National Exams May 2014

04-Agric-B8, Food Process Engineering (Part 1)

3 hours duration

NOTES:

1. If doubt exists as to the interpretation of any question, the candidate is urged to submit with the answer paper, a clear statement of any assumptions made.

2. This is an OPEN BOOK EXAM.
   Any non-communicating calculator is permitted.

3. Complete the questions as indicated on the paper. Some choices are provided. Six (6) questions constitute a complete exam paper.

4. Marks for each question are given at the end of the question.

I. Heat transfer

Do **one question** from the following two questions

1. A pudding product to be marketed as baby food is put into steel cans 7 cm in diameter and 8.5 cm long. The canned product having an initial uniform temperature of 28°C is then placed into a steam retort where steam at 130°C is introduced. The pudding properties are: density (ρ) = 1020 kg/m^3, thermal conductivity (k) = 0.32 W/(m.K), and specific heat (C_p) = 3.6 kJ/(kg.K). The convective heat transfer coefficient (h) between the outside of the can and the condensing steam is 8000 W/(m^2.K). The plant engineer estimated the cans of pudding must remain in the retort for 30 min to reach a geometric centre temperature of 93°C. Check the estimate accuracy. Use the charts given with the paper (Fig. 1). Thermal resistance and thermal capacity of steel can be neglected. (15 marks)

2. (a) Occasionally food products that have been in a cold storage room and are suddenly introduced into a warm processing room begin to "sweet" (wet surface). Explain the reason for the phenomenon. (5 marks)

   (b) For each of the following situations, indicate whether a transient (unsteady) analysis or a steady state analysis would be more appropriate (5 marks):
   (i) To determine the rate of heat transfer through an oven wall where the inside and outside surfaces temperatures are constant.
   (ii) To determine the rate at which the temperature of a quality of milk changes with time in a refrigerated tank.
   (iii) To determine the instantaneous rate of heat transfer to a piece of fruit immersed in liquid nitrogen.

   (c) Outline a procedure for determining the centre temperature as a function of time in a stick of bologna cooking in a smokehouse. (5 marks)

II. Food freezing and freeze concentration

Do any **one** out of the following two questions

3. Grapefruit is being frozen in a 4 cm diameter by 10 cm tall can in an air blast freezer with 20 W/(m^2.K) as a surface heat transfer coefficient (h). The initial product temperature is 2°C and the air used as a freezing medium is at -20°C. Estimate the time required to freeze the product to -10°C using the modified Plank's equation (Levy's). Assume infinite cylinder geometry. ΔH (enthalpy for sublimation) for water = 333 kJ/kg, C_{PI} (specific heat for frozen product) = 2.05 kJ/(kg.K), k_I (thermal conductivity of frozen product) = 1.108 W/(m.K), and ρ (product density) = 1000 kg/m^3, product moisture content = 90%, T_{fi} (initial product

freezing temperature) = -2°C, C_{PU} (specific heat for unfrozen product)= 4.22 kJ/(kg.K). (15 marks)

4. Sweet cherries (approximately 1.5 cm diameter) are being frozen in a freezer with -30°C air and a surface heat transfer coefficient (h) of 50 W/(m^2.K). If the initial product temperature is 5°C, how much time will be required to reduce the product's centre temperature to -15°C? Estimate the freezing time using Cleland-Earle approach. k_I = 1.108 W/(m.K), ΔH = 278 kJ/kg, C_{PU} = 0.22 kJ/(kg.K), C_{PI} = 2.05 kJ/(kg.K), ρ = 1050 kg/m^3, T_{fi} = -2.5 °C. See question 3 for symbol definition. (15 marks)

III. Thermal processing

Do any **two questions** out of the following three questions

5. a) A food product in a can has an f_h = 5 min and a j = 0.8. For an initial temperature of 80°F and a retort temperature of 250°F, calculate the process time. F_o (F at 250°F) = 4 min and z = 18°F. (b) The product in part (a) is processed in a stationary retort and it takes 4 min for the retort to reach 250°F from the time the steam was turned on. How many minutes after turning the steam on should the steam be turned off? (c) In one of the retorts where the cans were processed, there was a missed process and the record on the retort temperature chart showed the following:

Time, min	Retort temp.°F
0	70
3	210
10	210
Suddenly jump from 210 to 250 °F at 10 min	
15	250
16	Steam off, cooling water on.

What is the F_o of this process. The initial temperature of can was 80°F. The symbols used are standard symbols used in thermal process calculations. Use the attached table for g values. (15 marks)

6. The following heat penetration data were measured for a food product processed at 250°F in a retort having a come-up time of 3 min. (a) Calculate f_h and j_h values for the canned product, (b) calculate process at 260°F, Z = 18°F, F_o = 8 min, and initial food temperature is 120°F. Graph paper is attached. For log plot, use linear graph paper by using log values. Use the attached table for g values. The symbols used are standard symbols used in thermal process calculations. (15 marks)

Time, min	0	5	10	15	20	25	30	35	40	45	50
Temp., °F	170	170	180	187	200	209	216	223	228	235	236

7. Calculate the length of a holding tube for high temperature processing in an aseptic packaging system that would be necessary to provide a 5 D reduction of spores of a microorganism (D_o = 1.2 min) at 280°F. Use a z value of 50°F. The rate of flow in the tube is 113.6 litre/min, product density is 1042 kg/m^3, and product viscosity is 10 centipoise. The tube inside diameter is 3.48 cm. If in the same system, another food of viscosity 100 centipoise is used, calculate the probability of spoilage when the process is carried out at 280°F (z = 20°F). The rate of flow is same and initial inoculum is 100 spores per can (D_o = 1.2 min). The symbols used are standard symbols used in thermal process calculations. (15 marks)

IV.Evaporator

Do any **two questions** out of the following three questions. Steam table is provided to solve these questions.

