

ENGINEERING
TOMORROW

Danfoss

Danfoss | Sugar applications

On top of **sugar production** with the **widest Free Flow** **plate portfolio** in the world

We offer you a complete heat exchanger portfolio to support your production

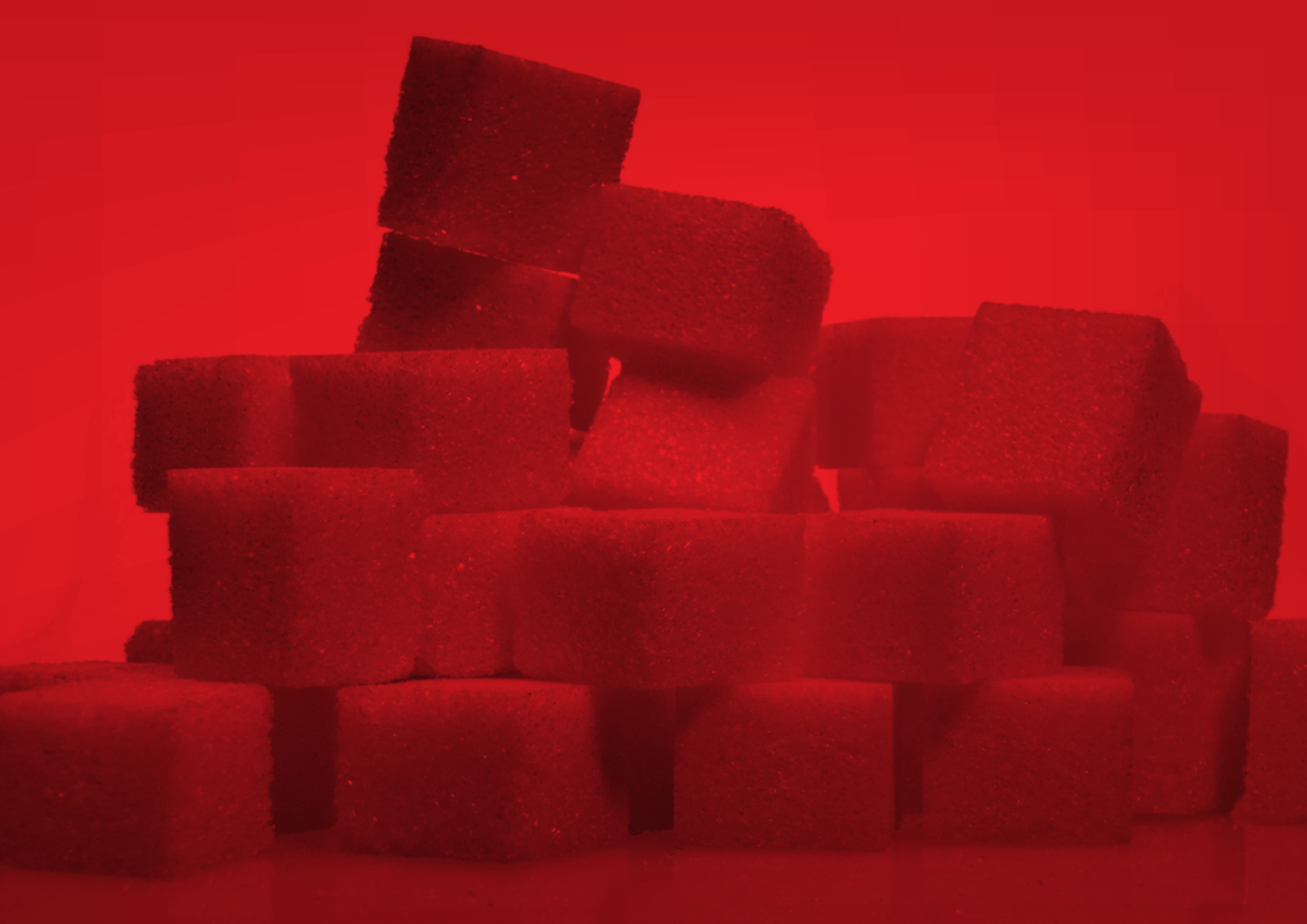
FULL

range of plate
gaps available to
suit your needed
configuration



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SONDEX®



Heat exchanger portfolio for sugar production

The sugar industry subsumes the production, processing, and marketing of sugars. At the heart of any sugar production is always a crop rich in sucrose.

Extracting sugar from the crop is a complex and fascinating process that leads to the finished products that most of us are probably familiar with, like refined sugar, molasses, or even ethanol / alcohol.

In some sugar refineries, you will even find integrated power plants that produce electricity and heat by utilizing the residual plant material.

Globally, most sugar is extracted from sugarcane (~80 %, mostly in the tropics) and sugar beets (~20%, mostly in temperate climate like in the U.S. or Europe).

Sugar beet and sugarcane processing have similar stages of obtaining sugar, with some differences (detailed in the diagrams on the following pages).

