

10

MIXING AND AGITATION

Mixing—the movement of fluids and solids to enhance a process result—is accomplished by means of an agitation source. For example, the sun is the agitation source for mixing in the earth's atmosphere. Similarly, an air compressor and/or a mechanical mixer is the agitation source in any municipal wastewater treatment plant to enhance the process results of (1) solids suspension and (2) oxygen absorption from sparged or entrained air.

In its most general sense, the process of mixing is concerned with all combinations of phases, of which the most frequently occurring are

1. Gases with gases
2. Gases into liquids: gas dispersion
3. Gases with granular solids: fluidization, pneumatic conveying, drying
4. Liquids into gases: spraying and atomization
5. Liquids into liquids: dissolution, emulsification, dispersion
6. Liquids with granular solids: solids suspension, mass transfer, and dissolution
7. Fluids with each other and with solids
8. Solids with solids: mixing of powders

Interaction of three phases—gases, liquids, and solids—may also occur, as in the hydrogenation of a vegetable oil in the presence of a suspended solid nickel catalyst in a hydrogen-sparged, mechanically agitated reactor.

Three of the processes involving liquids—numbers 2, 5, and 6 in the preceding list—employ the same equipment; namely, tanks in which the liquid is circulated and subjected to a desired level of shear. Mixing involving liquids has been most extensively studied and is most important in practice; thus, fluid mixing will be given most coverage here. Many mixing process results can be designed a priori, by using the mixing literature without resorting to experimental studies. These include agitator power requirements, heat transfer, liquid-liquid blending, solids suspension, mass transfer to

suspended particles, and many solid-solid applications. However, many other applications invariably involve experimental work followed by scale-up. These include liquid-liquid, gas-liquid, and fast competitive chemical reactions. Scale-up is addressed here, and, as we cover scaleup, the reader will discover that an understanding of mixing fundamentals is essential to the proper handling of scale-up.

This introduction would be incomplete without a short discussion of the place of this chapter in the toolbox of the practicing engineer. Today's engineer is faced with the daunting task of separating the truly practical and immediately useful design methods from the voluminous available literature. For example, the recent *Handbook of Industrial Mixing* (Paul et al., 2004) is comprised of 1,377 pages devoted only to the topic of Mixing and Agitation. Some of the coverage in that tome can be used with a minimum of effort; however, much of the coverage includes a literature survey with little emphasis on sifting the “truly useful” from the “mundane and ordinary.” It is our intent here to sift through the entire literature in the field of Mixing and Agitation and present only that material which is most useful to the busy practicing engineer and to present worked examples that apply the design methods.

In addition to the *Handbook of Industrial Mixing* there are at least 20 Mixing and Agitation books listed in the References. In today's electronic world there are also many web sites of equipment vendors that provide very valuable vendor design information. Among those sites are www.chemineer.com, www.clevelandmixer.com, www.lighthouse-mixers.com, www.proquipinc.com, www.philadelphia-mixers.com, and www.sulzerchemtech.com. All of these mentioned sites contain product information, but the Chemineer site (to a great extent) and the Lighthouse site (to a lesser extent) contain useful design-oriented technical literature. The annual Chemical Engineering Buyer's Guide is a good source for vendor identification.

10.1. A BASIC STIRRED TANK DESIGN

Figure 10.1 gives a “typical” geometry for an agitated vessel. “Typical” geometrical ratios are: $D/T = 1/3$; $B/T = 1/12$ ($B/T = 1/10$ in Europe); $C/D = 1$ and $Z/T = 1$. This so-called typical geometry is not economically optimal for all process results (e.g., optimal C/D for solids suspension is closer to $C/D = 1/3$ than to $C/D = 1$); as appropriate, the economical optimum geometry will be indicated later. Four “full” baffles are standard; they extend the full batch height, except baffles for dished bottoms may terminate near the bottom head tangent line. Baffles are normally offset from the vessel wall about $B/6$. The typical batch is “square”—that is, the batch height equals the vessel diameter ($Z/T = 1$). The vessel bottom and top heads can be either flat or dished. For axial flow impellers (discussed later) a draft tube, which is a centered cylinder with a diameter slightly larger than the impeller diameter and about

two-thirds Z tall, is placed inside the vessel. Sivbäck and Tassik (1965, p. 283) illustrate about a dozen applications of draft tubes, and Oldshue (1983, pp. 469–492) devotes a chapter to their design.

OFF-CENTER ANGLED SHAFT ELIMINATES VORTEXING AND SWIRL

For axial flow impellers, the effect of full baffling can be achieved in an unbaffled vessel with an off-center and angled impeller shaft location. J. B. Passano of Chemineer uses the following guideline: (1) vendors normally supply a 10° angled riser (2) at the vessel top, looking along the vessel centerline, move up (a) $0.19T$ and then (b) $0.17B_0$ to the right (3) position the agitator with the angled shaft pointing left. Vendors can help to provide optimum positioning.

An offset impeller location, illustrated in Figure 10.3(b) will not totally eliminate vortexing, but it will eliminate most swirl, give

Chapter 9 Agitation And Mixing Michigan Technological

Yi-Tong Ma



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