

**PILOT FRUIT DRIER FOR LOS AZUFRES GEOTHERMAL FIELD  
MICHIOACAN, MEXICO**

**FEBRUARY 1993**

DOE/ID/13040--19

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**For  
U. S. Department of Energy  
Office of Industrial Technologies  
Washington, D.C.**

**By  
Geo-Heat Center  
Oregon Institute of Technology  
Klamath Falls, OR 97601**

**MASTER**

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**PILOT FRUIT DRIER  
for  
Los Azufres Geothermal Field  
Michoacan, Mexico**

PILOT FRUIT DRIER

For

Los Azufres Geothermal Field  
Michoacan, Mexico

Prepared For:

Gerencia de Proyectos Geotermoelectrios  
Comision Federal de Electricidad  
Morelia, Michoacan, Mexico

Prepared By:

John W. Lund, P.E.

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3201 Campus Drive  
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# **DISCLAIMER STATEMENT**

This report was prepared with the support of the U.S. Department of Energy (DOE Grant No. DE-FG07-90ID 13040). However, any opinions, findings, conclusions, or recommendations expressed herein are those of the author(s) and do not necessarily reflect the view of DOE.

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Building and Tray Design Drawings

Fan and Heat Exchanger Design for Pace Engineered Sales

Drying Fruit at the Los Azufres Geothermal Field

Letter by James Thompson

Fruit Dehydration (Bulletin 698)

## Introduction

Comision Federal de Electricidad (CFE) has a Division in charge of the exploration of a geothermal reservoir located in Los Azufres, State of Michoacan. At present, CFE is only using the steam of the wells and rejecting the hot water that comes off associated with the steam.

CFE is interested in promoting the use of the hot water in industries with high consumption of heat. So far, they have installed a chamber for drying lumber (wood) with very good results. Several local industries are interested in constructing facilities at Los Azufres and to buy the heat from CFE. They have constructed a greenhouse to grow flowers in winter and produce gladiolus bulbs.

Since the region of Los Azufres is mainly a fruit producer (peaches, pears, apples, guava, etc.), they propose to install a small "fruit drier" for demonstration purpose. They are confident that if they succeed in showing the feasibility of drying fruit with geothermal water, they will have a demand for larger drying installations.

Based on a trip to the Los Azufres geothermal field in December of 1992, a design for a pilot geothermal fruit drier was undertaken for CFE. The details of the geothermal field and the local fruit production are detailed in an attached report prepared by Engineer Miguel Rangel.

## Fruit Drying

The fruit in the area is mainly pears. Thus, the drier was designed for this purpose; however, other fruits can also be dried in the same drier.

The processing and preparation of the fruit is based on a 1946 report prepared by the California Agricultural Experiment Station (Bulletin 698). No new publications are available; however, the information is still valid according to Dr. James Thompson of the Agricultural Engineering Station at U.C. Davis. A copy of Bulletin 698 is available in the Geo-Heat Center library.

## Drying Tray Design

Two trucks will be used; each 100 cm x 100 cm by 182 cm high when loaded with trays. The truck will have a base with four casters (pivot wheels) and a detachable handle that can be attached at either end. This will allow the trucks to be reversed when halfway through the drying process time. The base will be of plywood approximately 2 cm thick. The trucks will each carry 30 trays.

The trays will be constructed of 1 cm thick plywood and have a 5 cm high by 2 cm wide wood strip attached to either edge. The plywood will have 1 cm diameter holes drilled in them for drainage.

The trays are each designed to carry approximately 13.5 kg of moist fruit, or approximately 800 kg total for the 60 trays on two trucks. These weights will vary, depending on the type of fruit and placement on the trays.

### Building Design

The drier building will be about 400 cm long, 135 cm wide and 320 cm high. The actual dimensions will depend upon the size of local building materials.

The walls will be constructed of concrete block, the ceiling and roof of timber and the floor of placed concrete. The floor will have a slight depression down the middle and slope towards the front doors for ease of cleaning. The fan motor will be housed on the roof away from the hot air stream.

The trucks and walls will be designed so that there is about 2 to 2 1/2 cm of clearance on either side and at the top.

Louvered doors will be provided for entering, recirculation and leaving air. The louvers will be manually set, but could be set automatically as controlled by temperature sensors.

### Heat Exchanger

The required air flow for fruit drying is about 152 m<sup>3</sup>/min (500 ft<sup>3</sup>/min). Assuming the trays and fruit block 70% of the tunnel, then the cross section for air flow will be 1 m x 2 m x 0.30 = 0.6 m<sup>2</sup>. Thus, a capacity of 90 m<sup>3</sup>/min (2700 ft<sup>3</sup>/min) will be needed. Converting this requirement to 3000 m (10,000 ft) elevation, a capacity of 120 m<sup>3</sup>/min (4500 ft<sup>3</sup>/min) will be necessary at Los Azufres.

A minimum 0°C (32°F) outside entering air temperature and a 71°C (160°F) drying temperature was assumed. The geothermal resource was assumed to enter at 121°C (250°F) and exit at 99°C (210°F). Based on these assumptions, the required heat exchanger will need two rows of 8 tubes at 91 x 91 cm (36 x 36 in) cross sections.

The geothermal flow rate can be adjusted by a valve to compensate for changing outside air temperature. A three-way valve with a temperature sensor could be used for automatic control.

The coil model number from Pace is: 82HW-36.0 x 36.0 - A-6/8. The estimated price is \$800; however, it can probably be purchased for less.

#### Fan Unit

The tube axial fan was designed for 120 m<sup>3</sup>/min (4500 ft<sup>3</sup>/min) and 2 cm (3/4 inch) of water pressure loss (air flow friction loss). This will require 1.05 BHP or a 1.5 hp motor. The fan will be 45 cm (18 inches) in diameter and have 5 blades with a 10.5° blade tip pitch. Due to the high temperature of the air flow, the fan motor will have to be located on top of the building outside of the air stream. Details of the fan and housing are on the attached diagram.

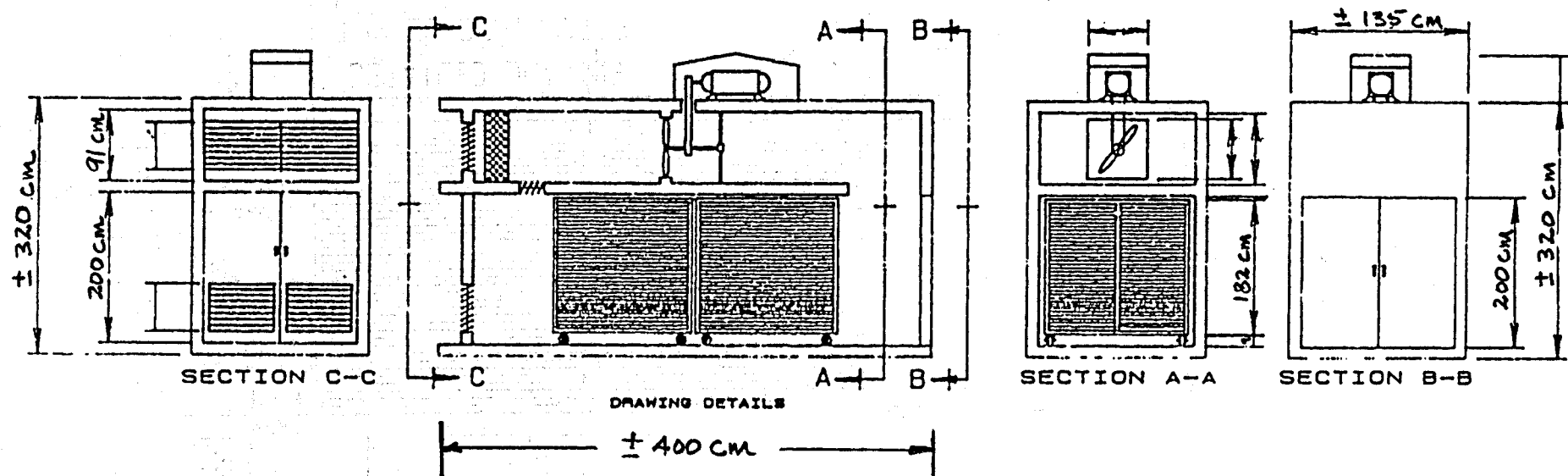
The estimated cost is \$1650, but this again is probably high. The fan specification from Pace is: 18D-6H-5R11-10.5T.

