1999)..... | 13 |
| 4 | Schematic diagram of conventional prototype of melon seeds extracting machine (Eliwa and Elfatih, 2012)..... | 25 |
| 5 | A photograph of the prototype melon seed extraction..... | 37 |
| 6 | Schematic diagram of the prototype for melon seeds extraction..... | 38 |
| 7 | Experiment design..... | 40 |
| 8 | Schematic diagram of cutting drum..... | 41 |
| 9 | Schematic diagram of crushing drum..... | 41 |
| 10 | Schematic diagram of extracting drum..... | 42 |
| 11 | Schematic diagram of cleaning brushes..... | 43 |
| 12 | Schematic diagram of transmission system..... | 44 |
| 13 | A photograph of melon seeds fruit..... | 47 |
| 14 | A photograph of seeds for melon seeds | 48 |
| 15 | Characteristic dimension of melon seeds and kernel | 51 |
| 16 | Terminal velocity set up (Awady and El-sayed,1994)..... | 53 |
| 17 | A photograph of friction coefficient apparatus..... | 54 |
| 18 | A photograph of hardness apparatus..... | 55 |
| 19 | Fuel consumption apparatus..... | 60 |

| | | |
|----|---|-----|
| 20 | Effect of drum speed, feed rate and time span on seeds machine productivity of melon seeds..... | 67 |
| 21 | Effect of drum speed, feed rate and time span on seed losses of melon seeds | 69 |
| 22 | Effect of drum speed, feed rate and time span on seed damage of melon seeds | 71 |
| 23 | Effect of drum speed, feed rate and time span on extraction efficiency of melon seeds | 73 |
| 24 | Effect of drum speed, feed rate and time span on material discharge efficiency of melon seeds | 75 |
| 25 | Effect of drum speed, feed rate and time span on overall efficiency of melon seeds | 78 |
| 26 | Effect of drum speed, feed rate and time span on cleaning efficiency of melon seeds | 80 |
| 27 | Effect of drum speed, feed rate and time span on power consumption of melon seeds | 82 |
| 28 | The process diagram of the melon seeds extractor..... | 119 |
| 29 | A photograph for melon seeds extraction during work..... | 120 |
| 30 | Determination of the pitch diameter of sprocket wheel..... | 121 |
| 31 | Spur gear tooth forces (Kurtz et al., 1984) | 122 |
| 32 | Gear tooth load (Kurtz et al., 1984)..... | 123 |
| 33 | Forces acting upon melon seeds on an inclined plane..... | 124 |
| 34 | The major (a) and minor (b) radius of melon seeds fruit.... | 125 |

LIST OF SYMBOLS

| Symbol | | Unit |
|---------------|---|-------------------|
| ρ_b | Bulk density of melon seeds | g/cm ³ |
| ρ_r | Real density of melon seeds | g/cm ³ |
| ε | The porosity of melon seeds | % |
| <i>SFC</i> | Static friction coefficient | ----- |
| P | Machine productivity of seeds for melon seeds | kg/h |
| S_l | Seed losses | % |
| s_d | Seed damage | % |
| η_e | Extraction efficiency | % |
| E_{md} | Material discharge efficiency | % |
| E_o | Overall efficiency | % |
| η_{cl} | Cleaning efficiency | % |
| P_c | Power consumption | kW |
| <i>SER</i> | Specific energy require | kW.h/ton |

5. SUMMARY AND CONCLUSION

This study was carried out during season 2013/2014, which includes two parts. Physical and mechanical properties are determined for melon seeds, melon seeds fruit and extraction processes. Determined physical and mechanical properties for melon seeds were carried out at Rice Mechanization Center, Meet El-Deeba, Kafrelsheikh Province. While, extraction process was carried out during season 2014/2015 at El-ete had village, Kafrelsheikh governorate. The manufactured prototype consists of frame, feeding hopper, crushing and extracting unit, peels outlet, conveying auger of seeds, cleaning brushes and seeds outlet. The prototype evaluation done based on machine productivity, extraction efficiency, cleaning efficiency, seed damaged, power consumed, and operational cost. This study has included the following specific objectives:

1. To develop a mechanical melon seeds extractor, which will improve the quality and quantity of extracted melon seeds and reduce drudgery.
2. To evaluate the extraction prototype based on cleaning efficiency, extraction efficiency, machine productivity, power consumed and seed damaged.
3. To calculate cost effectiveness and estimate of economic impact of manufactured prototype.