Danfoss offers a wide range of SONDEX® heat exchangers for the entire sugar refinery application, such as:

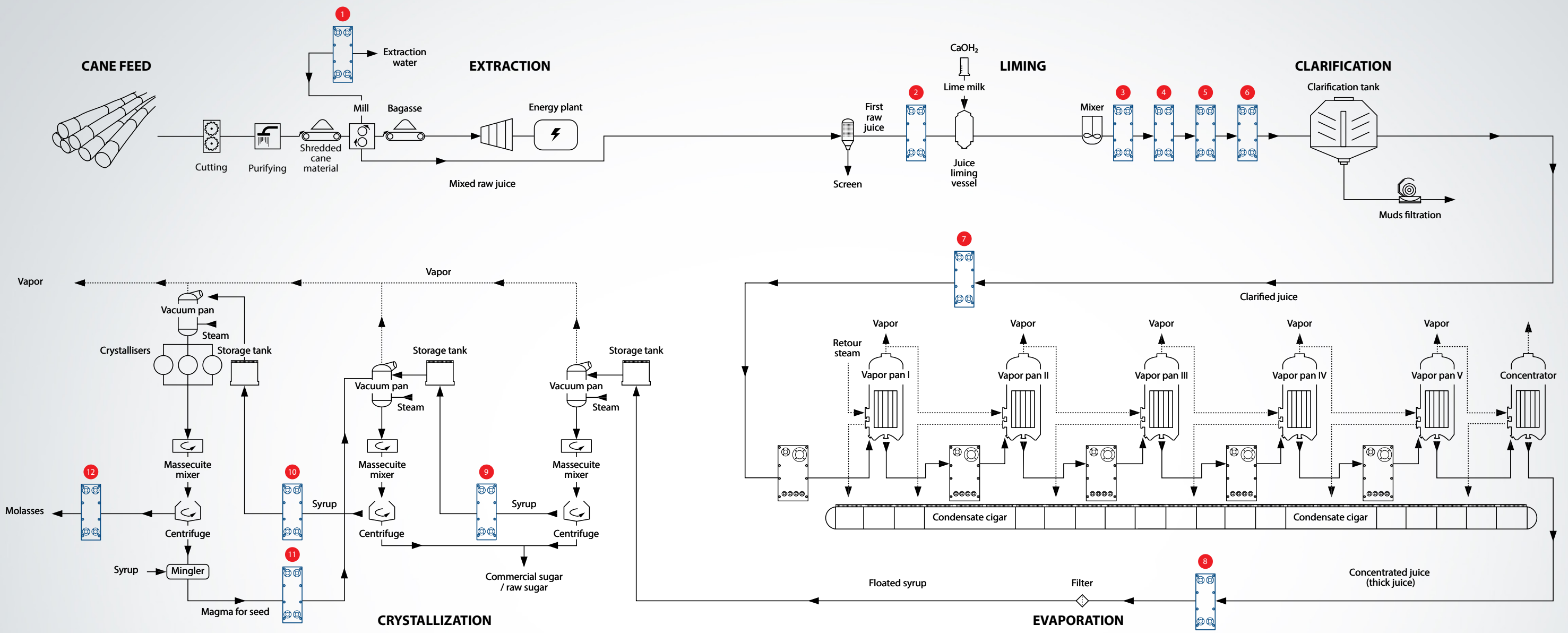
Free Flow plate heat exchangers, designed specifically for operation with media containing fibers and high-viscosity media.

Standard gasketed plate heat exchangers, used in many sub-processes.

Spiral heat exchangers, used as economizers and for cooling molasses and vinasses.



Sugarcane processing



The cane is delivered to the mill, where it is cut, cleaned (purified), and transferred to the mill. Here, the cane is cut into pieces with revolving knives, shredders, or crushers (for breaking down the organic material) and then ground (or milled) in a series of roller mills (consisting of 3-6 rollers each), being transported from one mill to the next.

1 | Extraction water heater (standard)

The extraction water is heated up in the heat exchanger (1) and fed to the mill in order to enhance the extraction of the juice from the crushed cane.

The crushed cane, or residual fibre, exiting the mill, is called "Bagasse". It serves as a fuel for running the micro power plant that is typically part of the installation site.

2 | Raw juice heater (Free Flow)

The mixed raw juice coming out of the mills is filtered to remove large particles and then clarified and heated up in the heat exchanger (2).

One of the most widely used methods to clarify raw sugarcane juice is carbonatation, which generally employs treatment with lime and controlled addition of carbon dioxide (CO₂).

Prior to liming, the mixed raw juice is preheated to a temperature of 50-85°C in the heat exchanger (2) for optimal clarification.

The milk of lime, calcium hydroxide or Ca(OH)₂, is added to the juice to neutralize the organic acids and raise the pH. CO₂ gas is then introduced into the limed juice to remove alkalinity.

3, 4, 5, 6 | Group of limed juice heaters (Free Flow)

Next, the temperature of the carbonatated juice is raised to the boiling point to remove excess carbonic acid, and the juice enters a gravitational settling tank, a clarifier, where heavy precipitate forms and is separated from the juice. The clarified juice (so-called thin juice) is processed in the evaporators without additional treatment.

7 | Clarified juice heater (standard)

The clarified juice reaches the first evaporator step, which has steam (of 100-110°C at saturation pressure) on the hot side.

8 | Concentrated juice heater (Free Flow)

In the crystallization process, the sugar rich fluid goes to the final evaporation in a vacuum pan, and seed crystals are added.

Seed crystals (basically a "handful of sugar") act as a catalyst for crystal formation, and all the sugar in the fluid now changes state from being a soluble part of the fluid, into a separate crystal.

The resulting material, which contains liquid (syrup) and crystals (sugar) is called cooked mass. The crystallization work is performed by using the three cooking system or batches in order to obtain better sucrose recovery.

Now the mother liquid (Massequite) is ready to be sent to the centrifuge. Here, the fluid is separated into two components: fluid molasses and raw unrefined sugar (a wet and sticky granulate matter).

The raw sugar is then led to a rotary drier that dries the sugar, after which the raw sugar is now ready for the final steps (typically bleaching, grinding, and sifting to create fine white sugar).

