

	<b><u>Lasheva V., Kamburov M., Bencheva S. Use of chitosan in the composition of paper packaging.....</u></b>	<b>117</b>
1.	<b><u>Luchian M., Stefanov S., Litovchenko I., et al. Modeling of mixing bread dough process using computational techniques.....</u></b>	<b>123</b>
2.	<b><u>Lungu C., Pricop E. Mechanical effects of power ultrasounds in food processing – a review.....</u></b>	<b>129</b>
3.	<b><u>Melenciuc M., Stoicev P., Lupaşco A., et al. Resonance technologies not just destroy but creates to (bibliographic study).....</u></b>	<b>135</b>
4.	<b><u>Melenciuc M., Stoicev P., Lupaşco A. Apication of resonace effects in food industry.....</u></b>	<b>141</b>
5.	<b><u>Nechita P., Stanciu C., Florea T., et al. The influence of the structural properties of cellulose filtering composites on the contaminants retention in alimentary liquids.....</u></b>	<b>144</b>
6.	<b><u>Poperechnyj A., Borovkov S., Didenko M. Background of vibration exposure influence on the extraction process in the system of “solid – liquid”.....</u></b>	<b>150</b>
7.	<b><u>Poperechnyj A., Jdanov I., Shulyga A. Drying in vibroboiling layer - a promising method of sunflower seeds dehydration.....</u></b>	<b>154</b>
8.	<b><u>Poperechnyj A., Kornijchuk V., Kalarash A. Liquid materials drying in the dryer of pseodoliquified layer with an inert carrier.....</u></b>	<b>160</b>
9.	<b><u>Potapov V., Petrenko E., Shevchenko S. Modeling of deep-frying culinary products.....</u></b>	<b>164</b>
10.	<b><u>Radionenko V., Kochetov V. Possibility of usage of selective membranes for vegetable products storage.....</u></b>	<b>168</b>
11.	<b><u>Rotari E., Lupaşco A., Bernic M., et al. The analisis of the burdock roots drying process with high frequency waves.....</u></b>	<b>171</b>
12.	<b><u>Schrempf B. ATP – agreement. Refrigeration and foodstuffs – energy consumption.....</u></b>	<b>175</b>
13.	<b><u>Sliusarenco V. Oil presses from oilseeds.....</u></b>	<b>179</b>
14.	<b><u>Stanciu C., Nechita P. Air permeability of food packaging papers.....</u></b>	<b>184</b>
15.	<b><u>Stoica M., Filimon V., Alexe P., et al. High hydrostatic pressure and pulsed electric fields. An overview.....</u></b>	<b>187</b>
16.	<b><u>Taneva D., Prokopov T., Balev D., et al. Investigation of working environment parameters in meat processing.....</u></b>	<b>190</b>
17.	<b><u>Tislinscaia N., Bernic M., Lupaşco A., et al. Simulation of the drying process with the optimization of energy.....</u></b>	<b>195</b>
18.	<b><u>Zavialov V., Malejic I., Bodrov V., et al. Principles of vibroextraction and prospects of its application in food production industry.....</u></b>	<b>199</b>

## Section II

### Food Technology

1.	<b><u>Antropova L., Gladkaya A., Datkov V. Research of the process of potato washing by means of vibration.....</u></b>	<b>206</b>
2.	<b><u>Baeva M., Milkova-Tomova I., Gogova T., et al. Preparation of sponge cakes with flour of topinambur tubers.....</u></b>	<b>212</b>

# MODELING OF MIXING BREAD DOUGH PROCESS USING COMPUTATIONAL TECHNIQUES

\*<sup>1</sup>Luchian Mihaela, <sup>2</sup>Stefanov Stefan, <sup>3</sup>Litovchenko Igor, <sup>2</sup>Michailov Ivan,  
<sup>2</sup>Hadgijski Wilhelm

