

**DEVELOPMENT OF A CLEANING AND GRADING
MACHINE TO IMPROVE THE QUALITY OF MILLED
RICE (*Oryza sativa* L.)**

BY

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CERTIFICATION

I certify that this work was carried out by Mr. A. A. OKUNOLA in the Department of Agricultural and Environmental Engineering, University of Ibadan.

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ABSTRACT

Locally processed rice (*Oryza sativa* L.) is characterized with high percentage of broken grains and impurities which impair the quality and reduces the market value. Reducing the proportion of broken rice and impurities after milling remains a challenge. There is therefore a need to develop a machine which cleans and grades the rice kernels based on quality. The objective of this work was to develop a cleaner - grader to improve the quality of milled rice.

The physical and aerodynamic properties of six rice cultivars (ITA 150, FARO 44, FARO 52, NERICA 1, IGBEMO 1 and IGBEMO II) were determined using ASAE Standards. Based on these properties, a three sieve oscillating cleaner - grader machine was developed. Samples from the six rice varieties were milled using No 1 rice huller and milling characteristics were evaluated according to NIS 230 Standards. The machine was tested to determine cleaning performance index and grading efficiency of the rice cultivars. The tilt angle of the top and bottom sieves were fixed at 2 and 15°, the intermediate sieve was set at 2, 4 and 6° and the blower was inclined at 0 and 5°. Data were analysed using ANOVA and descriptive statistics.

The moisture content of the rice cultivars during milling varied from 10.7 to 12.5% and 11.0 to 13.6% in the raw and parboiled paddy respectively. The mean angle of repose was $29.3^\circ \pm 0.4$ and the mean coefficient of friction was 0.3 ± 0.01 . The spherical mean ranged from 2.9 to 3.5 mm and was significantly different ($p < 0.05$) in Igbemo II cultivar when compared with other cultivars. The sphericity was within 0.41 to 0.5; the bulk density ranged from 1.34 to 1.38 gcm^{-3} , while the terminal velocity varied from 4.8 to 6.4

ms^{-1} . The machine was developed to operate at a fan speed of 240 rpm, air velocity of 4.8 ms^{-1} with aperture diameter of 3, 5.5 and 7 mm for bottom, intermediate and top sieves respectively. The head rice yield ranged from 22.3 to 34.1% and 44.8 to 55% for the raw and parboiled milled respectively. The percentages of broken grains obtained during milling of raw and parboiled rice were further reduced by 41.5 and 64.8% respectively with the use of the machine. The cleaning performance index of the machine ranged from 0.6 to 0.9; the highest occurred at a tilt angle of 4° and blower inclination of 5° for raw ITA 150. The grading efficiency ranged from 61.4 - 84.8% and 69.0 to 94.5% for raw and parboiled milled rice respectively. The highest values of 84.8% and 94.5% were obtained in raw FARO 44 at a tilt angle of 2° and in parboiled ITA 150 at a tilt angle of 6° respectively with blower inclination of 5° .

The use of the cleaning and grading machine after milling has substantially reduced broken kernels of locally processed rice in the raw and parboiled milled rice thereby enhancing the quality.

Key words: Rice, Terminal velocity, Cleaning and grading machine, Cleaning performance, Grading efficiency.

487 words

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DEDICATION

This work is dedicated to Jesus Christ, my lord who is the brightness of God's glory and the express image of his person.