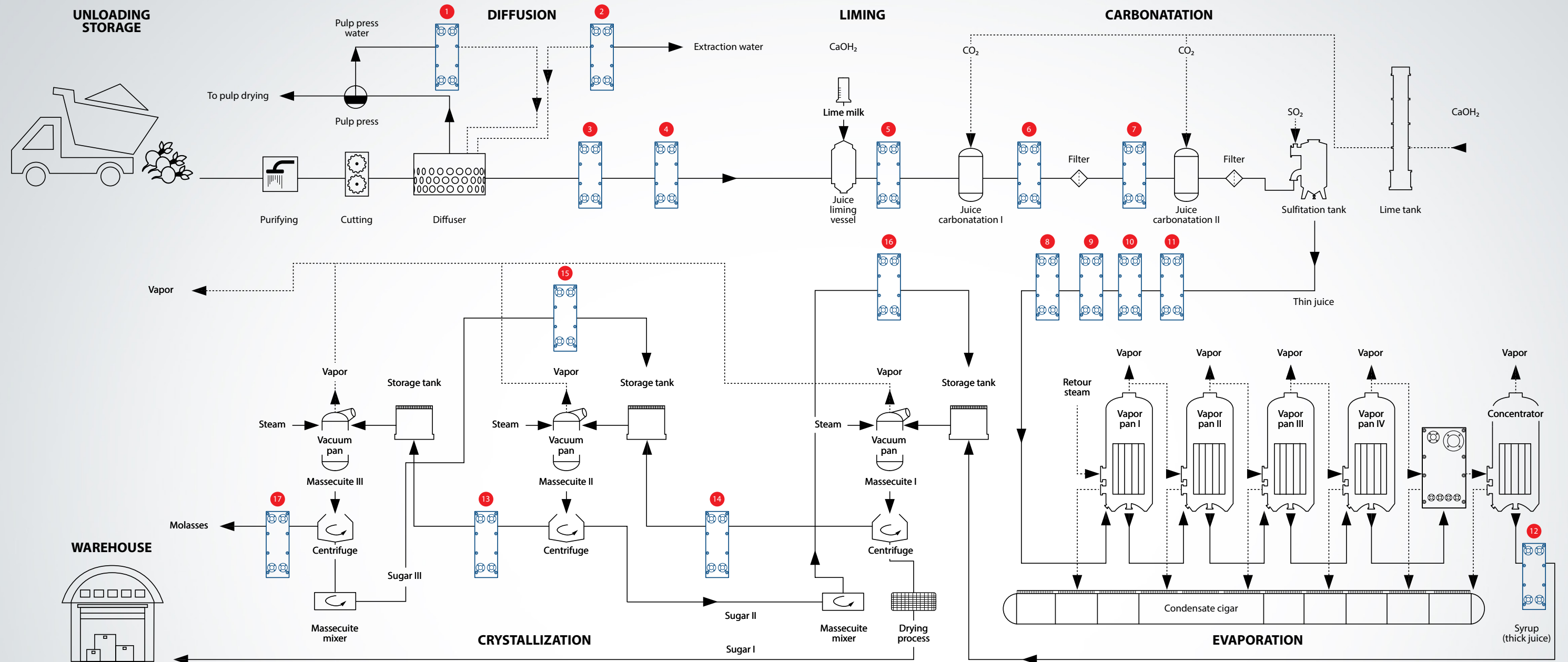
9, 10 | Syrup heater (Free Flow)

11 | Magma for seed heater (Free Flow)

12 | Molasses cooler (Free Flow)

The setup of the crystallization stage may vary in different regions and sugar refineries.

Sugar beet processing



Nowadays, a diffusion method is usually applied for obtaining beet juice. The first step in the diffusion process is to cut the beet roots into thin strips called cosettes. The cosettes then undergo countercurrent processing with hot water at temperatures of 72-75°C in a special machine referred to as a diffuser.

1 | Pulp press water heater (Free Flow)

Cosettes without sugar content (pulp) leave the diffuser to be pressed, and then the pressed pulp is dried or sold raw.

Pulp-press water is subject to heat treatment in the heat exchanger (1), purified from suspended impurities and returned to the diffuser. Caught wet pulp is also returned to the diffuser.

2 | Extraction water heater (standard)

In the diffuser, the sugar content is extracted from the

counter flow of cosettes and hot water, which has been preheated in the heat exchanger (2).

The diffused juice is separated from the wet pulp in a pulp catcher and sent for the lime and carbon-dioxide purification.

3, 4 | Diffusion juice heater (Free Flow)

The diffusion juice is preheated in the heat exchangers (3 and 4) and is then filtered and purified by CaOH and CO₂, which is obtained at the plant during the calcination of limestone (this stage is called liming).

5 | Limed juice heater (Free Flow)

The heat exchanger preheats the limed juice before it is treated with carbonation gas CO₂ (Juice carbonation I). In this process the lime is converted into calcium carbonate (CaCO₃), on the surface of which non-sugars are adsorbed.

6 | Juice heater after carbonation I (Free Flow)

The juice is heated before filtration, where the precipitate of CaCO₃ and non-sugars are separated from the juice.

7 | Juice heater before carbonation II (Free Flow)

The juice is heated to 92-95°C in the heat exchanger (7) and before its second carbonation (Juice carbonation II). After the separation of the saturation precipitate via filtration, the juice is sulfated, filtered, and fed to the evaporation station.