8. A double effect evaporator (shown in the figure at the end) is operating with reverse feed, where the feed enters the low temperature effect and the product leaves the high temperature effect. The saturated steam entering the first effect may be assumed to have a temperature of 100°C. Calculate the solids content of the liquid leaving the second effect. The specific heats of the solid and water are 2.095 and 4.186 kJ/(kg.K), respectively. Consider 100 kg/min of feed. (20 marks)

9. Skim milk is being concentrated in a double effect evaporator. Calculate the solids content of the liquid leaving the first effect. The specific heat of the solids is 2.09 kJ/(kg.K), and water is 4.186 kJ/(kg.K). Other data are given on the figure (given at the end). (20 marks)

10. Peach puree is being concentrated in a continuous vacuum evaporator at a rate of 70 kg/h. The feed has a temperature of 15°C and a total solids content of 10.9%. A product of 40.1% total solids is withdrawn at a temperature of 40°C, and the condensate leaves the condenser at 37°C. (a) Calculate the flow rates of the product and condensate streams. (b) If saturated steam condensing at 120°C is used to supply the heat of evaporation, calculate the steam consumption in kg/h. The specific heat of the solid material is 2.09 kJ/(kg.K) and for water is 4.19 kJ/(kg.K). (c) Cooling water enters the condenser at 20°C and leaves at 30°C. Calculate the cooling water flow rate. (20 marks)

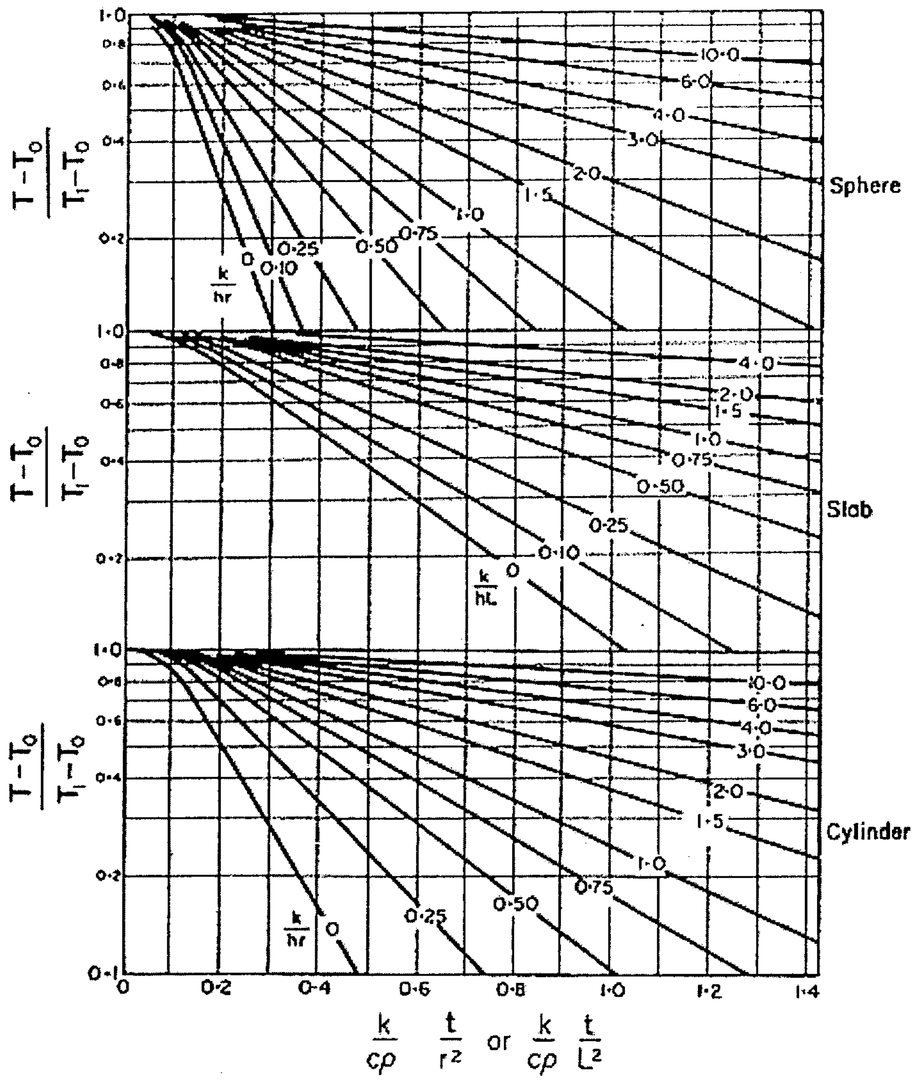

Fig. 1: Chart for Question #1

Table 9.12. f_h/U vs. g Table Used for Thermal Process Calculations by Stumbo's Procedure

	z = 14		z = 18		z = 22	
f_h/U	g	$\Delta g/\Delta j$	g	$\Delta g/\Delta j$	g	$\Delta g/\Delta j$
0.2	0.000091	0.0000118	0.0000509	0.0000168	0.0000616	0.0000226
0.3	0.00175	0.00059	0.0024	0.00066	0.00282	0.00106
0.4	0.0122	0.0038	0.0162	0.0047	0.020	0.0067
0.5	0.0396	0.0111	0.0506	0.0159	0.065	0.0197
0.6	0.0876	0.0224	0.109	0.036	0.143	0.040
0.7	0.155	0.036	0.189	0.066	0.25	0.069
0.8	0.238	0.053	0.287	0.103	0.38	0.105
0.9	0.334	0.07	0.400	0.145	0.527	0.147
1.0	0.438	0.009	0.523	0.192	0.685	0.196
2.0	1.56	0.37	1.93	0.68	2.41	0.83
3.0	2.53	0.70	3.26	1.05	3.98	1.44
4.0	3.33	1.03	4.41	1.34	5.33	1.97
5.0	4.02	1.32	5.40	1.59	6.51	2.39
6.0	4.63	1.56	6.25	1.82	7.53	2.75
7.0	5.17	1.77	7.00	2.05	8.44	3.06
8.0	5.67	1.95	7.66	2.27	9.26	3.32
9.0	6.13	2.09	8.25	2.48	10.00	3.55
10	6.55	2.22	8.78	2.69	10.67	3.77
15	8.29	2.68	10.88	3.57	13.40	4.60
20	9.63	2.96	12.40	4.28	15.30	5.50
25	10.7	3.18	13.60	4.80	16.9	6.10
30	11.6	3.37	14.60	5.30	18.2	6.70
35	12.4	3.50	15.50	5.70	19.3	7.20
40	13.1	3.70	16.30	6.00	20.3	7.60
45	13.7	3.80	17.00	6.20	21.1	8.0
50	14.2	4.00	17.7	6.40	21.9	8.3
60	15.1	4.3	18.9	6.80	23.2	9.0
70	15.9	4.5	19.9	7.10	24.3	9.5
80	16.5	4.8	20.8	7.30	25.3	9.8
90	17.1	5.0	21.6	7.60	26.2	10.1
100	17.6	5.2	22.3	7.80	27.0	10.4
150	19.5	6.1	25.2	8.40	30.3	11.4
200	20.8	6.7	27.1	9.10	32.7	12.1

Source: Based on f_h/U vs. g tables in Stumbo, C. R. 1973. *Thermobacteriology in Food Processing*, 2nd ed. Academic Press, New York.

