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PORTABLE FRUIT DRYER

ME 4098 ENGINEERING PROJECT

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NOMENCLATURE

A	:	Cross-sectional area, (m ²)
g	:	Gravitational force, (m/s ²)
h	:	Entalphy, (kj/kg)
H	:	Absolute humidity, (kg water/kg dry air)
m	:	Mass, (kg)
Q	:	Heat transfer, (kj)
T	:	Temperature, (°C)
V	:	Velocity, (m/s)
X_{wb}	:	Wet bulb moisture content, (kg water/kg wet solid)
X_{db}	:	Dry bulb moisture content, (kg water/kg dry solid)
<i>m</i>	:	Mass flow rate, (kg/s)
<i>V</i>	:	Volumetric flow rate, (m ³ /s)
ρ	:	Density, (kg/m ³)
RH	:	Relative Humidity
R	:	Drying rate, (kg/h.m ²)
h_{coeff}	:	Heat Transfer ceofficient, (W.m ² /K)

SUMMARY

Drying is one of the processes aimed at extending the shelf life of agricultural products without losing their nutritive properties during the period until they are consumed. Drying is defined as a product preservation method applied on an industrial scale with heated air in order to reduce the amount of water in fruits and vegetables, thereby minimizing biochemical, chemical and microbiological spoilage.

In this study, a portable fruit dryer was examined. The aim of this study was to dry fresh fruits as soon as they were harvested. Because fresh fruit has disadvantages such as transportation costs, physical disinformation such as deterioration, crushing and decay until it reaches the drying factory. For this reason, we have worked on a fruit dryer with a high capacity cabinet that can be carried.

In the first part of the study, the concept of drying was tried to be understood. The stages of drying and the methods of drying were examined. The effective conditions in drying were investigated. A study was carried out for the drying method and dryer type to be used in the design.

The next section was the study of fruit drying. There is a very high amount of water in the structure of fruits. At the end of drying, the target is to reduce this amount of water while minimizing the quality loss. For this, the pre-treatments before fruit drying were examined. Research was conducted on the main purposes of drying and the dynamics of drying.

In the third chapter, studies were made for the design of the fruit dryer. A container cabinet survey was conducted for the dryer. Heater and fan are important components for design. Research was carried out to identify them and learn their properties. The heater and fan to be used in the dryer were decided. A search was made for a low-cost fuel that could provide the needed energy for this heater. Since it is more convenient and efficient in the cabin, the trays were designed and these components were assembled.

In the last part, the physical and mathematical modeling of the fruit dryer system was done. The heater and dryer were evaluated as two separate components, and mass and energy equations were obtained for them

CHAPTER 1. INTRODUCTION TO DRYING

1.1 Drying

From a physics point of view, drying is a complex diffusion process. The drying process is the removal of liquids from gases, liquids or solids. The liquid can be water or any substance in the substance. The most common use of the drying process is defined as the process of removing water or other volatile substances from solid materials by thermal applications.

Drying is one of the oldest methods used since ancient times to preserve food for a long time. People have ensured that some of the agricultural and animal products they consume are preserved for a long time by drying them in suitable weather conditions. The method is based on the principle of first evaporating the water from the food and then removing this steam from the surface of the product. With the loss of available water, the water activity is reduced below the level at which microorganisms can grow; spoilage caused by bacteria, molds and yeasts is prevented and foods can be preserved for a longer period of time. Thus, the volume of the product is reduced and ease of transportation and storage is provided. This process was traditionally done in the sun. Materials made of soil and ceramics, which have survived to the present day, are obtained by drying and firing the raw material used after processing. This shows that the drying process has been used by people in production activities since the past.

When a wet solid is subjected to thermal drying two processes occur simultaneously:

- I. Transfer of energy (mostly as heat) from the surrounding environment to evaporate the surface moisture – Heat transfer
2. Transfer of internal moisture to the surface of the solid and its subsequent evaporation due to process I – Mass transfer or moisture transfer

Process 1: The removal of water as vapor from the material surface, depends on the external conditions of temperature, air humidity and flow, area of exposed surface, and pressure.

Process 2: The movement of moisture internally within the solid, is a function of the physical nature of the solid, the temperature, and its moisture content. In a drying operation any one of these processes may be the limiting factor governing the rate of drying, although they both proceed simultaneously throughout the drying cycle[1].

1.2 Drying Methods

Drying methods to be applied for vegetables and fruits are of great importance. In drying technology, it is necessary to determine the physical and chemical composition of the product, its dehydration ability, and initial and final moisture values in order to determine the appropriate method correctly. Otherwise, removal of moisture faster than necessary, excessively/understood or by wrong method damages the physical and mechanical aspects of the product. Dry product trade has gained importance with the spread of different drying methods and the diversification of production facilities around the world.

Drying can be divided into two groups as artificial drying and natural drying in terms of method. The method of drying in closed areas and under controllable conditions is called artificial drying. The transfer of heat supplied in order to remove the moisture in the product that is dependent on drying constitutes the basis of the artificial drying method. There are three types of heat transfer in drying:

- **Heat transfer by convection**
- **Heat transfer by conduction**
- **heat transfer by radiation**

Natural drying, also called solar drying, is the drying process carried out in the open air by utilizing the heat provided by the sun.

1.2.1 Indirect Drying

Indirect dryers, according to the definition given by Hall (1980), are dryers in which the heating medium (e.g., steam, hot gas, thermal fluids) does not come into contact with the product being dried. Instead, wet material is dried by contact with heated surface; heat transfer to the wet material is mainly by conduction from this surface. The temperature of heat transfer surfaces may range from -40°C (as in freeze drying) to about 300°C (as in the case of indirect dryers heated by direct combustion of products such as waste sludges) whereas the temperature of the solids in the dryer will be close to the boiling temperature of the moisture component being evaporated at the dryer operating pressure. As no hot gas is required as a source of heat in indirect dryers, only low gas flow (which is usually heated before entering the drying chamber to minimize localized condensation) or vacuum is needed to carry away the moisture evaporated from the wet material so that the drying chamber does not become saturated with vapor. The

heat transmitted to the dried product depends on the thermal conductivity of the wet material touching the hot surface and the thermal conductivity of the hot surface.

1.2.2 Direct Drying

In this method, heat is transferred from the drying medium (usually hot air) to the wet material by convection. Hot air is passed over or through the dried product layer. The thermal conductivity of this method is lower than contact drying. Tunnel dryers (tray dryers), fluidized bed dryers, spray dryers are different applications of this method.

It can also be defined as direct contact (direct) dryers. In these dryers, the drying gas/air is brought directly into contact with the material to be dried. Since the hot gas comes into direct contact with the material to be dried, drying takes place more quickly. These types of dryers are used in applications where the gas does not pollute the material to be dried.[2]

1.2.3 Radiation Drying

In this method, the heat energy required for drying is transmitted to the wet material by rays of the electromagnetic spectrum. These rays do not heat the medium through which they pass; They heat up the objects that absorb them. Since the depth that rays affect from the surface of the wet material is very small, this method is used for drying the layers in the form of thin films.

1.2.4 Dielectric Drying

In this type of drying, thermal energy is generated inside the material placed in an electromagnetic field with a very high frequency in the radio frequency or microwave region. The heat generated as a result of molecular friction due to rapid changes in the direction of the electromagnetic field changes the polar flow. Since the dielectric constant of liquid water is much higher than that of many solid materials, heat is generated in the water-containing part of the material.

- **Infrared Drying**
- **Microwave Drying**
- **Dielectric Drying**

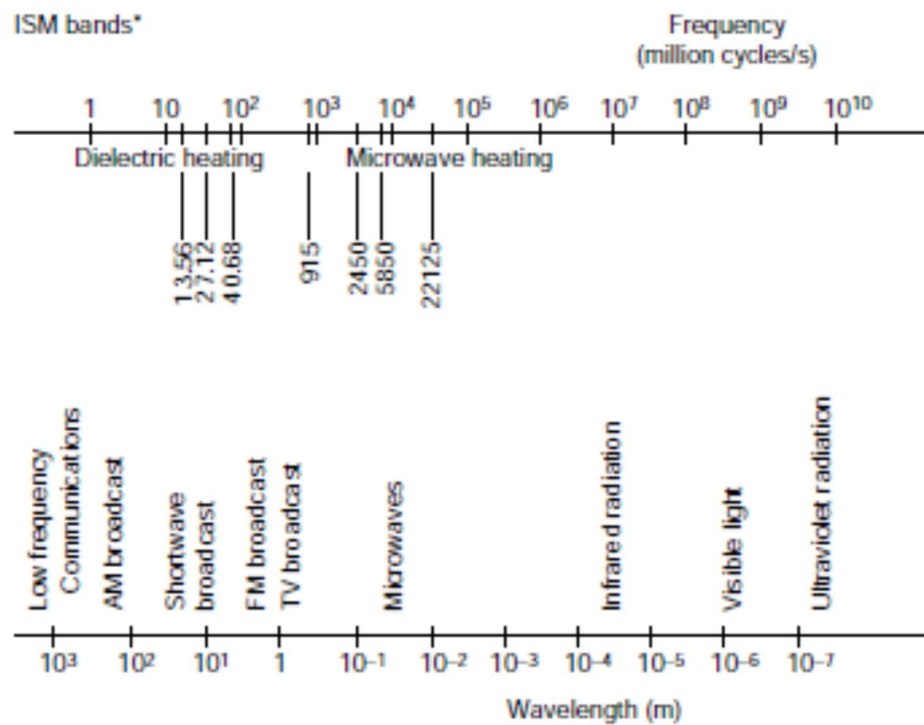


Figure 1.1 Electromagnetic spectrum.

1.2.5 Solar Drying

Solar dryers can be used in industries such as agriculture and food drying, agrochemical drying. There is a wide variety of solar dryers available on the market or studied in research. It has been proven in research that these are useful devices in terms of energy saving. These dryers not only save energy, but also save a lot of time, take up less space for drying, their overall purpose is to improve product quality, make the process more efficient than open sun drying, and protect the environment. Solar drying can be used for the entire drying process, or it can be used to supplement artificial drying systems. Thus, the total amount of fuel energy required for drying is reduced.

In solar collector dryers, the collectors are a separate part of the drying ovens. The energy collected in the collectors is transferred to the material to be dried by transferring with air or water. Since the geometry and arrangement of the furnace will not be adhered to, it is possible to move more flexible and independently in determining the size and arrangement of the collector surfaces. Especially the application of thermal storage systems and furnace thermal insulation are better. Control of the drying process can be achieved easily. The design of these furnaces is more complicated and the cost is higher than the greenhouse type. Drying costs and times vary according to the drying process. The air heated in the solar collectors is sucked by a

fan and passed over the fruit and vegetable pile in the drying oven, and the product to be dried is dehumidified and dried.

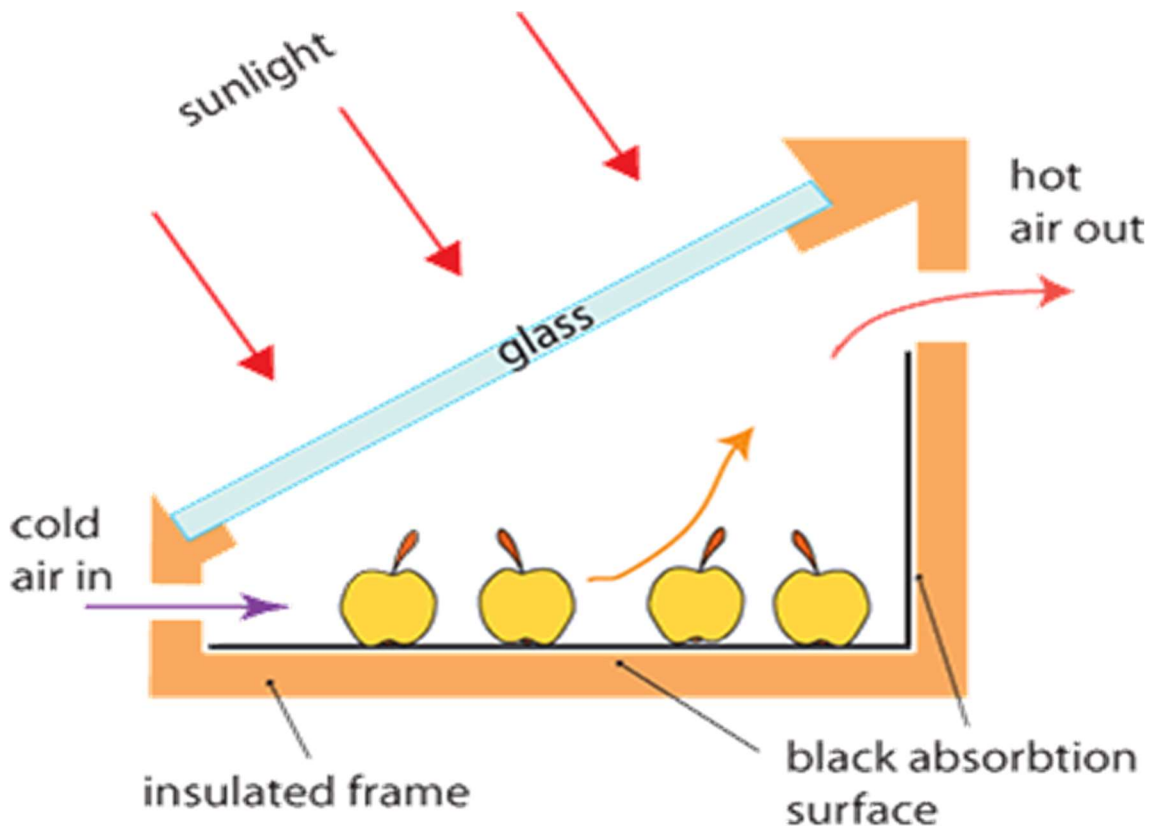


Figure 1.2 Schematic diagram of solar dryer.

1.2.6 Osmotic Drying

This method, known as osmotic drying, is the process of placing foodstuffs (fruits, vegetables, meat, cheese and fish) whole or in parts into high-concentration solutions and removing water from the product. There are three different mass transfers occurring simultaneously in osmotic drying. The first is the flow of water from the product to the solution. Through osmotic drying, foodstuffs lose up to 70% of their water content in the first three hours at temperatures between 30 and 50 °C. The solute transfer from solution to product is the second mass transfer. Thus, it is possible to add a preservative agent, any nutritional element or sensory quality enhancer to the product in desired amounts. The third mass transfer is the extraction of product solutes (sugars, organic acids, minerals, vitamins, etc.) into the solution. Although this is negligible in terms of quantity, besides water loss and solute transfer, it is important in terms of the composition of the final product.