8, 9, 10, 11 | Group of juice heaters before evaporation (standard)

The purified juice (so-called "thin juice") with 11-16 Brix is sulfated by sulfur dioxide (SO₂) and preheated in the group of juice heaters by steam and then concentrated to 60-65 Brix at the evaporation station.

12 | Syrup heater (Free Flow)

The syrup (thick juice) is preheated in the heat exchanger (12) and mixed with melt syrup of sugar II and III, sulfated, filtered, and passed along to the crystallization process.

13, 14 | Liquor heater (Free Flow)

To obtain pure granulated sugar, the syrup is boiled in a special pan under vacuum to the oversaturation state.

Powdered sugar is then added to start the crystal formation to get a mixture of crystals and syrup, the so-called massecuite (Massecuite I).

The massecuite is spun in centrifuges to separate the sugar from the first mother liquor. The sugar is then washed in centrifuges with hot water, producing a second mother liquor. The sugar is dried. The first and second mother liquors (with sugar content) are boiled

(Massecuite II) and is preheated in the heat exchangers (13 and 14). The massecuite is centrifuged, and the sugar is washed with hot water.

15, 16 | Melt syrup heater (Free Flow)

Sugar III (low-grade sugar) contains more impurities than sugar II (middling sugar), so it is preheated in the heat exchanger (15). It is then mixed with the diluted first mother liquor of Massecuite I, a so-called affined solution, after which it is centrifuged.

During stirring, part of the non-sugar passes from the film on the crystals to the affined solution, resulting in cleaner sugar.

The mixture of low-grade sugar and the diluted first mother liquor of Massecuite I, the so-called affined massecuite, is centrifuged with Massecuite II.

The middling sugar and low-grade sugar are dissolved in purified juice to 65-68 Brix (this solution is called melt syrup) and this juice is mixed with the syrup from the evaporation station before sulfitation.

17 | Molasses cooler/heater (Free Flow)

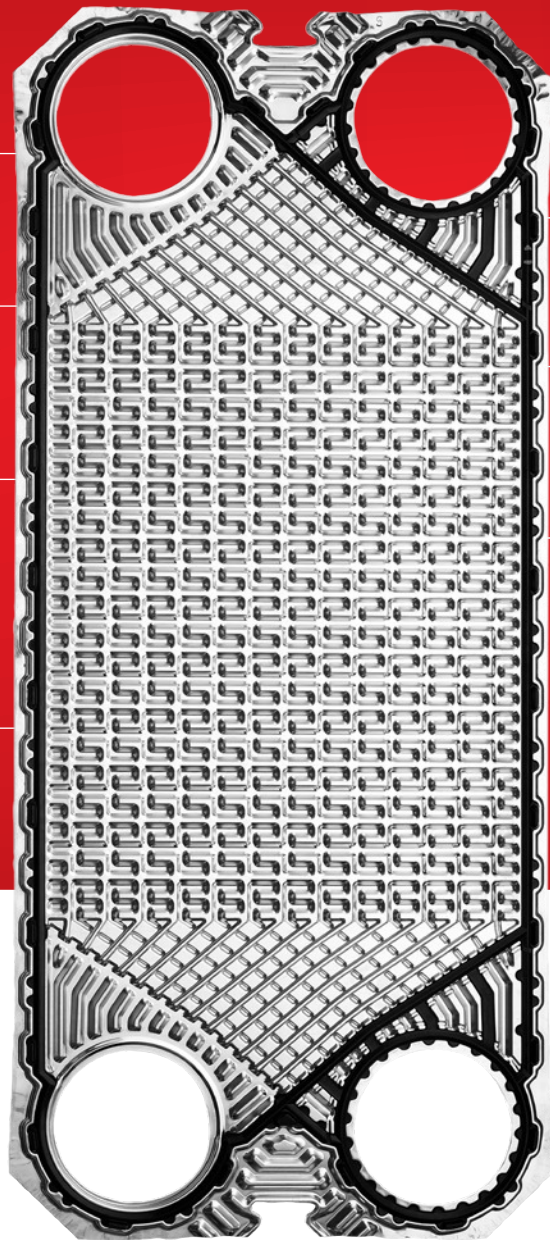
Depending on the technological setup of the plant, the molasses is cooled down or heated up in the heat exchanger (17) and sent to other factories for further processing.

DN25 - DN400
porthole connections

1 m - 3.4 m
plate heights

Up to 2700 m³/hour
flow rates

Designed to handle
media with fibers and
particles, high-viscosity
media, and fouling media



Very stable plate
pack even with
only line contact

5 mm - 12 mm
plate gap

Asymmetric
patterns available

Free Flow plates

Comprehensive process insight brings
about the crowning achievement within
treatment of hard-to-handle media.

The spacious SONDEX® Free Flow pattern is designed to treat media that is unsuitable for regular heat exchangers due to high viscosity, fiber and particle contents, or considerable risk of fouling.

The deep and wide channels provide ample room for difficult media to flow effortlessly, ensuring gentle treatment of the output product, leading to sustainable quality improvements.

Free Flow plate benefits

Since there is only line contact, even long and sticky particles will not get stuck and clog the heat exchanger.

The Free Flow plates are also well-suited for media that have a tendency to cause fouling, and are designed with the fouling factor in mind.

The plate channels allow for an efficient flow and heat transfer, and have strong anti-fouling properties.

This enables a sugar producer, for example, to operate at full capacity throughout an entire campaign without losing valuable production time and product output.