#### Construction and Operation

It is estimated that this unit will be constructed with local materials during the Spring of 1993. Operation will begin for the Summer/Fall 1993 harvest season.

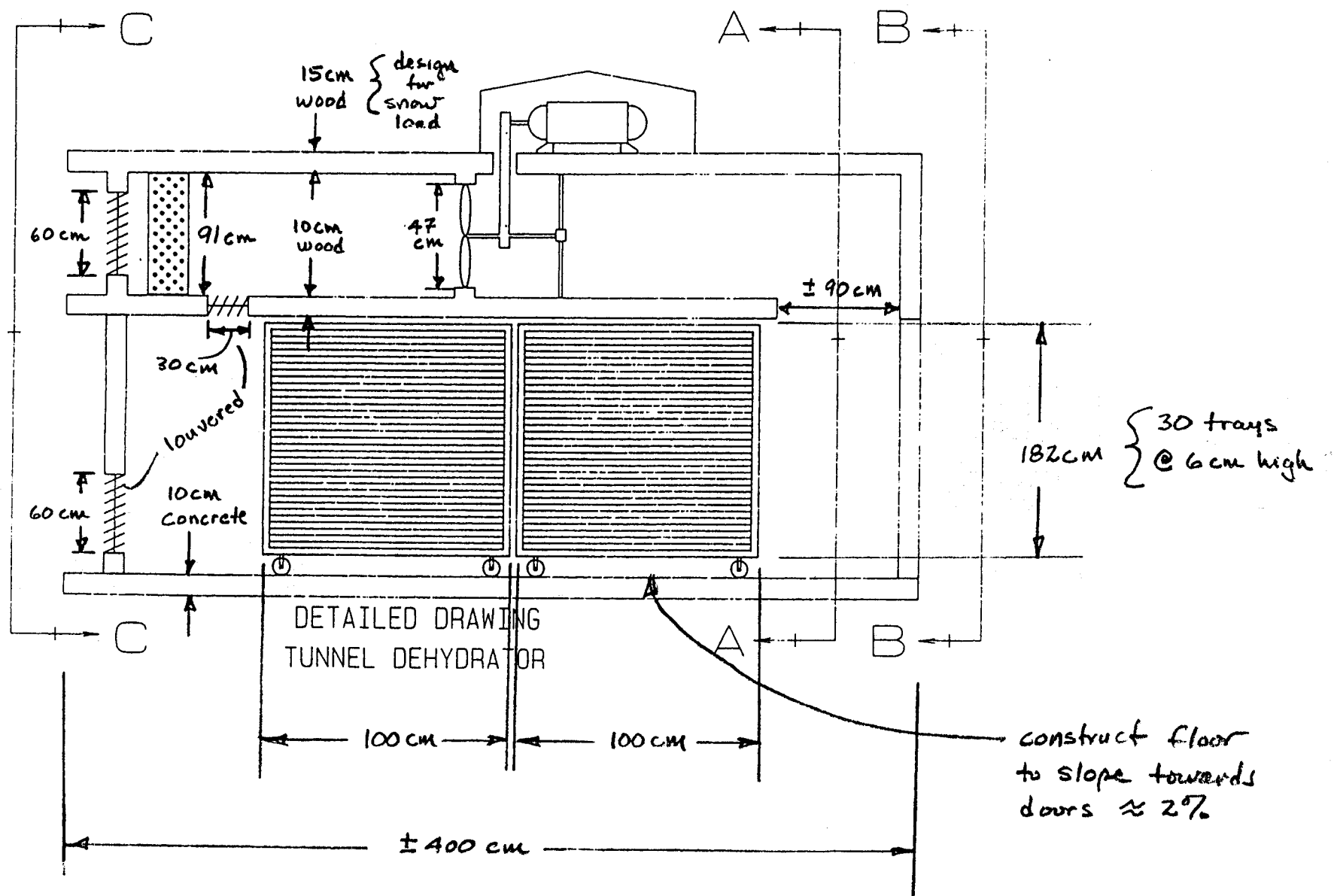
The actual temperature and air flow rates will have to be adjusted by trial-and-error to achieve the proper final product in terms of moisture and color.

