

Table of Contents

		PAGE NO
	Executive Summary	i
	Acknowledgements	vii
	Table of Contents	viii
	List of Figures	xii
	List of Tables	xv
	Nomenclature	xvi
1	INTRODUCTION	1-1
1.1	OBJECTIVES	1-2
1.1.1	Improve the Design of the Tubular Filter Press	1-2
1.1.2	Develop a Commercially Operational Unit for Waterworks Sludges	1-3
1.1.3	Monitor the Capital and Operating Costs	1-3
1.1.4	Assess the Performance of the New Design	1-3
1.1.5	Assess the Use of the New Design for Potable Water Production	1-3
1.1.6	Develop Techniques for Determining Design Parameters for the Tubular Filter Press	1-3
1.2	LITERATURE REVIEW	1-4
1.3	SUMMARY OF PROGRESS IN MEETING THE OBJECTIVES	1-6
2	DESIGN OF FULL-SCALE EXPRESS UNIT	2-1
2.1	PROBLEMS EXPERIENCED WITH THE PREVIOUS DESIGNS	2-1
2.2	DESIGN SUB-COMMITTEE	2-2
2.3	DESIGN SPECIFICATIONS	2-3
2.3.1	Modular Design	2-3
2.3.2	Double Curtain per Module	2-4
2.3.3	Inlet Feed Manifold Design	2-4
2.3.4	Size of Tubes	2-5
2.3.5	Cleaning Mechanism Design	2-6
2.3.6	Lime Addition	2-6
2.3.7	Future Expansion	2-7
2.4	CONSTRUCTION OF THE DEMONSTRATION UNIT	2-7
2.5	MODIFICATIONS AND IMPROVEMENTS TO THE DESIGN	2-8

3	CONSTANT PRESSURE COMPRESSIBLE CAKE FILTRATION MODEL	3-1
3.1	PERMEABILITY AND POROSITY CORRELATIONS	3-1
3.2	A NEW GENERALISED AREA CONTACT MODEL	3-3
3.2.1	Area Contact Function	3-4
3.2.2	Relationship Between Liquid and Solids Compressive Pressure	3-8
3.2.2.1	Planar Filtration	3-8
3.2.2.2	Internal Cylindrical Filtration	3-10
3.2.3	Solids Compressive Pressure and Liquid Pressure Gradients	3-12
3.2.3.1	Planar Filtration	3-13
3.2.3.2	Internal Cylindrical Filtration	3-14
3.2.4	Point-Area Compressive Pressure	3-17
3.2.4.1	Planar Filtration	3-18
3.2.4.2	Internal Cylindrical Filtration	3-19
3.2.4.3	Multiple Porosity Correlation Data	3-19
3.3	SOLUTION PROCEDURE	3-20
3.3.1	Predictive Model	3-20
3.3.1.1	Constant Pressure	3-21
3.3.1.2	Pseudo Variable Pressure	3-23
3.3.2	Regressive Model	3-24
3.4	COEFFICIENT OF EARTH PRESSURE AT REST	3-25
3.5	COMPRESSION - PERMEABILITY CELL TESTS	3-26
3.5.1	Determining Correlation Data	3-28
3.5.2	Approximate Correction for Side Wall Friction	3-28
3.6	SETTLING TESTS	3-30
3.6.1	Porosity Correlation Data	3-30
3.6.2	Permeability Correlation Data	3-32
3.7	CAKE EQUILIBRIUM EFFECTS	3-35
3.8	TUBULAR FILTER PRESS	3-36
3.8.1	Dynamic Dead-End Internal Cylindrical Filtration	3-36
3.8.1.1	Dead-End Shear Model	3-37
3.8.1.2	Axial Pressure Profiles	3-37
3.8.1.3	Axial Feed Solids Concentration Profiles	3-38
3.8.2	Cake Recovery	3-38
3.8.2.1	Recovery Due to Action of Rollers or Hydraulic Conveyance	3-38
3.8.2.2	Recovery Function	3-39