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TABLE OF CONTENTS

Title page	i
Certification	ii
Acknowledgement	iii
Dedication	iv
Table of contents	iv
List of Tables	xii
List of Plates	xvi
List of figures	xviii
List of abbreviation and symbols	xix
CHAPTER ONE: INTRODUCTION	1
1.1 Background	1
1.2 Objectives	2
1.3 Justification for the study	2
1.4 Scope of work	3
CHAPTER TWO: LITERATURE REVIEW	4
2.1 Rice production	4
2.2 Paddy grains structure and composition	4
2.3 Grain losses	7
2.4 Paddy harvesting	8
2.5 Paddy drying	9
2.6 Paddy parboiling	10

2.6.1	Soaking of paddy	11
2.6.2	Steaming of paddy	11
2.7	Drying	12
2.7.1	Methods of drying	12
2.8	Rice milling	14
2.9	Rice mills	16
2.10	Quality aspect of milled rice	17
2.10.1	Quality deterioration	18
2.10.2	Grain quality indicators	20
2.11	Grain separators	21
2.11.1	Sorting cylinders	21
2.11.2	Gravity separations	22
2.11.3	Air Screen cleaners	23
2.12	Physical and aerodynamic properties of rice	24
2.12.1	Axial Dimension	24
2.12.2	Bulk density	25
2.12.3	Terminal velocity	25
2.12.4	Co-efficient of friction	27
2.12.5	Angle of repose	27
CHAPTER THREE:	METHODOLOGY	28
3.1	Parboiling	28
3.2	Milling	28
3.2.1	Milling procedures	28

3.3	Appraisal of rice quality	29
3.3.1	Moisture content	29
3.3.2	Bulk density and 1000 grain weight	29
3.3.3	Terminal velocity	30
3.3.4	Co efficient of friction	30
3.3.5	Angle of repose	30
3.3.6	Milling and head rice yield	30
3.4	Design conception of rice cleaner and grader	31
3.4.1	Geometric characteristics	32
3.4.2	Screen characteristics	33
3.5	Design for cleaner / grader	34
3.5.1	Screen mechanism	35
3.5.2	Grain movement	37
3.5.3	Design of blower	39
3.5.4	Design of belt	41
3.5.4.1	Tension in belt	42
3.5.5	Angle of wrap on the pulleys	42
3.5.6	Shaft design	43
3.5.7	Critical speed	53
3.5.8	Design of connecting rod	54
3.5.9	Machine features	54
3.5.9.1	The frame	55
3.5.9.2	The hopper	55

3.5.9.3 The blower unit	55
3.5.9.4 The sieve assembly	60
3.5.9.5 Power transmission	60
3.5.9.6 Machine specification and production cost	64
3.6 Grain cleaning and grading	64
3.7 Statistical analyses	67
CHAPTER FOUR: RESULTS AND DISCUSSION	69
4.1 Grain size characteristics	69
4.2 Bulk density and thousand grain weight	77
4.3 Terminal velocity	77
4.4 Co-efficient of friction	80
4.5 Angle of repose	80
4.6 Moisture content of milled rice	83
4.7 Quality of milled rice	83
4.8 Cleaning and grading performance	92
4.9 Machine efficiency	112
CHAPTER FIVE: CONCLUSIONS AND RECOMMENDATIONS	119
5.1 Conclusions	119
5.2 Recommendations	120
REFERENCES	121
APPENDICES	
1. Axial dimensions of brown and milled rice	130
2. Classification of spherical mean of parboiled rice	154
3. Axial dimension of stones	156

4. Terminal velocity of Rice	159
5. Mean values of HRY, MRY and broken in milled rice	165
6. Computer print out: Grain size characteristics in milled rice	172
7. Computer print out: Grain quality characteristics	211
8. Computer print out for correlations on quality characteristics	224
9. Computer print out for machine parameters performance	227
10. Summary of weights collected during cleaning and grading	231
11. Machine products and rejects	236
12. Machine safety checks and precautions	250