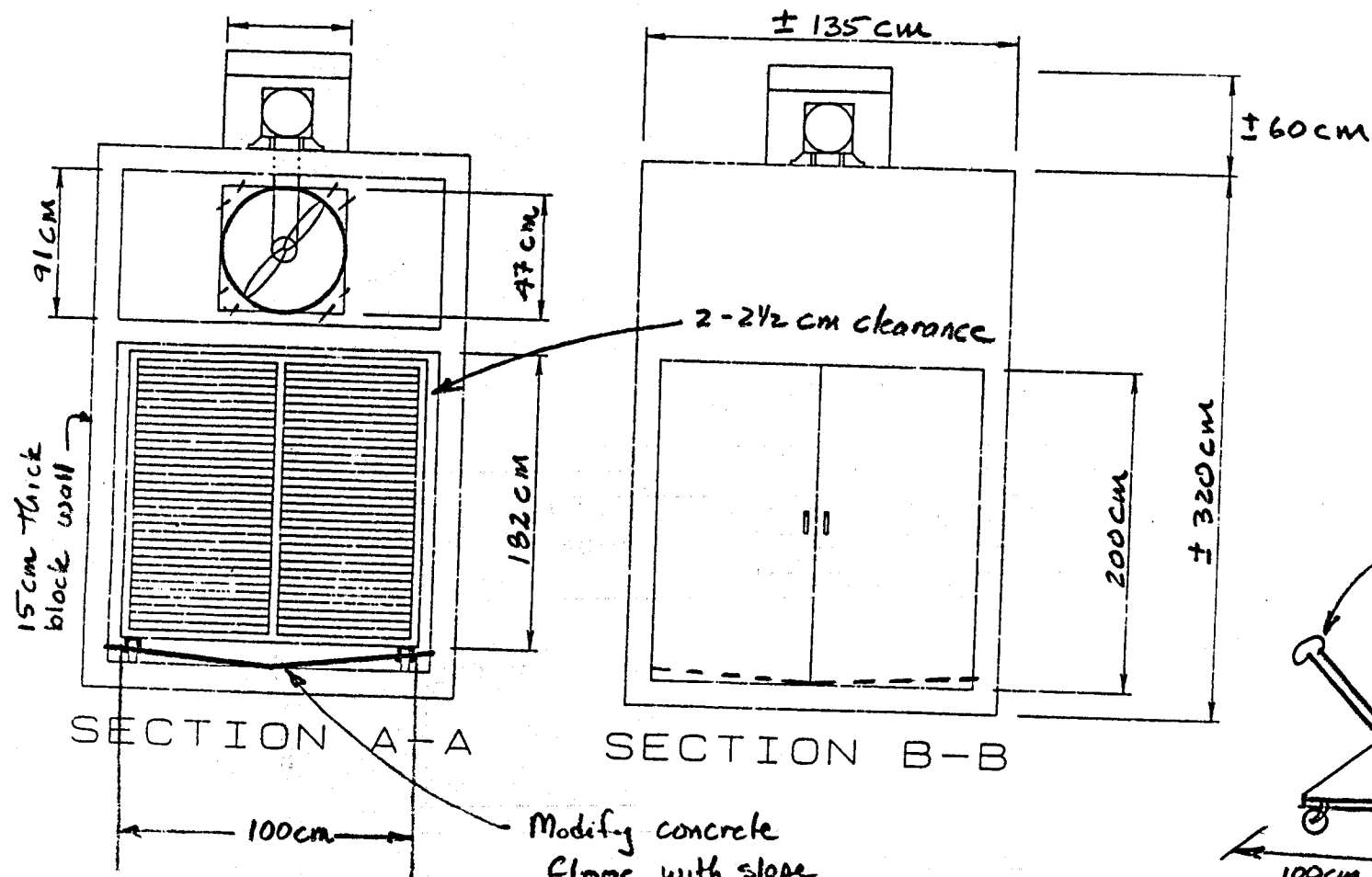
## **APPENDIX**



# TUNNEL DRYER

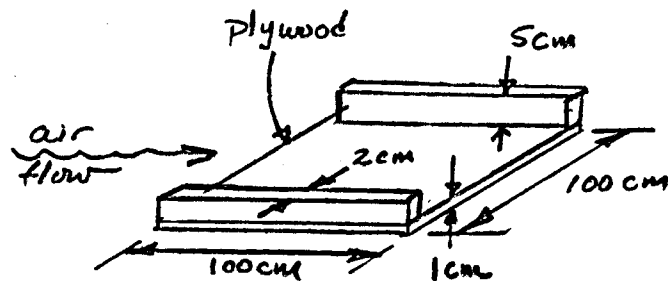
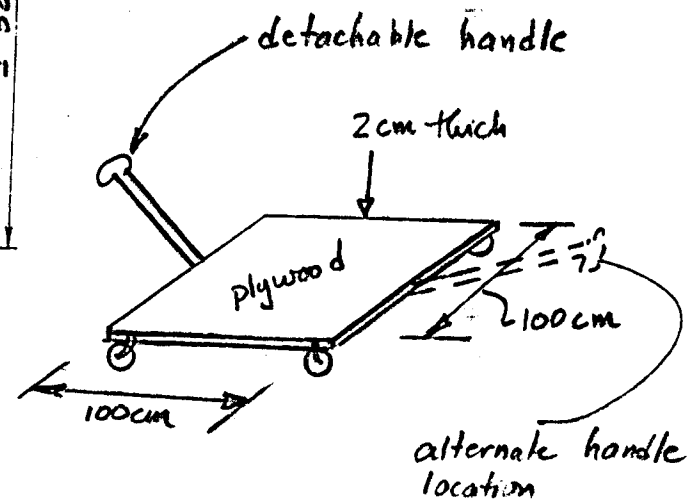
Tunnel Dryer,  
Design Details



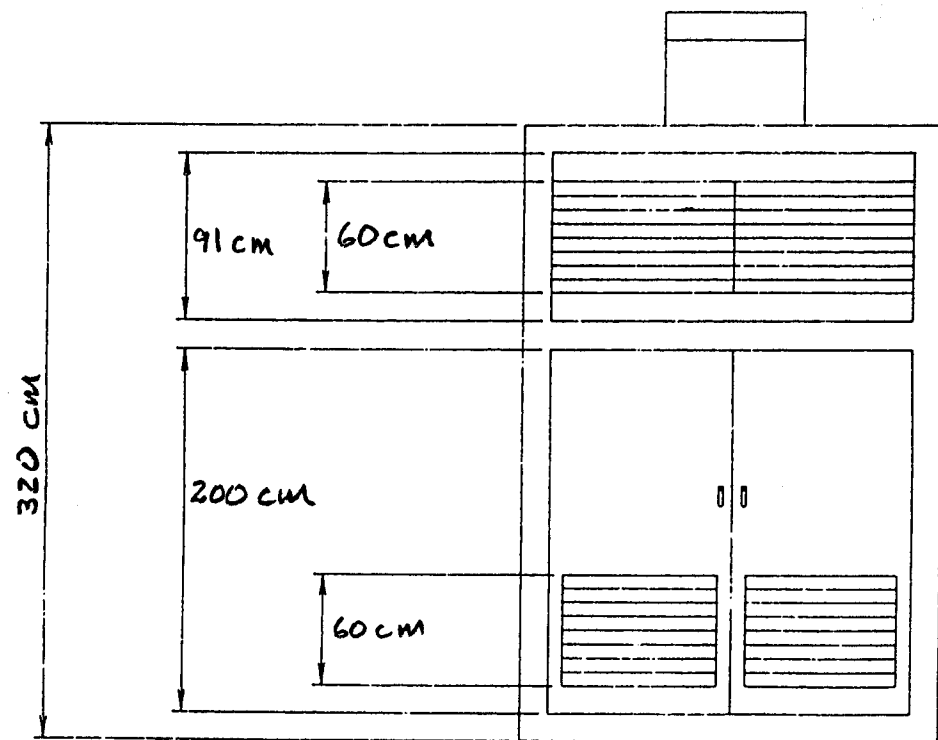


Modify concrete floor with slope to center.

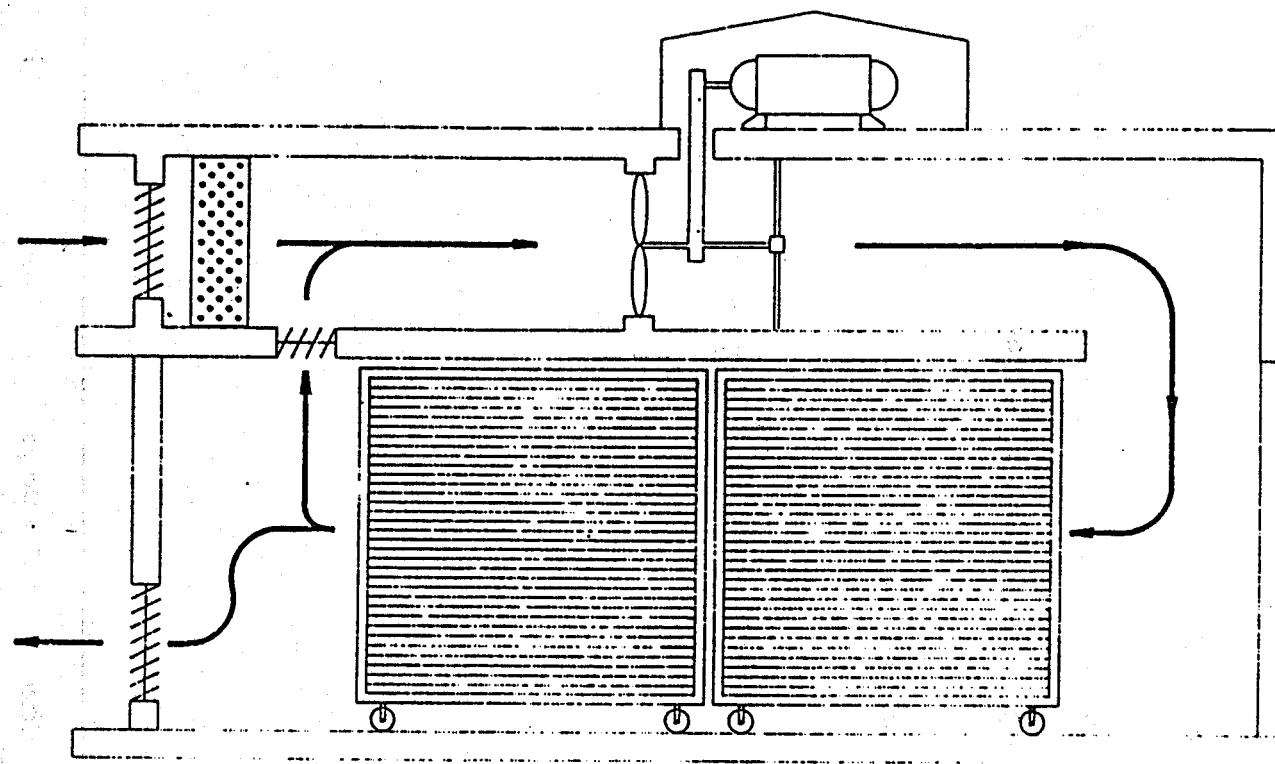
### TRUCK BASE DESIGN



### TRAY DESIGN (30 per truck)



SECTION C-C



AIR FLOW PATTERN



PACE Engineered Sales  
9460 S.E. Lawnfield  
Clackamas, Oregon 97015  
Phone (503) 652-7177  
Fax (503) 652-7195

Budget Pricing

~~FAN 1655 1754~~

To: John Lund

Re: Fan Selection/pricing, Coil pricing

Please see fan curve attached, budget price for one 18D-6H-5R11-10.5T Tube Axial PACE Fan, \$1650.

Budget price for one 82 HW 36 x 36 A 6/8 Hot Water Coil, \$795.

Please give me a call if you have any questions.