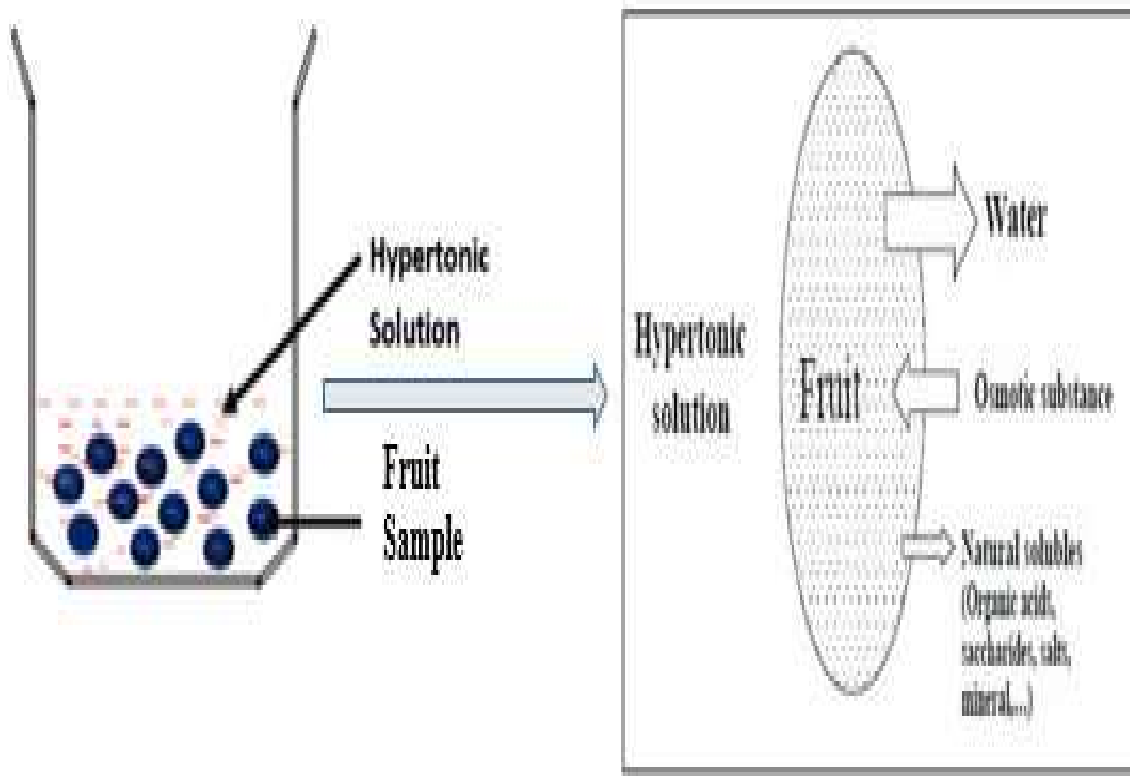


Figure 1.3 Schematic diagram of the osmotic dehydration process.

1.2.7 Freeze Drying

Freeze drying is the removal of solvent and bound water from frozen solutions, mostly at low pressure (Freeze Drying). Shock drying is used for pharmaceuticals, serums, bacterial and virus cultures, vaccines, juices, coffee and tea essences, vegetables, seafood, meats and milk. The material is first frozen, then placed in a high vacuum chamber connected to a low temperature condenser or chemical dryer. Heat is transmitted to the frozen material by infrared radiation, the volatile matter (usually water) becomes gaseous, condensed or absorbed by a chemical desiccant. Many freeze-drying processes take place under low pressures in the temperature range of 40°C to -10°C. Although this process is expensive and slow, it is quite suitable for heat sensitive materials. In order to carry out the drying process with this method, lyophilizers, also called freeze drying devices, are required. Lyophilizers consist of three main parts. These are: freezing and drying room, condenser and vacuum pump. In addition, there are compressors and heaters that provide cooling and heating in the device.[3]

1.2.8 Vacuum Drying

Vacuum drying is a process in which materials are dried in a reduced pressure environment, reducing the heat required for rapid drying. Despite its name, it does not take place in a true vacuum. The devices used for this process are known as vacuum dryers and can range in size from small units designed to fit kitchen counters to large chambers used to process things like timber products.

An advantage of vacuum drying is that it saves energy. Less energy is required to reduce the economic and environmental costs associated with drying a product for drying, storage, sale or other purposes. This process also tends to work faster than other drying methods and reduces processing time, which can be important in some facilities where products are moved quickly.

1.3 Factors Affecting Drying

There are numerous factors which must be taken into account for successful drying. Some of these are related to the characteristics of the product itself, while others pertain to design aspects of the dryer. Drying rate is controlled by factors that directly affect heat and mass transfer. The main of these factors are; Physical factors such as temperature, humidity and air velocity in the dryer, geometric arrangement (piece size, shape, bulk thickness, etc.) that will give the material to be dried the most surface area, and the composition of the dried material are its unique characteristics. The main factors affecting the drying speed are:

Temperature: One of the most important factors affecting the drying rate is the difference between the dry and wet bulb temperatures of the hot air used. The higher the difference between wet and dry thermometer grades, the faster the drying rate. Although this directly proportional effect is very evident at the beginning of drying, the drying rate does not increase at the same rate as the difference between wet and dry bulb temperatures increases as drying progresses. Provided that the difference between wet and dry bulb temperatures remains constant, if the air with a higher dry bulb temperature is used, there is no change in the drying speed at the beginning of drying, but the drying rate increases as the drying progresses. Because in the advanced stages of drying, the limiting factor of the drying rate is the diffusion of water in the inner layers to the surface. When the temperature difference increases, this diffusion event accelerates and accordingly the drying rate increases.

Speed of drying air: Another factor affecting drying speed is the air speed in the dryer. As the air velocity increases, the drying rate also increases. A stagnant vapor film is always formed on the surface of the dried material during drying. If this film is prevented from forming, or rather, this film is constantly removed, an acceleration in the evaporation of water appears. This air velocity has the effect of increasing the drying rate by continuously dragging the formed vapor film. However, this effect is seen until a certain air speed is reached. Although the air velocity is very effective in the initial stages of drying, high air velocity has no effect on this issue, since the drying rate is limited by the water transport rate in the lower layers in the advanced stages of drying.

Surface area of the dried substance: The drying rate is directly proportional to the surface area of the product to be dried and inversely proportional to the thickness. For this reason, the smaller the product to be dried, the larger the surface area and the lower the thickness, thus the drying speed is positively affected. In the initial stage of drying in fruits and vegetables, there is no significant difference in drying speed between the tissues cut into large and smaller pieces. However, as time progresses, the drying rate changes significantly according to the piece size. Because, especially during the drying phase with decreasing speed, the diffusion of water in the inner layers to the surface becomes difficult in large pieces and the drying rate decreases. It is beneficial to dry the fruits to be dried in small pieces due to this important effect of the piece size on the drying rate.

Humidity of the drying air: Another factor affecting the heat and mass transfer rate is the dryness of the drying air. When air is a drying medium or when the product is dried in air, the drying rate is closely related to the dryness of the air. It has dry air absorber and retainer properties. However, moist air is close to saturation and absorbs less moisture than dry air.

Ambient pressure: As it is known, water boils at 100°C at 760 mm of mercury pressure. As long as the pressure is reduced by keeping the boiling temperature constant, the boiling process will accelerate. If we put the product in an environment closed to the atmosphere, the water in the product can be removed at lower temperatures.

Other variables: Apart from the variables listed above, other factors that have significant effects on drying speed and final product quality; are the unique properties of the product, such as its water retention and chemical composition. If sugar, oil etc. It is seen that a material rich in substances dries more difficult than normal material.[4]

1.4 Dryer Types

1.4.1 Cabinet Dryer

It is used for drying large masses where belt dryer or tunnel type drying systems cannot perform their function. Here, the standard drying process should be carried out by adjusting the air flow and drying temperature correctly. Cabinet dryers represent a basic type of batch style dryer. The material to be dried is placed on racks inside the drying chamber of the cabinet and hot dry air is blown across it.

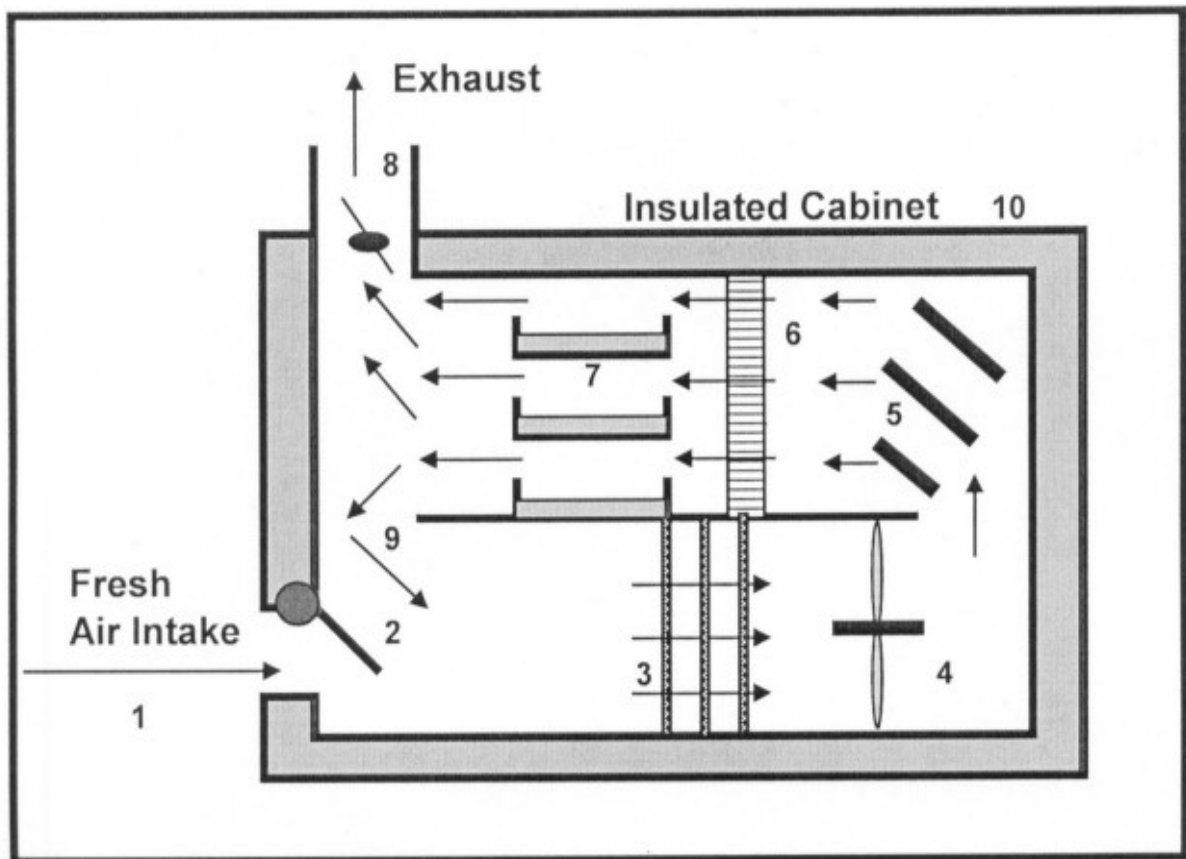


Figure 1.4 Diagram of cabinet dryer.

1.4.2 Tunnel Dryer

Tunnel dryers can be thought of as a more advanced model of cabinet dryers. Tunnel dryers operated continuously or semi-continuously are of the modified dryer type. Hot air is circulated in the system with the help of a fan. The product to be dried on the trays that are constantly or periodically in the dryer is moved in trolleys or compartments. Air flows across the tray surface, vertically along the bed, or in any direction. By reheating or reusing the drying air in the dryer, more moisture can be obtained before leaving the system. It is possible to dry with different air

speed, temperature and flow direction in tunnel dryers. The air flow can be moved parallel, diagonally.

1.4.3 Conveyor Dryer

The conveyor dryer is conceptually very simple. Product is carried through the dryer on conveyors and hot air is forced through the bed of product. It is often described as simply a conveyor in a box with hot air. The reality, however, is that the conveyor dryer is one of the most versatile dryers available. Conveyor dryers - also referred to as belt or apron dryers - are used extensively throughout a variety of industries.

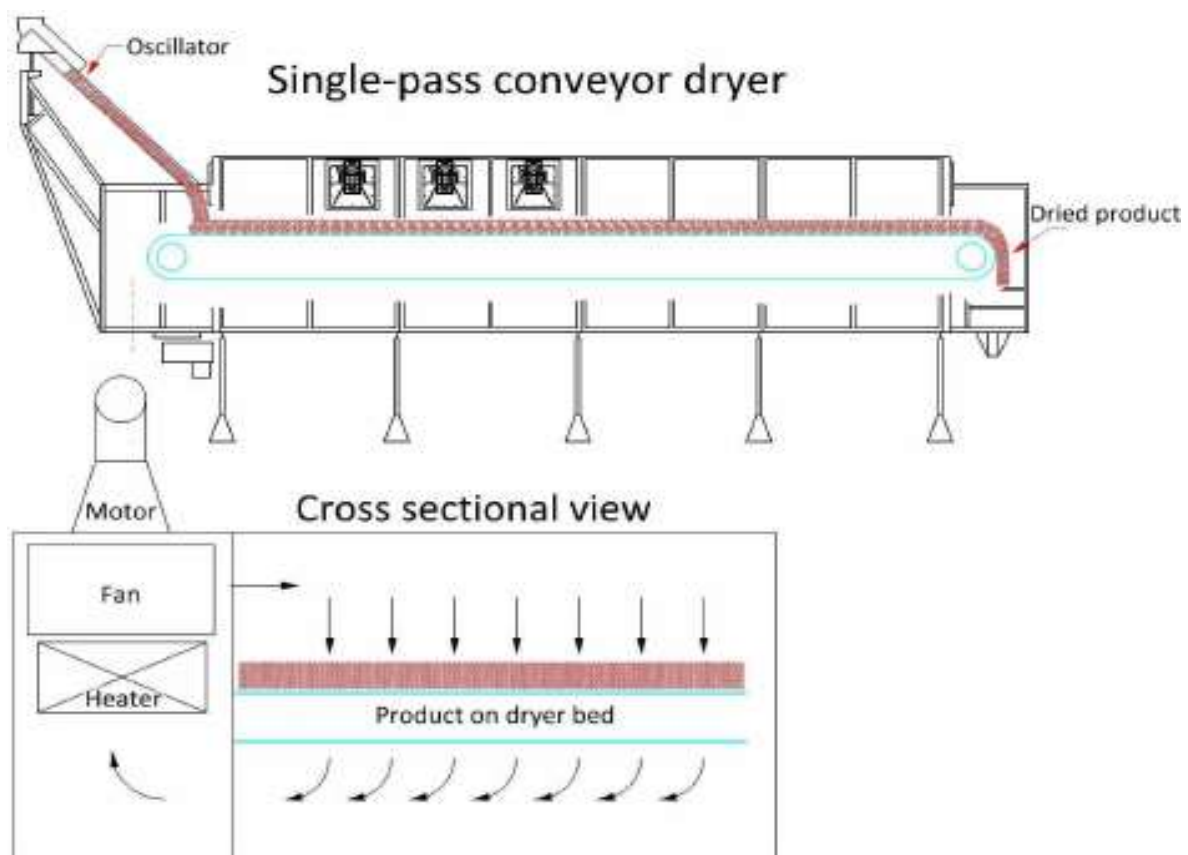


Figure 1.5 Schematic diagram of the single-pass conveyor dryer.

1.4.4 Tray Dryer

This type of dryer works by passing hot air over the wet solid surface spread over the trays. Tray dryers are the simplest and least expensive type of dryer. This type is most commonly used in the food and pharmaceutical industries. The main advantage of tray dryers, apart from their low initial cost, is their versatility. With the exception of powders, materials in almost any other physical form can be dried.