UNIVERSITY OF IBADAN

LIST OF TABLES

Table	Page
3.1 Cleaning and grading machine specification	65
3.2 Bill of materials for the construction of the machine	66
4.1 Size characteristics of raw brown and raw milled rice	73
4.2 Size characteristics of parboiled brown and parboiled milled rice	74
4.3 Size distribution characteristics of brown rice	75
4.4 Shape distribution characteristics of brown rice	76
4.5 Bulk density and thousand grain weight of milled rice	78
4.6 Terminal velocity of parboiled milled rice	79
4.7 Mean values of co-efficient of static friction of parboiled milled rice	81
4.8 Mean values of angle of repose of parboiled milled rice	82
4.9 Moisture content of raw and parboiled paddy at the point of milling	84
4.10 The effects of variety on quality of milled rice at specified moisture content	85
4.11 Quality characteristics of milled rice	87
4.12 Pearson correlation co-efficient for quality characteristics of raw milled rice	88
4.13 Pearson correlation co-efficient for quality characteristics of parboiled milled rice	89
4.14 Spearman correlation co-efficient for quality characteristics of raw milled rice	90
4.15 Spearman correlation co-efficient for quality characteristics of parboiled milled rice	91
4.16 Separation and grading efficiencies of parboiled and raw ITA 150	96
4.17 Separation and grading efficiencies of parboiled and raw FARO 44	97
4.18 Separation and grading efficiencies of parboiled and raw FARO 52	98
4.19 Separation and grading efficiencies of parboiled and raw NERICA I	99
4.20 Separation and grading efficiencies of parboiled and raw IGBEMO I	100
4.21 Separation and grading efficiencies of parboiled and raw IGBEMO II	101
4.22 Performance evaluation of grading of parboiled and raw ITA 150	102
4.23 Performance evaluation of grading of parboiled and raw FARO 44	103

4.24 Performance evaluation of grading of parboiled and raw FARO 52	104
4.25 Performance evaluation of grading of parboiled and raw NERICA I	105
4.26 Performance evaluation of grading of parboiled and raw IGBEMO I	106
4.27 Performance evaluation of grading of parboiled and raw IGBEMO II	107
4.28 Pearson correlation of machine parameter performance of parboiled rice @ 0° blower inclination	108
4.29 Pearson correlation of machine parameter performance of parboiled rice @ 5° blower inclinations	109
4.30 Pearson correlation of machine parameter performance of raw rice @ 0° blower inclinations	110
4.31 Pearson correlation of machine parameter performance of raw rice @ 5° blower inclinations	111
A1.1 Axial dimension, spherical mean and sphericity of raw ITA 150 brown rice	130
A1.2 Axial dimension, spherical mean and sphericity of raw FARO 44 brown rice	131
A1.3 Axial dimension, spherical mean and sphericity of raw FARO 52 brown rice	132
A1.4 Axial dimension, spherical mean and sphericity of raw NERICA I brown rice	133
A1.5 Axial dimension, spherical mean and sphericity of raw IGBEMO I brown rice	134
A1.6 Axial dimension, spherical mean and sphericity of raw IGBEMO II brown rice	135
A1.7 Axial dimension, spherical mean and sphericity of raw ITA 150 milled rice	136
A1.8 Axial dimension, spherical mean and sphericity of raw FARO 44 milled rice	137
A1.9 Axial dimension, spherical mean and sphericity of raw FARO 52 milled rice	138
A1.10 Axial dimension, spherical mean and sphericity of raw NERICA I milled rice	139
A1.11 Axial dimension, spherical mean and sphericity of raw IGBEMO I milled rice	140
A1.12 Axial dimension, spherical mean and sphericity of raw IGBEMO II milled rice	141
A1.13 Axial dimension, spherical mean and sphericity of Parboiled ITA 150 brown rice	142
A1.14 Axial dimension, spherical mean and sphericity of Parboiled FARO 44 brown rice	143
A1.15 Axial dimension, spherical mean and sphericity of parboiled FARO 52 brown rice	144
A1.16 Axial dimension, spherical mean and sphericity of	