Cheers,

American Stabilis  
CAM-FARR  
Cesco  
Cosatron  
Engwald  
Fiber Bond

Hermadifier  
Indecon  
Louvers & Dampers  
Markel  
Patterson-Kelley  
Ted Reed Thermal

Flow Design  
-AutoFlow  
-FlowSet  
Reliance Electric  
Safe-Air, Inc.  
Thycurb  
Vari-Cool

Carnes  
-GRD's  
-Exhaust Fans  
-Humidifiers  
-Louvers  
-Terminal Units

PACE  
-Air Handlers  
-Industrial Fans  
-H/C Coils  
-Louvers/Dampers  
-GEM Components

1/ 5/93 @ 17:01

B-R-O-D & Mc-C-L-U-N-G P-A-C-E C-O

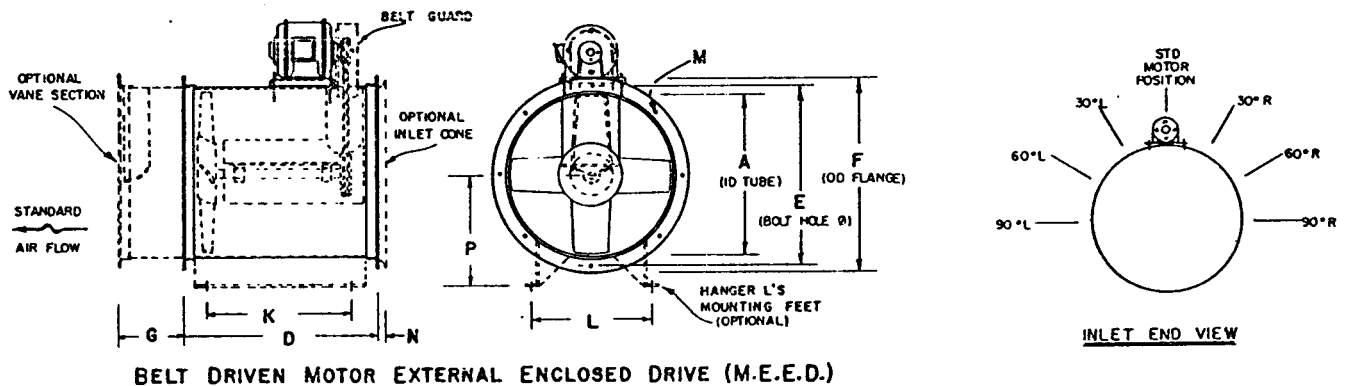
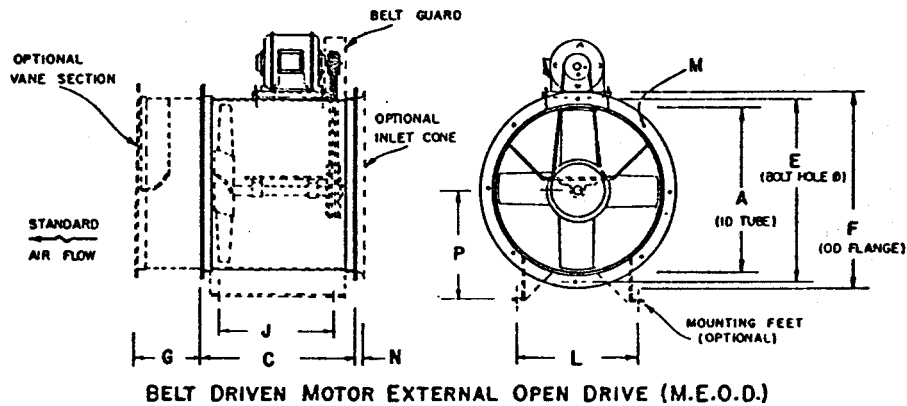
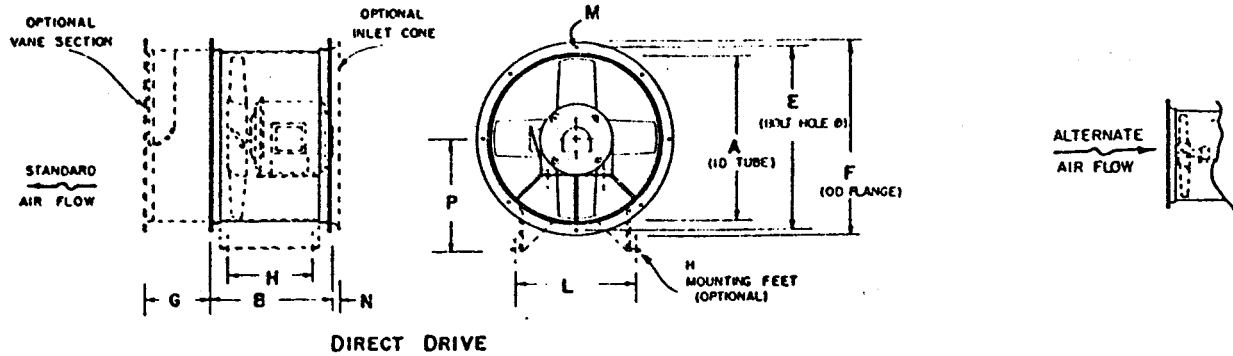
C-O-I-L S-E-L-E-C-T-I-O-N P-R-O-G-R-A-M  
W-A-T-E-R H-E-A-T-I-N-G & S-E-N-S-I-B-L-E C-O-O-L-I-N-G  
\*\*\*\*\*

-PACE Coil Model Number-

B 2 HW - 36.0 X 36.0 -\_A- 6/ 8

| Item Number Identifier                        | Fruit Dryer |
|-----------------------------------------------|-------------|
| Standard Air Flow Rate (CFM)                  | 2666.       |
| Actual Air Flow Rate (CFM)                    | 4500.       |
| Elevation (Ft)                                | 10000.      |
| Density Ratio                                 | .592        |
| This selection is for DRAW-Thru Configuration |             |
| Entering Air Dry Bulb Temperature (F)         | 32.0        |
| Leaving Air Dry Bulb Temperature (F)          | 159.5       |
| Entering Water Temperature (F)                | 250.0       |
| Leaving Water Temperature (F)                 | 210.0       |
| Total BTU/HR for Each Coil                    | 370616.     |
| Gallons per Minute Each Coil                  | 18.53       |
| Gallons per Minute per Feed                   | 3.09        |
| Coil Face Area (Sq. Ft.)                      | 9.00        |
| Standard Face Velocity (FPM)                  | 296.2       |
| Actual Face Velocity (FPM)                    | 500.0       |
| .....                                         |             |
| Rows Required for 8 -FPI                      | 2.00        |
| Rows Required for 10-FPI                      | 1.66        |
| Rows Required for 12-FPI                      | 1.43        |
| .....                                         |             |
| Air Pressure Drop @ 8-FPI (In WG)             | .10         |
| Number of Tubes Fed (circuits)                | 6           |
| Number of Passes                              | 8           |
| Water pressure Drop (Ft. of H2O)              | 2.82        |
| Connection Size (In)                          | 1.50        |