<sup>1</sup>Transilvania University of Brasov – Brasov, Romania

<sup>2</sup>University for Food Technologies – Plovdiv, Bulgaria

<sup>3</sup>National University of Food Technologies – Kyiv, Ukraine

\*Luchian Mihaela, [m\\_luchian@yahoo.com](mailto:m_luchian@yahoo.com)

**Abstract:** Mixing theory is important for its relevance in understanding some of the most fundamental problems involving bread dough flows, and for its practical impact in connection with bakery industry and other food industries. Mixing is a crucial operation in the bakery industry. The bread dough is a very complex material, considered viscoelastic whose behavior depends on moisture content and temperature. This article aim is to develop advanced technology for modeling bread dough mixing, in order to provide a predictive capability of optimum design parameters of dough mixers using computational techniques.

**Key words:** mixing, bread dough, modeling, simulation, Flow Vision.

## 1. Introduction

Computational techniques used for studying mixing process is a powerful tool that is used to mathematically model fluid flows of different mixing arms designs in mixing tanks. [4], [5]

Mixing of bread dough is a common operation in bread making industries. Understanding the bread dough motion in these tanks is critical for equipment design, scale-up, process control and economic factors.

Computational techniques used for studying mixing process allow us to see what is taking place in the mixing vessel.

The results enable an engineer to select the best mixing arm design to obtain the desired process performance. The movements of bread dough in mixing tanks are complex, which makes computational techniques used for mixing a time-consuming process. It may need a long time to define all of the equations and run the program.

## 2. Computer simulation

Many modeling studies have focused on bread baking stage in order to predict heat flow and expansion of dough during thermal accumulation. Mixing parameters are external factors for mixing operation that may adapt to the requirements of mixing in correlation with physical and chemical composition of wheat flour dough.

The dimensions of the mixing space and the amounts of mixed materials play important role in dough formation and influence its properties. Many researches have been done and studied the flow of material by numerical simulation and mixing mechanism in conventional mixers or extruders. [7]

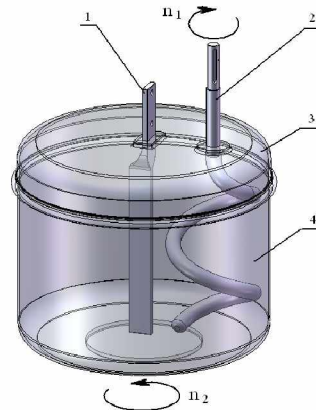
This study approach three-dimensional numerical simulation of dough mixing that occurs very often in the bread processing industry. The motivation of this study is to

develop advanced technology for modeling dough mixing, in order to provide a predictive capability of optimum design parameters of dough mixers.

It was investigated a dough mixer with rotating mixing spiral arm Model SL 50 (Figure 1), placed eccentric from batter bowl.



**Fig 1.** Spiral Mixer SL 50



**Fig 2.** 3D - model of mixer  
1- opposite spiral; 2- spiral mixing; 3- lid; 4- batter bowl

The spiral mixing arm is rotating around a vertical axis in the batter bowl, considered in a vertical orientation (x, y, z), as can be seen in Figure 2.

In this study, a CFD package (Computational Fluid Dynamics) called Flow Vision was applied to build the model calculation and the calculation results. First was designed a parameterized three-dimensional geometric model of the mixer with spiral arm. For this purpose was applied a CAD software (called Solid Works), used in the design of objects with very complex geometry. Geometry from Solid Works transferred to CFD Flow Vision preprocessor package is more flexible and precise than in the case that be realized with the preprocessor itself.

The results of the simulation flow in the mixer using Flow Vision, e.g. contour lines of the component of the vector velocity and speed, are presented in next figures.

For study of the processes passing in the mixer at the time of its work, there are made computer simulations in medium of the program system Flow Vision. For the purposes of the simulations it is used the method of the finite elements. [6]

The given model describes the flowing of viscose fluid on small numbers of Max ( $M < 0.3$ ), small and big (turbulent) numbers of Reynolds. In this model are included the equations of Navier-Stokes and the energy equations.