To use for values of j other than 1, solve for g_j as follows:

$$g_j = j_{j=1} + (j - 1)(\Delta g/\Delta j)$$

Example: g for $(f_h/U) = 20$ and $j = 1.4$ at $z = 18$.

$$g_{j=1.4} = 12.4 + (0.4)(4.28) = 14.11$$

Reprinted from: Toledo, R. T. 1980. Fundamentals of Food Process Engineering, 1st ed. AVI Pub. Co. Westport, CT.

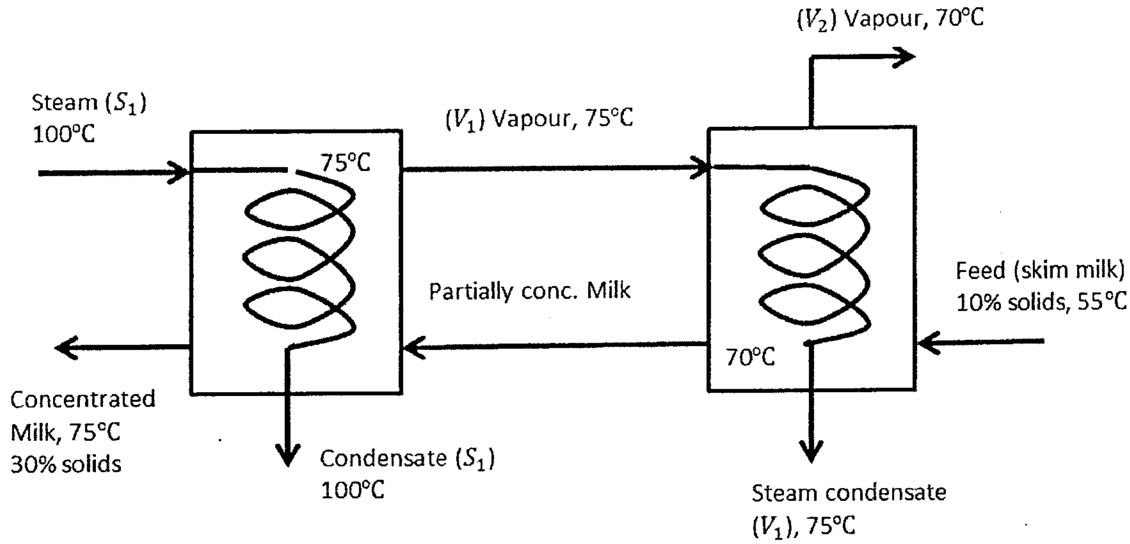

Figure for question #8

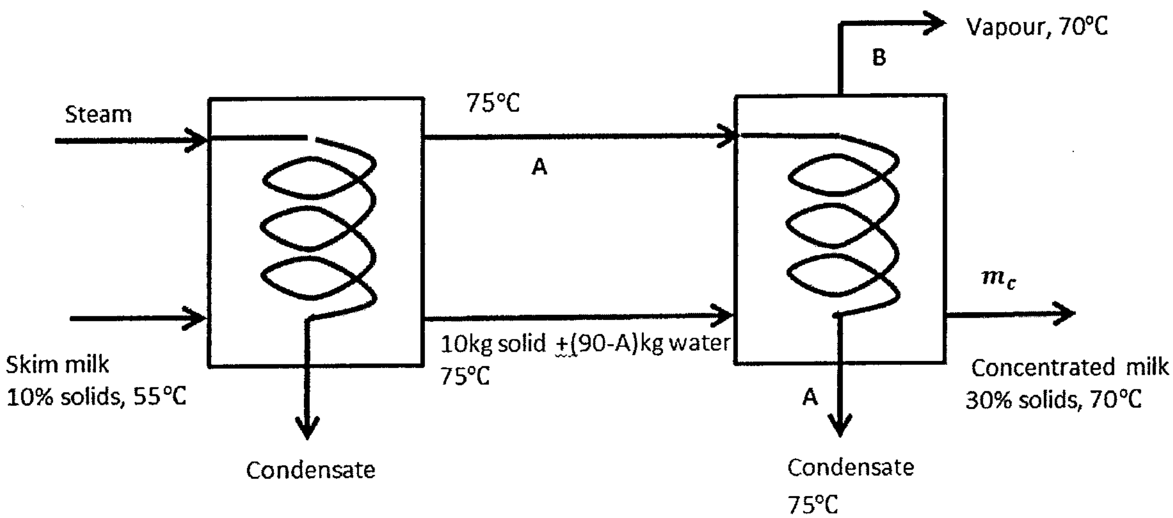

Figure for question #9

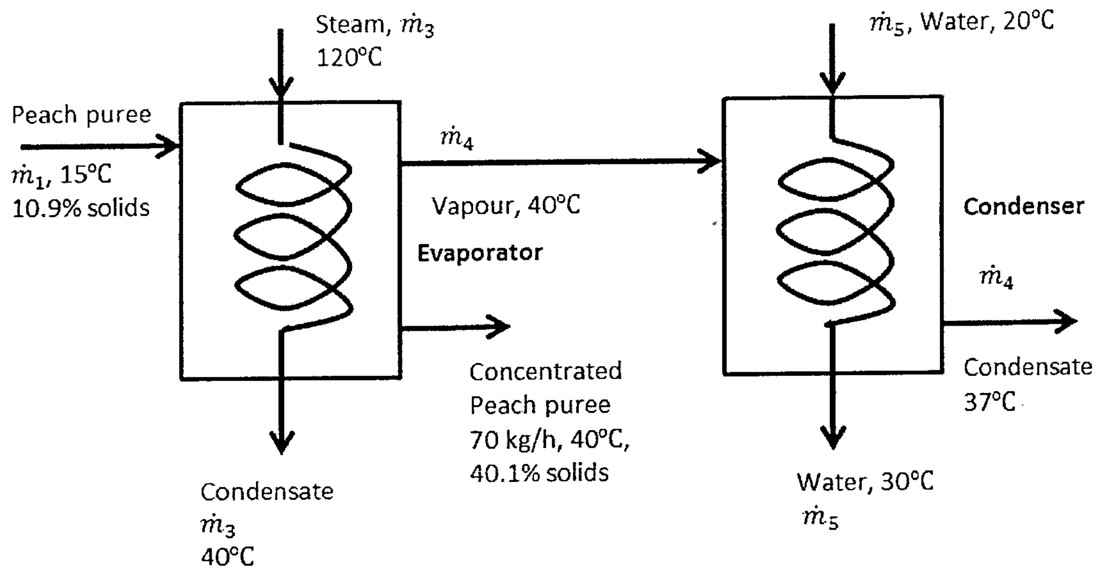

Figure for Question #10

Appendix B Steam Tables

Saturated Steam--Temperature Table

Temp., °C T	Press., kPa P	Specific Volume, m³/kg: Sat. Liquid v_f	Sat. Vapor v_g	Internal Energy, kJ/kg: Sat. Liquid u_f	Eavp. u_{fg}	Sat. Vapor u_g	Enthalpy, kJ/kg: Sat. Liquid h_f	Evap. h_{fg}	Sat. Vapor h_g	Entropy, kJ/kg: Sat. Liquid s_f	Evap. s_{fg}	Sat. Vapor s_g
0.01	0.61	0.001000	206.14	00.00	2375.3	2375.3	00.01	2501.3	2501.4	0.0000	9.1562	9.1562
5	0.87	0.001000	147.12	20.97	2361.3	2382.3	20.98	2489.6	2510.6	0.0761	8.9496	9.0257
10	1.23	0.001000	106.38	42.00	2347.2	2389.2	42.01	2477.7	2519.8	0.1510	8.7498	8.9008
15	1.70	0.001001	77.93	62.99	2333.1	2396.1	62.99	2465.9	2528.9	0.2245	8.5569	8.7814
20	2.34	0.001002	57.79	83.95	2319.0	2402.9	83.96	2454.1	2538.1	0.2966	8.3706	8.6672
25	3.17	0.001003	43.36	104.88	2304.9	2409.8	104.89	2442.3	2547.2	0.3674	8.1905	8.5580
30	4.25	0.001004	32.89	125.78	2290.8	2416.6	125.79	2430.5	2556.3	0.4369	8.0164	8.4533
35	5.63	0.001006	25.22	146.67	2276.7	2423.4	146.68	2418.6	2565.3	0.5053	7.8478	8.3531
40	7.38	0.001008	19.52	167.56	2262.6	2430.1	167.57	2406.7	2574.3	0.5725	7.6845	8.2570
45	9.59	0.001010	15.26	188.44	2248.4	2436.8	188.45	2394.8	2583.2	0.6387	7.5261	8.1648
50	12.35	0.001012	12.03	209.32	2234.2	2443.5	209.33	2382.7	2592.1	0.7038	7.3725	8.0763
55	15.76	0.001015	9.568	230.21	2219.9	2450.1	230.23	2370.7	2600.9	0.7679	7.2234	7.9913
60	19.94	0.001017	7.671	251.11	2205.5	2456.6	251.13	2358.5	2609.6	0.8312	7.0784	7.9096