Performance of the extraction machine was evaluated under the following parameter:

- a. Five drum speeds (3.25, 5.47, 6.98, 8.52, 10.64 m/s,) (345, 580, 740, 903 and 1130 rpm, respectively).

Summary and Conclusion

- b. Four feeding rates (20, 30, 40, 50 kg/min) and
- c. Four Time-spans of extracting after harvesting (0, 3, 6, 9 days).

The experiments were carried out with three replicates to evaluate the extraction performance in the following terms: cleaning efficiency, extraction efficiency, machine productivity, material discharge efficiency, overall efficiency, power requirements, seed damage percentage, seed losses percentage and cost estimation.

The following conclusions are drawn from the study:

1. The machine productivity, kg/h, decreased by increasing crushing drum speed, it had directly proportional to feed rate and melon seeds time span. The highest value of machine productivity of seed was 152.14 kg/h at crushing drum speed of 3.25 m/s; feed rate of 50 kg/min and melon seeds time span 9 days. However, the lowest value of machine productivity was 49.36 kg/h at crushing drum speed of 10.64 m/s; feed rate of 20 kg/min and melon seeds time span 0 day.
2. The seed losses. %, increased by increasing crushing drum speed and melon seeds feed rate. Whereas it had inversely proportional of melon seeds time span. The highest value of seed losses were 7.82 % at crushing drum speed of 10.64 m/s; feed rate of 50 kg/min and melon seeds time span 0 day. Where the lowest value was 1.15 % at crushing drum speed of 3.25 m/s; feed rate of 20 kg/min and melon seeds time span 9 days.
3. The seed damage. %, increased by increasing crushing drum speed whereas, it had inversely proportional to crop feed rate and melon seeds time span. The highest value of seed damage was 5.22 % at crushing drum speed of 10.64 m/s; feed rate of 20 kg/min and melon seeds time span 0 day. Where, the lowest value was 1.53 % at

Summary and Conclusion

crushing drum speed of 3.25 m/s; feed rate of 20 kg/min and melon seeds time span 9 days.

4. The extraction efficiency, %, decreased by increasing crushing drum speed while, it had inversely proportional to crop feed rate and melon seeds time span. The highest value of extraction efficiency was 98.85 % at crushing drum speed of 3.25 m/s; feed rate of 20 kg/min and melon seeds time span 9 day
5. The material discharge efficiency, %, decreased by increasing crushing drum speed while, it had inversely proportional to crop feed rate and melon seeds time span. The highest value of material discharge efficiency was 52.44 % at crushing drum speed of 3.25 m/s; feed rate of 20 kg/min and melon seeds time span 0 day. Meanwhile, the lowest value of material discharge efficiency was 16.07 % at crushing drum speed of 10.64 m/s; feed rate of 50kg/min and melon seeds time span 9 day
6. The overall efficiency. %, decreased by increasing crushing drum speed, also it had inversely proportional to crop feed rate and melon seeds time span. The highest value of overall efficiency was 50.48 % at crushing drum speed of 3.25 m/s; feed rate of 20 kg/min and melon seeds time span 0 day. Meanwhile, the lowest value of material discharge efficiency was 15.21 % at crushing drum speed of 10.6 m/s; feed rate of 50 kg/min and melon seeds time span 9 day
7. The cleaning efficiency, %, increased by increasing crushing drum speed while, it had inversely proportional to crop feed rate and directly proportional to melon seeds time span. The highest value of cleaning efficiency was 88.83 % at crushing drum speed of 10.64 m/s; feed rate of 20 kg/min kg/h and melon seeds time span 9 days. Meanwhile, the lowest value of cleaning efficiency was 74 % at

Summary and Conclusion

crushing drum speed of 3.25 m/s; feed rate of 50 kg/min and melon seeds time span 0 day