In a tray dryer, the material to be dried is placed on large trays, generally made of metal. The tray itself can be a solid sheet of metal, or it may have a more open structure with slots or holes in it to allow drying air to pass through the material being dried. Wire mesh is often used as it maximizes the amount of open area for air circulation. Once they are loaded, the trays are placed on supports inside a drying cabinet or compartment. The trays look like shelves inside a large box that is actually the dryer. After all the trays have been loaded, the drying chamber is closed and air is blown through the drying compartment. By monitoring the humidity of the air leaving the tray dryer, the progress of the drying process can be followed. Once the drying is completed, the air flow is stopped; the dryer is opened; and the trays are removed. The dried contents of the trays are then dumped and the trays are reloaded for the next load of product that is to go into the dryer.

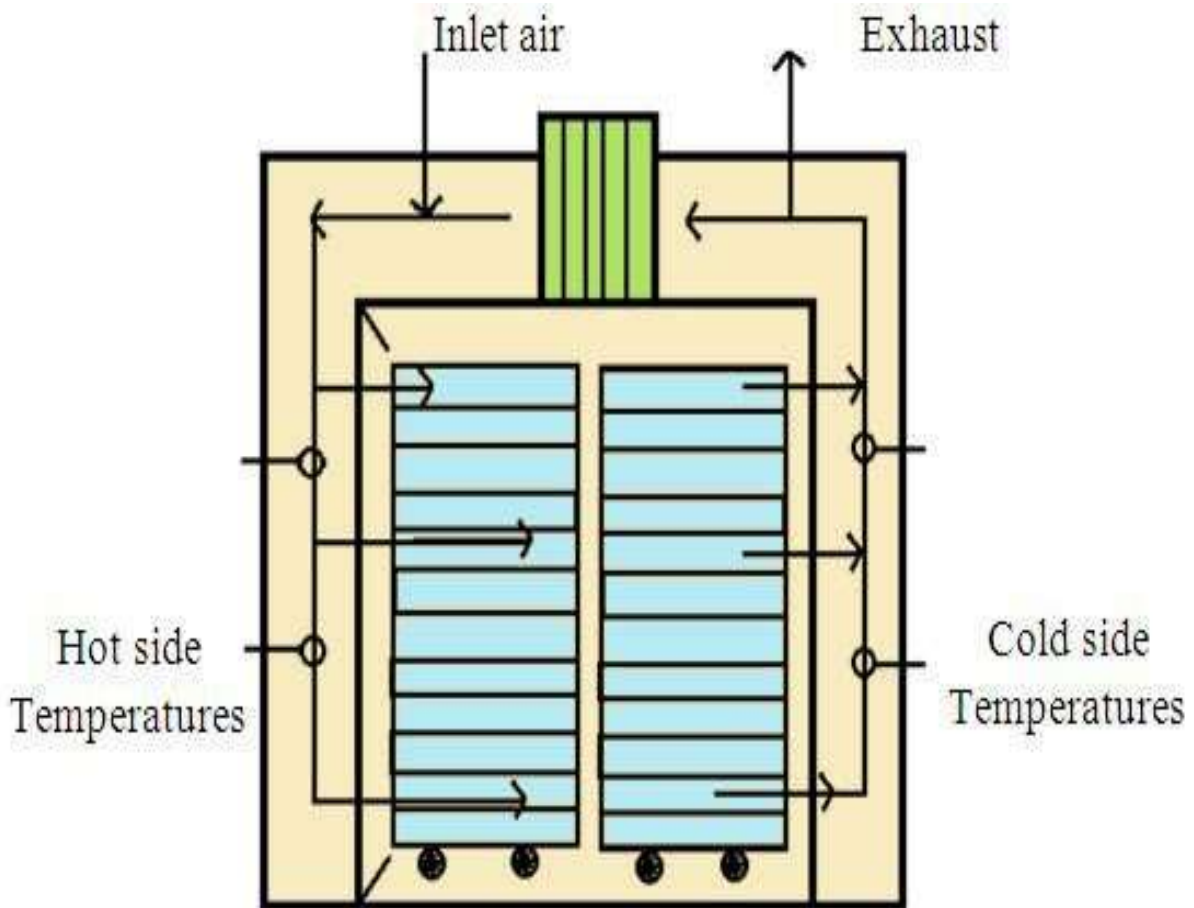


Figure 1.6 Schematic diagram of tray dryer.

1.4.5 Fluidized Bed Dryer

In these, the product to be dried is in the state of a bed that is constantly mixed with the hot and dry air given from the bottom at high speed and a slight boiling appearance almost suspended. Moist air is exhausted from the top of the system. Since the drying is continuous, the time it stays in the fluidized bed dryer may vary depending on the thickness of the bed. Cereals, peas and segmented vegetables can be dried in this type of dryer, which provides rapid drying.

Fluidized bed dryer (also called fluid bed dryer) is a kind of equipment used extensively in the pharmaceutical industries to reduce the moisture content of pharmaceutical powder and granules. The equipment works on a principle of fluidization of the feed materials.

In fluidization process, hot air is introduced at high pressure through a perforated bed of moist solid particulate. The wet solids are lifted from the bottom and suspended in a stream of air (fluidized state). Heat transfer is accomplished by direct contact between the wet solid and hot gases. The vaporized liquid is carried away by the drying gasses. Sometimes to save energy, the exit gas is partially recycled.[5]

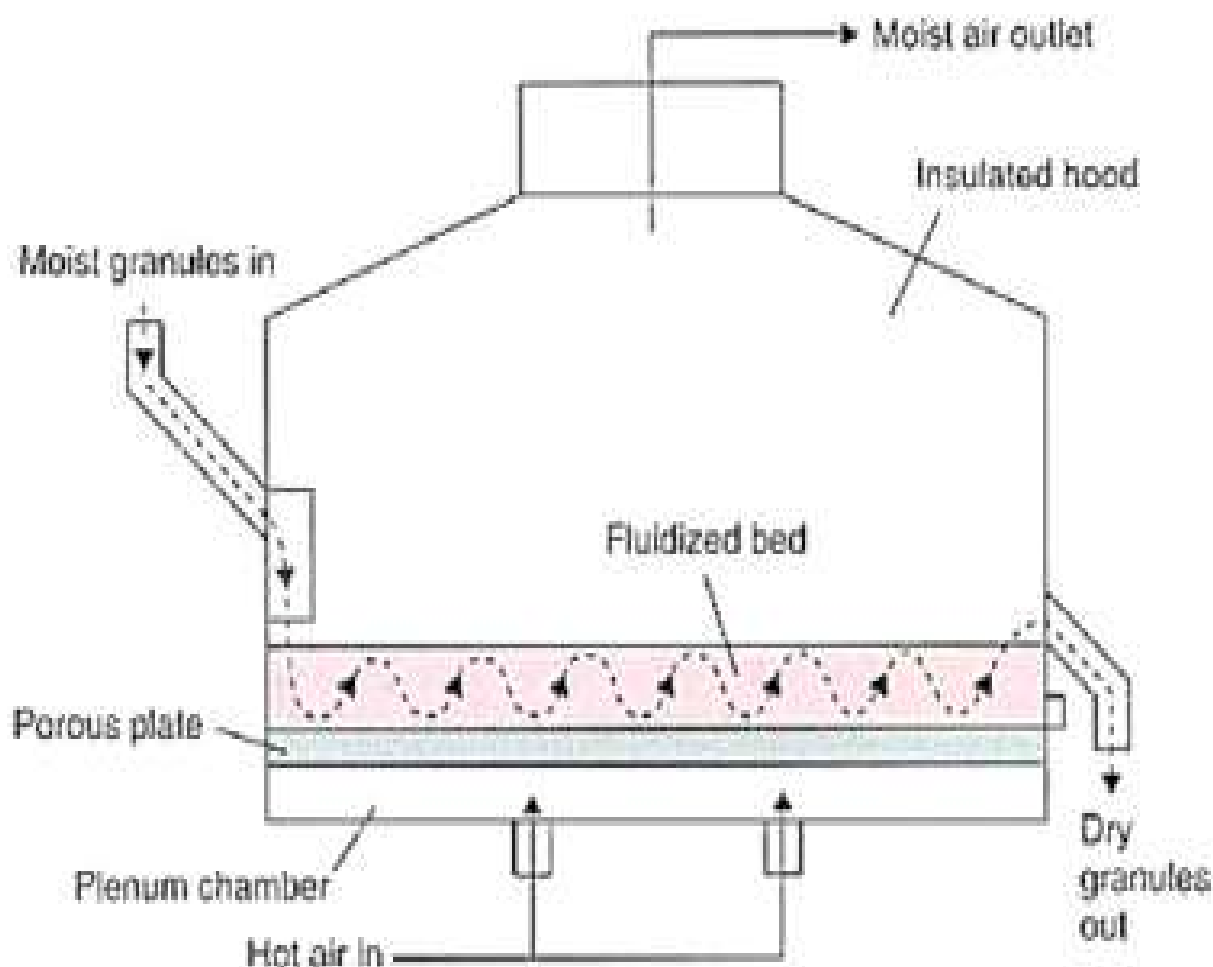


Figure 1.7 Concept of fluidized bed dryer.

1.4.6 Spouted Bed Drying

The applicability of the spouted bed technique to drying of granular products that are too coarse to be readily fluidized (e.g., grains) was recognized in the early 1950s. Interest in this area received appreciable impetus two decades later as the energy-intensive drying processes were reexamined with renewed vigor. Spouted bed dryers (SBDs) display numerous advantages and some limitations over competing conventional dryers. Because of the short dwell time in the spout, SBDs can be used to dry heat-sensitive solids, such as foods, pharmaceuticals, and plastics. With simple modification the so-called modified spouted beds can be designed to ensure good mixing, controlled residence time, minimum attrition, and other desirable features. Also, the operations of coating, granulation agglomeration, and cooling, among others, can be carried out by the same apparatus by varying the operating parameters. SBDs can be used for solids with constant as well as falling rate drying periods. Using inert solids as the bed material, SBDs have been used successfully to dry pastes, slurries, and heat-sensitive materials.



A rotary dryer is a device that uses rotation, gravity, and hot gases to dry a material. These dryers range from small household clothes dryers to large industrial systems. Regardless of their size, most rotary dryers work the same way. The hot gases allow it to dry quickly as the drum rotates and moves the material. The main distinction in these dryers is the type of gases used and the method used to generate heat. As a result of the enormous kinetic energy they create, rotary dryers, the smallest of them all, require fixed support systems such as concrete columns or ground bolts. Regardless of its size and purpose, the inner workings of a rotary dryer are basically the same as any other. The main user component is the drum in which the work material is placed. The inside of the drum contains many large fins that help lift and agitate the work material as the dryer rotates. This drum connects to the dryer's internal processes, but

these are hidden from the outside. A door closes the drum opening so the chamber can be closed. As the rotary dryer rotates, the fins lift the work material from the bottom of the drum and lift it to the side. As the flap approaches the top of the drum, gravity causes the lifted material to fall to the bottom. As the work material falls, it is sprayed with warm gas. This gas is very effective in drying as it is completely open on all sides of the material.[6]

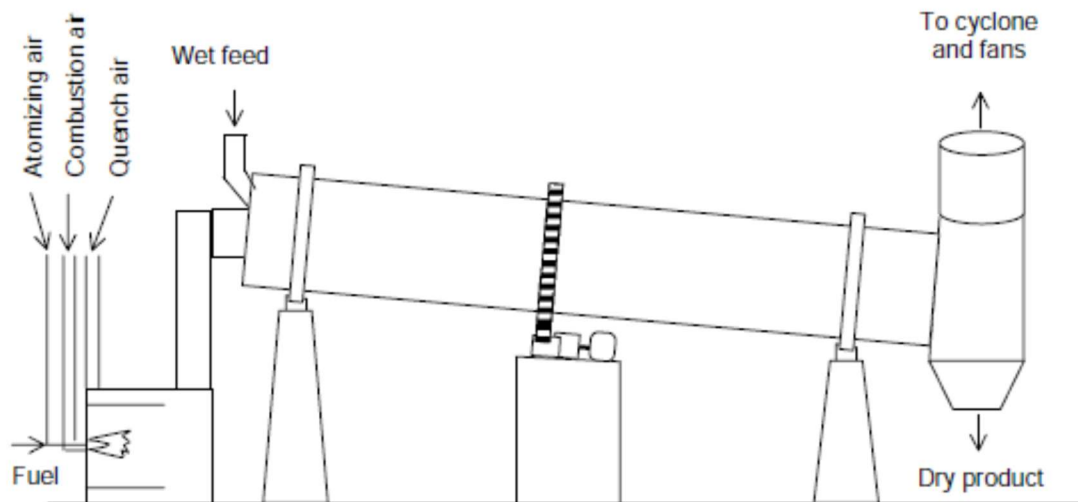


Figure 1.9 Simplified diagram of direct-heat rotary dryer.

1.4.8 Drum Dryer

A tumble dryer is a rotary cylinder that uses steam or hot air to heat the feedstock and reduce its moisture content during the production process. The configuration may contain one or more drums. A drum dryer can use atmospheric pressure or function under a vacuum. Drum dryers have many applications in the food industry because they are very effective for drying doughs or gelatinous materials.

In the simplest configuration, a single drum dryer is supported on a frame so it can rotate on its axis. Steam is forced from the inside. A fine feedstock is then applied to the outside of the drum. As the temperature rises, moisture in the feedstock reaches its boiling point, begins to evaporate and leaves the feedstock. The dried feedstock is removed from the drum with a scraper.

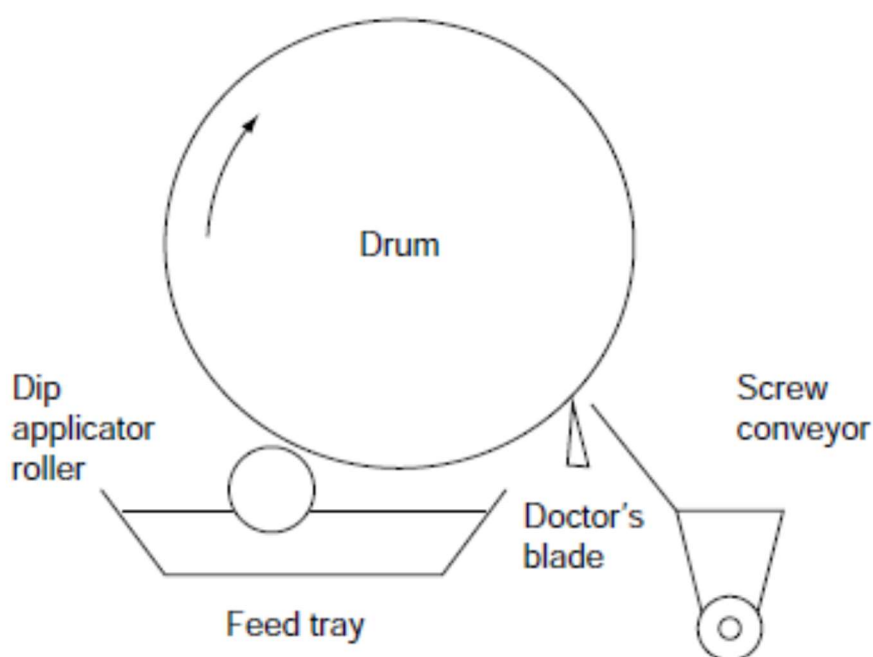


Figure 1.10 Schematic diagram of drum dryer.