65	25.03	0.001020	6.197	272.02	2191.1	2463.1	272.06	2346.2	2618.3	0.8935	6.9375	7.8310
70	31.19	0.001023	5.042	292.95	2176.6	2469.6	292.98	2333.8	2626.8	0.9549	6.8004	7.7553
75	38.58	0.001026	4.131	313.90	2162.0	2475.9	313.93	2321.4	2635.3	1.0155	6.6669	7.6824
80	47.39	0.001029	3.407	334.86	2147.4	2482.2	334.91	2308.8	2643.7	1.0753	6.5369	7.6122
85	57.83	0.001033	2.828	355.84	2132.6	2488.4	355.90	2296.0	2651.9	1.1343	6.4102	7.5445
90	70.14	0.001036	2.361	376.85	2117.7	2494.5	376.92	2283.2	2660.1	1.1925	6.2866	7.4791
95	84.55	0.001040	1.982	397.88	2102.7	2500.6	397.96	2270.2	2668.1	1.2500	6.1659	7.4159

Saturated Steam--Temperature Table (Continued)

Temp., °C T	Pres., MPa P	Specific Volume, m³/kg: Sat. Liquid v_f	Sat. Vapor v_g	Internal Energy, kJ/kg: Sat. Liquid u_f	Eavp. u_{fg}	Sat. Vapor u_g	Enthalpy, kJ/kg: Sat. Liquid h_f	Evap. h_{fg}	Sat. Vapor h_g	Entropy, kJ/kg: Sat. Liquid s_f	Evap. s_{fg}	Sat. Vapor s_g
100	0.10132	0.001044	1.6729	418.94	2087.6	2506.5	419.04	2257.0	2676.1	1.3069	6.0480	7.3549
105	0.12082	0.001048	1.4194	440.02	2072.3	2512.4	440.15	2243.7	2683.8	1.3630	5.9328	7.2958
110	0.14327	0.001052	1.2102	461.14	2057.0	2518.1	461.30	2230.2	2691.5	1.4185	5.8202	7.2387
115	0.16906	0.001056	1.0366	482.30	2041.4	2523.7	482.48	2216.5	2699.0	1.4734	5.7100	7.1833
120	0.19853	0.001060	0.8919	503.50	2025.8	2529.3	503.71	2202.6	2706.3	1.5276	5.6020	7.1296
125	0.2321	0.001065	0.7706	524.74	2009.9	2534.6	524.99	2188.5	2713.5	1.5813	5.4962	7.0775
130	0.2701	0.001070	0.6685	546.02	1993.9	2539.9	546.31	2174.2	2720.5	1.6344	5.3925	7.0269
135	0.3130	0.001075	0.5822	567.35	1977.7	2545.0	567.69	2159.6	2727.3	1.6870	5.2907	6.9777
140	0.3613	0.001080	0.5089	588.74	1961.3	2550.0	589.13	2144.7	2733.9	1.7391	5.1908	6.9299
145	0.4154	0.001085	0.4463	610.18	1944.7	2554.9	610.63	2129.6	2740.3	1.7907	5.0926	6.8833
150	0.4758	0.001091	0.3928	631.68	1927.9	2559.5	632.20	2114.3	2746.5	1.8418	4.9960	6.8379