8. The power consumption, kW, increased by crushing drum speed and melon seeds feed rate, whereas, it had inversely proportional to melon seeds time span. The highest value of power consumption was 5.98 kW at crushing drum speed of 10.64 m/s; feed rate of 20 kg/min and melon seeds time span 0 day. While, the lowest value was 2.61 at crushing drum speed of 3.25 m/s; feed rate of 50 kg/min and melon seeds time span 9 days.
9. The specific energy, kW.h/Mg, increased by crushing drum speed and melon seeds feed rate whereas, it had inversely proportional to melon seeds time span. The highest value of specific energy was 92.99 kW.h/Mg at crushing drum speed of 10.64 m/s; feed rate of 20 kg/min and melon seeds time span 0 day. While, the lowest value was 21.05 kW.h/Mg at crushing drum speed of 3.25 m/s; feed rate of 50 kg/min and melon seeds time span 9 days.
10. The total cost, LE/kg, increased by melon seeds time span whereas, it had inversely proportional to crushing drum speed and melon seeds feed rate. The highest value total cost was 0.68 LE/kg at crushing drum speed of 10.64 m/s; feed rate of 20 kg/min and melon seeds time span 0 day. Meanwhile, the lowest value was 0.21 LE/kg at crushing drum speed of 3.25 m/s; feed rate of 50 kg/min and melon seeds time span 9 days.
11. A multiple regression analysis was made taking cleaning efficiency (η_c), extraction efficiency (η_e), machine productivity (M_p), seed damage (S_d), and power consumption (P_c), as dependent variables and time span of melon seed, melon seeds feed rate and crushing

Summary and Conclusion

drum speed as independent variables. The regression equation was as follows:

$$Y = a_0 + b_1 T.S + b_2 F.R + b_3 C.S \dots\dots\dots (5.1)$$

Where:

Y = dependent variable,

T.S = time span of melon seeds, day, ($0 \leq TS \leq 9$),

F.R. = Melon seeds feed rate, kg/min, ($20 \leq F.R \leq 50$)

C.S = crushing drum speed, m/s, ($3.25 \leq S \leq 10.64$)

a_0 = Constant and

a_1, b_2 and b_3 = regression coefficients.

Table 5: Multiple regression coefficients for the output parameters of the extraction machine during experiments.

| Dependent variable (Y) | a_0^* | Regression coefficients | | | R^2 |
|------------------------|---------|-------------------------|--------|---------|-------|
| | | b_1 | b_2 | b_3 | |
| Machine productivity | 2.320 | 0.980 | 2.680 | - 1.150 | 0.993 |
| Seed losses | 2.220 | -0.380 | 0.085 | 0.110 | 0.970 |
| Seed damage | 5.640 | -0.950 | -0.056 | -0.520 | 0.820 |
| Machine discharge | 68.820 | -1.016 | -0.034 | 2.450 | 0.880 |
| Overall efficiency | 66.480 | -0.856 | -0.360 | 2.330 | 0.880 |
| Extraction efficiency, | 97.660 | 0.330 | -0.087 | - 0.075 | 0.972 |
| Cleaning efficiency | 80.180 | 1.08 | -0.112 | - 0.085 | 0.697 |
| Power consumption | 0.635 | -0.970 | 0.044 | 0.029 | 0.960 |

* a_0 = constant

a_1, b_2 and b_3 = regression coefficients

Summary and Conclusion

Applied recommendations:

1. The best performance for the extraction machine were obtained at crushing drum speed of 3.25 m/s feed rate of 20 kg/min and melon seeds time span of 9 days, where it gave the following results:
 - a. Machine productivity of 152.14 kg/h.
 - b. Seed losses of 1.15%.
 - c. Seed damage of 1.53 %.
 - d. Extraction efficiency of 98.85 %,
 - e. Material discharge efficiency of 52.44 %.
 - f. Overall efficiency of 50.48 %.
 - g. Cleaning efficiency of 88.83 %.
 - h. Specific energy of 21.06 kW.h/Mg.
 - i. Total cost of 0.21 LE/kg.

The study strongly recommended to use mechanical extraction using the prototype for melon seeds due to the labor shortage during the harvesting time.