1.4.9 Spray Drying

Foods in liquid form are converted into powder form by spray drying. The moisture is removed by spraying (atomizing) the feed into the hot dryer chamber. The spray dryer was patented in 1872 by Samuel Percy. Its first use in industry was in the production of milk powder and detergent in the 1920s. Spray drying is widely used in the food, pharmaceutical, cosmetic, agricultural and chemical industries. By spray drying, a spherical powder product with homogeneous particle size distribution is obtained. Drying time is shorter compared to other drying methods and this provides an advantage in drying temperature sensitive products. Spray drying is widely used in the food industry. This is because foods are sensitive to heat and consumers' interest in powdered products. Milk powder, whey protein, coffee, tea extracts, baby foods, starch, enzymes, microorganisms, yeasts are some of the products produced by spray drying.

The drying stages in the spray dryer are as follows. First, the liquid feed is pumped into the atomizer. It is sprayed into the hot environment (usually hot air) with the feeding atomizer. When the product comes into contact with the hot environment, the moisture in it evaporates and the drops turn into dry particles. The resulting dry product is collected as the final product.[7]

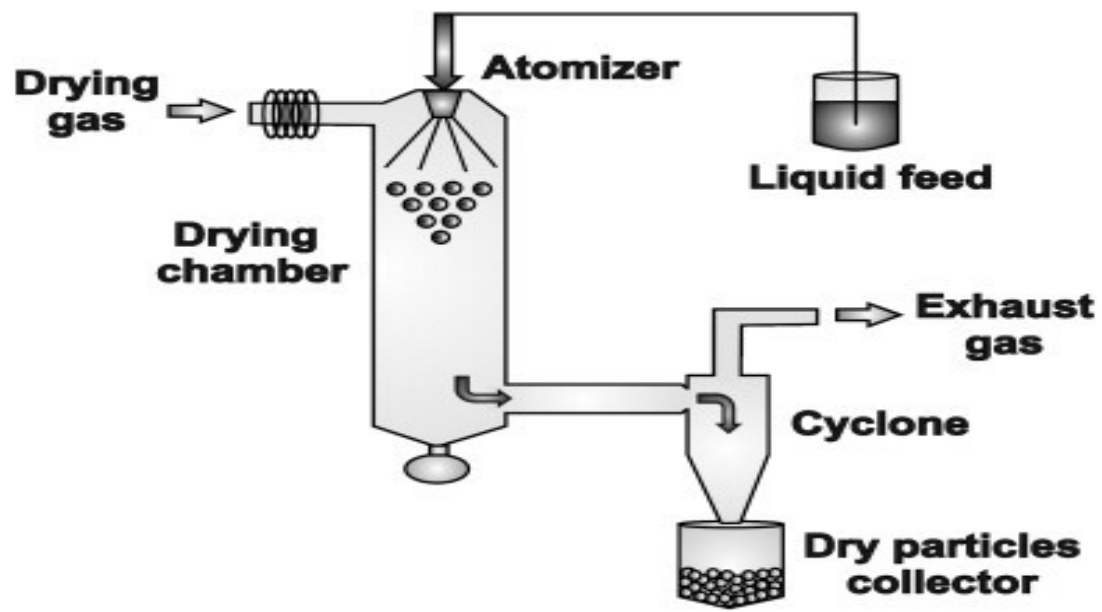


Figure 1.11 Schematic diagram of spray dryer.

CHAPTER 2. FRUIT DRYING

2.1 Introduction

From the point of view of consumption, fruits are plant products with aromatic flavor that are naturally sweet or normally sweetened before usage. Apart from providing flavor and variety to human diet, they serve as important and indispensable sources of vitamins and minerals although they are not good or economic sources of protein, fat, and energy. Moisture is the most abundant substance in the structure of fruits.

Fruits and vegetables have gained commercial importance and their growth on a commercial scale has become an important sector of the agricultural industry. Recent developments in agricultural technology have substantially increased the world production of fruits and vegetables. Consequently a larger proportion of several important commodities is handled, transported, and marketed all over the world than before with concomitant losses calling for suitable postharvest techniques for storage and processing to ensure improved shelf life. Production and consumption of processed fruits and vegetables are also increasing.

Most fruits and vegetables contain more than 80% water and are therefore highly perishable. Water loss and decay account for most of their losses, which are estimated to be more than 30–40% in the developing countries in the tropics and subtropics due to inadequate handling, transportation, and storage facilities. Apart from physical and economic losses, serious losses do occur in the availability of essential nutrients, notably vitamins and minerals.

The need to reduce postharvest losses of perishable horticultural commodities is of paramount importance for developing countries to increase their availability, especially in the present context when the constraints on food production (land, water, and energy) are continually increasing. It is being increasingly realized that the production of more and better food alone is not enough and should go hand in hand with suitable postharvest conservation techniques to minimize losses, thereby increasing supplies and availability of nutrients besides giving the economic incentive to produce more.

One of the prime goals of food processing or preservation is to convert perishable foods such as fruits and vegetables into stabilized products that can be stored for extended periods of time to reduce their postharvest losses. Processing extends the availability of seasonal commodities, retaining their nutritive and esthetic values, and adds variety to the otherwise monotonous diet. It adds convenience to the products. In particular it has expanded the markets of fruit and

vegetable products and ready-to-serve convenience foods all over the world, the per capita consumption of which has rapidly increased during the past two to three decades.

Several process technologies have been employed on an industrial scale to preserve fruits and vegetables; the major ones are canning, freezing, and dehydration. Among these, dehydration is especially suited for developing countries with poorly established low-temperature and thermal processing facilities. It offers a highly effective and practical means of preservation to reduce postharvest losses and offset the shortages in supply.

The technique of dehydration is probably the oldest method of food preservation practiced by humankind. The removal of moisture prevents the growth and reproduction of microorganisms causing decay and minimizes many of the moisture-mediated deteriorative reactions. It brings about substantial reduction in weight and volume, minimizing packing, storage, and transportation costs and enables storability of the product under ambient temperatures. These features are especially important for developing countries and in military feeding and space food formulations.



Figure 2.1 Dried fruits.

2.2 Pretreatment of Fruit Drying

Fruits and vegetables are subjected to certain pretreatments with a view to improve drying characteristics and minimize adverse changes during drying and subsequent storage of the products. These include alkaline dips for fruits and sulfiting and blanching for fruits and vegetables

2.2.1 Alkaline Dip

The alkaline dip involves immersion of the product in an alkaline solution before drying and is used primarily for fruits that are dried whole, especially prunes and grapes. A sodium carbonate or lye solution (0.5% or less) is usually used at a temperature ranging from 93.3 to 100.8°C. It facilitates drying by forming fine cracks in the skin.

2.2.2 Sulfiting

Sulfur dioxide treatments are widely used in fruit and vegetable drying as sulfur dioxide is by far the most effective additive to avoid nonenzymatic browning. It also inhibits various enzyme-catalyzed reactions, notably enzymic browning, and acts as an antioxidant in preventing loss of ascorbic acid and protecting lipids, essential oils, and carotenoids against oxidative deterioration during processing and storage. It also helps in inhibition and control of microorganisms, especially microbial fermentation of sugars in fruits such as sun-dried apricots as encountered during prolonged drying. It has the advantage of allowing higher temperatures, hence shorter drying times, to be used. It is intended to maintain color, prevent spoilage, and preserve certain nutritive attributes until marketed.

Fruits for dehydration are often treated with gaseous SO₂ from burning sulfur as used in the manufacture of dried apricots, peaches, bananas, raisins, and sultanas. Alternatively, apple slices are generally dipped in solutions of the additive (prepared by dissolving sodium bisulfite or SO₂ in water) and may receive an extra treatment with gaseous SO₂ during drying.

Treatment of vegetables with SO₂ gas is impractical. Sulfite solutions are preferred as the most practical method of controlling absorption. As vegetables are blanched before drying, generally the additive is incorporated at the blanching stage either in the blanch liquor if the vegetable is to be dipped or as a spray in the case of steam blanching.

Sufficient SO₂ must be absorbed by the prepared material to allow for losses that occur during drying and subsequent storage. The various methods of application of SO₂ result in varying levels of uptake, which is a function of SO₂ concentration, length of treatment, and time allowed

for draining, size and geometry of the food, and the pH of the blanch liquor or spray. Drying times in excess of 12 h for fruits and vegetables and of several days as in sun drying of fruits necessitate use of large amounts of SO₂. It has been shown that only 35–45% of the additive initially incorporated is measurable after drying. The subsequent loss of SO₂ from dried products occurring during storage determines the practical shelf life with respect to spoilage through NEB.

2.2.3 Blanching

Blanching consists of a partial cooking, usually in steam or hot water, before dehydration. It is intended to denature enzymes responsible for bringing about undesirable reactions that adversely affect product quality such as enzymic browning and oxidation during processing and storage. The effectiveness of the treatment is judged by the degree of enzyme inactivation. Thus, activity of polyphenoloxidase is followed in fruits, that of catalase in cabbage and of peroxidase in other vegetables. The other beneficial effects produced by blanching include reduced drying time, removal of intercellular air from the tissues, softening of texture, and retention of carotene and ascorbic acid during storage. Commercially both continuous- and batch-type blanchers are employed, involving 2- to 10-min exposure to live steam. Series blanching in hot water is also used, in which the solids content of the water is maintained at an equilibrium level to minimize leaching losses.[8]

2.3 Purposes of Drying Fruits

Drying is done for various purposes. It is possible to collect them under this headings.

2.3.1 Prolonged Storage Life

If we remove most of the water from the fruits, there will no longer be enough moisture present to support the growth of microorganisms. As a result, the fruits will not spoil as rapidly as they would if the water was present. This means that we will have a “shelf-stable” product that can be kept for several months without spoiling. Even though most of the water has been removed, the dried flesh of the fruits will retain most of its nutritional properties.

An added advantage of increasing the shelf-life of fruits or vegetables through dehydration is that they can be shipped longer distances (possibly to foreign markets). During the considerable time it takes to reach far-off destinations, fresh produce could easily spoil. However, this problem can be avoided if dried products are exported.

2.3.2 Weight and Volume Reduction

In addition to making fruits and vegetables last longer before they spoil, there are some additional reasons for drying them. By removing most of the water that was originally present, we are left with only the solids and a small amount of water. This makes a very large difference between the weight of the fresh fruits and those that have been dried. The water content in the raw material is as low as possible, making it economical to transport that product over long distances. For example, coals with high water content are subjected to a certain amount of drying before being loaded onto the ship.

2.3.3 Taste and Texture

Taste and texture are two other things to consider when comparing fresh and dried produce. This is especially true in regard to sweet fleshy fruits and berries. When water is removed from them, the sugars that were dissolved in their juice remain in the dried flesh. This means that the dried slices of fruit or the dried berries will contain a high concentration of natural sugars and will have a very pleasant sweet taste with a somewhat stronger flavour than the fresh “wet” fruit. Drying also tends to make the flesh take on a leathery texture which creates a pleasant chewy snack.

The overall change in moisture content, volume, and sweetness can have an effect on the consumption of these snacks. Care must be taken not to overindulge in eating dried products, and water consumption should be monitored to compensate for the reduced moisture in the snacks. For those who are conscious of their sugar intake, a few slices of dried fruit may contain as much sugar as eating an entire fresh fruit such as a mango.

2.3.4 Convenience and Variety

Fruits and vegetables may also be dried as a manner of increasing their convenience for later use, or to add variety to our diets. Even though grapes and raisins are obtained from the same basic starting material, they offer quite different alternatives to the way in which they are consumed. Fresh grapes are generally eaten “as is” with little or no further modification. In comparison, raisins may be used in a much wider range of products such as an ingredient in baked goods, or as a convenient, natural, and nutritious snack requiring little or no clean-up.

CHAPTER 3. COMPENENTS

3.1 Cabinet

A portable drying cabinet is needed for the fruit dryer. For this cabin, we thought of using this dry container, which is produced as a standard and used in cargo and sea transportation, which is suitable for transportation.

Dry containers are a type of standard shipping or cargo container that accommodates dry, non-temperature-sensitive shipments. They are typically available in 40' size, although there are 20' options available. The containers consist of strong steel to resist wind, rain and saltwater. You can customize a dry container to have more security or added features for special loads in some cases.

Some dry containers commonly used across industries include:

Storage roll containers

Half-height containers

Open-top containers

Double door containers

Open-side containers

Tunnel containers

Flat racks

Dry containers are versatile. In addition to bulk international shipping, many businesses have converted unused containers into innovative structures, like workstations, mobile clinics, retail stores, restaurants, food trucks, heavy equipment storage solutions, warehouses and even residential living.

We decided that the 20' dryer container would be sufficient for the drying cabinet.

Table 3.1 Dimensions of 20' dry container.

20' dry container

Tare weight	Payload capacity	Cubic capacity	Internal length
2,300	25,000 kg	33.2 m ³	5.9 m
5,071.5 lbs	55,126.9 lbs	1,172 cu ft	19.4 ft
Internal width	Internal height	Door opening width	Door opening height
2.35 m	2.39 m	2.34 m	2.28 m
7.7 ft	7.9 ft	7.7 ft	7.5 ft

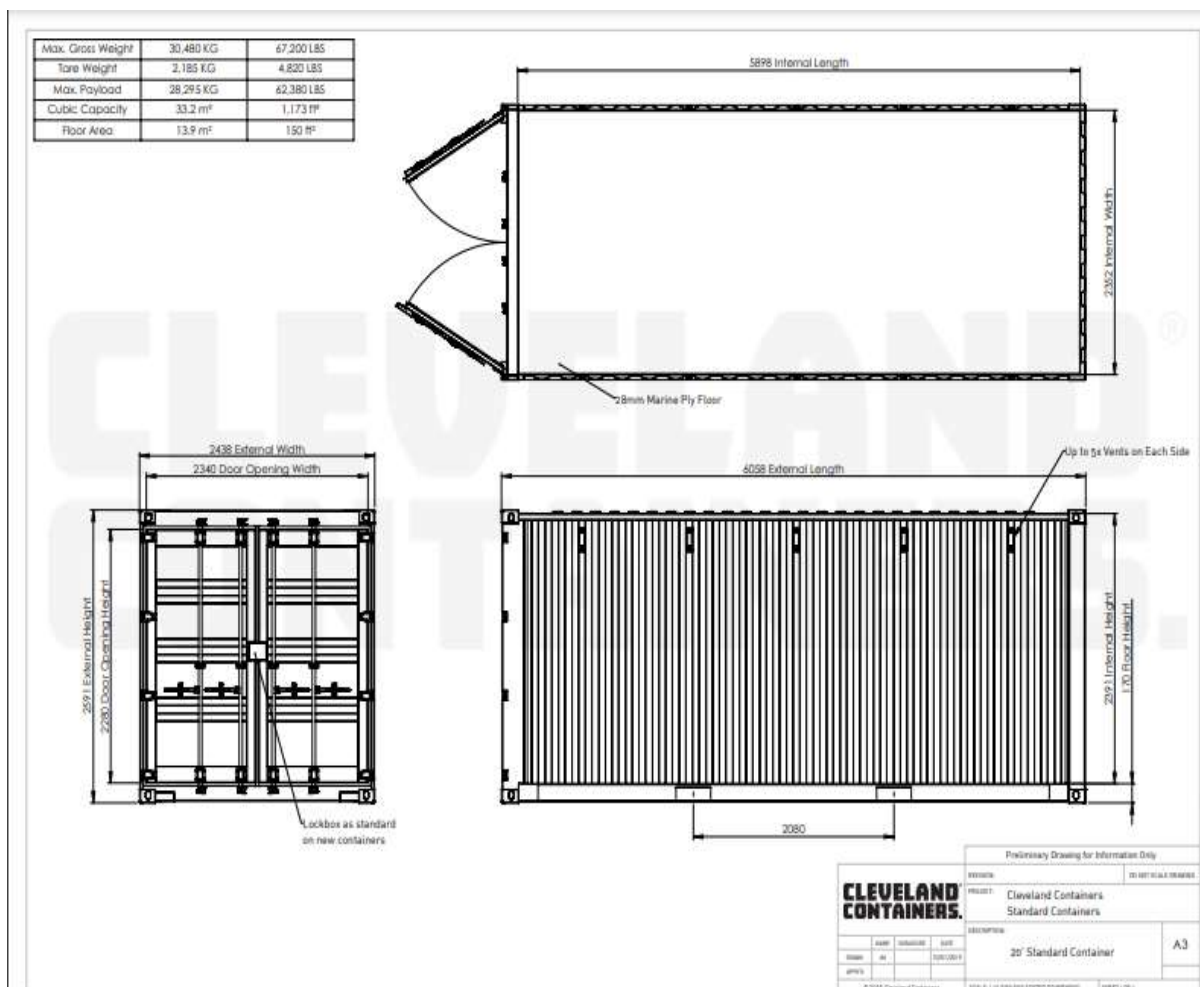


Figure 3.1 Technical Drawing of 20' dry container.

