

Contents

1	Introduction	1
1.1	Task Description	1
1.2	Conveying Methods	1
1.3	Pneumatic Conveying	4
	References	7
2	General Principles	9
2.1	Conveying Gas	10
2.1.1	Density	10
2.1.2	Viscosity	11
2.1.3	Moisture	11
2.1.4	Mixture Temperature	13
2.1.5	Calculation Example 1: Condensation Along a Conveying Line	14
2.2	Bulk Material	19
2.2.1	Resting Pressure Coefficient	20
2.2.2	Individual Particles	22
2.2.3	Bulk Solid	24
2.2.4	Consideration as a Continuum	32
2.2.5	Adhesive Forces	39
2.2.6	Sorption Behavior	44
2.2.7	Combustion and Explosion Characteristics	45
2.3	Conservation Laws of Multiphase Systems	49
2.3.1	Mass Conservation	50
2.3.2	Momentum Conservation	51
2.3.3	Energy Conservation	53
2.3.4	Calculation Example 2: Pressure Loss of a Compressible Gas Flow	54

2.4	Scale-up, Dimensional Analysis	56
2.4.1	Model Transfer.	56
2.4.2	Dimensional Analysis	57
2.4.3	Calculation Example 3: Model Transfer of Pneumatic Conveying Experiments.	62
2.5	Pressure Losses of Single-phase Fluids	68
2.5.1	Horizontal Pipe Flow	68
2.5.2	Vertical Pipe Flow	70
2.5.3	Deflections, Other Pressure Losses	70
	References.	71
3	Gas/Solid Systems	75
3.1	Single Particles in the Gas Stream.	75
3.1.1	Particle Flow Around	75
3.1.2	Influences on c_w	78
3.1.3	Settling Velocity.	80
3.1.4	Calculation Example 4: Acceleration Distance of a 10 μm Particle	82
3.2	Flow through Bulk Materials.	85
3.2.1	Stationary Bed Packing	85
3.2.2	Moving Bulk Material	86
3.2.3	Further Influences	87
3.2.4	Calculation Example 5: Determination of a Characteristic Particle Diameter	88
3.3	Fluidized Beds	92
3.3.1	Fluidization Velocity	92
3.3.2	Geldart Diagram/Classification	94
3.3.3	Operation of Fluidized Beds	98
3.4	Particle Swarm in Gas Flow.	102
	References.	103
4	Basics of Pneumatic Conveying	105
4.1	Conveying Diagram	105
4.1.1	Standard Representation	105
4.1.2	Modified Representations	108
4.2	Flow Forms	109
4.3	Introduction to Dense Phase Conveying	113
4.3.1	Delimitation of Dilute and Dense Phase Conveying	114
4.3.2	Advantages and Disadvantages	118
4.3.3	Calculation Example 6: Expansion of a Conveying System	119
4.4	Processes at the Plug	121
4.5	Bulk Material Influences on Conveying Behavior.	126
4.6	Characteristic Gas Velocities	132

4.6.1	Interaction of Pressure Generator and Conveying Line	132
4.6.2	Horizontal Minimum Conveying Gas Velocity	133
4.6.3	Vertical Minimum Conveying Gas Velocity, <i>Choking</i>	138
4.6.4	Characteristic Horizontal Conveying Gas Velocities	143
4.6.5	Calculation Example 7: Calculation of Characteristic Conveying Speeds	148
4.7	Pressure Loss in Pneumatic Conveying Lines	157
4.7.1	Solid Friction Horizontal Straight Pipe	158
4.7.2	Solid Friction Vertical Straight Pipe	162
4.7.3	Solid Lifting	162
4.7.4	Solid Initial Acceleration	163
4.7.5	Solid Deflection	164
4.7.6	Pressure Loss of Conveying Gas	169
4.7.7	Compressible Flow	170
4.8	Velocity Ratio Solid/Gas	173
4.9	Calculation Example 8: Characteristic Curve of a Pneumatic Vertical Conveying	174
4.10	Interaction of Pipeline Elements	178
4.10.1	Vertical Section with Upstream 90° Deflection	178
4.10.2	Potential Problem Sources in Conveying Routes	184
4.11	Staggering of Conveying Lines	189
4.11.1	Calculation Model	190
4.11.2	Checks/Applications	195
4.12	Energy Optimization	200
4.12.1	Basic Relationships	201
4.12.2	Applications	204
4.12.3	Calculation Example 9: Energetic Optimization of a Fly Ash Conveying	211
4.13	Selected Measurement Results	213
4.13.1	Length Dependency of the Conveying Diagram	213
4.13.2	Solid Dependence of Conveyance	214
4.13.3	Influence of Grain Size Distribution	215
4.13.4	Unstable Operating Conditions of Specific Bulk Materials	217
	References	219
5	Special Calculation Approaches, Scale-up	225
5.1	Strand Conveyance of Fine-Grained Bulk Materials	225
5.1.1	Gas Distribution Over the Conveying Pipe Cross-Section	226
5.1.2	Calculation Approaches	230
5.2	Plug Conveying of Coarse-Grained Bulk Materials	242
5.3	Scale-up of Conveying Systems	251
5.3.1	Minimum Velocity, Reference State	252