The model of turbulent incompressible fluid is based on the using turbulent viscosity  $\mu_t$ . The determination of  $\mu_t$  depends on the chosen model of turbulence.

In the model are used the Navier-Stokes equations:

$$\frac{\partial V}{\partial t} + \nabla(V \otimes V) = -\frac{\nabla P}{\rho} + \frac{1}{\rho} \nabla((\mu + \mu_t)(\nabla V + (\nabla V)^T)) + S \quad (1)$$

$$\nabla V = 0 \quad (2)$$

where the S is equal to:

$$S = \left(1 - \frac{\rho_{hyd}}{\rho}\right)g + B + \frac{R}{\rho} \quad (3)$$

At rotating coordinate system, the force of rotating (Koriolis and centrifugal) looks like equation (4):

$$B = -2\omega V - \omega^2 r \quad (4)$$

**The equation used for energy calculation is:**

$$\frac{\partial h}{\partial t} + \nabla(Vh) = \frac{1}{\rho} \nabla \left( \left( \frac{\lambda}{C_p} + \frac{\mu_t}{Pr_t} \right) \nabla h \right) + \frac{Q}{\rho} \quad (5)$$

The simulation of the process of flowing of bread dough comprises the following steps:

- creating of a calculation field in CAD and importing through the format VRML or STL;
- setting of the mathematical models;
- setting of the boundary conditions;
- setting of the starting computing grid and criterion for its adaptation to the decision and the boundary conditions;
- setting of the parameters of the method of calculation;
- carrying out the calculation;
- presenting the results in graphical form.

The starting point of any numerical method is the mathematical model, i.e. the set of differential equations and boundary conditions. [1]

After selecting the mathematical model, it has been choose a suitable discretization method; a method of approximating the differential equations by a system of algebraic equations for the variables at some set of discrete locations in space and time. There are many approaches, but the most important of which are: finite difference (FD), finite volume (FV) and finite element (FE) methods. [6]

The discrete locations at which the variables are to be calculated are defined by the numerical grid which is essentially a discrete representation of the geometric domain on which the mixing problem will be solved. It divides the solution domain into a finite number of subdomains (elements, control volumes, etc.). [3] [8]

The method of calculation depends of the complexity of the mixing problem and used the differential equations. [2]

### 3. Results and discussion

The object of the investigation is mixing bread dough (Mixer SL 50) with the geometric and force characteristics. There have been carried out simulation studies of the processes in the mixer during its work with bread dough.

The conditions of the simulated experiment are: density of the bread dough:  $\rho_1=1100$  kg/m<sup>3</sup> and  $\rho_2=1200$  kg/m<sup>3</sup>; viscosity:  $\mu=2,61$  Pa.s; frequency of rotation of the spiral mixing:  $n_1=180$  rev/min and frequency of rotation of the batter bowl:  $n_2=30$  rev/min.

There are investigated the following indexes of the regime of the mixer:

- distribution of velocity vectors in vertical and horizontal direction of the mixer.

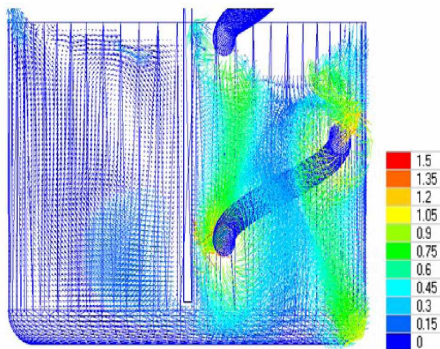
Velocity vector are determined for two densities of the bread dough  $\rho_1=1100$  kg/m<sup>3</sup> and  $\rho_2=1200$  kg/m<sup>3</sup>;

- dissipation of the kinetic energy in the mixer at a density of bread dough  $\rho_1=1100$  kg/m<sup>3</sup> and  $\rho_2=1200$  kg/m<sup>3</sup>.

