

# Index

## A

- acid-alkali modeling, 154–156
- acid rain, 141
- active layer thickness, 59–60, 88–90
- active layer velocity, 83–87, 90, 99–100
- aggregate, lightweight (LWA), 3, 285–294
- aggregate kilns, 43*f*
- air
  - composition, 299
  - infiltration, 34, 43, 47, 56, 259
  - at low pressure (dry), 303–304
  - water percentage
    - calculations, 256
- air-fuel ratio, 136–137
- air requirements for combustion
  - acid-alkali modeling, 154–156
  - determining, 135–136
  - pulverized coal or coke, 145, 146–147, 170
  - sources of, 34
- air velocities, typical values
  - of, 43*f*
- annular shift kiln, 5*f*
- Arrhenius equation, 41, 153
- Ash Grove Cement Plant, 51
- Aspdin, Joseph, 2
- atmosphere
  - international standard
    - measurements, 312–313
  - units of conversion, 301

- atmospheric discharge, 34
- atomization, 149–152
- axial motion, 26–28
- axial segregation, 102

## B

- Bac, N., 196
- Bagnold, R. A., 53–54, 63
- banding, 102
- Barr, P. V., 67, 68, 197, 200–201
- Becher process, 283–284
- Becker, H. A., 47
- bed. *See also specific types*
  - depth, determining, 29–30
  - heat transfer
    - flame to bed, 195–196
    - introduction, 173–174
    - paths, 17*f*
    - rotating bed mode, 214–215
    - wall to bed, 198–199, 207–211
  - segregation model, 106–110
  - thermal model, 218–224
- bed behavior diagram, 23–24
- bed motion, modes of, 20*f*
- bed phenomenon, 15–18
- Blasius, H., 39
- Blasius problem, 80
- bloating, 233, 286, 288–292
- Boateng, A. A., 67, 68, 69, 197
- boiler and industrial furnace act (EPA), 130, 141

Boudouard reaction, 281–282

Boynton, R. S., 272

Brimacombe, J. K., 282

## C

calcination, 246–247, 261,  
266–272

calcination calculation, 251, 255

calciners, fluidized-bed, 6*f*

Campbell, C. S., 70

carbon black, 142

carbon dioxide (CO<sub>2</sub>), 133,  
138, 289

carbon monoxide (CO), 133, 163

carbothermic reduction, 280–284

Carnot cycle, 240

cascading bed, 19–21

cataracting bed, 20*f*

cement, history of, 1–2

cement kilns

air infiltration, 47

air velocities, 43*f*

Craya-Curtet parameter,  
47, 156

energy usage, 278–280

fuel types used, 141

history of, 1–2

schematic, 276

cement process chemistry,  
275–278

cenosphere, 149

centrifuging bed, 19–21

CFD. *See* computational fluid  
dynamics (CFD)

char combustion, 147–149

clay, 287, 289–294

coal

combustion chemistry, 133

combustion requirements,  
170–171

conveying air, 248, 259

delivery and firing systems,  
145–146

firing in kilns, 143–144, 156

heat transfer, 196

sensible heat calculations, 258

tires combined with, 142

types of, 139–140

Cohen, E. S., 196

coke, 140–141, 143–146, 170–171

combustion. *See also specific types,*  
*e.g.* char combustion

air requirements for

acid-alkali modeling,  
154–156

determining, 135–136

pulverized coal or coke, 145,  
146–147, 170

sources of, 34

CFD modeling, 156–158

heat release calculations, 261

introduction, 129–131

mass and energy balance, 255

mole and mass fractions of  
intended fuel, 131–133

practical stoichiometry,  
135–136

radiative effect of combustion  
gases, 195–196

combustion chemistry, 133–135

combustion efficiency, 34, 46,  
48, 50

combustion modeling

acid-alkali, 154–156

Hawthorne method, 154

overview, 152–154

computational fluid

dynamics (CFD)

modeling rotary kiln processes,  
156–160

pulverized fuel burner  
evaluation, 163–169

concentration transport equation,  
41, 153

concrete, 3, 287*f*

concrete ships, 286

confined flame theory, 47

confined jet-free jet relation,  
46–47  
confined jets, 34, 43–44,  
46–48, 155  
continuity equation, 40, 153  
conversion factors, SI to British,  
298, 302  
coolers, 10, 12*f*  
Couette flow, 35–37  
countercurrent flow rotary  
kiln, 4*f*  
cracking, 51, 140  
Craya, A., 47  
Craya-Curtet parameter, 47–48,  
155–156  
Curtet, R., 47

