# Contents


**1 Introduction** . . . . . 1
1.1 Some Historical Background . . . . . 1
1.2 Removal of Particles from Gases . . . . . 6
1.2.1 Filtration . . . . . 8
1.2.2 Wet Scrubbers . . . . . 10
1.2.3 Centrifugal/Cyclonic Devices . . . . . 11
1.2.4 Knock-out Vessels and Settling Chambers . . . . . 12
1.3 A Closer Look at Centrifugal Gas Cleaning Devices . . . . . 12
1.3.1 Applications of Centrifugal Separators . . . . . 13
1.3.2 Classification of Centrifugal Separators . . . . . 17
1.3.3 Two Main Classes—Cyclones and Swirl Tubes . . . . . 20

**2 Basic Ideas** . . . . . 23
2.1 Gas Flow . . . . . 23
2.1.1 Swirling Flow . . . . . 23
2.1.2 Static and Dynamic Pressure . . . . . 26
2.2 Particle Motion . . . . . 27
2.3 Particle Size . . . . . 32
2.3.1 Definitions of Particle Size . . . . . 32
2.3.2 Particle Size Distribution . . . . . 33
2.4 Particle Density . . . . . 37
2.A Ideal Vortex Laws from N-S Eqs. . . . . 38
2.B Model Functions for Size Distributions . . . . . 41
2.B.1 The Normal Distribution . . . . . 42
2.B.2 The Log-Normal Distribution . . . . . 42
2.B.3 The Rosin-Rammler Distribution . . . . . 43

**3 How Cyclones Work** . . . . . 45
3.1 Flow in Cyclones . . . . . 45
3.1.1 Gas Flow Pattern . . . . . 45
3.1.2 Particle Flow . . . . . 49

3.2 Separation Efficiency . . . . . 51
3.2.1 Overall Separation Efficiency . . . . . 51
3.2.2 Grade-Efficiency . . . . . 51
3.2.3 Converting Between Overall Efficiency and Cut-size . . . . 54
3.3 Pressure Drop . . . . . 54
3.A Worked Example: Calculating a Grade-Efficiency Curve . . . . . 56

**4 Cyclone Flow Pattern and Pressure Drop** . . . . . 59
4.1 Discussion . . . . . 59
4.1.1 Flow Pattern . . . . . 60
4.1.2 Pressure Drop . . . . . 61
4.2 Models for the Flow Pattern . . . . . 64
4.2.1 n-Type Model . . . . . 65
4.2.2 Barth . . . . . 66
4.3 Models for the Pressure Drop . . . . . 70
4.3.1 Models Based on Estimating the Dissipative Loss . . . . . 71
4.3.2 Core Model . . . . . 72
4.3.3 Purely Empirical Models . . . . . 77
4.4 Model Assumptions in Light of CFD and Experiment . . . . . 78
4.5 Overview . . . . . 82
4.A Worked Example for Calculating Cyclone Pressure Drop . . . . . 83
4.B The Meissner and Löffler Model . . . . . 85

**5 Cyclone Separation Efficiency** . . . . . 89
5.1 Discussion . . . . . 89
5.2 Models . . . . . 90
5.2.1 Equilibrium-orbit Models: the Model of Barth . . . . . 90
5.2.2 Time-of-Flight Models . . . . . 93
5.2.3 Hybrid Models . . . . . 96
5.2.4 Comparing the Models . . . . . 96
5.3 Comparison of Model Predictions with Experiment. . . . . 97
5.3.1 Agreement with Experiment in General . . . . . 97
5.3.2 A Case Study: the Effect of Cyclone Length . . . . . 98
5.4 Overview . . . . . 102
5.A Worked Example, Separation Performance . . . . . 103
5.B Models of Dietz and of Mothes and Löffler . . . . . 106

**6 The Muschelknautz Method of Modeling** . . . . . 111
6.1 Basis of the Model . . . . . 112
6.2 Computation of the Inner Vortex Cut-Point, $x_{50}$ . . . . . 118
6.3 Computation of Efficiency at Low Solids Loadings . . . . . 120
6.4 Determining if the Mass Loading Effect will Occur . . . . . 122
6.5 Overall Separation Efficiency when $c_o > c_{oL}$ . . . . . 122
6.6 Computation of Pressure Drop . . . . . 124
6.A Example Problems . . . . . 125