parboiled NERICA brown rice	145
A1.17 Axial dimension, spherical mean and sphericity of parboiled IGEMO I brown rice	146
A1.18 Axial dimension, spherical mean and sphericity of parboiled IGEMO II brown rice	147
A1.19 Axial dimension, spherical mean and sphericity of parboiled ITA 150 milled rice	148
A1.20 Axial dimension, spherical mean and sphericity of parboiled FARO 44 milled rice	149
A1.21 Axial dimension, spherical mean and sphericity of parboiled FARO 52 milled rice	150
A1.22 Axial dimension, spherical mean and sphericity of parboiled NERICA 1 milled rice	151
A1.23 Axial dimension, spherical mean and sphericity of parboiled IGEMO I milled rice	152
A1.24 Axial dimension, spherical mean and sphericity of parboiled IGEMO II milled rice	153
A.2.1 Spherical mean of parboiled milled rice	154
A2.2 Classification of all varieties of parboiled milled rice	155
A3.1 Axial dimension, spherical mean and sphericity of small stone	156
A3.2 Axial dimension, spherical mean and sphericity of medium stone	157
A3.3 Bulk density of small stone	158
A4.1 Terminal velocity of parboiled ITA 150 milled rice	159
A4.2 Terminal velocity of parboiled FARO 44 milled rice	160
A4.3 Terminal velocity of parboiled FARO 52 milled rice	161
A4.4 Terminal velocity of parboiled NERICA 1 milled rice	162
A4.5 Terminal velocity of parboiled IGBEMO 1 milled rice	163
A4.6 Terminal velocity of parboiled IGBEMO 11 milled rice	164
A5.1 Moisture content of paddy at the point milling	165
A5.2 Mean value of HRY, MRY and broken ITA 150 at specified	

moisture content	166
A5.3 Mean value of HRY, MRY and brokens FARO 44 at specified moisture content	167
A5.4 Mean value of HRY, MRY and brokens FARO 52 at specified moisture content	168
A5.5 Mean value of HRY, MRY and brokens NERICA 1 at specified moisture content	169
A5.6 Mean value of HRY, MRY and brokens IGBEMO 1 at specified moisture content	170
A5.7 Mean value of HRY, MRY and brokens IGBEMO 11 at specified moisture content	171
A10.1 Summary of weights collected during cleaning and grading of parboiled and raw ITA 150	231
A10.2 Summary of weights collected during cleaning and grading of parboiled and raw FARO 44	232
A10.3 Summary of weights collected during cleaning and grading of parboiled and raw FARO52	233
A10.4 Summary of weights collected during cleaning and grading of parboiled and raw NERICA I	234
A10.5 Summary of weights collected during cleaning and grading of parboiled and raw IGBEMO I	235
A10.6 Summary of weights collected during cleaning and grading of parboiled IGBEMO II	236

LIST OF PLATES

Plate	Page
3.1 Pictorial top view of the rice cleaner / grader	58
3.2 Blower assembly at 5° inclinations to the horizontal	59
3.3 Pictorial side view of the rice cleaner / grader	60
3.4 Pictorial front view of the rice cleaner / grader	62
3.5 Bottom sieve for separation of thr rice cleaner / grader	63
A11.1 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on raw ITA150	237
A11.2 Product, reject 2 and 1 obtained using the rice cleaner/grader on raw FARO 44	238
A11.3 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on raw FARO 52	239
A11.4 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on raw NERICA 1	240
A11.5 Product, reject2 and reject 1 obtained using the rice cleaner/grader on raw IGBEMO I	241
A11.6 Product, reject2 and reject 1 obtained using the rice cleaner/grader on raw IGBEMO II	242
A11.7 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on parboiled ITA 150	243
A11.8 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on parboiled FARO 44	244
A11.9 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on parboiled FARO 52	245
A11.10 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on parboiled NERICA I	246
A11.11 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on parboiled IGBEMO I	247
A11.12 Product, reject 2 and reject 1 obtained using the rice cleaner/grader on parboiled IGBEMO II	248