Free Flow plate highlights



Spacious channels

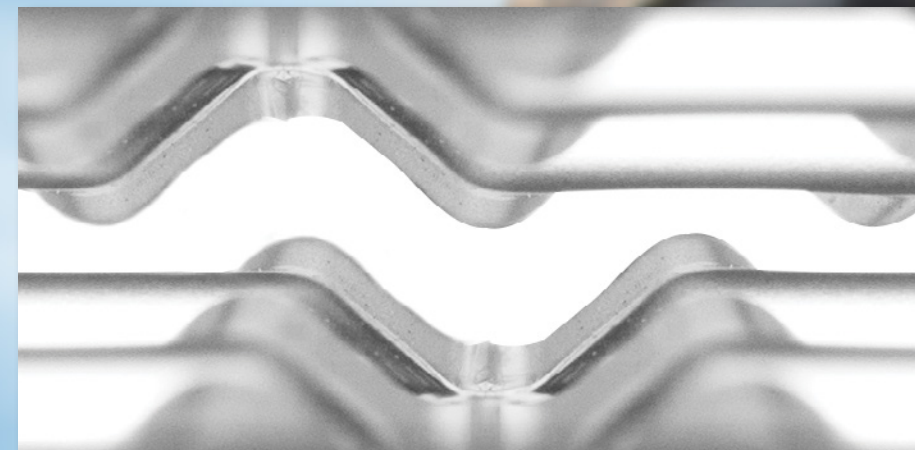
The SONDEX® Free Flow pattern ensures an unimpeded flow due to the deep channels.

With only line-contact, the media has ample room to flow inside the plate channels, benefiting greatly from the increased level of turbulence, compared to tubular heat exchangers.

Contact-free inlets

The design of the SONDEX® Free Flow inlets maintains the sturdy and robust construction of the traditional plate design, while having no contact points at all.

This greatly minimizes the risk of clogging the inlets and subsequently decommissioning the heat exchanger for service and maintenance.



Large plate gap

The large plate gap is designed to handle media that would otherwise cause fouling and clog regular heat exchangers.

Our process and application knowledge enables us to design Free Flow plate heat exchangers that perform optimally, regardless of the media's viscosity, fouling tendency, and particle contents.

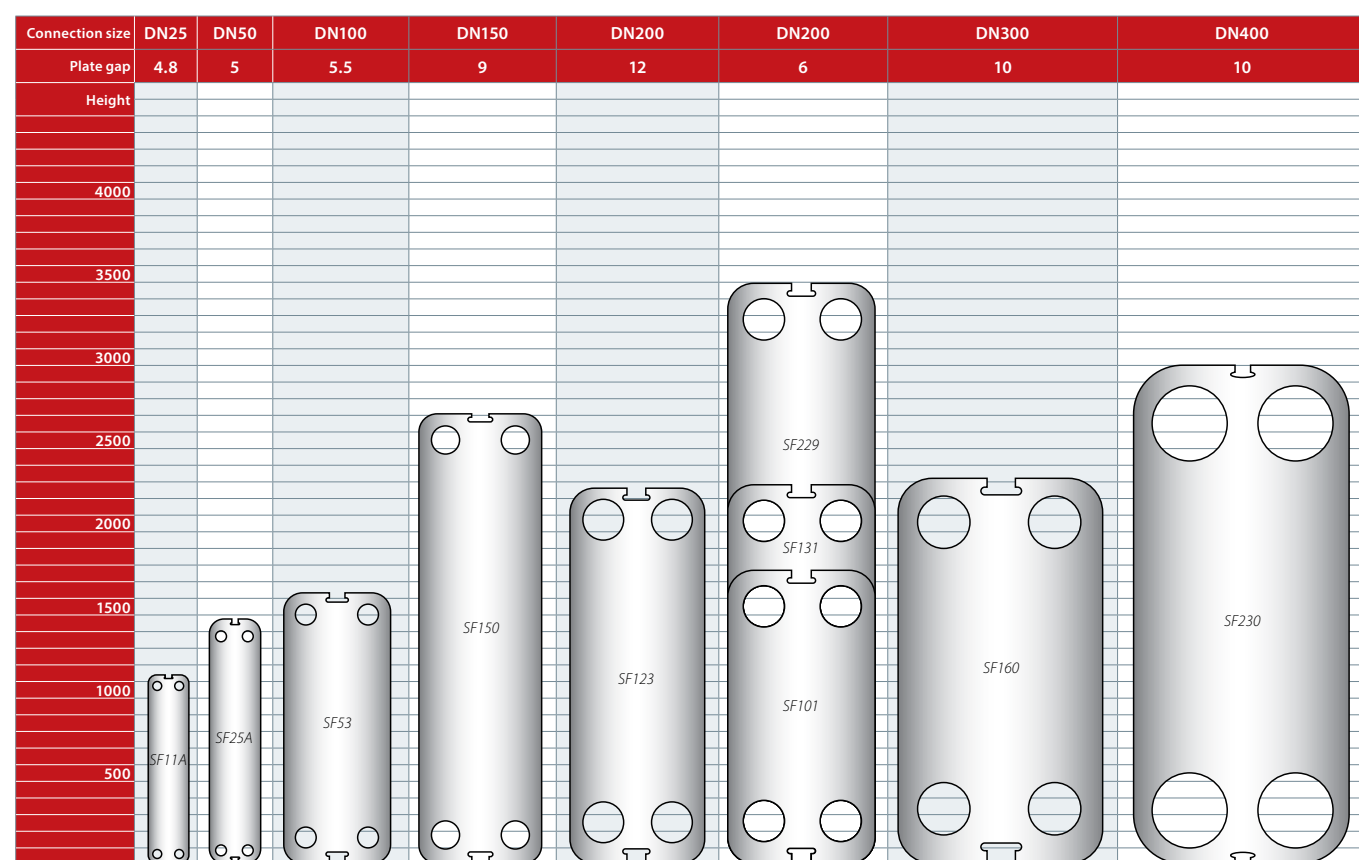
Line-contact

The Free Flow plates feature only line-contact between each plate. The design forms straight-line contact that maintains the sturdiness of conventional plate design, but allows for an unimpeded flow.