MPa

Saturated Steam–Temperature Table (continued)

T	P	v_f	v_g	u_f	u_{fg}	u_g	h_f	h_{fg}	h_g	s_f	s_{fg}	s_g
155	0.5431	0.001096	0.3468	653.24	1910.8	2564.1	653.84	2098.6	2752.4	1.8925	4.9010	6.7935
160	0.6178	0.001102	0.3071	674.87	1893.5	2568.4	675.55	2082.6	2758.1	1.9427	4.8075	6.7502
165	0.7005	0.001108	0.2727	696.56	1876.0	2572.5	697.34	2066.2	2763.5	1.9925	4.7153	6.7078
170	0.7917	0.001114	0.2428	718.33	1858.1	2576.5	719.21	2049.5	2768.7	2.0419	4.6244	6.6663
175	0.8920	0.001121	0.2168	740.17	1840.0	2580.2	741.17	2032.4	2773.6	2.0909	4.5347	6.6256
180	1.0021	0.001127	0.19405	762.09	1821.6	2583.7	763.22	2015.0	2778.2	2.1396	4.4461	6.5857
185	1.1227	0.001134	0.17409	784.10	1802.9	2587.0	785.37	1997.1	2782.4	2.1879	4.3586	6.5465
190	1.2544	0.001141	0.15654	806.19	1783.8	2590.0	807.62	1978.8	2786.4	2.2359	4.2720	6.5079
195	1.3978	0.001149	0.14105	828.37	1764.4	2592.8	829.98	1960.0	2790.0	2.2835	4.1863	6.4698
200	1.5538	0.001157	0.12736	850.65	1744.7	2595.3	852.45	1940.7	2793.2	2.3309	4.1014	6.4323
205	1.7230	0.001164	0.11521	873.04	1724.5	2597.5	875.04	1921.0	2796.0	2.3780	4.0172	6.3952
210	1.9062	0.001173	0.10441	895.53	1703.9	2599.5	897.76	1900.7	2798.5	2.4248	3.9337	6.3585
215	2.104	0.001181	0.09479	918.14	1682.9	2601.1	920.62	1879.9	2800.5	2.4714	3.8507	6.3221
220	2.318	0.001190	0.08619	940.87	1661.5	2602.4	943.62	1858.5	2802.1	2.5178	3.7683	6.2861
225	2.548	0.001199	0.07849	963.73	1639.6	2603.3	966.78	1836.5	2803.3	2.5639	3.6863	6.2503
230	2.795	0.001209	0.07158	986.74	1617.2	2603.9	990.12	1813.8	2804.0	2.6099	3.6047	6.2146
235	3.06	0.001219	0.06537	1009.89	1594.2	2604.1	1013.62	1790.5	2804.2	2.6558	3.5233	6.1791
240	3.344	0.001229	0.05976	1033.21	1570.8	2604.0	1037.32	1766.5	2803.8	2.7015	3.4422	6.1437
245	3.648	0.001240	0.05471	1056.71	1546.7	2603.4	1061.23	1741.7	2803.0	2.7472	3.3612	6.1083
250	3.973	0.001251	0.05013	1080.39	1522.0	2602.4	1085.36	1716.2	2801.5	2.7927	3.2802	6.0730
255	4.319	0.001263	0.04598	1104.28	1496.7	2600.9	1109.73	1689.8	2799.5	2.8383	3.1992	6.0375
260	4.688	0.001276	0.04221	1128.39	1470.6	2599.0	1134.37	1662.5	2796.9	2.8838	3.1181	6.0019
265	5.081	0.001289	0.03877	1152.74	1443.9	2596.6	1159.28	1634.4	2793.6	2.9294	3.0368	5.9662
270	5.499	0.001302	0.03564	1177.36	1416.3	2593.7	1184.51	1605.2	2789.7	2.9751	2.9551	5.9301
275	5.942	0.001317	0.03279	1202.25	1387.9	2590.2	1210.07	1574.9	2785.0	3.0208	2.8730	5.8938
280	6.412	0.001332	0.03017	1227.46	1358.7	2586.1	1235.99	1543.6	2779.6	3.0668	2.7903	5.8571
285	6.909	0.001348	0.02777	1253.00	1328.4	2581.4	1262.31	1511.0	2773.3	3.1130	2.7070	5.8199
290	7.436	0.001366	0.02557	1278.92	1297.1	2576.0	1289.07	1477.1	2766.2	3.1594	2.6227	5.7821
295	7.993	0.001384	0.02354	1305.20	1264.7	2569.9	1316.30	1441.8	2758.1	3.2062	2.5375	5.7437
300	8.581	0.001404	0.02167	1332.00	1231.0	2563.0	1344.00	1404.9	2749.0	3.2534	2.4511	5.7045
305	9.202	0.001425	0.019948	1359.30	1195.9	2555.2	1372.40	1366.4	2738.7	3.3010	2.3633	5.6643
310	9.856	0.001447	0.018350	1387.10	1159.4	2546.4	1401.30	1326.0	2727.3	3.3493	2.2737	5.6230
315	10.547	0.001472	0.016867	1415.50	1121.1	2536.6	1431.00	1283.5	2714.5	3.3982	2.1821	5.5804
320	11.274	0.001499	0.015488	1444.60	1080.9	2525.5	1461.50	1238.6	2700.1	3.4480	2.0882	5.5362
330	12.845	0.001561	0.012996	1505.30	993.7	2498.9	1525.30	1140.6	2665.9	3.5507	1.8909	5.4417
340	14.586	0.001638	0.010797	1570.30	894.3	2464.6	1594.20	1027.9	2622.0	3.6594	1.6763	5.3357
350	16.513	0.001740	0.008813	1641.90	776.6	2418.4	1670.60	893.4	2563.9	3.7777	1.4335	5.2112
360	18.651	0.001893	0.006945	1725.20	626.3	2351.5	1760.50	720.5	2481.0	3.9147	1.1379	5.0526
370	21.03	0.002213	0.004925	1844.00	384.5	2228.5	1890.50	441.6	2332.1	4.1106	0.6865	4.7971
374.14	22.09	0.003155	0.003155	2029.60	0.0	2029.6	2099.30	0.0	2099.3	4.4298	0.0000	4.4298