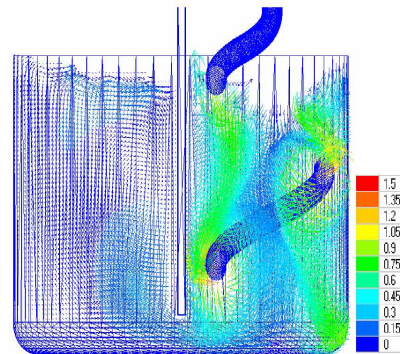
The Figures 3 and 4 are presented distribution of the velocity vectors of the bread dough flow in the vertical direction at density of the product:  $\rho_1=1100$  kg/m<sup>3</sup> and  $\rho_2=1200$  kg/m<sup>3</sup>, at maximum value of the scale of the velocity 1,5 m/s.

In the Figures 5 and 6 we can see distribution of the velocity vectors of the bread dough flow in 3D horizontal sections of the mixer at a density of the product  $\rho_1=1100$  kg/m<sup>3</sup> and  $\rho_2=1200$  kg/m<sup>3</sup>, at maximum value of the scale of the velocity 1,5 m/s.

The last Figures 7 and 8 contain the representation of dissipation of the kinetic energy in the mixer at a density of the bread dough  $\rho_1=1100$  kg/m<sup>3</sup> and  $\rho_2=1200$  kg/m<sup>3</sup>.



**Fig. 3.** Vectors of the flow velocity in vertical direction at a density of the bread dough 1100 kg/m<sup>3</sup>



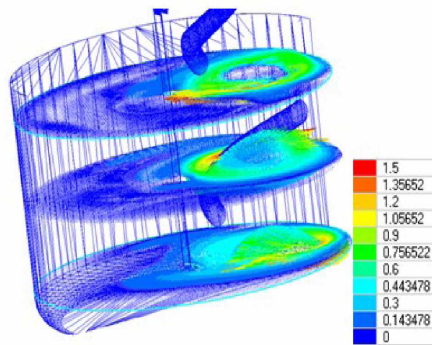
**Fig. 4.** Vectors of the flow velocity in vertical direction at a density of the bread dough 1200 kg/m<sup>3</sup>

The analysis of the distribution of the flow velocity vectors of bread dough in vertical direction of the mixer (Figures 3 and 4) reveals the existence of vertical cylindrical zones of increased pressure (0,75...1,2 m/s). This boundary layer retains higher velocity even after overshooting the mixing spiral, explaining the phenomenon with high elastic properties of the bread dough.

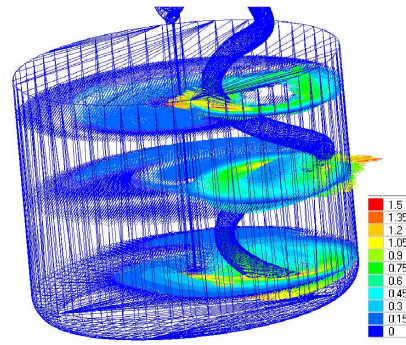
From the distribution of the velocity vectors in three horizontal sections of the mixer (Figures 5 and 6) can be concluded that the prevailing speed of the dough is 0,5...0,8 m/s. The highest values of the dough speed are observed on the surface of the spiral 1,35 m/s, it is equal to the peripheral speed of the loops. Intensive movement (mixing) of the dough

takes place only in the range of the spiral.

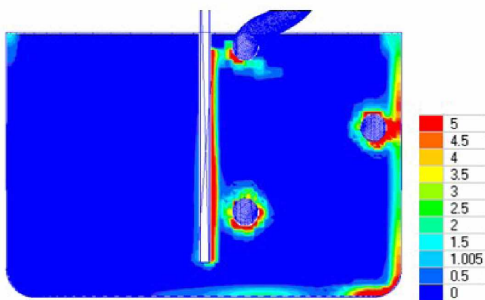
In the rest of the batter bowl the dough is put in motion by the rotation of the batter bowl due to its adhesion properties.