6.A.1 Data from Hoffmann, Peng and Postma (2001) . . . . . 125
6.A.2 Data from Obermair and Staudinger (2001) . . . . . 128
6.A.3 Simulation of the Data from Greif (1997) . . . . . 129
6.B Incorporation of the 'Inner Feed' . . . . . 133

**7 Computational Fluid Dynamics** . . . . . 139
7.1 Simulating the Gas Flow Pattern . . . . . 140
7.1.1 Setting up the Finite Difference Equations . . . . . 140
7.1.2 Turbulence Models . . . . . 142
7.1.3 Simulations . . . . . 143
7.2 Simulating the Particle Flow . . . . . 147
7.2.1 Eulerian Modeling . . . . . 148
7.2.2 Lagrangian Particle Tracking . . . . . 148
7.2.3 3-D particle tracks . . . . . 148
7.3 Some Simulations of the Gas and Particle Flow in Cyclones . . . 149
7.3.1 LES Simulations of Derksen and van den Akker . . . . . 149
7.3.2 Some Remarks on CFD in Cyclones . . . . . 160
7.A Transport Equations . . . . . 161

**8 Dimensional Analysis and Scaling Rules** . . . . . 163
8.1 Classical Dimensional Analysis . . . . . 164
8.1.1 Separation Efficiency . . . . . 164
8.1.2 Pressure Drop . . . . . 167
8.2 Scaling Cyclones in Practice . . . . . 168
8.2.1 Approximately Constant $Stk_{50}$ over a Wide Range of $Re$ 168
8.2.2 $Eu$ Only Weakly Dependent on $Re$ . . . . . 171
8.2.3 Some other Considerations . . . . . 172
8.2.4 $Stk$-$Eu$ Relationships . . . . . 173
8.A Inspecting the Equations of Motion . . . . . 176
8.A.1 Equation of Motion for the Gas . . . . . 176
8.A.2 Equation of Motion for a Particle . . . . . 176
8.B Sample Cyclone Scaling Calculations . . . . . 177
8.B.1 Inlet Velocity for $Re$ Similarity . . . . . 177
8.B.2 Prediction from Scale Model . . . . . 178

**9 Other Factors Influencing Performance** . . . . . 183
9.1 The Effect of Solids Loading . . . . . 183
9.1.1 Effect on Separation Efficiency of Cyclones . . . . . 183
9.1.2 Models for Effect on Separation Efficiency . . . . . 185
9.1.3 Effect on the Separation Efficiency of Swirl Tubes . . . . . 191
9.1.4 Effect on the Pressure Drop of Cyclones . . . . . 192
9.1.5 Effect on the Pressure Drop Across Swirl Tubes . . . . . 194
9.1.6 Computing Performance with High Loading . . . . . 194
9.2 The Effect of the Natural Vortex Length . . . . . 195
9.2.1 The Nature of the Vortex End . . . . . 195

9.2.2 Wall Velocity Due to Core Precession . . . 197
9.2.3 The Significance of the Vortex End . . . 199
9.2.4 Models for the Natural Vortex Length . . . 203
9.A Predicting the Effect of Solids Loading on Cyclone Efficiency . . 205
9.B Predicting the Effect of Loading on Cyclone Pressure Drop . . . 208

**10 Measurement Techniques** . . . 213
10.1 Gas Flow Pattern . . . 216
10.2 Pressure Drop . . . 218
10.3 Particle Flow . . . 219
10.4 Overall Separation Efficiency . . . 220
10.4.1 On-line Sampling of Solids . . . 221
10.5 Grade-Efficiency . . . 224
10.5.1 On-Line *vs.* Off-Line Size Analysis . . . 224
10.5.2 Sample Capture and Preparation . . . 225
10.5.3 Methods for Size Analysis . . . 226
10.A Estimate of Errors . . . 231

**11 Underflow Configurations and Considerations** . . . 235
11.1 Underflow Configurations . . . 235
11.2 Importance of a Good Underflow Seal . . . 239
11.2.1 Inleakage Example . . . 242
11.3 Upsets Caused by 'Too Good' an Underflow Seal . . . 243
11.4 Second-Stage Dipleg Solids 'Backup' . . . 246
11.5 Hopper 'Crossflow' . . . 248
11.6 Hopper Venting Options . . . 250
11.A Dipleg Calculation . . . 253
11.B Moment Balance on Flapper Valve Plate . . . 253
11.B.1 Example . . . 256