5.3.2	Pipeline Pressure Loss	252
5.3.3	Required Experimental Effort	259
5.3.4	Experimental Verification.	260
5.3.5	Procedure for Scale-up.	265
5.3.6	Calculation Example 10: Dimensional Analysis Verification of the Scale-up Approach	266
5.4	Calculation with Equivalent Lengths.	268
5.4.1	Calculation Approach.	268
5.4.2	Applications.	270
5.4.3	Calculation Example 11: Reactor Feeding with Parallel Conveying Lines	273
	References.	275
6	Modern Dense Phase Conveying Methods	279
6.1	Controlled Plug Generation	279
6.2	Targeted Plug Dissolution	283
6.3	Suspension Methods	285
6.4	Processes with Uncontrolled Gas Addition	286
6.5	Notes on Process Selection	287
6.6	FLUIDCON Conveying.	289
6.6.1	Structure and Function.	290
6.6.2	Suitable Bulk Materials	294
6.6.3	Calculation Approach.	295
6.6.4	Application Examples	298
	References.	305
7	Bulk Material Locks	307
7.1	Pressure Vessel Locks	308
7.1.1	Single Pressure Vessel	310
7.1.2	Twin Pressure Vessel	325
7.1.3	Double-deck Pressure Vessel	326
7.1.4	Multi-pressure Vessel.	329
7.1.5	Tank vehicle	331
7.2	Screw Feeders	333
7.2.1	Designs and Operating Principle	334
7.2.2	Feeder Size.	336
7.2.3	Drive Power	342
7.3	Rotary Valve Locks	344
7.3.1	Feeder size, conveying characteristic.	346
7.3.2	Leakage Gas Flow and Removal	351
7.3.3	Drive Power	358
7.3.4	High-pressure Locks	360
7.3.5	Practical Aspects	363

7.4	Injector Feeder	365
7.4.1	Operating Principle	366
7.4.2	Calculation Approaches	368
7.4.3	Practical Application	372
7.5	Flap Locks	373
7.6	Pneumatic Vertical Conveyors (Airlift)	374
7.7	Suction Nozzles	378
	References.	380
8	Wear in Conveying Systems	383
8.1	Basics of Impact and Sliding Wear	384
8.1.1	Contact and Fracture Mechanical Influencing Factors	384
8.1.2	Wear Mechanisms	392
8.1.3	Calculation Approaches/Models	395
8.1.4	Dependencies of Wear	398
8.2	Wear in Pneumatic Conveying Systems.	413
8.2.1	Conveying Line	413
8.2.2	Rotary Valve.	418
8.2.3	Screw Feeder	419
8.2.4	Pressure vessel lock	420
8.3	Wear Measurement and Prediction	422
8.4	Calculation Example 12: Wear Analysis of a 90° Deflector	428
	References.	430
9	Design of a Conveying System	433
9.1	Task Description	433
9.2	Clarification of the Task.	433
9.3	Evaluation of the Conveyed Material.	435
9.4	Selection of the Solid Lock	436
9.5	Design of the Conveying Route	437
9.6	Design of the Pressure Vessel Lock	453
9.7	Filter Verification	459
	References.	464