The pinnacle of design for hard-to-handle media, our Free Flow pattern ensures longer intervals between cleaning and service, maximizing the uptime of your installation.



SONDEX® Free Flow heat exchanger plate portfolio



Measurements in mm

Rev.11.10.2019

With our extensive Free Flow plate portfolio, we can provide you with an optimal solution for your business and applications.

Design pressure:

PN 10, PN 16

Min. working temperature:

-20°C (depending on gasket material selected)

Max. working temperature:

180°C (depending on gasket material selected)

Frame (head and follower) materials:

Mild steel, painted in RAL 5010.
Other colors are available upon request

Plate materials:

AISI 304, AISI 316, titanium.
Other materials are available upon request

Gasket materials:

NBR, EPDM and Viton.
Other materials are available upon request

Construction standard:

PED 2014/68/EU (EN13445),
ASME sec VIII, Div. 1 (In select countries)

Compliant to:

FDA, 3A

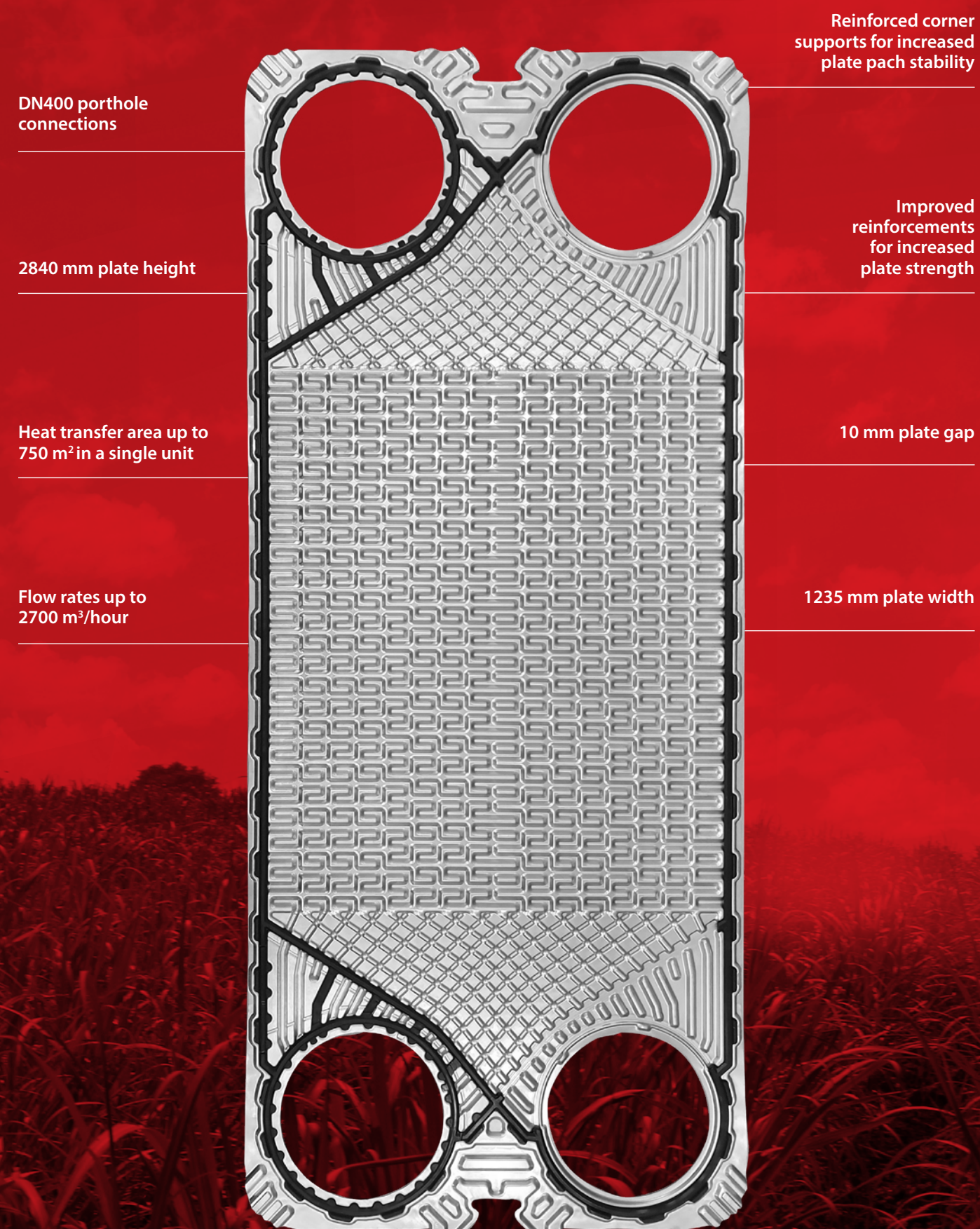
Performance certificates:

AHRI (LLHE)