3.1.1 Trolley and tray

In fruit drying process we need put our products on a tray. This tray needs to endure some heat and it can not have high thermal conductivity so that fruits won't get roasted. We select stainless steel 304 for the trays which has 15.6 thermal conductivity(k). There are some holes on the trays so hot air can do its job.

We select the same material for the trolley as well. Trolleys have 4 wheels attached to their bottom surfaces so they can move around with trays. We select our measurements to maximize the fruit we are drying with maximum efficiency. Our measurements will be shown in the appendix.

3.2 Fan

The devices that provide the flow of air by creating a pressure difference are called fans. Fans are simple machines that move air or gases by rotating impeller blades. The blades, which are the moving elements of the fan, do work on the air and give it static and kinetic energy. The ratio of these static and kinetic energies added to the air depends on the characteristics of the fan.

The impeller, which is the movable element of the fans, which provides the flow of air by creating a pressure difference, gives static and kinetic energy to the air. Fans are generally classified as centrifugal (radial) or axial depending on the flow direction of the air on the impeller.

With axial fans, high flow and low pressure are obtained. With radial fans, high pressure and low flow are achieved. There are forward-curved, backward-curved, straight-wing and aircraft wing-section types. Forward curved blade fans are used in low and medium pressure ventilation. Investment costs are lower than other radial fans. Forward curved fans, whose blade inclinations are in the direction of rotation, have small bodies and low revolutions.

Flat bladed radial fans are preferred for conveying small parts and dust. Fans with backward curved blades are preferred in medium and high pressure ventilation. The blade tilts are opposite to the direction of rotation. Airfoil section fans are also called airfoil blades. Their cost and efficiency are higher among other fans. They are preferred for medium and high pressure ventilation. The blade tilts are opposite to the direction of rotation and backwards.

For the designed fruit dryer, it is the equipment that performs the ventilation process required for fan drying and the removal of the moisture in the product. We deal with the air flow in the

system and the relationship with the heater with the piping system. In this design, we decided to use axial fans. Because the features we wanted were low cost, low pressure and low flow.

Technical properties of the selected fan:

Table 3.2 Properties of fan.

PRESSURE	VOLTAGE	FREQUENCY	POWER	REVOLUTUON	AIR FLOW RATE
400 Pa	220V	50Hz	0,37Kw	1400rev/min	1500m ³ /h

Since the motors of axial fans are out of the air flow, they can be used in air circulation up to 150 °C. Optionally, air flow and pressure can be adjusted with a speed control device.

3.3 Selectin of Heater

In a system, process stream, or enclosed environment, industrial heaters are used to convert energy from a fuel or energy source to thermal energy. Heat transfer is the method through which thermal energy is transferred from an energy source to a system.

There are three fundamental methods of heat transfer: conduction, convection and radiation. Industrial heaters use one or a combination of these three methods to transfer heat.

Conduction

The movement of heat energy over a solid object is known as thermal conduction. When an energy source is applied directly to a solid item, the material's molecules begin to vibrate at a higher frequency and transmit the energy to the molecules next to them.

Convection

Thermal energy is transferred through a fluid or material via the process of convection. A forced or free-flowing convection current is produced by the fluid or medium. A fan or a pump circulates the medium in forced flow convection. Convection cycles only depend on temperature variations and density gradients in free-flowing systems.

Radiation

An indirect way to transport heat is by thermal radiation. With this technique, electromagnetic waves are used to transport thermal energy. The waves are free to travel across empty space until they come into touch with a physical substance since they have very little mass, which means that the transfer of heat does not require any physical contact between the substances.

We experience an excited state when the waves are absorbed, and the impacted molecules start to vibrate at a higher frequency. Heat or, to put it more simply, an increase in temperature is the product of absorption and vibration frequency.

We used duct heaters which are used to heat moving gas streams. They are installed in the middle of moving air or gas stream in order to heat the air as it moves through the heater. We used waste fuel and brushwood that we can collect from around.

3.3.1 Combustible Material

We hope to make use of the wastes in the region where we will be drying as combustible material in the fruit dryer. We will provide the necessary energy for the dryer by using wood, wood waste, forestry waste, agricultural waste, animal waste and industrial waste. In short, we will use the biomass energy in the environment where we are drying. Or as an alternative, we will use pellets, which is also a renewable energy source. Pellets are small particles typically created by compressing waste materials.

The pellet has a small cylindrical form, usually 6-8-10 mm in diameter and 10-40 mm in length, compressed; It is a type of fuel obtained from natural products and wastes such as sawdust, wood chips, bark, tree branches, crop stalks, hazelnuts, cones at the bottom of the trees.

Although it differs in terms of raw materials and production techniques, there is no use of binders in the conversion of wood and its derivatives into pellets. In some other raw materials, auxiliary binders (such as molasses, starch, vegetable paraffin, tall oil, lignin, water) are used at certain rates.

The energy content of wood pellets is approximately 4.7 – 5.2 MWh/tonne. High-efficiency wood pellet stoves and boilers have been developed in recent years, typically offering combustion efficiencies of over 85%. The newest generation of wood pellet boilers can work in condensing mode and therefore achieve 12% higher efficiency values. Wood pellet boilers have limited control over the rate and presence of combustion compared to liquid or gaseous-fired systems.

CHAPTER 4. MASS, ENERGY AND HEAT CALCULATIONS

In this section, calculations and analyzes will be made for the designed fruit dryer. Calculations will be based on assumptions, idealizations and specific situations.

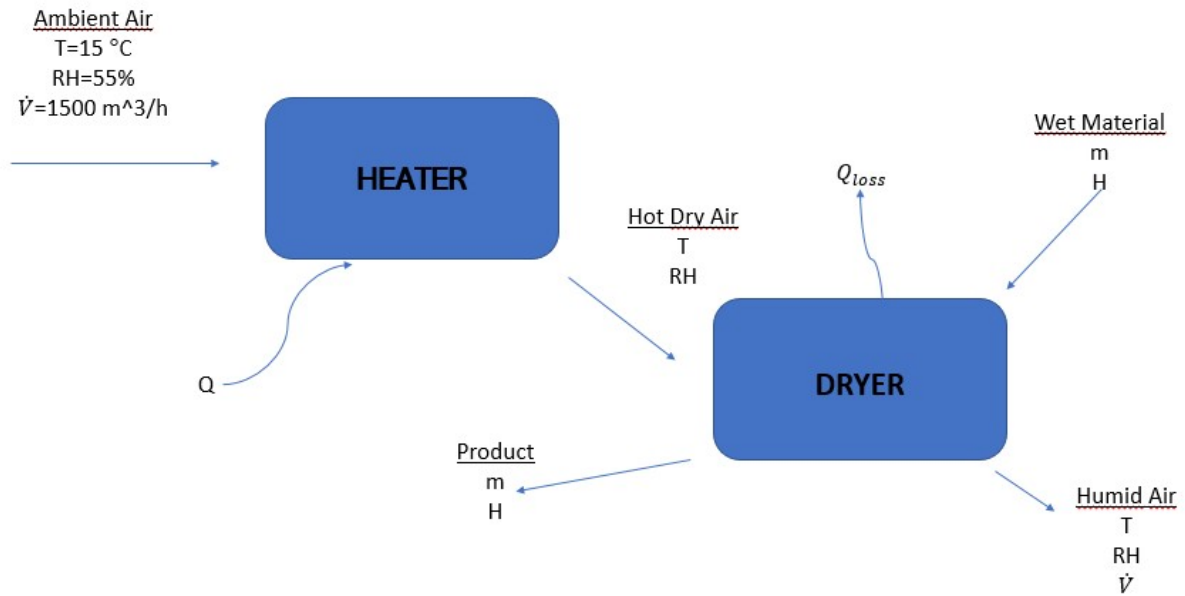


Figure 4.1 Diagram of fruit dryer system.

4.1 Enviromental Conditions and Fruit Properties

The environmental conditions, properties and type of dried fruit are the determining factors in the calculations for the fruit dryer. We selected fruit and medium to calculate. We chose banana as the fruit selection. The reason we prefer banana is because it is a fruit grown in our country and consumed a lot in the world. In order to determine the environmental conditions, Mersin, Anamur, which is famous for its bananas, was chosen as the working environment. The end of March was chosen as the harvest time.



Figure 4.2 10-year average temperature data, Anamur. (Red line:daytime, Blue line:night)



Figure 4.3 10-year average temperature data, Anamur.

According to the information obtained from the internet, the environmental conditions in Anamur at the end of March are as follows:

Average temperature = 15 °C

Average humidity ratio = 55%

Banana features:

Banana, the product we will dry, contains 75% water in its structure.

$X_{wb} = 0.75$

Bananas will be dried in slices on trays. The thickness of the banana slices will be approximately 7 mm. The average banana capacity of trays is 300 kg.

$$m_B = 300 \text{ kg}$$

$$m_{B,water} = m_B \times 0.75 = 225 \text{ kg}$$

$$m_{B,solids} = m_B - m_{B,water} = 75 \text{ kg}$$

4.2 Calculations for Heater

At the first stage of the fruit dryer, the atmospheric air sucked from the outside with the help of the fan is transferred to the heater. Dry air sucked in from the outside is heated up to 50-55 °C, which is the optimum temperature for the drying process. Controls have been made to keep the outlet temperature within this range.

Properties of the air entering the heater:

- $T = 15 \text{ }^{\circ}\text{C}$

- $RH = 55\%$

- Air flow rate of fan = 1500 m³/h

$$\text{Air density, } \rho_{15^{\circ}\text{C}} = 1.225 \text{ kg/m}^3$$

$$\text{Mass flow rate, } \dot{m} = \dot{V} \times \rho = 0.51 \text{ kg/s} \quad (1)$$

$$\text{Cross-sectional area, } A = 0.59 \text{ m}^2$$

$$\text{Velocity, } v = \frac{\dot{V}}{A} = 0.7 \text{ m/s} \quad (2)$$

Desired temperature at heater outlet → $T = 55 \text{ }^{\circ}\text{C}$

Assumption: Air flow is steady-flow.

Conservation of mass for the steady-flow control volume:

$$\sum_{inlets} \dot{m}_i = \sum_{exits} \dot{m}_e$$

$$\dot{m}_e = 0.51 \text{ kg/s.}$$

$T_e = 55 \text{ }^{\circ}\text{C}$, Its temperature will be controlled around this value.

- This desired temperature value is the dry bulb temperature of the exiting air.
- The amount of moisture in the air remains constant during this process since no moisture is added to or removed from the air. That is, the specific humidity of the

Other properties of hot air are calculated from the psychrometric chart.

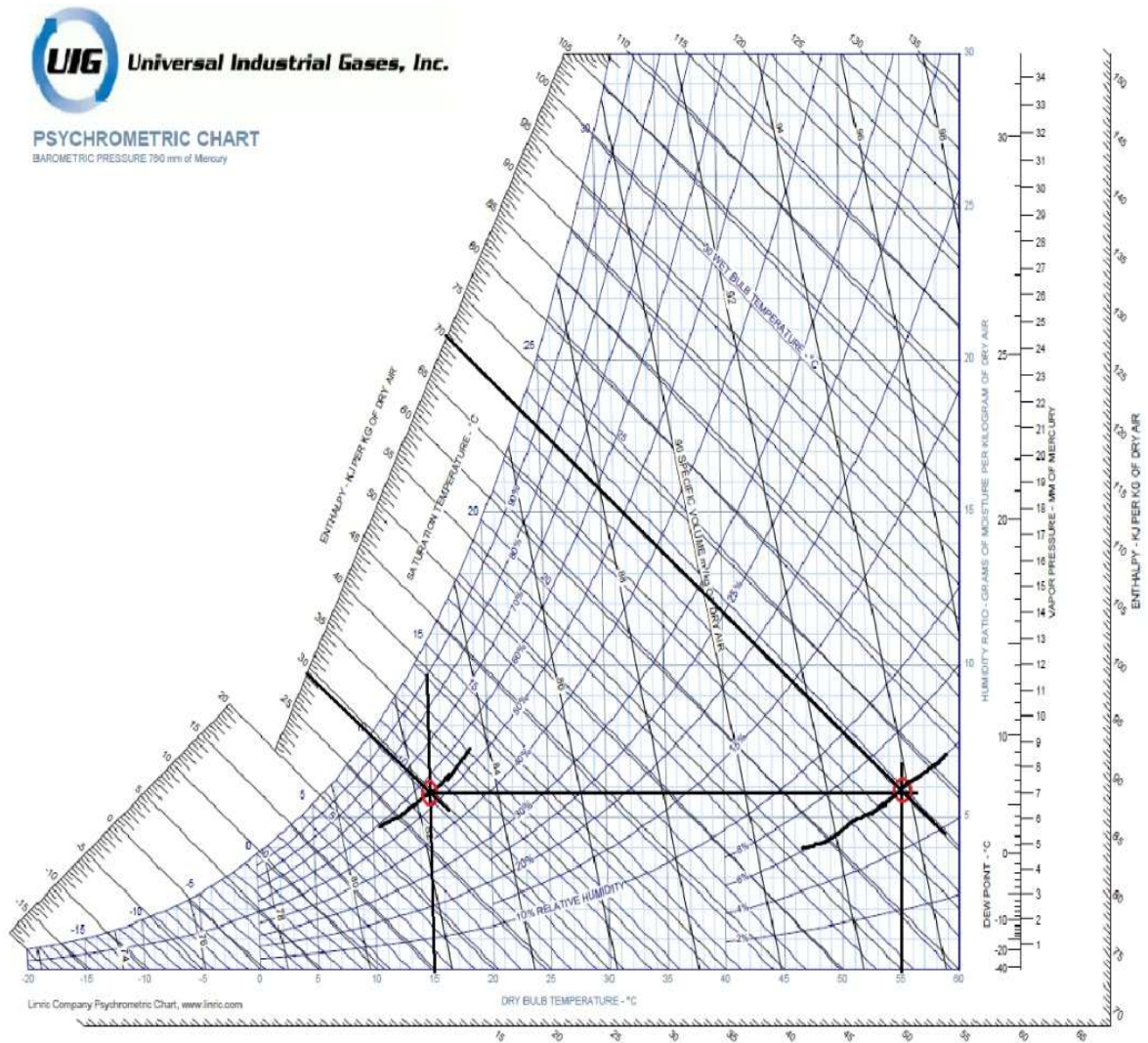


Figure 4.4 Sketch of psychrometric chart.