# TUBE AXIAL FANS "TA"

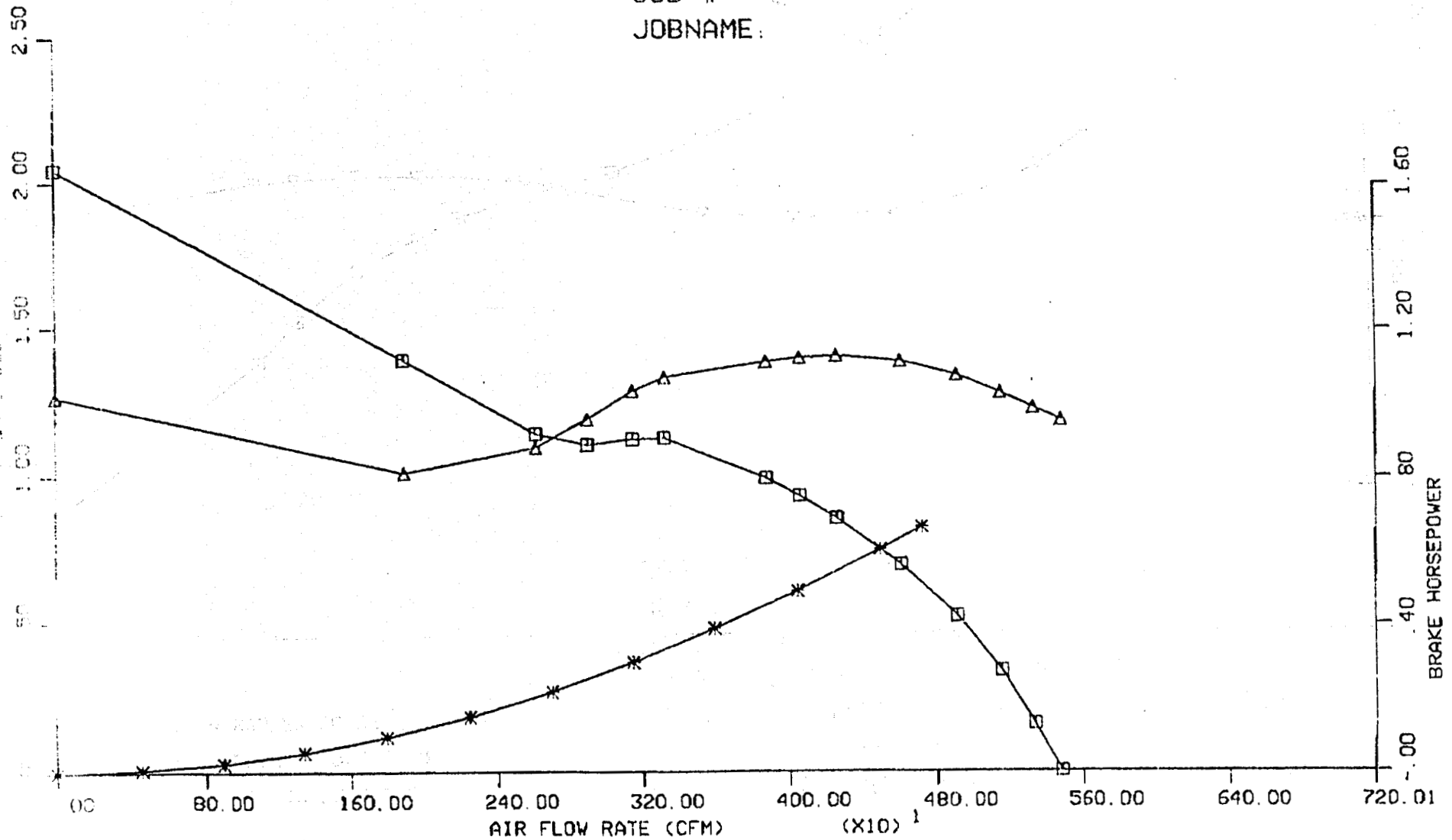


| SIZE | A      | B  | C      | D  | E       | F       | G      | H  | J      | K  | L      | M           | N | P        | SHAFT   |
|------|--------|----|--------|----|---------|---------|--------|----|--------|----|--------|-------------|---|----------|---------|
| 15   | 15-3/8 | 15 | 25-1/2 | 32 | 16-9/16 | 17-9/16 | 8      | 11 | 21-1/2 | 28 | 12-1/2 | 8 - 3/8" Ø  | 3 | 11-3/4   | 1-7/16  |
| 18   | 18-3/8 | 16 | 26     | 32 | 19-9/16 | 20-9/16 | 8-1/2  | 12 | 22     | 28 | 14-1/2 | 8 - 3/8" Ø  | 3 | 13-1/4   | 1-7/16  |
| 21   | 21-3/8 | 19 | 27-1/2 | 32 | 23-1/16 | 24-9/16 | 9      | 14 | 22-1/2 | 27 | 16-3/4 | 8 - 1/2" Ø  | 3 | 14-3/4   | 1-7/16  |
| 24   | 24-3/8 | 19 | 28     | 32 | 26-1/8  | 27-5/8  | 9-1/2  | 14 | 23     | 27 | 19     | 8 - 1/2" Ø  | 3 | 16-5/16  | 1-7/16  |
| 27   | 27-3/8 | 20 | 28-1/2 | 32 | 29-1/8  | 30-5/8  | 10     | 15 | 23-1/2 | 27 | 21     | 8 - 1/2" Ø  | 3 | 17-13/16 | 1-7/16  |
| 30   | 30-3/8 | 23 | 29     | 32 | 32-1/8  | 33-5/8  | 10-1/2 | 18 | 24     | 27 | 23-1/8 | 8 - 1/2" Ø  | 4 | 20-5/16  | 1-7/16  |
| 32   | 32-3/8 | 23 | 29-1/2 | 32 | 34-1/8  | 35-5/8  | 10-1/2 | 18 | 24-1/2 | 27 | 24-1/2 | 8 - 1/2" Ø  | 4 | 21-5/16  | 1-7/16  |
| 34   | 34-3/8 | 23 | 30-1/2 | 41 | 36-1/8  | 37-5/8  | 11     | 18 | 25-1/2 | 36 | 26     | 8 - 1/2" Ø  | 4 | 22-5/16  | 1-11/16 |
| 36   | 36-3/8 | 27 | 32     | 41 | 38-3/4  | 39-3/4  | 11-1/2 | 22 | 27     | 36 | 27-1/2 | 16 - 1/2" Ø | 4 | 23-3/8   | 1-11/16 |
| 40   | 40-3/8 | 27 | 34     | 51 | 42-3/4  | 44-3/4  | 12     | 21 | 28     | 45 | 30-3/8 | 16 - 1/2" Ø | 4 | 25-3/8   | 1-15/16 |
| 44   | 44-3/8 | 29 | 34-1/2 | 51 | 46-3/4  | 48-3/4  | 12-1/2 | 23 | 28-1/2 | 45 | 33-1/8 | 16 - 1/2" Ø | 5 | 28-3/8   | 1-15/16 |
| 48   | 48-1/2 | 29 | 35     | 51 | 50-7/8  | 52-7/8  | 13     | 23 | 29     | 45 | 36     | 16 - 1/2" Ø | 5 | 30-1/2   | 1-15/16 |
| 54   | 54-1/2 | 31 | 37     | 58 | 57-3/8  | 59-7/8  | 14     | 24 | 30     | 51 | 40-3/8 | 16 - 1/2" Ø | 5 | 33-7/16  | 1-15/16 |
| 60   | 60-1/2 | 33 | 38     | 64 | 63-3/8  | 65-7/8  | 15     | 26 | 31     | 57 | 44-1/2 | 16 - 1/2" Ø | 5 | 36-7/16  | 2-3/16  |
| 66   | 66-1/2 |    | 39     | 64 | 69-3/8  | 71-7/8  | 16     |    | 32     | 57 | 51     | 16 - 1/2" Ø | 5 | 39-1/2   | 2-3/16  |
| 72   | 72-1/2 |    | 40     | 64 | 75-3/8  | 77-7/8  | 17     |    | 33     | 57 | 52-3/4 | 16 - 1/2" Ø | 5 | 42-1/2   | 2-3/16  |
| 84   | 84-1/2 |    | 44-1/2 | 88 | 87-3/8  | 89-7/8  | 18-1/2 |    | 37-1/2 | 81 | 61-1/4 | 24 - 1/2" Ø | 5 | 48-1/2   | 2-7/16  |