## D

Damkohler I and II, 42, 46  
Davies, T. R. H., 61  
dirty fans, 56  
dolomite, 267–268  
dryers, 10  
dry kilns, 9–10  
dumbell-type rotary kiln, 7*f*  
dust, site survey, 249  
dust constituents, 260  
dust entrainment, 34, 40, 53–56.  
*See also* entrainment;  
saltation

## E

Edison, Thomas A., 2  
efficiency, thermal, 243–244  
Ehlers, E. G., 289, 290  
emissions modeling, 161–163  
emissivity, 194–195  
energy cost savings, 142, 145  
energy savings, maximizing, 135  
enthalpy transport equation,  
41, 153  
entrainment. *See also* dust  
entrainment

jet properties and, 43–53  
saltation and, 53–56  
environmental sustainability, 145  
equation of state, 41, 153

## F

Fan, L. T., 106  
fans. *See specific types of*  
Ferron, J. R., 60, 72, 207–211  
field kilns, 2  
flame shape and character  
air-fuel ratio in, 137–138  
Craya-Curtet parameters,  
47–48, 156  
droplet fuel size and, 151  
heat dissipation and, 130  
heat flux and, 46–47  
luminosity-emissions relation,  
51, 195  
flame temperature, adiabatic,  
136–138  
flame theory, 47  
flotsam, 109, 114. *See also*  
percolation  
flow behavior, transverse,  
24–26  
flow visualization modeling,  
154–156  
flue gases, 134, 260  
fluid flow  
laminar and turbulent,  
36–39, 154  
in pipes, 33–40  
sources of, 34, 43  
forced draft fans, 56  
4-nine destruction  
efficiencies, 138  
freeboard aerodynamics  
in dust entrainment, 34, 40,  
53–56  
fluid flow in pipes, effect on,  
33–40  
introduction, 33–34

freeboard aerodynamics  
     (Continued)  
     mixing and, 43–53  
     total flow inducement, 56  
 freeboard phenomenon-bed  
     phenomena synergy,  
     15–17, 33  
 freeboard(s)  
     dimensionless parameters of  
     combustion, 42  
     heat transfer  
         among exposed surfaces,  
         199–203  
         coefficients for radiation,  
         196–198  
         to exposed bed and wall,  
         3–4, 4f, 15, 198–199  
         introduction, 173–174  
         to the wall, 187–189  
     in indirect fired kilns, purging  
         volatiles, 12  
     thermal model, 218–221  
 free jet-confined jet relation,  
     46–47  
 free jets, 43–45  
 friction velocity, 40  
 fuel. *See also specific fuel types*  
     atomization of liquid, 149–152  
     combustion and, 129–131  
     energy calculations, 256  
     types used in rotary kilns,  
         130–131, 138–139  
 fuel-air systems, 135–136, 137f  
 fuel efficiency, 51, 135, 138,  
     154, 244  
 fuel heating value, 130, 134–135  
 fuel NO<sub>x</sub>, 161–162  
 fuel oil firing, 149–152  
  
**G**  
 gas components, natural and exit  
     gas, 250  
 gaseous fuels, 130, 137, 138f

gases  
     H, U, S, G, 306–311  
     radiative effect of combustion,  
         195–196  
     specific heats, 304–305  
 gas flow rate, 34  
 gas-phase combustion, 158–159  
 Gauthier, C., 86  
 Gibbs free energy and entropy,  
     159, 240–243  
 grain inertia regime, 63  
 grain temperature, 66  
 granular flow  
     defined, 59  
     equations of motion, 64–67  
     kinetic theory application  
         to, 63–64  
     mechanisms of momentum  
         transfer, 63  
     modeling, 59–62, 72  
     observed, in a rotary drum, 25,  
         68–72  
     other flow types compared,  
         61–62, 61f  
     theories governing, 62–63  
 granular temperature, 66,  
     87–88, 90  
 Greek nomenclature, Appendix  
 green coke, 140  
 Guruz, H. K., 196  
 Gyro-Therm, 50