Table 4.1 Reading values from sketch of psychrometric chart.

Point	T [°C]	X [g/kg]	H [kJ/kg]	RH [%]	ρ [kg/m ³]	Pv [Pa]	Tdew [°C]	Twb [°C]
0	15	5.8	29.8	55	1.221	938	6.1	10.2
1	55	5.8	70.4	6	1.072	938	6.1	23.6

Conservation of energy to the steady-flow control volume:

$$\dot{Q}_{net} + \sum_{inlets} \dot{m}_i \left(h + \frac{\bar{v}^2}{2} + gz \right)_i = \dot{W}_{net} + \sum_{exits} \dot{m}_e \left(h + \frac{\bar{v}^2}{2} + gz \right)_e \quad (3)$$

- $\dot{W}_{net} = 0$,
- Potential energy and kinetic energy are neglected.
- $\sum_{inlets} \dot{m}_i = \sum_{exits} \dot{m}_e = \dot{m} = 0.51 \text{ kg/s}$

$$\dot{Q}_{net} = \dot{m}(h_e - h_i) \quad (4)$$

$$\dot{Q}_{net} = \left(0.51 \frac{\text{kg}}{\text{s}} \right) \left(70.4 \frac{\text{kJ}}{\text{kg}} - 29.8 \frac{\text{kJ}}{\text{kg}} \right) = 20.7 \frac{\text{kJ}}{\text{s}}.$$

20 kJ/s energy is needed to heat the ambient air to the desired temperature.

4.3 Calculations for Dryer

Table 4.2 Inlet properties of air and fruit.

Properties	Properties
$T_{i,air} = 55 \text{ }^{\circ}\text{C}$ $\dot{V}_{i,air} = 1500 \text{ m}^3/\text{h}$	$T_{i,fruit} = 15 \text{ }^{\circ}\text{C} \Rightarrow \text{same as ambient temperature}$

$\dot{m}_{i,air} = 0.51 \text{ kg/s}$ $H_i = 5.8 \frac{\text{g water}}{\text{kg dry air}}$ $RH_i = 6\%$ $v = 0.7 \text{ m/s}$	$m_B = 300 \text{ kg}$ $m_{B,water} = m_B \times 0.75 = 225 \text{ kg}$ $m_{B,solids} = m_B - m_{B,water} = 75 \text{ kg}$
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4.3.1

Drying Rate Period

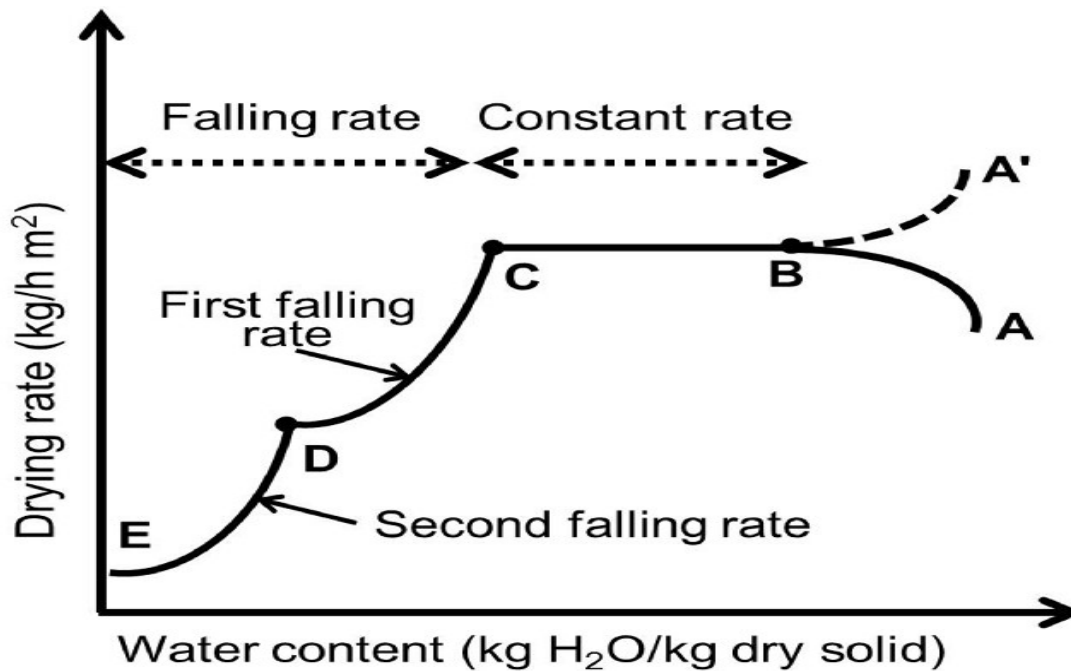


Figure 4.5 Plot drying rate versus to moisture content.

Drying process of a material can be described as a series of steps in which drying rate plays a key role. Following figure shows typical drying rate curve for a constant drying conditions. Point B represents equilibrium temperature conditions of the product surface. Section B to C of the curve, known as the constant rate periods, represents removal of unbound water from the product. The water acts as if the solid is not present. The surface of the product is very wet and water. And the water activity is equal to one. The constant rate period continues as long as the amount of water evaporates is equal to the amount of water supplied to the surface of the material.

The falling rate period is reached when the drying rate starts to decrease, and the surface water activity falls to less than one. The rate of drying is governed by the internal flow of liquid or vapor. This point is represented by C in the figure. At this point there is not enough water on the surface to maintain a water activity value of one. The falling rate period can be divided into

two steps. A first falling drying rate occurs when wetted spots in the surface continually diminish until the surface is dried (Point D).

Second falling rate period begins at point D when the surface is completely dry. The plane of evaporation recedes from the surface. Heat required for moisture removal is transferred through the solid to the vaporization of moisture in the solid and the vapor moves through the solid into air stream. The amount water removed in this period can be relatively small compared to the constant rate and first falling rate period. However this period may take much longer than constant rate period because the drying is slow.

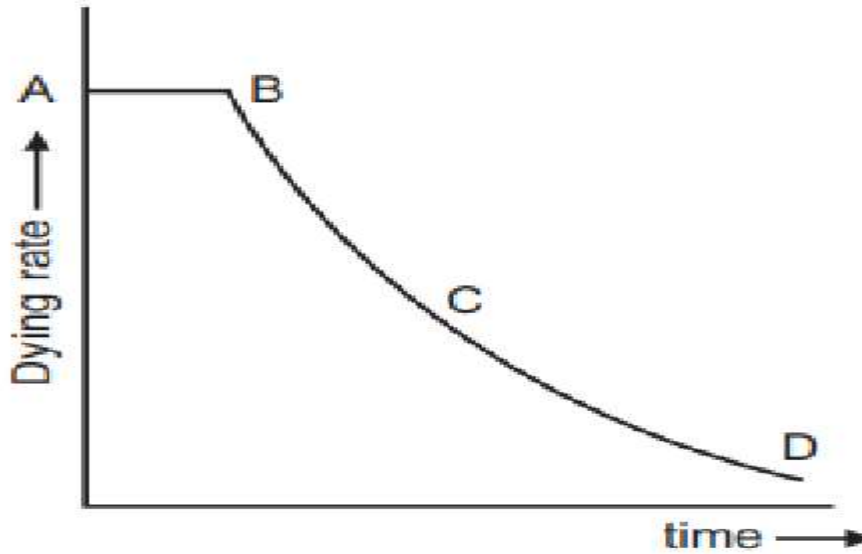


Figure 4.6 Plot of drying rate versus to time.

- $t_t = t_c + t_f$ (5)

- $t_c = -\frac{Ls}{A} \frac{\Delta x}{R_c}$, drying time during constant rate period (6)

- For t_f , We are idealizing the CD curve assuming it is linear function through the origin, $R=ax$. So, $t_f = \frac{Ls}{axA} \ln \frac{R_1}{R_2}$, $a = \frac{R_1 - R_2}{x_1 - x_2}$

- $\Rightarrow t_f = \frac{Ls}{A} \frac{X_c}{R_c} \ln \frac{X_c}{X_2}$ (7)

- $R_c = \frac{h_{coeff}(T - T_{wb})}{\lambda_w}$, constant drying rate (8)

4.3.2 Result

$$G = vx\rho_{55^{\circ}\text{C}} = 2701 \frac{\text{kg}}{\text{m}^2\text{h}}, \text{ mass velocity}$$

⇒ **Assumption: For air temperature of 45-150 °C and mass velocity G of 2450-29300 kg/h.m² or a velocity of 0.61-7.6 m/s and air flowing parallel to drying surface. The heat transfer coefficient can be calculated by the formula**

$$h_{\text{coeff}} = 0.0204x(G)^{0.8} = 11.35 \frac{\text{W}}{\text{m}^2\text{K}} \quad (9)$$

$$\text{At } T_{i,\text{air}} = 55^{\circ}\text{C} \Rightarrow T_{wb} = 23.6^{\circ}\text{C} \text{ (from table 4.1) ,}$$

$$\text{At } T_{wb} = 23.6^{\circ}\text{C} \Rightarrow \lambda_w = 2405 \text{ kJ/kg (from saturated steam table)}$$

$$\Rightarrow R_c = \frac{h_{\text{coeff}}(T - T_{wb})}{\lambda_w} = \frac{11.35(55 - 23.6)}{2405x \frac{1000 \text{ J}}{\text{kJ}}} x \frac{3600 \text{ s}}{1 \text{ h}} = 0.533 \frac{\text{kg}}{\text{m}^2\text{h}}$$

⇒ **Assumption: A banana slice is assumed to be a cylinder with a diameter of 30 mm and a height of 7 mm and 50 grams.**

$$Ls = (mb, \text{slice})x(1 - X_{wb}) = (0.05 \text{ kg})x(0.75) = 0.0125 \text{ kg}$$

$$A = 0.00207 \text{ m}^2$$

⇒ **Assumption: Critical moisture content is 0.50.**

$$t_c = -\frac{Ls}{A} \frac{\Delta x}{R_c} = -\frac{0.0125}{0.00207} \frac{X_c - X_i}{0.533}$$

Desired moisture content of the product is $X_i = X_{i,wb} = 0.15$.

$$\text{So, } t_c = -\frac{0.0125}{0.00207} \frac{0.50 - 0.75}{0.533} = 2.83 \text{ h}$$

$$t_f = \frac{Ls}{A} \frac{X_c}{R_c} \ln \frac{X_c}{X_e} = \frac{0.0125}{0.00207} \frac{0.5}{0.533} \ln \frac{0.5}{0.15} = 6.82 \text{ h}$$

$$t_t = 2.83\text{h} + 6.82\text{h} = 9.65\text{h}$$

Mass Balance

$$\dot{m}_a H_1 + \dot{m}_p X_{1,db} = \dot{m}_a H_2 + \dot{m}_p X_{2,db} \quad (10)$$

$$\dot{m}_a = 0.51 \frac{\text{kg}}{\text{s}}, \quad H_1 = 5.8 \frac{\text{g water}}{\text{kg dry air}}, \quad X_{1,db} = \frac{225}{75} = 3,$$

$$X_{2,db} = \frac{13.235}{75} = 0.176$$

$$\dot{m}_p = \frac{75}{t_t} = 7.77 \frac{\text{kg dry solids}}{\text{h}}$$

From the equation, $H_2 = 17.7 \frac{g \text{ water}}{kg \text{ dry air}}$

Table 4.3 Reading values from sketch of psychrometric chart for isothermal drying processes.

Point Values

Point	T [°C]	X [g/kg]	H [kJ/kg]	RH [%]	ρ [kg/m³]	Pv [Pa]	Tdew [°C]	Twb [°C]
0	15	5.8	29.8	55	1.221	938	6.1	10.2
1	55	5.8	70.4	6	1.072	938	6.1	23.6
2	55	17.7	101.4	17.8	1.064	2805	23	30.3

Process Δ-Changes

Process	Action	ΔT [°C]	ΔX [g/kg]	ΔX [l/h]	ΔH [kJ/kg]	Power ΔH [kW]	Power ΔT [kW-T]
0-1	Heat	40	0	0	40.7	19.4	19.4
1-2	Humidify	0	11.9	19.1	30.9	13.8	0

Processes are calculated with: 1500m³/h

Table 4.4 Reading values from sketch of psychrometric chart for adiabatic drying processes.

Point Values

Point	T [°C]	X [g/kg]	H [kJ/kg]	RH [%]	ρ [kg/m³]	Pv [Pa]	Tdew [°C]	Twb [°C]
0	15	5.8	29.8	55	1.221	938	6.1	10.2
1	55	5.8	70.4	6	1.072	938	6.1	23.6
2	25.2	17.7	70.4	87.5	1.171	2805	23	23.6

Process Δ-Changes

Process	Action	ΔT [°C]	ΔX [g/kg]	ΔX [l/h]	ΔH [kJ/kg]	Power ΔH [kW]	Power ΔT [kW-T]
0-1	Heat	40	0	0	40.7	19.4	19.4
1-2	Humidify	-29.8	11.9	20.1	0	0	-14.2

Processes are calculated with: 1500m³/h

CONCLUSION

As part of this work, a portable fruit dryer was designed. At the beginning of the design, the aim was to ensure that the fruit is dried in the same place immediately after harvest. A dryer has been designed to dry fruit quickly, which can be used in different places at different times when the harvest of each fruit is not in the same place at the same time.

In general, fossil fuel, electric and recently infrared dryers are used in agricultural enterprises in Turkey for product drying, drying after washing process and heat treatment to reduce the microorganism values of the product after production. But in this design, solid waste fuels were preferred due to cost and easy access to the areas where we will be drying. With the help of the fan, the air sucked from the environment was passed through the heater and its temperature was increased. The relative humidity of the air, which remained constant while the temperature increased, decreased. At the end of the Fan and Heater stage, hot dry air with a certain flow rate was obtained. As a result of the scanned articles of the researches, it was seen that the effect of the air speed on the drying speed decreased at values above 1 m/s. Therefore, no studies were made to increase the drying rate.

The hot dry air obtained at the end of the heater stage passed to the dryer stage. Thanks to the pipes and channels, a homogeneous flow towards the fresh fruits was ensured. The moisture of these fruits was removed by passing the warm air through the fruits in the perforated trays in the winter tray trolleys. Fruits with a water content of around 85% were turned into a dry snack with a high sugar concentration of around 15% with a drying dryer. In order for the fruits to dry faster, they are dried in small pieces.

The dryer designed in this study is generally used as a heat pump type heater in the world. The reason why we did not choose a heat pump was the problem of finding the electrical energy required for the heat pump in the agricultural lands where the fruit dryer was moved. As an alternative to this design, there is a liquid fuel heater, which is more accessible and has high energy. A dryer design could be made using a cabinet with higher insulation.