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Superheated Vapor

T	P = 0.010 MPa (45.81)				P = 0.050 MPa (81.33)				P = 0.10 MPa (99.63)			
	v	u	h	s	v	u	h	s	v	u	h	s
Sat.	14.674	2437.9	2584.7	8.1502	3.240	2483.9	2645.9	7.5939	1.6940	2506.1	2675.5	7.3594
50	14.869	2443.9	2592.6	8.1749								
100	17.196	2515.5	2687.5	8.4479	3.418	2511.6	2682.5	7.6947	1.6958	2506.7	2676.2	7.3614
150	19.512	2587.9	2783.0	8.6882	3.889	2585.6	2780.1	7.9401	1.9364	2582.8	2776.4	7.6134
200	21.825	2661.3	2879.5	8.9038	4.356	2659.9	2877.7	8.1580	2.172	2658.1	2875.3	7.8343
250	24.136	2736.0	2977.3	9.1002	4.820	2735.0	2976.0	8.3556	2.406	2733.7	2974.3	8.0333
300	26.445	2812.1	3076.5	9.2813	5.284	2811.3	3075.5	8.5373	2.639	2810.4	3074.3	8.2158
400	31.063	2968.9	3279.6	9.6077	6.209	2968.5	3278.9	8.8642	3.103	2967.9	3278.2	8.5435
500	35.679	3132.3	3489.1	9.8978	7.134	3132.0	3488.7	9.1546	3.565	3131.6	3488.1	8.8342
600	40.295	3302.5	3705.4	10.1608	8.057	3302.2	3705.1	9.4178	4.028	3301.9	3704.7	9.0976
700	44.911	3479.6	3928.7	10.4028	8.981	3479.4	3928.5	9.6599	4.490	3479.2	3928.2	9.3398
800	49.526	3663.8	4159.0	10.6281	9.904	3663.6	4158.9	9.8852	4.952	3663.5	4158.6	9.5652
900	54.141	3855.0	4396.4	10.8396	10.828	3854.9	4396.3	10.0967	5.414	3854.8	4396.1	9.7767
1000	58.757	4053.0	4640.6	11.0393	11.751	4052.9	4640.5	10.2964	5.875	4052.8	4640.3	9.9764
1100	63.372	4257.5	4891.2	11.2287	12.674	4257.4	4891.1	10.4859	6.337	4257.3	4891.0	10.1659
1200	67.987	4467.9	5147.8	11.4091	13.597	4467.8	5147.7	10.6662	6.799	4467.7	5147.6	10.3463
1300	72.602	4683.7	5409.7	11.5811	14.521	4683.6	5409.6	10.8382	7.260	4683.5	5409.5	10.5183

T	P = 0.20 MPa (120.23)				P = 0.30 MPa (133.55)				P = 0.40 MPa (143.63)			
	v	u	h	s	v	u	h	s	v	u	h	s
Sat.	0.8857	2529.5	2706.7	7.1272	0.6058	2543.6	2725.3	6.9919	0.4625	2553.6	2738.6	6.8959
150	0.9596	2576.9	2768.8	7.2795	0.6339	2570.8	2761.0	7.0778	0.4708	2564.5	2752.8	6.9299
200	1.0803	2654.4	2870.5	7.5066	0.7163	2650.7	2865.6	7.3115	0.5342	2646.8	2860.5	7.1706
250	1.1988	2731.2	2971.0	7.7086	0.7964	2728.7	2967.6	7.5166	0.5951	2726.1	2964.2	7.3789
300	1.3162	2808.6	3071.8	7.8926	0.8753	2806.7	3069.3	7.7022	0.6548	2804.8	3066.8	7.5662
400	1.5493	2966.7	3276.6	8.2218	1.0315	2965.6	3275.0	8.0330	0.7726	2964.4	3273.4	7.8985
500	1.7814	3130.8	3487.1	8.5133	1.1867	3130.0	3486.0	8.3251	0.8893	3129.2	3484.9	8.1913
600	2.013	3301.4	3704.0	8.7770	1.3414	3300.8	3703.2	8.5892	1.0055	3300.2	3702.4	8.4558
700	2.244	3478.8	3927.6	9.0194	1.4957	3478.4	3927.1	8.8319	1.1215	3477.9	3926.5	8.6987
800	2.475	3663.1	4158.2	9.2449	1.6499	3662.9	4157.8	9.0576	1.2372	3662.4	4157.3	8.9244
900	2.706	3854.5	4395.8	9.4566	1.8041	3854.2	4395.4	9.2692	1.3529	3853.9	4395.1	9.1362
1000	2.937	4052.5	4640.0	9.6563	1.9581	4052.3	4639.7	9.4690	1.4685	4052.0	4639.4	9.3360
1100	3.168	4257.0	4890.7	9.8458	2.1121	4256.8	4890.4	9.6585	1.5840	4256.5	4890.2	9.5256
1200	3.399	4467.5	5147.3	10.0262	2.2661	4467.2	5147.1	9.8389	1.6996	4467.0	5146.8	9.7060
1300	3.630	4683.2	5409.3	10.1982	2.4201	4683.0	5409.0	10.0110	1.8151	4682.8	5408.8	9.8780

T	P = 0.50 MPa (151.86)				P = 0.60 MPa (158.85)				P = 0.80 MPa (170.43)			
	v	u	h	s	v	u	h	s	v	u	h	s
Sat.	0.3749	2561.2	2748.7	6.8213	0.3157	2567.4	2756.8	6.7600	0.2404	2576.8	2769.1	6.6628
200	0.4249	2642.9	2855.4	7.0592	0.3520	2638.9	2850.1	6.9665	0.2608	2630.6	2839.3	6.8158
250	0.4744	2723.5	2960.7	7.2709	0.3938	2720.9	2957.2	7.1816	0.2931	2715.5	2950.0	7.0384
300	0.5226	2802.9	3064.2	7.4599	0.4344	2801.0	3061.6	7.3724	0.3241	2797.2	3056.5	7.2328
350	0.5701	2882.6	3167.7	7.6329	0.4742	2881.2	3165.7	7.5464	0.3544	2878.2	3161.7	7.4089