Sea Level

- = STATIC PRESSURE
- △ = BRAKE HORSEPOWER
- \* = SYSTEM CURVE

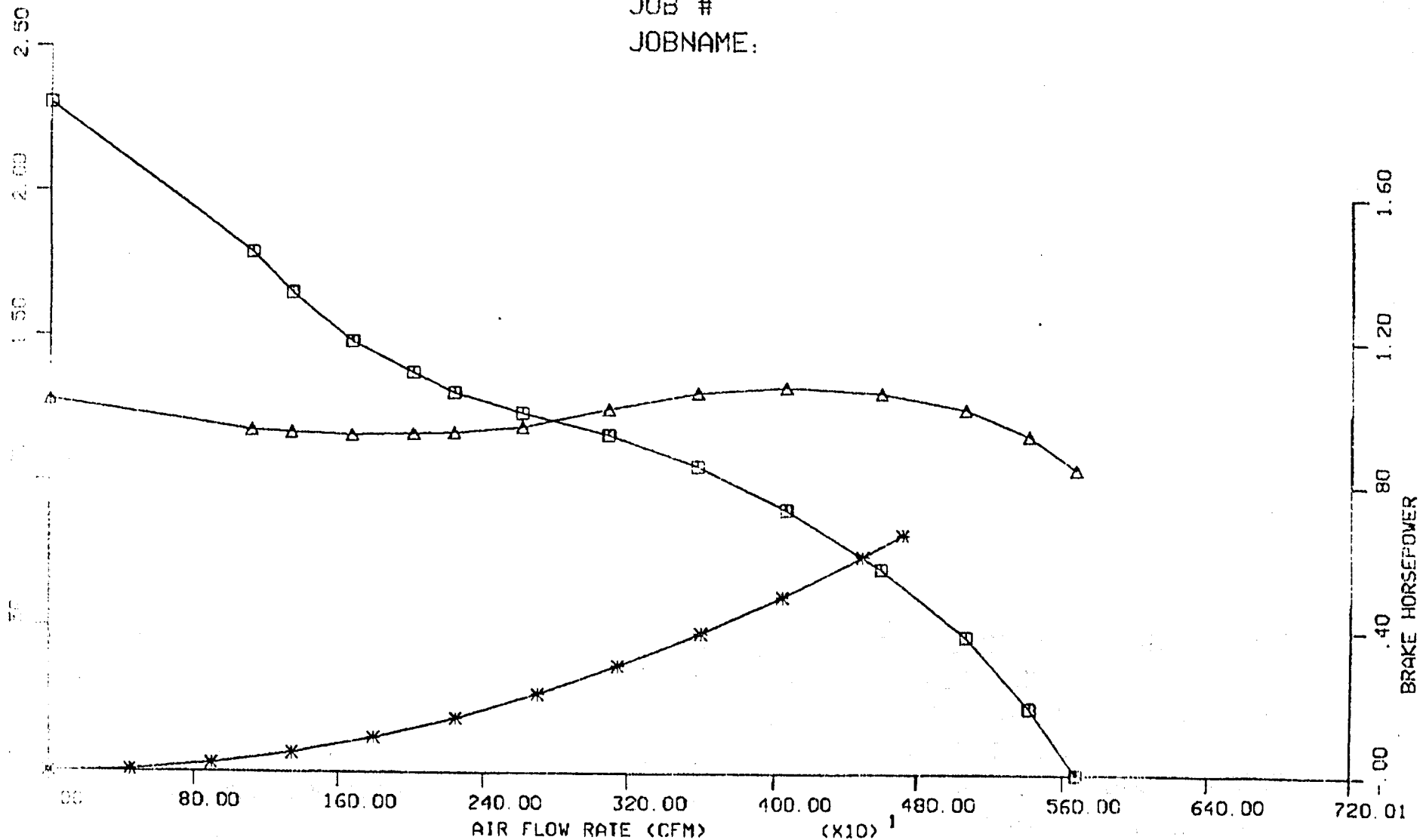
BROD & McCLUNG - PACE Co. PORTLAND, OR  
SIZE 18D-6H-5R11-17.5T  
2287 RPM .0750 #/CF INLET AIR DENSITY  
INLET VOLUME = 4500 CFM BHP = 1.11  
DISCHARGE STATIC PRES. = 0.750 IN. W.G.  
JOB #  
JOBNAME:



10,000 ft

- = STATIC PRESSURE
- △ = BRAKE HORSEPOWER
- \* = SYSTEM CURVE

BROD & McCLUNG - PACE Co. PORTLAND, OR  
SIZE 18D-6H-5R11-10.5T  
3158 RPM .0451 #/CF INLET AIR DENSITY  
INLET VOLUME = 4500 CFM BHP = 1.05  
DISCHARGE STATIC PRES. = 0.750 IN. W.G.  
JOB #  
JOBNAME:



## DRYING FRUIT AT THE LOS AZUFRES GEOTHERMAL FIELD

### 1.- SCOPE OF THE PROJECT

Comision Federal de Electricidad (CFE) has a Division in charge of the exploration of a geothermal reservoir located in Los Azufres, State of Michoacan.

At present CFE is only using the steam of the wells and rejecting the hot water that comes off associated with the steam.

CFE is interested in promoting the use of the hot water in industries with high consumption of heat. So far we have installed a chamber for drying lumber (wood) with very good results. Several local industrials are interested in constructing their own in Los Azufres and to buy the heat from CFE. We also construted a green house to grow flowers in winter and produce gladiolous bulbs.

Since the region of Los Azufres is mainly a fruit producer (peaches, pears, apple, guava, etc...) we have plans to instal a small "Fruit dryer" for demosfration purpose. We are confident that if we succed in showing the feasibility to dry fruit with geothermal steam, we will have a big demand of heat for big drying factories.

In this report we present the basic information of the field, the heat and the fruits, expecting to receive a proposal with the minimun size of a drying plant, for demostration purpose, having in mind that CFE will promote this industry for wide application in Michoacan State.

## 2.- GEOGRAPHICAL

The Los Azufres geothermal field is located in the Michoacan State at the southwest of the Mexican Republic (Fig. 1). The most important city of Michoacan is Morelia, which is located approximately 80 Km away from Los Azufres (Fig. 2). The city population is around 1,000,000 inhabitants.

The distance between Morelia and Mexico City is approximately 300 Km. Communication between this two cities is wide, there are three daily flights and the road conditions are excelent. Going by car it takes approximately 4 hours.

## 3.- ATMOSPHERIC CONDITIONS

Average conditions from 1983 to 1990.

|                                |       |     |      |
|--------------------------------|-------|-----|------|
| Atmospheric pressure           | 0.73  | bar |      |
| Maximum temperature            | 31    | °C  | 88°F |
| Minimum temperature            | -4    | °C  | 25°F |
| Mean anual temperature         | 12    | °C  | 54°F |
| Anual precipitacion            | 1,171 | mm  |      |
| Relative Humidity (anual mean) | 63    | %   |      |
| Mean wind speed                | 2.2   | m/s |      |

Figs. 4 and 5 show the dry bulb temperature and the relative humidity evolution along the year.

#### 4.- STEAM AND BRINE PRODUCTION

The field has 63 geothermal wells at an average depth of 2,100 m (Fig. 3). The total steam production is 1,550 t/h with a noncondensable gases content of 3 % by weight, which are composed of 97 %  $\text{CO}_2$  and 3 %  $\text{H}_2\text{S}$ . The field brine production is 1,600 t/h at a separation temperature of 170 °C.

The brine production by well is approximately 50 t/h.

##### BRINE CHEMICAL COMPOSITION (pmm)

|                |          |
|----------------|----------|
| PH             | 7.2      |
| EC             | 12,500.0 |
| Cl             | 4,399.0  |
| B              | 365.4    |
| $\text{HCO}_3$ | 83.2     |
| $\text{SiO}_2$ | 1,050.4  |
| $\text{SO}_4$  | 22.8     |
| Na             | 2,321.4  |
| K              | 628.0    |
| Li             | 31.8     |
| Rb             | 5.4      |
| Cs             | 4.1      |
| Ca             | 16.4     |
| As             | 28.2     |
| Mg             | 0.03     |