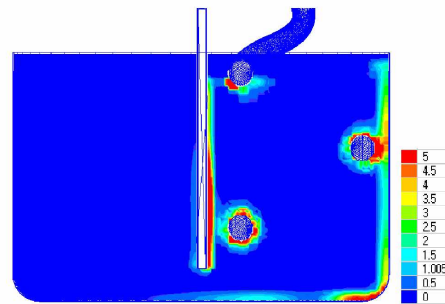
**Fig. 5.** Vectors of the flow velocity in horizontal direction at a density of the bread dough  $1100 \text{ kg/m}^3$



**Fig. 6.** Vectors of the flow velocity in horizontal direction at a density of the bread dough  $1200 \text{ kg/m}^3$



**Fig. 7.** Dissipation of the kinetic energy in the mixer at a density of bread dough  $1100 \text{ kg/m}^3$



**Fig. 8.** Dissipation of the kinetic energy in the mixer at a density of bread dough  $1200 \text{ kg/m}^3$

The dissipation of the kinetic energy (Figures 7 and 8) is proportional to the gradient of the velocity. The highest values have been observed in areas adjacent to the surface of the spiral, the opposite spiral and the walls of the batter bowl.

In the carried out simulation experiments with bread dough with different density ( $1100 \text{ kg/m}^3$  and  $1200 \text{ kg/m}^3$ ) results are not significantly different, since the change in viscosity is not significant (important) to change the picture.

The obtained results provide a possibility for optimization of this type dough mixing machines in reference to the size and proportions of the batter bowl and the working organs.

#### 4. Conclusion

The obtained results allow:

- assessing the effectiveness of the mixing process;
- removal of the areas in the batter bowl, where the working organ insufficiently treats (processes) the dough;
- assessing the size of the boundary layer; i.e. determining the minimum distance between the working organ and the batter bowl wall;
- determining the driving force of the working organ and improving of its optimum shape and geometrical parameters;
- determination of the optimum frequency of rotating of the working organ and the batter bowl

#### 5. Acknowledgements

This paper is supported by the Sectorial Operational Programme Human Resources Development (SOP HRD), financed from the European Social Fund and by the Romanian Government under the contract number POSDRU /88/1.5/S/59321: *Investment in sustainable development through doctoral scholarships INDED*.

Thanks for help to PhD Prof. Eng. Lytovchenko Igor from National University of Food Technology, Kyiv, Ukraine and also I want to thank you to Assoc. PhD Prof. Eng. Stefanov Stefan and his team from University of Food Technologies, Plovdiv, Bulgaria

#### 6. References

1. Bakker A., Cathie N., LaRoche R.: *Modeling of the Flow and Mixing in HEV Static Mixers*, 8th European Conference on Mixing, Cambridge, U.K. IChemE Symposium Series No. 136, 1994, p. 533-540.
2. Bakker A., Fasano J. B.: *Time Dependent, Turbulent Mixing and Chemical Reaction in Stirred Tanks*, Annual AIChE Meeting, Missouri, Volume 90, 1993, p. 71-78.
3. Fox, R. O.: *On the Relationship between Lagrangian Micromixing Models and Computational Fluid Dynamics*, Chem. Eng. and Proc. 37, 1998, p. 521-535.
4. Oshinowo L., Bakker A., Marshall E. M.: *Mixing Time - A CFD Approach*, Canada, 1999.
5. Read, N. K., Zhang S. X., Ray W. H.: *Simulations of a LDPE Reactor Using Computational Fluid Dynamics*, AIChE Journal 43(1), 1997, p. 104-117.
6. Versteeg, H. K., Malalasekera W.: *An Introduction to Computational Fluid Dynamics: The Finite Volume Method*, Longman Scientific & Technical, Essex, UK, 1995.
7. Yi P., Hu Y., Liu S.: *Numerical Investigation of Effect of Stirring Blades on Mixing Efficiency of a Planetary Kneading Mixer with Non-Newtonian and Viscoplastic Materials*, TheXV<sup>th</sup> International Congress on Rheology, 2008, p. 442-444.
8. Wyman, N.: CFD Review, available at <http://www.cfdreview.com>.