Superheated Vapor (continued)

400	0.6173	2963.2	3271.9	7.7938	0.5137	2962.1	3270.3	7.7079	0.3843	2959.7	3267.1	7.5716
500	0.7109	3128.4	3483.9	8.0873	0.5920	3127.6	3482.8	8.0021	0.4433	3126.0	3480.6	7.8673
600	0.8041	3299.6	3701.7	7.3522	0.6697	3299.1	3700.9	8.2674	0.5018	3297.9	3699.4	8.1333
700	0.8969	3477.5	3925.9	8.5952	0.7472	3477.0	3925.3	8.5107	0.5601	3476.2	3942.2	8.3770
800	0.9896	3662.1	4156.9	8.8211	0.8245	3661.8	4156.5	8.7367	0.6181	3661.1	4155.6	8.6033
900	1.0822	3853.6	4394.7	9.0329	0.9017	3853.4	4394.4	8.9486	0.6761	3852.8	4393.7	8.8153
1000	1.1747	4051.8	4639.1	9.2328	0.9788	4051.5	4638.8	9.1485	0.7340	4051.0	4638.2	9.0153
1100	1.2672	4256.3	4889.9	9.4224	1.0559	4256.1	4889.6	9.3381	0.7919	4255.6	4889.1	9.2050
1200	1.3596	4466.8	5146.6	9.6029	1.1330	4466.5	5146.3	9.5185	0.8497	4466.1	5145.9	9.3855
1300	1.4521	4682.5	5408.6	9.7749	1.2101	4682.3	5408.3	9.6906	0.9076	4681.8	5407.9	9.5575

	P = 1.00 MPa (179.91)				P = 1.20 MPa (187.99)				P = 1.40 MPa (195.07)			
T	v	u	h	s	v	u	h	s	v	u	h	s
Sat.	0.19444	2583.6	2778.1	6.5865	0.16333	2588.8	2784.8	6.5233	0.14084	2592.8	2790.0	6.4693
200	0.2060	2621.9	2827.9	6.6940	0.16930	2612.8	2815.9	6.5898	0.14302	2603.1	2803.3	6.4975
250	0.2327	2709.9	2942.6	6.9247	0.19234	2704.2	2935.0	6.8294	0.16350	2698.3	2927.2	6.7467
300	0.2579	2793.2	3151.2	7.1229	0.2138	2789.2	3045.8	7.0317	0.18228	2785.2	3040.4	6.9534
350	0.2825	2875.2	3157.7	7.3011	0.2345	2872.2	3153.6	7.2121	0.2003	2869.2	3149.5	7.1360
400	0.3066	2957.3	3263.9	7.4651	0.2548	2954.9	3260.7	7.3774	0.2178	2952.5	3257.5	7.3026
500	0.3541	3124.4	3478.5	7.7622	0.2946	3122.8	3476.3	7.6759	0.2521	3121.1	3474.1	7.6027
600	0.4011	3296.8	3697.9	8.0290	0.3339	3295.6	3696.3	7.9435	0.2860	3294.4	3694.8	7.8710
700	0.4478	3475.3	3923.1	8.2731	0.3729	3474.4	3922.0	8.1881	0.3195	3473.6	3920.8	8.1160
800	0.4943	3660.4	4154.7	8.4996	0.4118	3659.7	4153.8	8.4148	0.3528	3659.0	4153.0	8.3431
900	0.5407	3852.2	4392.9	8.7118	0.4505	3851.6	4392.2	8.6272	0.3861	3851.1	4391.5	8.5556
1000	0.5871	4050.5	4637.6	8.9119	0.4892	4050.0	4637.0	8.8274	0.4192	4049.5	4636.4	8.7559
1100	0.6335	4255.1	4888.6	9.1017	0.5278	4254.6	4888.0	9.0172	0.4524	4254.1	4887.5	8.9457
1200	0.6798	4465.6	5145.4	9.2822	0.5665	4465.1	5144.9	9.1977	0.4855	4464.7	5144.4	9.1262
1300	0.7261	4681.3	5407.4	9.4543	0.6051	4680.9	5407.0	9.3698	0.5186	4680.4	5406.5	9.2984

	P = 1.60 MPa (201.41)				P = 1.80 MPa (207.15)				P = 2.00 MPa (212.42)			
T	v	u	h	s	v	u	h	s	v	u	h	s
Sat.	0.12380	2596.0	2794.0	6.4218	0.11042	2598.4	2797.1	6.3794	0.09963	2600.3	2799.5	6.3409
225	0.13287	2644.7	2857.3	6.5518	0.11673	2636.6	2846.7	6.4808	0.10377	2628.3	2835.8	6.4147
250	0.14184	2692.3	2919.2	6.6732	0.12497	2686.0	2911.0	6.6066	0.11144	2679.6	2902.5	6.5453
300	0.15862	2781.1	3034.8	6.8844	0.14021	2776.9	3029.2	6.8226	0.12547	2772.6	3023.5	6.7664
350	0.17456	2866.1	3145.4	7.0694	0.15457	2863.0	3141.2	7.0100	0.13857	2859.8	3137.0	6.9563
400	0.19005	2950.1	3254.2	7.2374	0.16847	2947.7	3250.9	7.1794	0.15120	2945.2	3247.6	7.1271
500	0.2203	3119.5	3472.0	7.5390	0.19550	3117.9	3469.8	7.4825	0.17568	3116.2	3467.6	7.4317
600	0.2500	3293.3	3693.2	7.8080	0.2220	3292.1	3691.7	7.7523	0.19960	3290.9	3690.1	7.7024
700	0.2794	3472.7	3919.7	8.0535	0.2482	3471.8	3918.5	7.9983	0.2232	3470.9	3917.4	7.9487
800	0.3086	3658.3	4152.1	8.2808	0.2742	3657.6	4151.2	8.2258	0.2467	3657.0	4150.3	8.1765
900	0.3377	3850.5	4390.8	8.4935	0.3001	3849.9	4390.1	8.4386	0.2700	3849.3	4389.4	8.3895
1000	0.3668	4049.0	4635.8	8.6938	0.3260	4048.5	4635.2	8.6391	0.2933	4048.0	4634.6	8.5901
1100	0.3958	4253.7	4887.0	8.8837	0.3518	4253.2	4886.4	8.8290	0.3166	4252.7	4885.9	8.7800
1200	0.4248	4464.2	5143.9	9.0643	0.3776	4463.7	5143.4	9.0096	0.3398	4463.3	5142.9	8.9607
1300	0.4538	4679.9	5406.0	9.2364	0.4034	4679.5	5405.6	9.1818	0.3631	4679.0	5405.1	9.1329