## H

Hagen-Poiseuille equation of  
     laminar flow, 37  
 Hawthorne method, 154  
 Hayde, Stephen J., 3, 286  
 hazardous waste incineration, 130,  
     138, 243  
 heat balance, 239  
 heat content, units of conversion,  
     300–301  
 heat exchange, cross section, 16f  
 heat flux, 46–47, 175

heat of reaction/heat of formation, 240  
heat recuperators, 8  
heat transfer  
  in the bed, 173–174, 207–215  
  bed to wall, 198–199, 207–211  
  combustive gases, radiative effect, 195–196  
  conduction, 174, 175–180, 211–215  
  conduction-convection problems, 182–184  
  conduction in the wall, 187–189  
  convection, 174, 180–182  
  estimating, 40  
  exposed surfaces, 198–203  
  flame to bed, 195–196  
  in the fluid, 42  
  methods overview, 174–175  
  packed beds, 211–214  
  radiant, 50  
  radiation, 51, 138, 174, 189–191  
  radiation exchange, 194–195  
  radiation shape factors, 192–194  
  refractory lining materials and, 184–187  
  rotating bed mode, 214–215  
  shell losses, 184  
  wall to bed, 198–199, 207–211  
heat transfer, freeboard  
  among exposed surfaces, 199–203  
  coefficients for radiation, 196–198  
  to exposed bed and wall, 198–199  
  introduction, 173–174  
  to the wall, 187–189  
heat transfer model  
  results and application, 228–232

  single particle for shale processing, 232–237  
  solution procedure, 224–227  
Henein, H., 67, 69, 113, 119  
higher heating value (HHV), 134  
horizontal kilns, 4–7  
Hottel, H. C., 196

## I

ilmenite, 283  
indirect fired kilns, 12–13  
induced draft (I.D.) fan, 34, 35, 56  
infiltration air, 34, 43, 47, 56, 259  
instantaneous jet, 51  
irradiation, 192

## J

Jenkins, B. G., 154, 205  
jets. *See* flame shape and character; *specific types of*  
jetsam, 109. *See also* percolation  
jetsam loading-number concentration, 124–125

## K

kerosene, 149  
kidney, 107  
kiln design, 29–30, 56, 135. *See also specific types of kilns*  
kiln geometry  
  determining capacity, 28  
  plug-flow estimations from, 29  
  residence time relation, 18, 23, 26–27  
kiln loading, 21–23  
kiln wall  
  heat transfer  
    freeboard, 187–189  
    refractory lining materials and, 184–187

kiln wall (*Continued*)  
 shell losses, 184  
 wall to bed, 198–199,  
 207–211

## L

laminar jets, 45  
 Lewis number, 152  
 lightweight aggregate (LWA), 3,  
 285–294  
 lime kilns  
 about, 272–274  
 active layer, 59  
 air velocities, 43*f*  
 Craya-Curtet parameter,  
 156, 273  
 history of, 1–2, 266  
 modern, 10  
 lime manufacturing, 265–266, 272  
 lime products, 260  
 limestone, 248, 259, 266  
 limestone calcination, 246–247,  
 261, 266–272  
 limestone calcination kilns, 47  
 liquid burnable materials (LBM),  
 130, 152, 196  
 long dry kilns, 9–10  
 long kilns, history of, 2  
 lower heating value (LHV),  
 134–135  
 Luminis Pty. Ltd., 50  
 Lun, C. K. K., 65, 83, 98  
 Lunn, 104  
 Luxton, R. E., 51