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APPENDIX

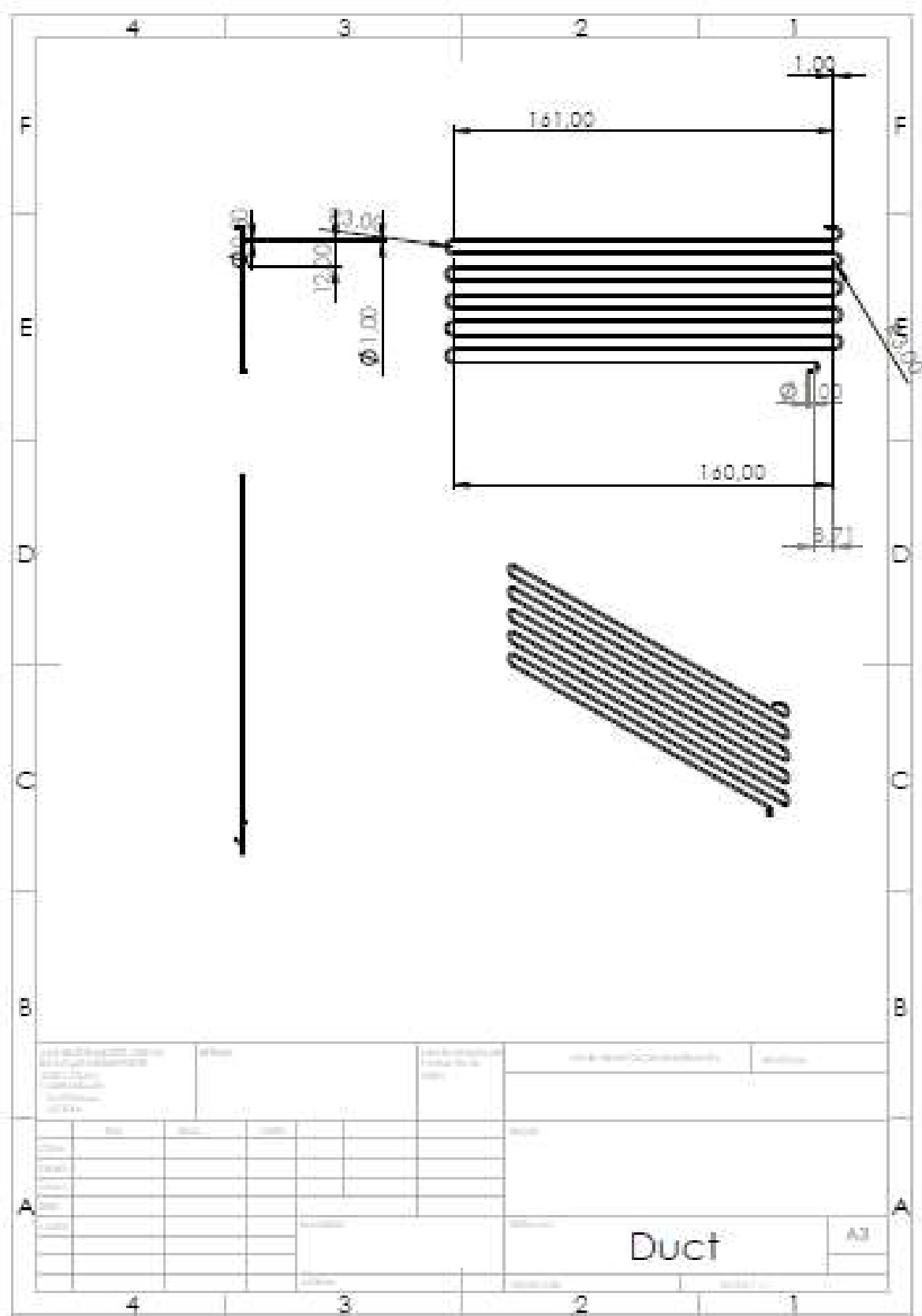


Figure 5.1 Technical Drawing of Duct

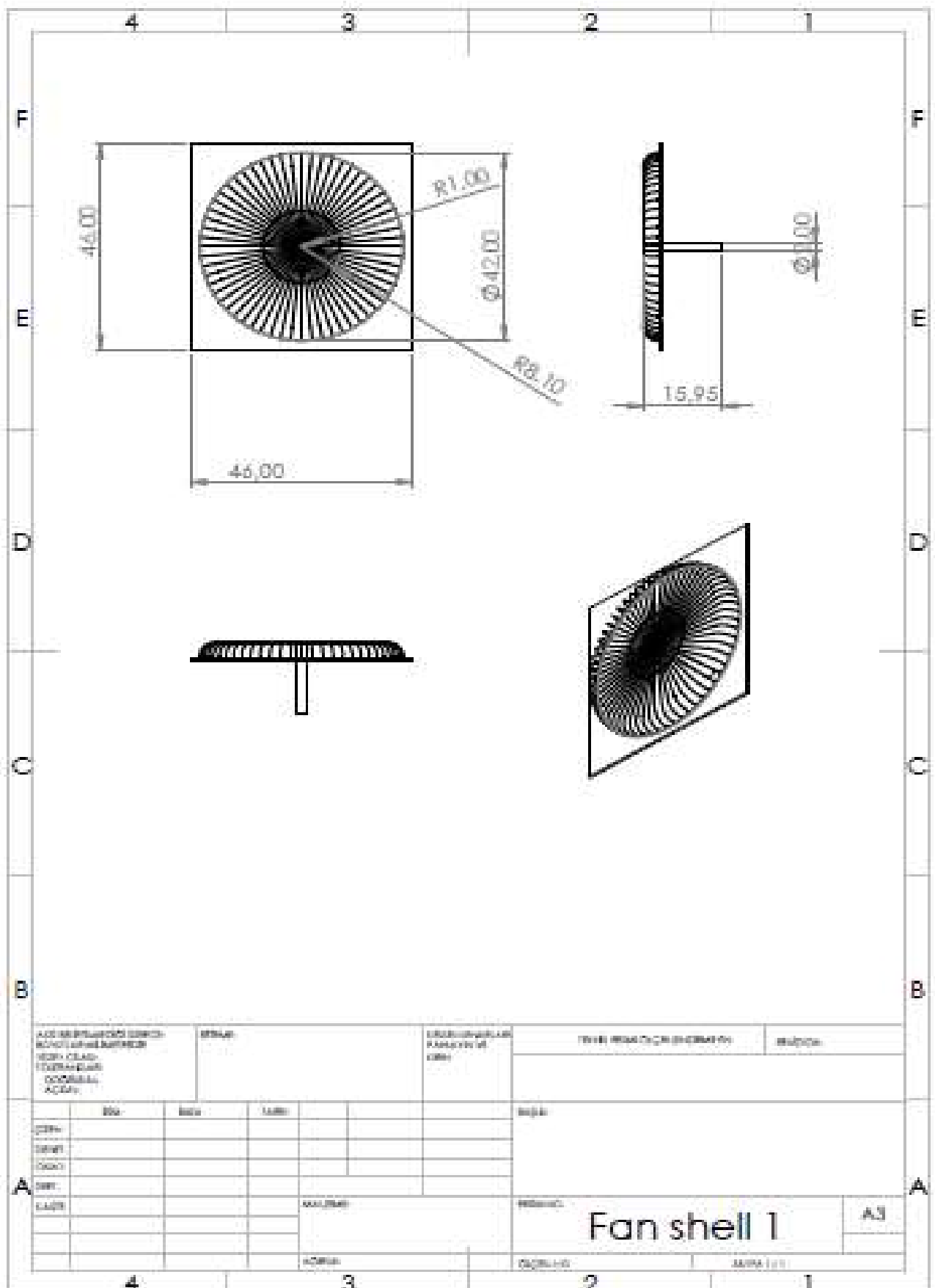


Figure 5.2 Technical Drawing of Fan Shell 1

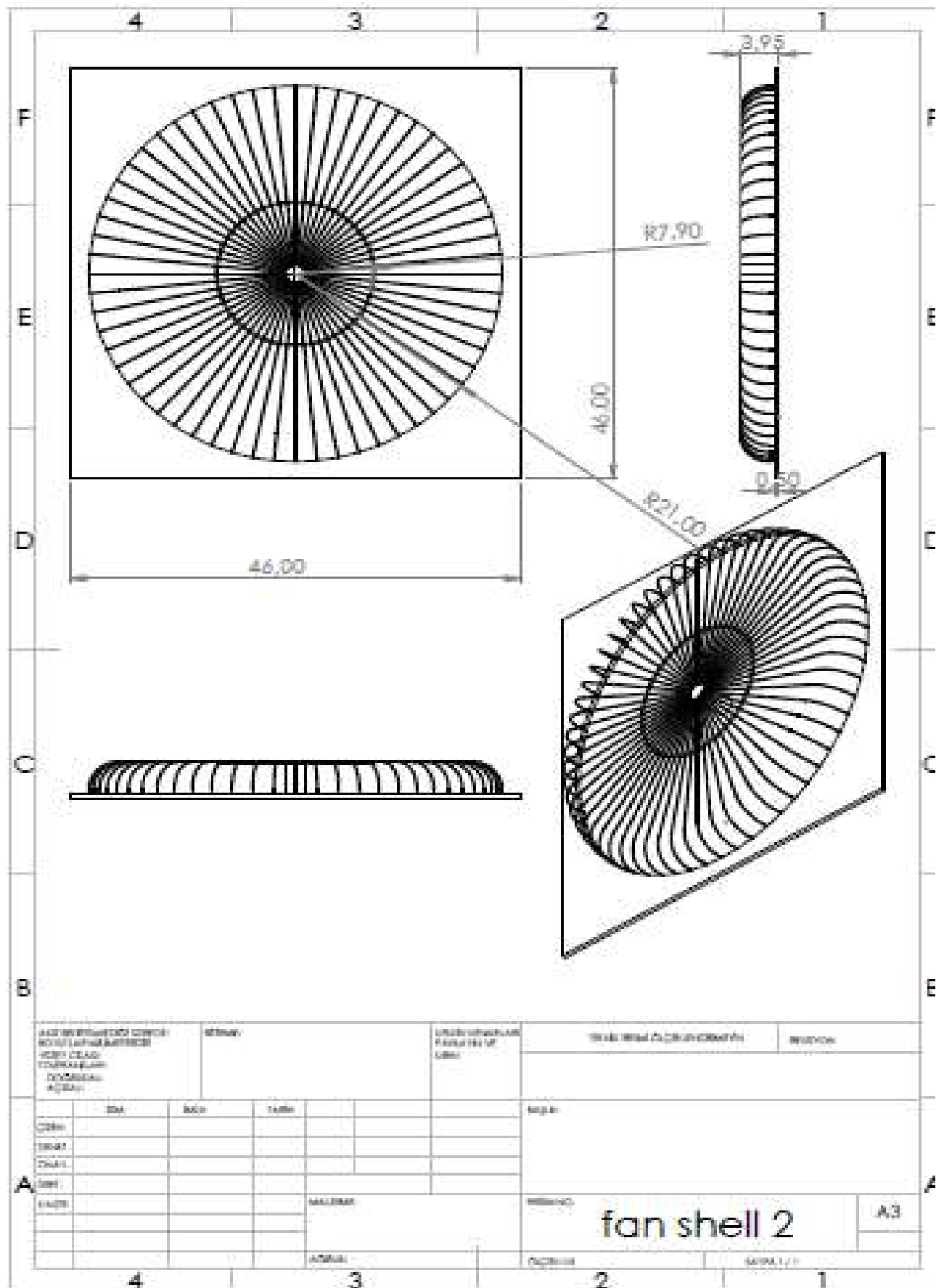
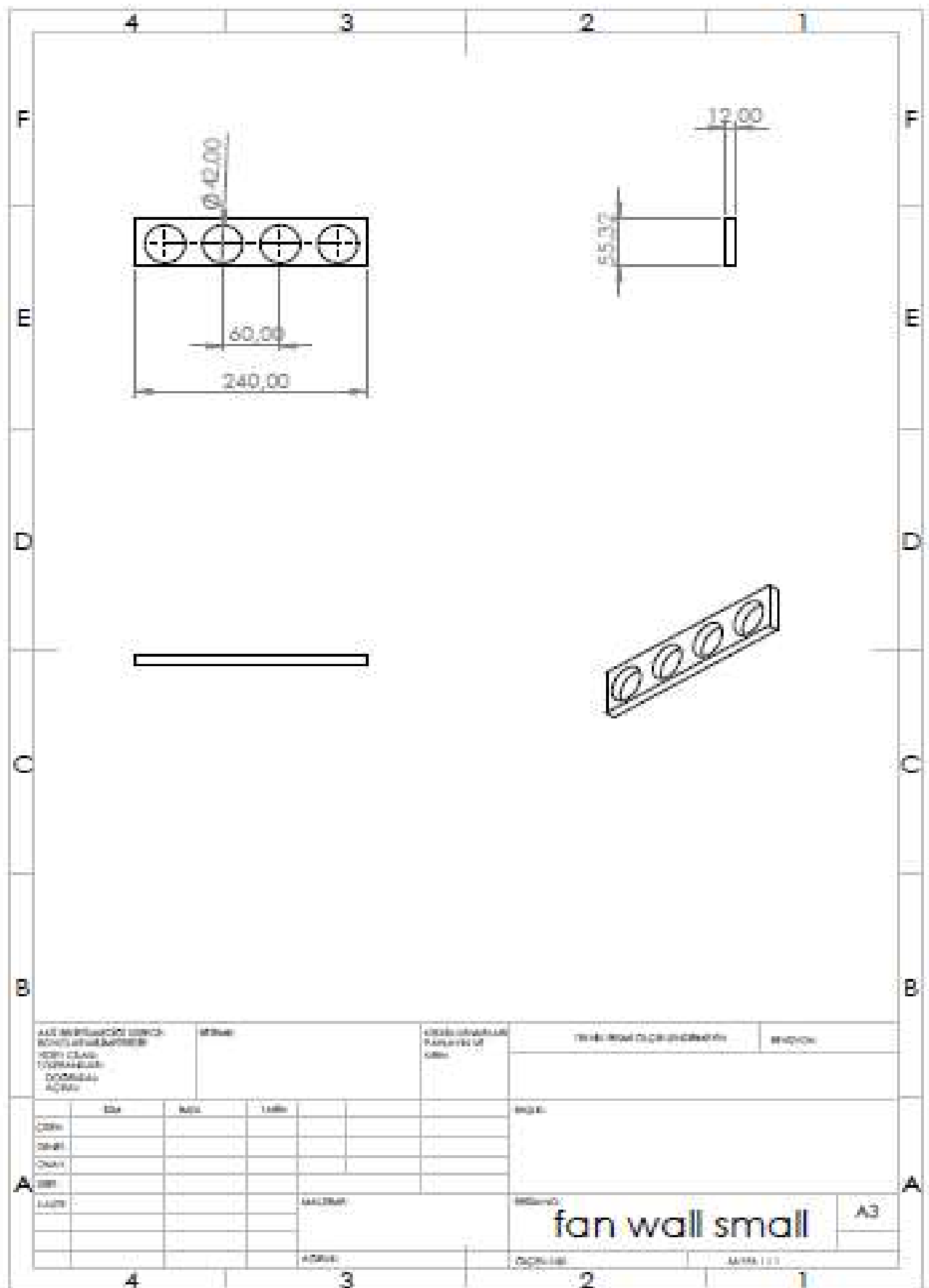


Figure 5.3 Technical Drawing of Fan Shell 2



Technical drawing of a fan wall showing front, side, and perspective views with dimensions.

Front View: A rectangular panel with a width of 240.00 and a height of 184.68. It features a 3x4 grid of circular fans. The center-to-center distance between fans is 60.00 horizontally and 42.00 vertically. The panel has a thickness of 12.00.

Side View: A rectangular panel with a width of 60.00 and a height of 60.00. It shows the side profile of the fan wall.

Perspective View: A 3D view of the fan wall showing its depth and the arrangement of the fans.

Technical drawing of a fan, showing multiple views and dimensions. The drawing is on a grid with coordinates 1-4 and A-F.