Superheated Vapor (continued)

T	P = 2.50 MPa (223.99) v	u	h	s	P = 3.00 MPa (233.90) v	u	h	s	P = 3.50 MPa (242.60) v	u	h	s
Sat.	0.07998	2603.1	2803.1	6.2575	0.06668	2604.1	2804.2	6.1869	0.05707	2603.7	2803.4	6.1253
225	0.08027	2605.6	2806.3	6.2639								
250	0.08700	2662.6	2880.1	6.4085	0.07058	2644.0	2855.8	6.2872	0.05872	2623.7	2829.2	6.1749
300	0.09890	2761.6	3008.8	6.6438	0.08114	2750.1	2993.5	6.5390	0.06842	2738.0	2977.5	6.4461
350	0.10976	2851.9	3126.3	6.8403	0.09053	2843.7	3115.3	6.7428	0.07678	2835.3	3104.0	6.6579
400	0.12010	2939.1	3239.3	7.0148	0.09936	2932.8	3230.9	6.9212	0.08453	2926.4	3222.3	6.8405
450	0.13014	3025.5	3350.8	7.1746	0.10787	3020.4	3344.0	7.0834	0.09196	3015.3	3337.2	7.0052
500	0.13998	3112.1	3462.1	7.3234	0.11619	3108.0	3456.5	7.2338	0.09918	3103.0	3450.9	7.1572
600	0.15930	3288.0	3686.3	7.5960	0.13243	3285.0	3682.3	7.5085	0.11324	3282.1	3678.4	7.4339
700	0.17832	3468.7	3914.5	7.8435	0.14838	3466.5	3911.7	7.7571	0.12699	3464.3	3908.8	7.6837
800	0.19716	3655.3	4148.2	8.0720	0.16414	3653.5	4145.9	7.9862	0.14056	3651.8	4143.7	7.9134
900	0.2159	3847.9	4387.6	8.2853	0.17980	3846.5	4385.9	8.1999	0.15402	3845.0	4384.1	8.1276
1000	0.2346	4046.7	4633.1	8.4861	0.19541	4045.4	4631.6	8.4009	0.16743	4044.1	4630.1	8.3288
1100	0.2532	4251.5	4884.6	8.6762	0.21098	4250.3	4883.3	8.5912	0.18080	4249.2	4881.9	8.5192
1200	0.2718	4462.1	5141.7	8.8569	0.22652	4460.9	5140.5	8.7720	0.19415	4459.8	5139.3	8.7000
1300	0.2905	4677.8	5404.0	9.0291	0.24206	4676.6	5402.8	8.9442	0.20749	4675.5	5401.7	8.8723

Compressed Liquid

T	P = 5.00 MPa (263.99) v	u	h	s	P = 10.00 MPa (311.06) v	u	h	s	P = 15.00 MPa (342.24) v	u	h	s
Sat.	0.0012859	1147.8	1154.2	2.9202	0.0014524	1393.0	1407.6	3.3596	0.0016581	1585.6	1610.5	3.6848
0	0.0009977	0.04	5.04	0.0001	0.0009952	0.09	10.04	0.0002	0.0009928	0.15	15.05	0.0004
20	0.0009995	83.65	88.65	0.2956	0.0009972	83.36	93.33	0.2945	0.0009950	83.06	97.99	0.2934
40	0.0010056	166.95	171.97	0.5705	0.0010034	166.35	176.38	0.5686	0.0010013	165.76	180.78	0.5666
60	0.0010149	250.23	255.30	0.8285	0.0010127	249.36	259.49	0.8258	0.0010105	248.51	263.67	0.8232
80	0.0010268	333.72	338.85	1.0720	0.0010245	332.59	342.83	1.0688	0.0010222	331.48	346.81	1.0656
100	0.0010410	417.52	422.72	1.3030	0.0010385	416.12	426.50	1.2992	0.0010361	414.74	430.28	1.2955
120	0.0010576	501.80	507.09	1.5233	0.0010549	500.08	510.64	1.5189	0.0010522	498.40	514.19	1.5145
140	0.0010768	586.76	592.15	1.7343	0.0010737	584.68	595.42	1.7292	0.0010707	582.66	598.72	1.7242
160	0.0010988	672.62	678.12	1.9375	0.0010953	670.13	681.08	1.9317	0.0010918	667.71	684.09	1.9260
180	0.0011240	759.63	765.25	2.1341	0.0011199	756.65	767.84	2.1275	0.0011159	753.76	770.50	2.1210
200	0.0011530	848.1	853.9	2.3255	0.0011480	844.5	856.0	2.3178	0.0011433	841.0	858.2	1.3104
220	0.0011866	938.4	944.4	2.5128	0.0011805	934.1	945.9	2.5039	0.0011748	929.9	947.5	2.4953
240	0.0012264	1031.4	1037.5	2.6979	0.0012187	1026.0	1038.1	2.6872	0.0012114	1020.8	1039.0	2.6771
260	0.0012749	1127.9	1134.3	2.8830	0.0012645	1121.1	1133.7	2.8699	0.0012550	1114.6	1133.4	2.8576
280					0.0013216	1220.9	1234.1	3.0548	0.0013084	1212.5	1232.1	3.0393
300					0.0013972	1328.4	1342.3	3.2469	0.0013770	1316.6	1337.3	3.2260
320									0.0014724	1431.1	1453.2	3.4247
340									0.0016311	1567.5	1591.9	3.6546

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04-Agric-B8 Food Process Engineering (part 1)

Marking Scheme

1. 15 marks
2. (a) 5 marks, (b) 5 marks, (c) 5 marks
3. 15 marks
4. 15 marks
5. 15 marks
6. 15 marks
7. 15 marks
8. 20 marks
9. 20 marks
10. 20 marks