4	EXPERIMENTAL PROCEDURES AND TECHNIQUES	4-1
4.1	SLUDGE	4-1
4.1.1	Determination of Solids Density	4-1
4.1.1.1	Evaporation Method	4-1
4.1.1.2	Specific Gravity Bottle Method	4-2
4.2	COMPRESSION - PERMEABILITY CELL TESTS	4-2
4.2.1	Assembly of the Compression-Permeability Cell	4-5
4.2.2	Experimental Procedure	4-7
4.3	SETTLING TESTS	4-7
4.3.1	Determination of Porosity at Low Solids Compressive Pressures	4-7
4.3.2	Determination of Permeability at Low Solids Compressive Pressures	4-8
4.4	SINGLE VERTICAL TUBE PILOT PLANT TESTS	4-8
4.4.1	Experimental System	4-8
4.4.2	Assembly of the Pilot Plant on the Trailer	4-10
4.4.3	Sludge Preparation	4-10
4.4.4	Filtration Cycle	4-11
4.4.5	Flush Cycle	4-11
4.4.6	Mass Balance and Calculation of Cake Recovery	4-12
4.5	FULL-SCALE VERTICAL TUBULAR FILTER PRESS	4-12
4.5.1	Control of the Vertical Tubular Filter Press	4-12
4.5.2	Filtration Cycle	4-12
4.5.3	Flush Cycle	4-13
4.5.4	Roller Operation and Tube Cleaning	4-14
4.5.4	Cake Collection and Mass Balance	4-14
5	RESULTS AND DISCUSSION	5-1
5.1	NATURE OF THE SLUDGE AND WIGGINS RAW WATER QUALITY	5-1
5.2	DENSITY MEASUREMENT	5-3
5.3	COMPRESSION PERMEABILITY CELL TESTS	5-4
5.3.1	Compression-Permeability Cell Tests - Cell A	5-4
5.3.1.1	Experimental Technique	5-4
5.3.1.2	Filter Medium Resistance	5-5
5.3.1.3	The Effect of Lime Addition on Filter Cake Characteristics	5-6
5.3.2	Compression-Permeability Cell Tests - Cell B	5-9
5.3.2.1	Standard Analysis	5-9
5.3.2.2	Approximate Correction for Side Wall Friction	5-11
5.3.3	Common Experimental Problems	5-14
5.4	SETTLING TESTS	5-15
5.4.1	Determination of Porosity at Low Solids Compressive Pressures	5-15
5.4.2	Determination of Permeability at Low Solids Compressive Pressures	5-16

5.5	PERMEABILITY AND POROSITY CORRELATIONS	5-17
5.5.1	Wall Friction in Compression-Permeability Cell Tests Neglected	5-18
5.5.2	Wall Friction in Compression-Permeability Cell Tests Accounted	5-18
5.6	SINGLE TUBE PILOT PLANT TESTS	5-19
5.6.1	Feasibility of Vertical Tubular Filtration	5-19
5.6.2	Process Investigation Using the Single Tube Pilot Plant	5-19
5.6.2.1	Effect of Feed Solids Concentration	5-20
5.6.2.2	Effect of Filtration Pressure	5-21
5.6.2.3	Effect of Final Permeate Flowrate Before Cleaning	5-21
5.6.2.4	Mass of Solids Removed per Unit Filtration Area	5-22
5.7	OPERATION OF THE VERTICAL TUBULAR FILTER PRESS	5-23
5.7.1	Batch Operation to Decide on Operating Parameters	5-23
5.7.1.1	The Effect of Filtration Pressure	5-23
5.7.1.2	The Effect of Feed Solids Concentration	5-24
5.7.1.3	The Effect of Final Permeate Flux Before Cleaning	5-26
5.7.1.4	Improving the Dewatering Rate of the Filter	5-27
5.7.1.5	The Efficiency of the Cleaning Sequence	5-27
5.7.1.6	Cake Solids Concentration	5-28
5.7.1.7	Power Consumption of the Vertical Tubular Filter Press	5-29
5.7.2	Continuous Operation of the Vertical Tubular Filter Press	5-30
5.7.2.1	The Effects of Feed Solids Concentration on the Length of the Filtration Cycle	5-31
5.8	QUALITY OF THE FILTRATE	5-33
5.8.1	Production of Potable Water	5-34
5.9	COMPUTER SOFTWARE DEVELOPMENT	5-35
5.10	TECHNOLOGY TRANSFER	5-36
5.10.1	Sizing of a Vertical Tubular Filter Press for Umgeni Water	5-36
5.10.1.1	Single Tube Pilot Plant Trials	5-37
5.10.1.2	Sizing and Recommendations	5-39
6	CONCLUSIONS	6-1
7	RECOMMENDATIONS	7-1
	REFERENCES	R-1