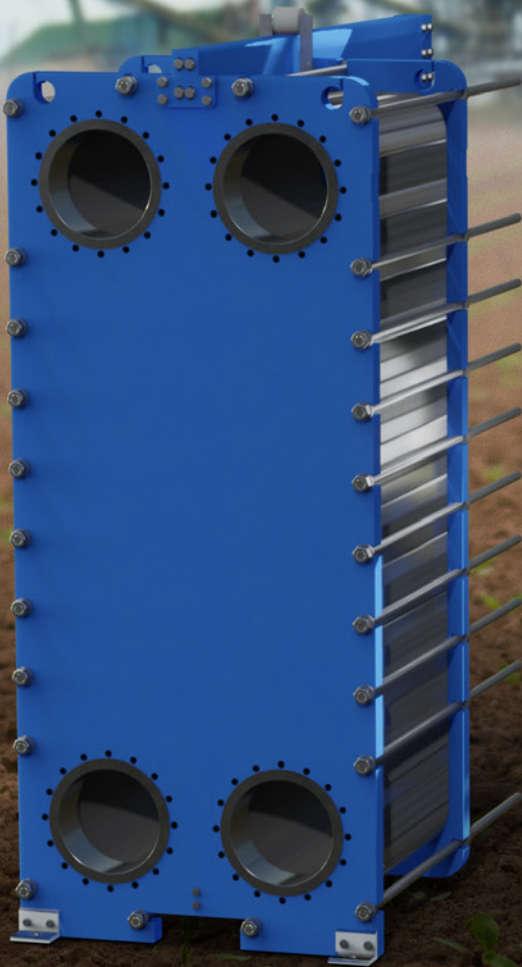
Plate gap configurations:

Symmetric, asymmetric

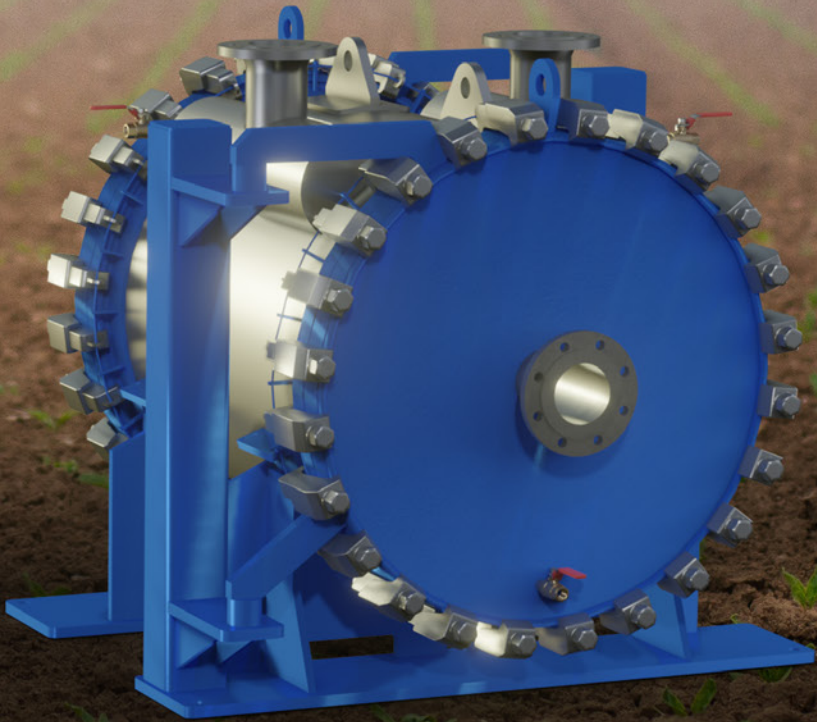
Introducing the **largest** Free Flow plate on the market,
SF230



SONDEX® heat exchanger product range for **sugar/ethanol** applications



Standard heat exchangers



Spiral heat exchangers



Various sub-processes



Clean liquids



High thermal efficiency



Molasses and vinasses cooling



Media containing fibers and particles, and high-viscosity media



Excellent heat recovery

Spiral heat exchangers

Our SONDEX® spiral heat exchangers are the definitive solution for applications that require treatment of challenging fluids, such as sludges, slurries, waste water, liquids that cause fouling or contain fibers and solids, and liquids with high viscosity.



Features and benefits

- The design allows for a countercurrent flow that makes it possible to achieve very close temperature approaches.
- Single-channel design that generates high shear rates which contribute to a self-cleaning effect, preventing clogging of the unit. Spiral heat exchangers are the perfect solution for high-viscosity media.
- The channel size is selected to fit the flow and qualities of the media. The many variations in diameters and widths of the spiral coil allow for many different combinations, which mean that we can create the optimal solution for every duty.
- Designed to handle a very aggressive temperature program and with a wide range of materials and plate thicknesses available, we customize each spiral heat exchanger to match the requirements

of your application.

- Limited need for maintenance and cleaning ensures extended operational uptime. If particularly difficult media makes it necessary to clean, the hinged covers provide easy access to the entire heat transfer surface.
- Our spiral heat exchangers have minimal space requirements. Despite being small, the long, curved flow paths allow for very high heat transfer coefficients up to twice as high as their shell and tube counterparts.

Common applications

- Food/beverage industry
- Biogas industry
- Wastewater industry
- Pulp and paper industry
- Heavy industry
- Petrochemical industry
- Chemical industry

Standard plate heat exchangers

Our SONDEX® standard plate heat exchangers are the ideal choice for a wide range of applications across numerous market segments. We have one of the largest plate portfolio in the world, and we configure each heat exchanger to meet your requirements. Innovative technologies and smart design make our traditional plate heat exchangers a stellar investment.