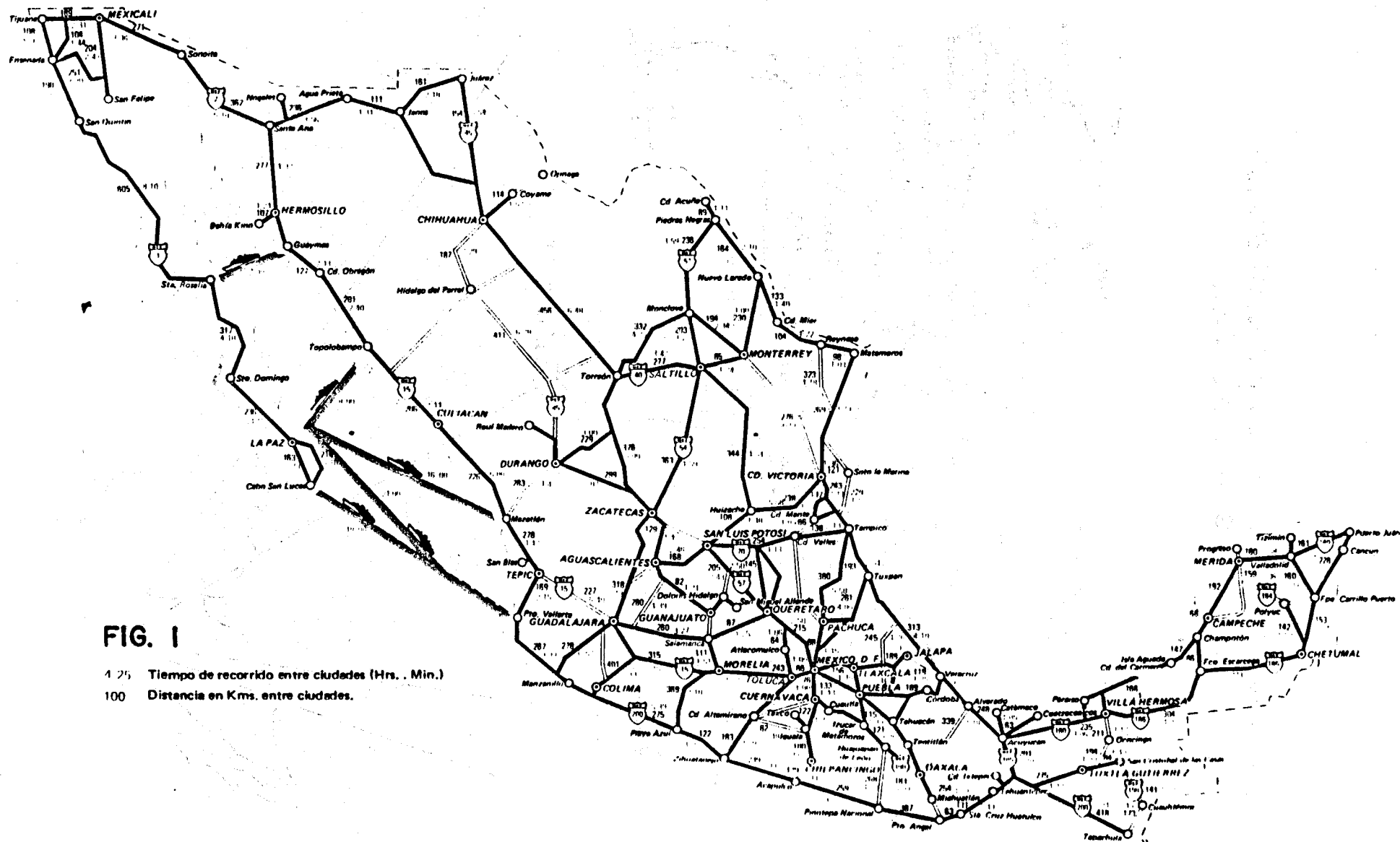
## 5.- FRUIT TO DRY

At present, the anual fruit production of the area are the following:

|         | <u>Kg/year</u> |
|---------|----------------|
| - Pear  | 15,000,000     |
| - Peach | 1,350,000      |
| - Guava | 900,000        |
| - Apple | 140,000        |
| - Prune | 5,000,000      |

According with recent studies, drying necessities in some cases are estimated in 40 % of the anual production.

