

Contents

Glossary	III
1 Introduction	1
1.1 Motivation	2
1.2 Objective and outline	3
2 Basic principles and state of the art	5
2.1 Wood pellets as biomass fuel	5
2.1.1 Production process	7
2.1.2 Domestic delivery and storage procedure	8
2.1.3 Pellet degradation and fines formation	10
2.2 Basics of pneumatic conveying	11
2.2.1 Types of pneumatic conveying systems	11
2.2.2 Modes of flow through pipelines	13
2.2.3 Conveying characteristics	17
2.2.4 Bends in pneumatic conveying systems	18
2.3 Experimental studies and numerical examinations	21
2.3.1 Experiments on pressure drops and particle velocities	21
2.3.2 Numerical investigations	22
2.3.3 Flow through bends	25
2.3.4 Particle degradation	26
2.4 Demarcation of own thesis	30
3 Numerical methods	31
3.1 Fluid phase modelling	31
3.1.1 Governing equations	31
3.1.2 Turbulence modelling	33
3.2 Solid phase modelling	34
3.2.1 Governing equations	34
3.2.2 Contact forces	35
3.2.3 Particle shape	38
3.2.4 Neighbour and contact detection	39
3.2.5 Coordinate systems and particle orientation	41
3.3 Modelling of particle-fluid interaction	43
3.3.1 Particle-fluid interaction	43

3.3.2	Determination of porosity	49
3.3.3	Coupling implementation	50
4	Single particle degradation analysis	53
4.1	Experimental setup	53
4.2	Materials	56
4.3	Development of empirical model	57
4.3.1	Selection function	57
4.3.2	Breakage function	60
4.4	Numerical investigation	66
4.4.1	Implementation in DEM	66
4.4.2	Verification	71
5	Experimental and numerical setup for pneumatic conveying analysis	73
5.1	Experimental setup	73
5.1.1	Optical length measuring system	73
5.1.2	Pneumatic conveying test facility	79
5.2	Numerical setup	84
5.2.1	Domain and simulation parameters	84
5.2.2	Verification of the numerical models	87
5.2.2.1	Solid phase interactions	88
5.2.2.2	Settling behaviour of single particles	89
6	Conveying behaviour and particle degradation analysis	95
6.1	Overview of investigated conditions	95
6.2	Dependencies among key flow features	96
6.3	Conveying behaviour	97
6.3.1	Influence of operating conditions	97
6.3.2	Dependence on shape of pipe components	107
6.4	Particle degradation	111
6.4.1	Assumptions and simplifications	112
6.4.2	Influence of operating conditions	112
6.4.3	Dependence on shape of pipe components	122
7	Summary and outlook	129
7.1	Summary	129
7.2	Outlook	132
	List of Figures	135
	List of Tables	139
	Bibliography	141