Features and benefits

- Experience the benefit of a heat transfer solution that perfectly matches your requirements and lowers your energy consumption.
- High performance and a low pressure drop eliminate unnecessary burdens on your system and optimize overall system performance.
- The design results in a compact solution with a small footprint, simple installation, and easy access for maintenance.

Common applications

- Marine applications, such as central and lubrication oil cooling.
- District cooling solutions using seawater and groundwater as a cooling source.
- District heating solutions using, for example, solar and geothermal energy as heating source.
- Food and dairy applications, including pasteurization, heat recovery, and duties that require gentle treatment.
- Chemical applications, for example waste heat recovery from condenser water.



Product selection



Flexible solutions



Optimized for your applications



Product lifetime



After-sales service

A partnership based on extensive application knowledge

Working with Danfoss means more. It means that you do not only get highly reliable, efficient, and innovative solutions – you also get a partner that is a world-leading supplier in a wide range of applications. Our partnership gives you access to a

wide range of benefits. From extensive application knowledge to a wide range of solutions and tools.

Do you want to discover more?

Visit heatexchangers.danfoss.com to learn more about our heat exchanger solutions.

Gasketed HEX

Standard plate HEX
Semi-welded plate HEX
Free Flow plate HEX
Sanitary plate HEX

Welded HEX

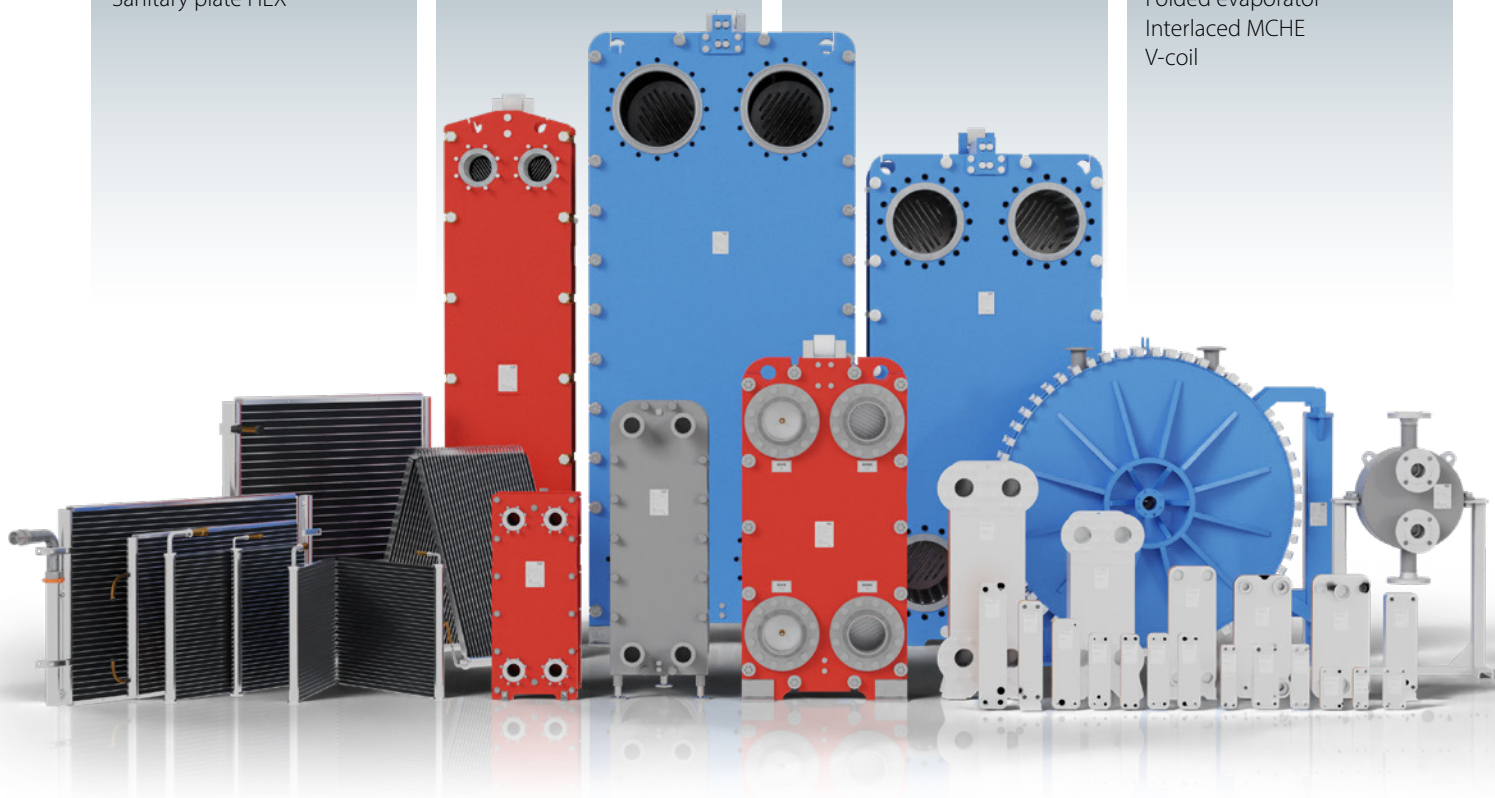
Plate and shell HEX
Spiral HEX

Brazed HEX

Fishbone brazed HEX
Micro Plate™ brazed HEX

Micro channel

Flat condenser
Formed condenser
Slab evaporator
Folded evaporator
Interlaced MCHE
V-coil



Danfoss A/S

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