# TIEMPOS DE RECORRIDO



**FIG. 2. LOCALIZACION DEL CAMPO GEOTERMICO  
DE LOS AZUFRES, MICH.**

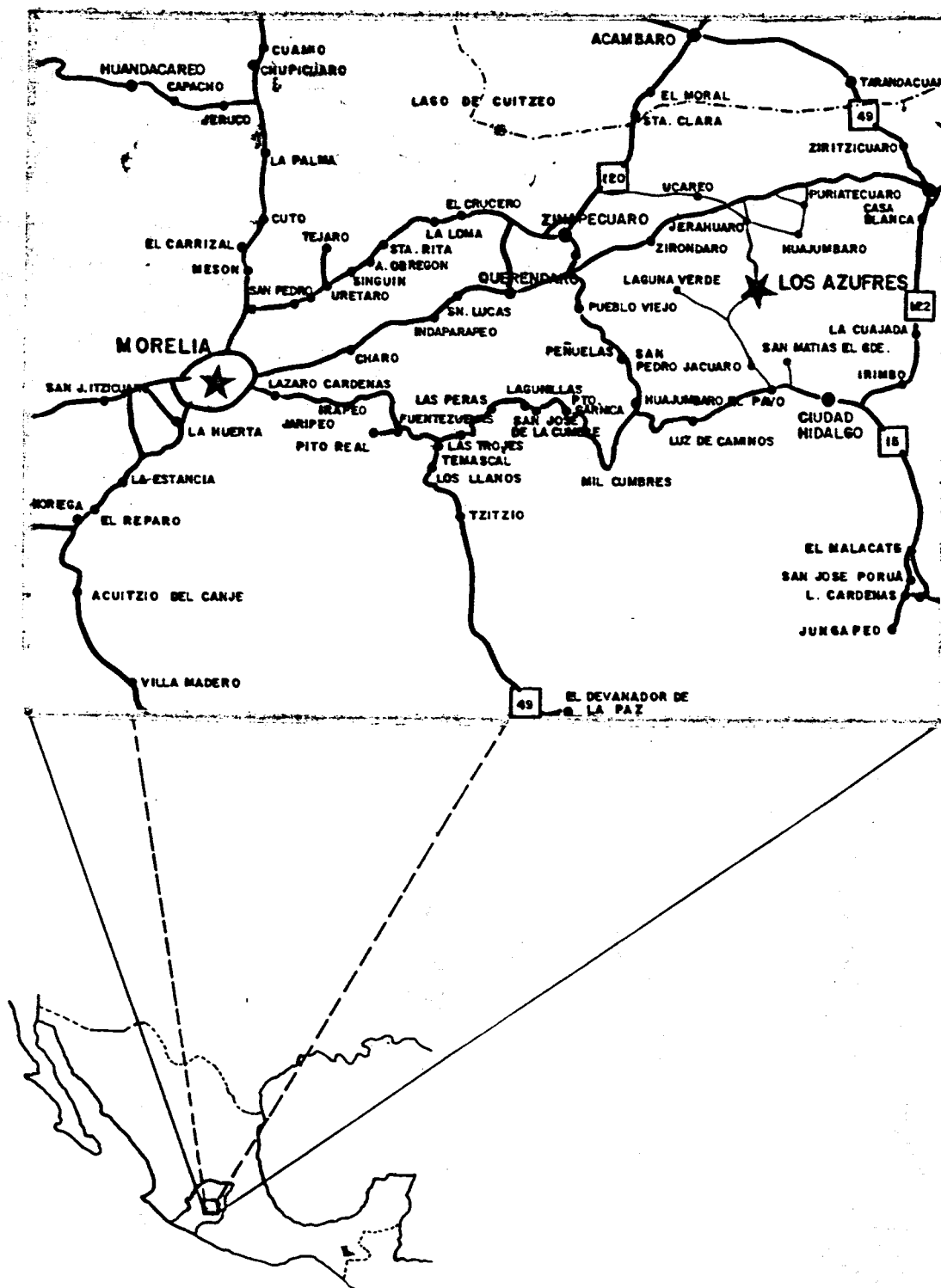




FIG. 4 TEMPERATURA DE BULBO SECO ESTACION TEJAMANILES  
 PERIODO 1982 - 1986  
 T.B.S MEDIA ANUAL = 7.8 °C

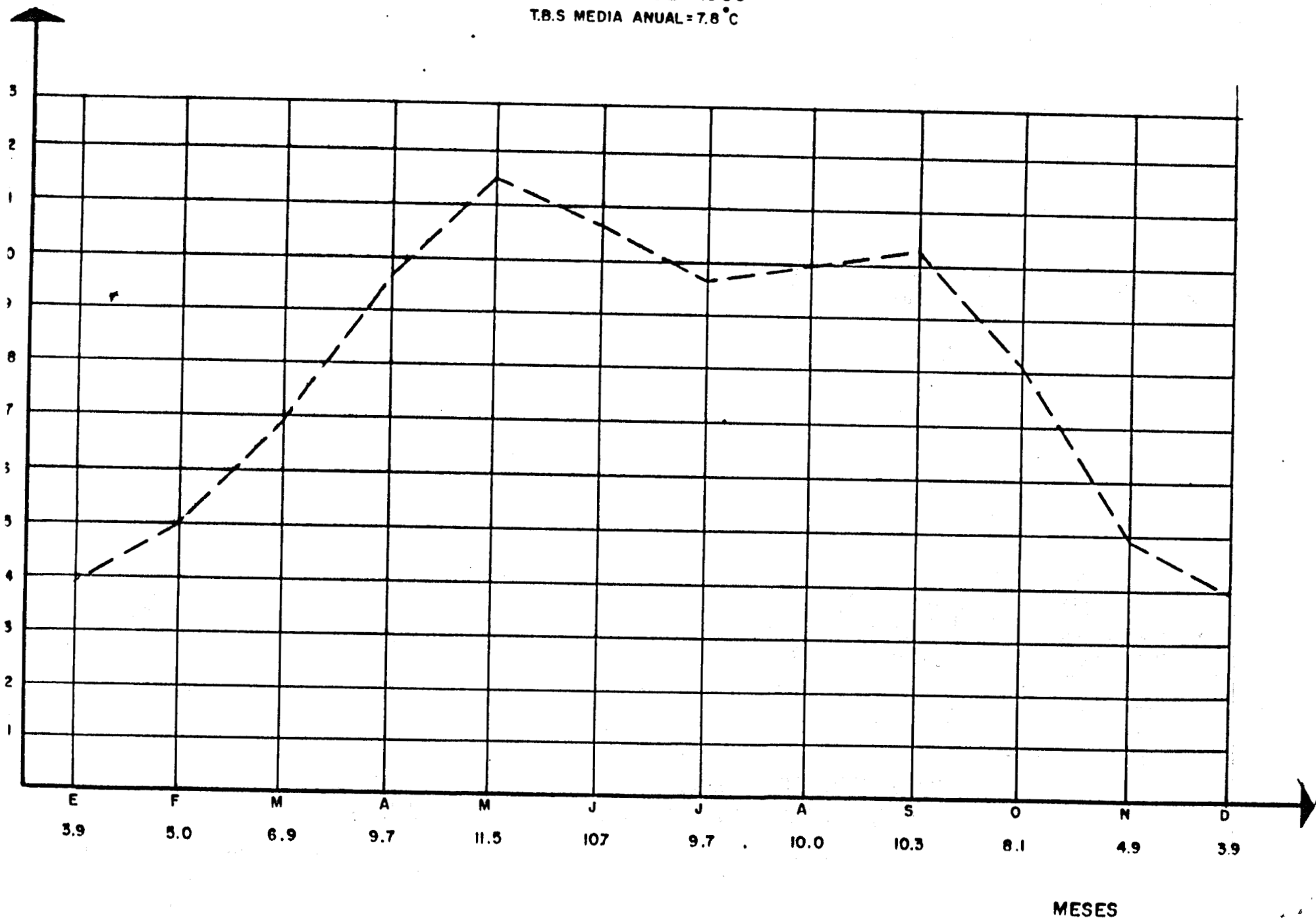
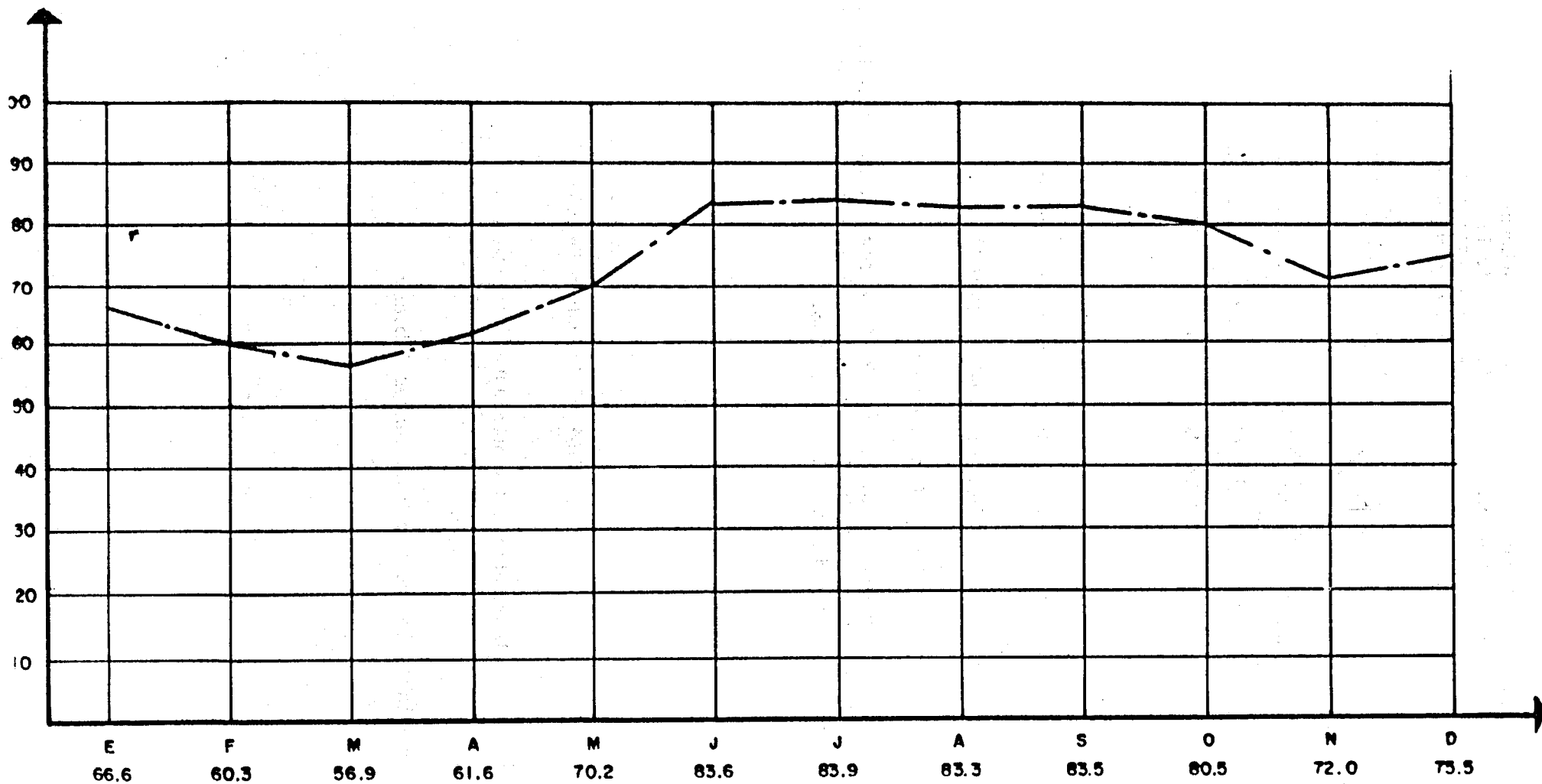


FIG. 5 HUMEDAD RELATIVA ESTACION TEJAMANILES  
PERIODO 1982 - 1986  
H.R. MEDIA ANUAL = 73.1 %



M E S E S

AP-TJ-0189

COOPERATIVE EXTENSION  
UNIVERSITY OF CALIFORNIA

Agricultural Engineering Ext.  
Davis, CA 95616  
Phone: (916) 752-6167  
Fax No. (916) 752-2640

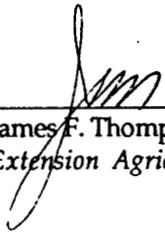
Date: 14 Jan

TO: John Lund  
Geo Heat Center  
Oregon Inst. of Tech.  
Klamath Falls, OR 97601

*Enclosed is a good reference  
on fruit drying (out of print)*

"Fruit Dehydration"

1. "Principles and Equipment" by R. L. Perry, E. M. Mrak, H. J. Phaff, G. L. Marsh, and C. D. Fisher, California Agriculture Experiment Station, Bulletin 698, December 1946.\*

  
James F. Thompson, P. E.  
Extension Agricultural Engineer

University of California and the United States  
Department of Agriculture Cooperating

\* Available in the Geo-Heat Center library.