## M

Mach number, 41  
 mass, units of conversion, 300  
 mass and energy balance  
 calcination calculation,  
 251, 255  
 chemical compositions, 246  
 combustion, 251, 255

energy balance inputs, 246–247  
 global heat and material,  
 243–244  
 introduction, 239  
 mass balance inputs, 245–246  
 sensible energy, input and  
 output, 258–260  
 shell heat loss, 251–254  
 site survey-measured variables,  
 247–251  
 thermal module for chemically  
 reactive system, 244–245  
 metallurgy, extractive, 280  
 methane combustion, 133–134  
 microexplosions, 152  
 Millen, Thomas, 2  
 minerals process applications  
 carbothermic reduction  
 processes, 280–283  
 cement kilns, 275–280  
 cement process chemistry,  
 276–278  
 introduction, 265  
 lightweight aggregate, 285–294  
 lime manufacturing, 265–266  
 limestone dissociation  
 (calcination), 266–272  
 ore reduction processes, 280  
 rotary lime kiln, 272–274  
 mixing  
 atomization requirements,  
 149–152  
 in carbothermic processes, 282  
 Hawthorne method, 154  
 introduction, 101  
 jet properties and, 43–53  
 modeling within the bed,  
 105–106  
 purpose of, 24  
 turbulent, 39, 154  
 Moles, F. D., 154, 196, 205  
 momentum equation, 153  
 Mullinger, P. J., 154

## N

Nathan, G. J., 51  
natural gas, 138, 196, 250, 256, 258  
Navier-Stokes, 56, 64, 159  
Newby, M. P., 47  
Nicholson, T., 26–28  
nitric oxide (NO<sub>x</sub>) emissions, 51, 161–162  
nomenclature, Appendix  
notation, variables, unit, and description, 297  
nozzle tip velocities, 43

## O

Owen, P. R., 54  
oxy-hemoglobin formation, 133

## P

Parker, D. J., 29  
particle-laden jets, 52–53, 143  
particulate flow behavior in rotary kilns, 67–68, 160  
particulate flow model  
  active layer  
    analytical expression for thickness of the, 88–90  
    momentum equation solution, 83–85  
    velocity profile in the, 85–87  
  application, 94–95  
  density and granular temperature profiles, 87–88  
  description, 73–74  
  introduction, 72–73  
  momentum conservation governing equations, 75–79  
  integral equation, 79–83

  momentum equation  
    numerical solution scheme, 90–91  
    solution in the active layer, 83–85  
  results and validation, 92–94  
  simplifying assumptions, 74–75  
Peclet number, 42  
Peray, K. E., 275  
percolation  
  defined, 102  
  spontaneous, 104, 107–109, 112–113, 120  
percolation velocity, 106, 107, 110–112, 114  
Pershin, V. F., 59–60  
petroleum coke, 140–141  
Phillips, E. L., 289  
pipes, fluid flow in, 33–40  
PJ burner, 51  
plug-flow estimations, 29  
Polak, S. L., 140  
pollution control, 34, 50, 135, 244. *See also specific pollutants*  
Portland cement, 2  
pot kilns, 2  
Prandtl number, 38, 41  
precalciners, 10  
precessing jets, 49–51  
preheaters, 11f  
pressure, units of conversion, 301  
prompt NO, 162  
pulverized fuel  
  burner evaluation using CFD, 163–169  
  combustion systems  
    confined jets, 33–34, 46  
    particle-laden jets, 52  
  delivery and firing systems, 145–146  
  reaction kinetics of carbon particles, 147–149  
  sources of, 139–144

## R

radiosity, 192  
 Ransome, F., 2  
 reacting flows, multicomponent,  
     basic equations, 40–43  
 recirculation, 46–47  
 recirculation vortex, 48–49, 156  
 relaxation time, 52–53  
 residence time, 46, 149, 154  
     dimensionless, 28–30  
 residence time-kiln geometry  
     relation, 18, 23, 26–27  
 Reynolds number, 36, 41, 46, 150  
 Reynolds principle, 36, 37, 38  
 Ricou, F. P., 45–46  
 rolling bed, 20–22, 73–79, 82  
 Rosin-Rammler relation,  
     143–144, 160  
 rotary kilns. *See also specific types of*  
     basics, 3–4, 129  
     competitive features, 3, 12, 287  
     dams and tumblers, purpose  
         of, 7–8  
     design challenges, 56  
     efficiency, 51, 56  
     evolution of, 1–7  
     fuel types used in, 130–131,  
         138–139  
     lifters, energy-savings with, 7–8  
     other contact kilns compared,  
         4–7  
     regulation of, 130, 141,  
         287–288  
     sizing, 19  
     types of, 7–13  
 rotary kilns, operation basics  
     axial motion, 26–28  
     bed phenomenon, 16–19  
     dimensionless residence time,  
         28–30  
     freeboard phenomenon, 15–17  
     geometrical features and their  
         transport effects, 18–19