Views and Dimensions:

- Top View (Top Left):** Shows a fan with 8 blades. The central hole has a diameter of $\varnothing 8.32$. The total width of the fan is 10.19. A dimension of 1.60 is shown for the depth of the fan.
- Side View (Top Right):** Shows the fan from the side, highlighting the curved shape of the blades.
- Front View (Bottom Left):** Shows the fan from the front, highlighting the curved shape of the blades. The total width is 10.19, and the depth is 1.60.
- Top View (Bottom Right):** Shows the fan from the top, highlighting the curved shape of the blades.

Dimensions:

- Central hole diameter: $\varnothing 8.32$
- Total width: 10.19
- Depth: 1.60

Grid coordinates: 1-4 (horizontal), A-F (vertical).

Figure 5.6 Technical Drawing of Fan

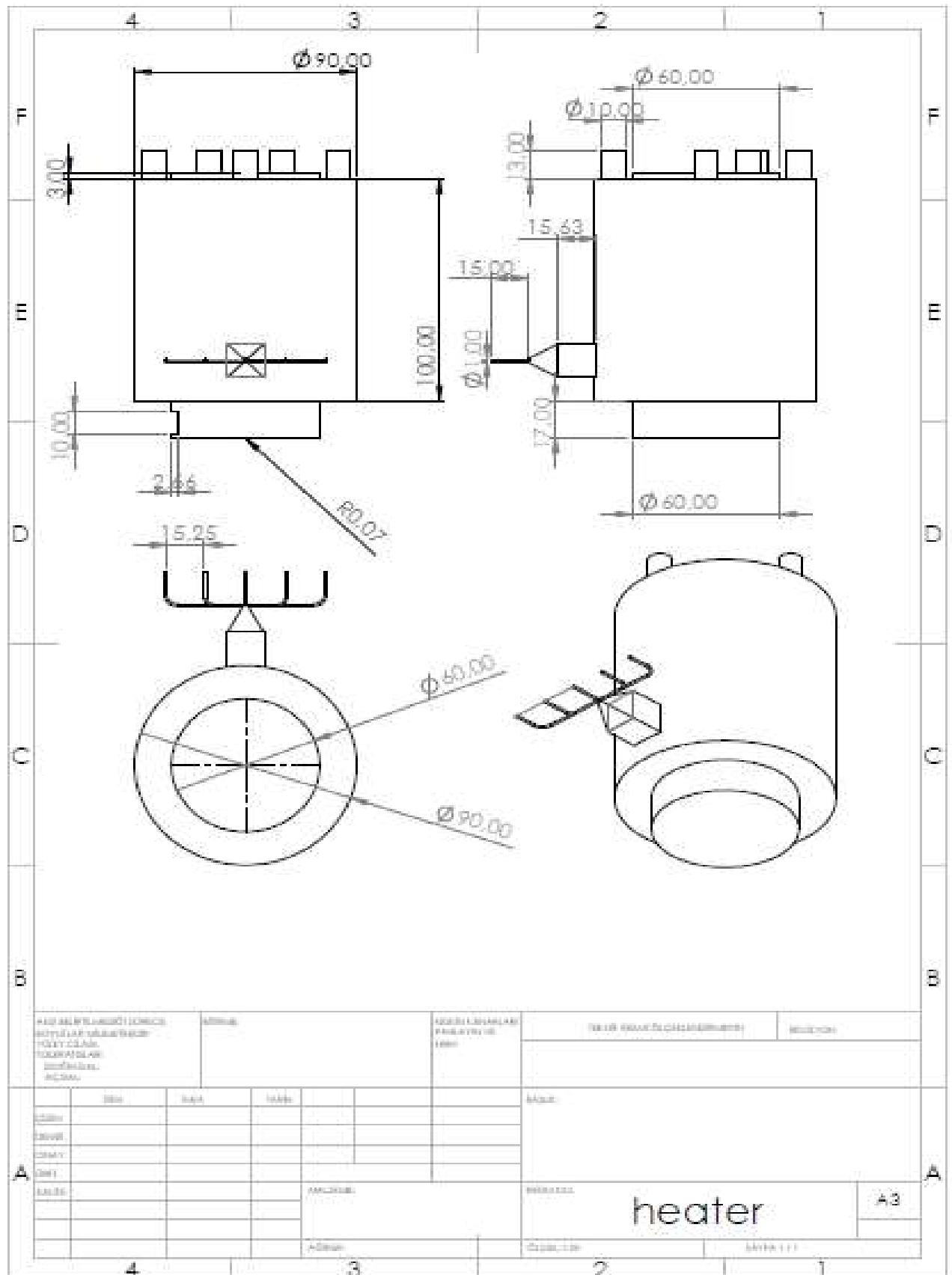


Figure 5.7 Technical Drawing of Heater

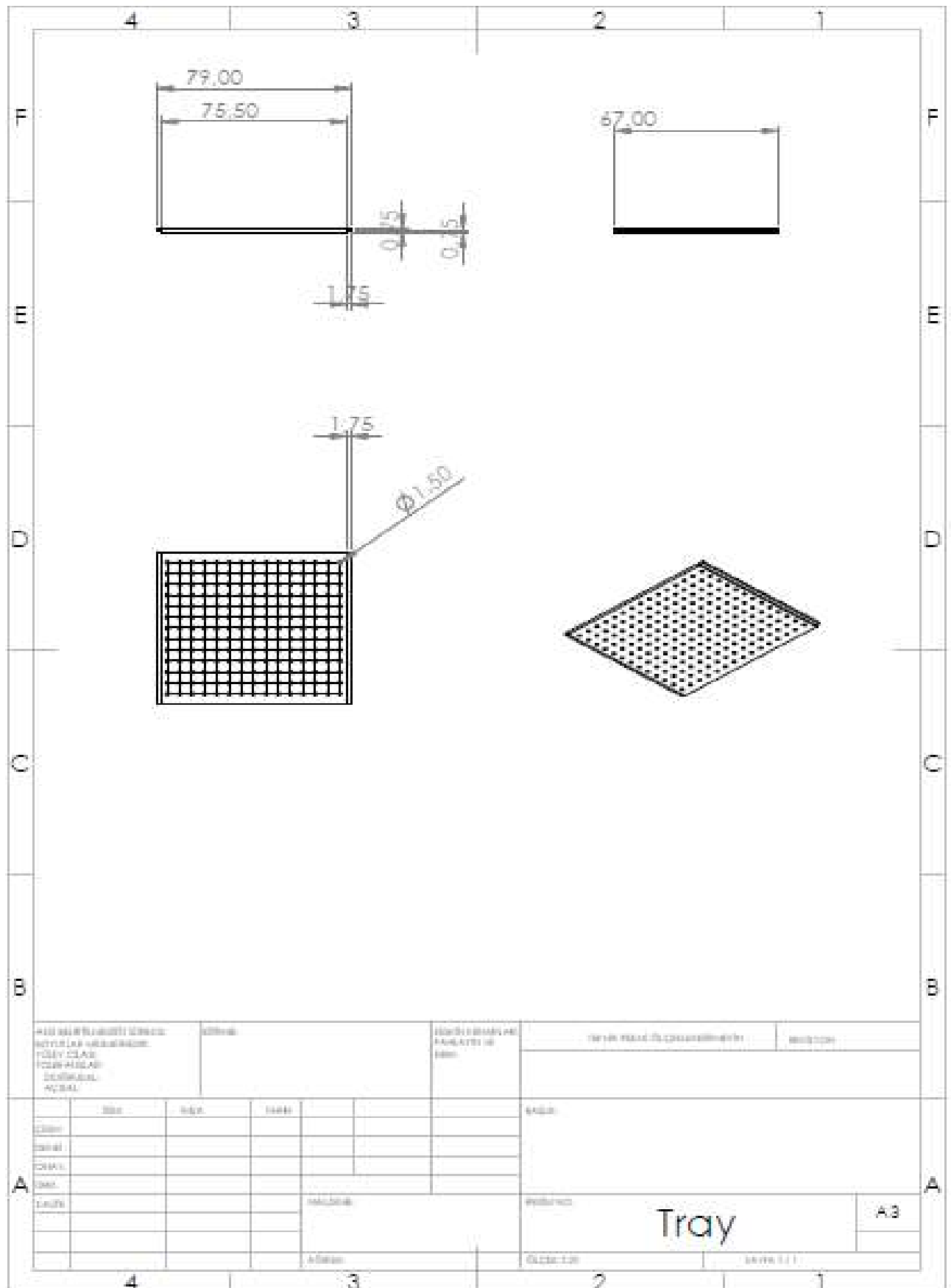
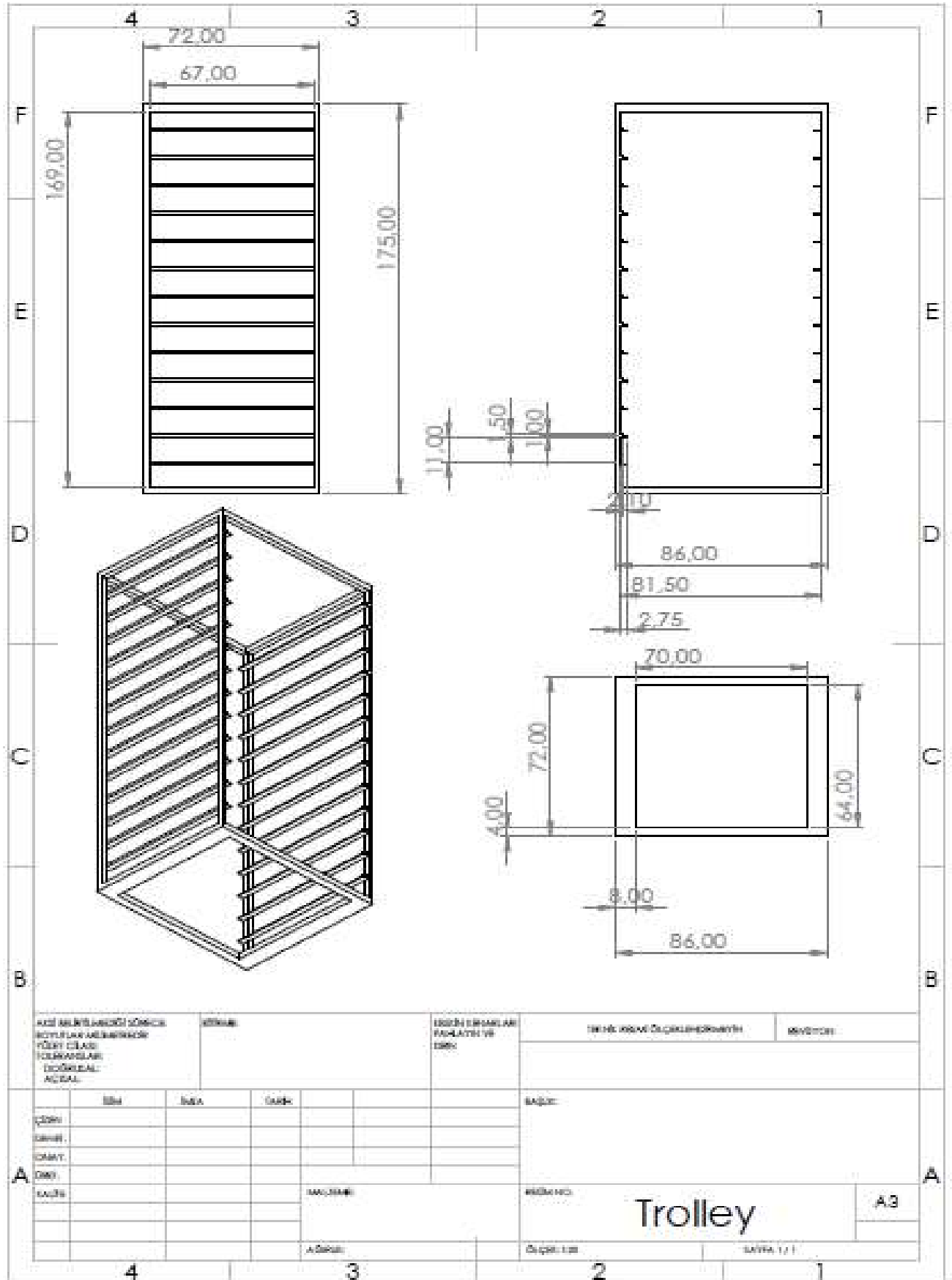


Figure 5.8 Technical Drawing of Tray



Technical drawing of a wheel part 1. The drawing includes a front view, a side view, and an isometric view. The front view shows a rectangular base with a width of 7.00 and a height of 8.07. A vertical plate of width 0.75 is attached to the right side, with a height of 7.32. The side view shows a triangular profile with a base of 10.00, a height of 8.18, and a top radius of R1.50. A central hole with a diameter of Ø1.50 is located at the top. The isometric view shows the 3D shape of the part.

[illegible]

Technical drawing of a wheel, showing four views: front, side, top, and isometric.

Front View: Circular wheel with a central hub. Dimensions: $\varnothing 8.50$ (outer diameter), $\varnothing 4.63$ (inner diameter), $\varnothing 1.50$ (hub diameter).

Side View: Profile view showing a rounded top with a radius of $R2.00$ and a width of 1.00 .

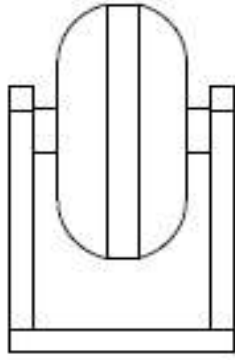
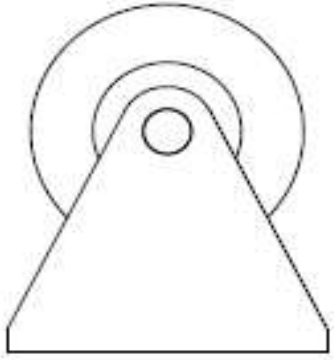

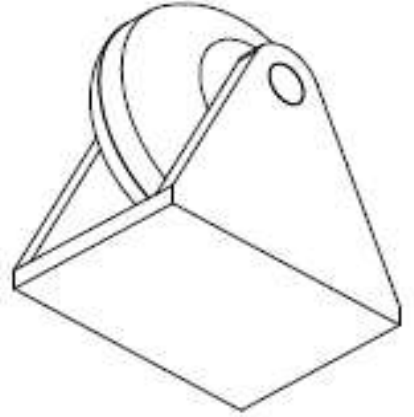

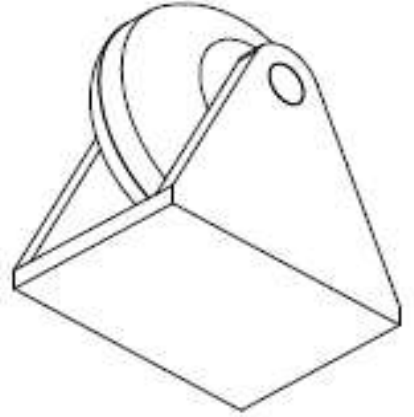
Top View: Circular wheel with a central hub. Dimensions: $\varnothing 1.50$ (hub diameter).

Isometric View: 3D representation of the wheel.

Table:

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İSİM									
KALİTE									
MALZEME:						REVİZYON NO.			
AĞIRLIK:						ÖLÇÜ: 1:2			
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Figure 5.12 Technical Drawing of Wheel

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[illegible]

Figure 5.14 Technical Drawing of Trolley With Trays and Wheel