**12 Some Special Topics** . . . 257
12.1 Cyclone Erosion . . . 257
12.1.1 Inlet 'Target Zone' . . . 257
12.1.2 Lower Cone Section . . . 260
12.1.3 Vortex Tube Outer Surface . . . 263
12.1.4 Erosion Protection . . . 268
12.2 Critical Deposition Velocity . . . 279
12.3 High Vacuum Case . . . 281
12.3.1 Application to Cyclone or Swirl Tube Simulation . . . 282
12.A Worked Example for Critical Deposition Velocity . . . 283
12.B Worked Example with Slip . . . 283

**13 Demisting Cyclones** . . . . . 287
13.1 Liquid Creep and 'Layer Loss' . . . . . 288
13.2 Demisting Cyclone Design Considerations . . . . . 290
13.3 Some Vapor-Liquid Cyclone Design Geometries and Features . . 292
13.4 Estimating Inlet Drop Size for Two-Phase Mist-Annular Flow . 299
13.4.1 Estimating Drop Size Distribution . . . . . 301
13.5 Modeling the Performance of Vapor-Liquid Cyclones . . . . . 302
13.5.1 Computation of Cut Size . . . . . 302
13.5.2 Computation of Efficiency at Low Inlet Loadings . . . . . 303
13.6 Criteria for Determining if 'Mass loading' ('Saltation') Occurs . 303
13.6.1 Overall Separation Efficiency when $c_o > c_{oL}$ . . . . . 304
13.7 Re-entrainment From Demisting Cyclones . . . . . 305
13.7.1 Re-entrainment Mechanisms and Governing Parameters 305
13.7.2 Data for Re-entrainment . . . . . 308
13.A Example Calculations of Droplet Sizes in Pipe Flow . . . . . 311
13.A.1 Finding the Mean Droplet Size . . . . . 311
13.A.2 Finding the Droplet Size Distribution . . . . . 312
13.B Flow Distribution in Parallel Demisting Cyclones . . . . . 312
13.B.1 Calculation of Flow Distribution . . . . . 317
13.B.2 Calculation of Liquid Level Difference . . . . . 317
13.C Method for Estimating Wall Film Thickness and Velocity . . . . . 318
13.C.1 Two-Phase, Co-current, Annular Force Balance, Resolved in the Axial Direction . . . . . 320
13.C.2 Friction Factors and Shear Stresses . . . . . 321
13.C.3 Final Form of Void Fraction Equation . . . . . 323
13.D Example calculation . . . . . 324

**14 Foam-Breaking Cyclones** . . . . . 327
14.1 Introduction . . . . . 327
14.2 Some Design Considerations and Factors Influencing Behavior . 330
14.3 Applications . . . . . 334
14.4 Estimating Submergence Required to Prevent Gas 'Blow Out' 334
14.A Example Calculation of Submergence Required . . . . . 340

**15 Design Aspects** . . . . . 341
15.1 Cylinder-on-Cone Cyclones with Tangential Inlet . . . . . 341
15.1.1 Some Standard Cyclone Designs . . . . . 341
15.1.2 Design of the Inlet . . . . . 342
15.1.3 Design of the Cone Section . . . . . 349
15.1.4 Solids Outlet Configurations . . . . . 350
15.1.5 Vortex Finder Geometries . . . . . 353
15.1.6 Cyclone Length . . . . . 363
15.1.7 Cyclone Roof . . . . . 364
15.1.8 Cyclone Operating Conditions . . . . . 367
15.2 Design of Swirl Tubes with Swirl Vanes . . . . . 368

15.2.1 Design of the Inlet Vanes . . . 368
15.2.2 Calculation of Inlet 'Throat' Area . . . 370
15.2.3 Length of the Swirl Tube Body and the Solids Exit . . . 372
15.A Example Calculation of the Throat Area . . . 373
15.B Construction of Vane "Cut-out" pattern . . . 374

**16 Multicyclone Arrangements** . . . 381
16.1 Cyclones in Series . . . 381
16.2 Cyclones in Parallel . . . 382
16.A Example Calculation for Multicyclone Arrangements . . . 391

**List of Symbols** . . . 397

**List of Tradenames** . . . 403

**References** . . . 405

**Index** . . . 411