    introduction, 15–17

    transverse bed motion, 19–23

    transverse flow behavior, 24–26

rotary reactor, 15

round jets, 45–46

Ruhland, W., 154

rutile, 283

## S

saltation, 53–56, 146

Sarofim, A., 196

Savage, S. B., 62, 104, 111

Schlichting, H., 35

Schneider, G. M., 51

scrubbing, 141

seals, 34

Seaman, W. C., 22, 26, 28, 61

segregation

    mechanisms of, 102–104

    reducing, 104

segregation equation solutions

    mixing and segregation,

        116–117, 125–127

    radial mixing, 115–116

    strongly segregating system,

        114–115

segregation model

    application, 120–121

    within the bed, 106–110

    boundary conditions, 113–114

    governing equations, 110–113

    governing equations numerical

        solution, 117–119

    introduction, 105–106

    validation, 119–120

segregation rates, 103

sensible heat calculations, 66

sensible heat defined, 240

shaft-type kilns, 4, 6

shale, 3, 232–237, 286, 288–294

shell heat loss, 184, 250, 251–254

ships, concrete, 286

short dry kilns, 10, 11*f*



sieving, inverse, 103  
Singh, D. K., 60, 68, 72, 207–211  
skin friction coefficient, 40  
slate, 286, 289–294  
slipping bed, 20  
SL/RN kilns, 280–283  
slumping bed, 20, 82  
Spaulding, D. B., 45–46  
squeeze expulsion, 110  
stack gases, 134  
stationary kilns, 2  
Stefan-Boltzmann constant, 300  
Strouhal number, 50–51  
submerged jets, 43–44  
sulfur dioxide (SO<sub>2</sub>)  
    emissions, 141  
surface velocity, deep beds, 26  
swirling jets, 48–49  
swirl number, 49

## T

Tackie, E. N., 56  
temperature, formulas for  
    calculating, 300. *See also*  
    *specific types of*  
    *temperature*  
thermal model  
    description, 216–217  
    one-dimensional for bed and  
        freeboard, 218–221  
    quasi three-dimensional for  
        the bed, 223–224  
    of rotary kiln processes,  
        215–216  
    two-dimensional for the bed,  
        221–223  
thermal NO, 162  
thermodynamics, chemical,  
    239–240  
thermodynamic tables  
    gases, 301  
    inorganic materials, 313

Thring, M. W., 47  
tire combustion, 141–143  
titaniferous materials, 282–285  
tongue, 107  
trajectory segregation, 102–103  
transport phenomenon  
    history of, 2  
    modeling, 16  
Tscheng, S. H., 211  
turbulence modeling, 158–159  
turbulent diffusion flames, 34,  
    42, 46  
turbulent jets, 43–46, 154  
turbulent kinetic energy  
    (TKE), 154  
turbulent variable swirl burners,  
    48, 50

## V

van der Hegge Zijnen, 45  
vaporization, 134–135,  
    150–152  
vapors  
    H, U, S, G, 306–311  
    specific heats, 304–305  
velocity, units of  
    conversion, 300  
Venkateswaran, V., 282  
vertical kilns, 4–7  
viscosity, 35–36, 98–99  
von Karman, T., 79  
vortex shedding, 48–49, 156

## W

Wang, R. H., 106  
waste fuels, 130, 152, 196, 287  
Watkinson, A. P., 211  
wet kilns, 9

## Z

Zhang, Y., 70