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LIST OF FIGURES

Figure	Page
1.1 Structure of a rice kernel	5
3.1 Position of connecting rod at two extreme positions	36
3.2 Force polygon triangle on the shaft	44
3.3 Vertical forces acting on fan shaft	46
3.4 Vertical bending movement diagram on fan shaft	47
3.5 Horizontal forces acting on fan shaft	48
3.6 Horizontal bending movement diagram on fan shaft	49
3.7 Resultant forces acting on fan shaft	52
3.8 Isometric view of the rice cleaner / grader	56
3.9 Frame support of the rice cleaner / grader	57
3.10 Flow chart of materials the rice cleaner / grader	67
4.1 Efficiency curves for grain grading of parboiled rice at 0° blower inclination	113
4.2 Efficiency curves for grain grading of parboiled rice at 5° blower inclination	114
4.3 Efficiency curves for grain grading of raw rice at 0° blower inclination	117
4.4 Efficiency curves for grain grading of raw rice at 5° blower inclination	118
A.1 Exploded view of rice cleaner and grader	251

LIST OF ABBREVIATIONS

Symbol/ Abbreviation	Meaning	Unit
a	acceleration	ms^{-2}
A_p	projected area	m^2
A	Cross sectional area	m^2
B_p	Bad Product	g
Br	Bad reject	g
CPI	Cleaning performance index	
$C_{d\text{max}}$	Belt maximum centre distance	m
$C_{d\text{min}}$	Belt minimum centre distance	m
C	drag co-efficient	unit less
C_o	Co-efficient of opening	unit less
dd/dt	velocity	ms^{-1}
d^2d/dt	acceleration	ms^{-2}
ρ_f	density of fluid	kg/m^3
ρ_a	density of air	kg/m^3
ρ_p	mass density of particle	lg/m^3
\emptyset	diameter	mm
D	diameter of hole	mm
d	thickness of wire	mm
Egr	efficiency of separating whole grain	%
E	modulations of elasticity	N/M^2
Ebc	Efficiency of separating broken/chaff	%
Eg	efficiency of grading whole grain	%
FAO	Food and Agriculture Organization	
Fr	Drag force	N
FGIS	Federal Grain Inspection service	
Fg	Gravitational force	N
F_A, F_B, F_C, F_D, F_E	Resultant forces on shaft	N

F	Feed	g
G	Torsional modulus of rigidity	N/m ²
GT	Gelatinization temperature	
g	acceleration due to gravity	m/S ²
GP	good product	g
GR	Good reject	g
HYV	High yield variety	%
HRV	Head rice yield	%
HP	Horse power	kw
I	least second d moment area	m ³
IRRI	International Rice Research Institute	
(LWT) ^{1/3} /L	Sphericity	
(LWT) ^{1/3}	Spherical mean	
LV	local variety	
L	Length or major diameter	mm
L/W	Length/width	unit less
L/T	Length/Thickness	unit less
MC	Moisture content	% wet basis
MOG	Material other than grain	
m	mass of particle	g or kg
Mt	Torsional moment	Nm
Mb	Maximum bending moment	Nm
NCRI	National Cereals Research Institute	
Np	Permissible speed	rpm
Nc	critical speed	rpm
N	Brower speed	rpm
NIS	Nigeria industrial standard	
R	Radius of eccentricity	m
r.p.m	revolution per minute	
Q _A	Actual air discharge	
Q _T	Theoretical air discharge	m ³ /s

Θ	angle of wrap	
Pe	Critical load	kg
S	Distance	m
Φ	Sphericity	unit less
S.D.	Standard deviation	
T	Thickness/Minor diameter	mm
T	time	s
USDA	United States Department of Agriculture	
μ	Co-efficient of friction	unit less
UG	Undersized grain	g
UM	Unmilled grain	g
Vt	Terminal velocity	m/S ²
WG	Whole grain	g
W	width/intermediate diameter	mm
W/T	width/thickness	unit less
ω	angular velocity	rad/s
WARDA	West African Rice development agency	
y	deflection	m