

**INMATEH -**

**AGRICULTURAL  
ENGINEERING**

**MAY - AUGUST**

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## *Editorial*

*The National Institute of Research-Development for Machines and Installations designed to Agriculture and Food Industry - INMA Bucharest has the oldest and most prestigious research activity in the field of agricultural machinery and mechanizing technologies in Romania.*

### *Short History*

- ✓ *In 1927, the first research Center for Agricultural Machinery in Agricultural Research Institute of Romania - ICAR (Establishing Law was published in O.D. no. 97/05.05.1927) was established;*
- ✓ *In 1930, was founded The Testing Department of Agricultural Machinery and Tools by transforming Agricultural Research Centre of ICAR- that founded the science of methodologies and experimental techniques in the field (Decision no. 2000/1930 of ICAR Manager - GHEORGHE IONESCU ȘIȘEȘTI);*
- ✓ *In 1952, was established the Research Institute for Mechanization and Electrification of Agriculture - ICMA Băneasa, by transforming the Department of Agricultural Machines and Tools Testing;*
- ✓ *In 1979, the Research Institute of Scientific and Technological Engineering for Agricultural Machinery and Tools - ICSITMUA was founded - subordinated to Ministry of Machine Building Industry - MICM, by unifying ICMA subordinated to MAA with ICPMA subordinated to MICM;*
- ✓ *In 1996 the National Institute of Research-Development for Machines and Installations designed to Agriculture and Food Industry - INMA was founded - according to G.D. no.1308/25.11.1996, by reorganizing ICSITMUA, G.D no. 1308/1996 coordinated by the Ministry of Education and Research G.D. no. 823/2004;*
- ✓ *In 2008 INMA has been accredited to carry out research and developing activities financed from public funds under G.D. no. 551/2007, Decision of the National Authority for Scientific Research - ANCSno. 9634/2008.*

*As a result of widening the spectrum of communication, dissemination and implementation of scientific research results, in 2000 was founded the institute magazine, issued under the name of SCIENTIFIC PAPERS (INMATEH), ISSN 1583 – 1019.*

*Starting with volume 30, no. 1/2010, the magazine changed its name to INMATEH - *Agricultural Engineering*, appearing both in print format (ISSN 2068 - 4215), and online (ISSN online: 2068 - 2239). The magazine is bilingual, abstract being published in native language and English, with a rhythm of three issues / year: January-April, May-August, September-December and is recognized by CNCSIS – with B<sup>+</sup> category. Published articles are from the field of AGRICULTURAL ENGINEERING: technologies and technical equipment for agriculture and food industry, renewable energy, machinery testing, environment, transport in agriculture etc. and are evaluated by specialists inside the country and abroad, in mentioned domains.*

*Technical level and performance processes, technology and machinery for agriculture and food industry increasing, according to national requirements and European and international regulations, as well as exploitation of renewable resources in terms of efficiency, life, health and environment protection represent referential elements for the magazine „INMATEH - *Agricultural Engineering*”.*

*We are thankful to all readers, publishers and assessors.*

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## CONTENT

		Page(s)
1.	<p><b>EXPERIMENTAL STUDY OF THE MOVEMENT CONTROLLABILITY OF A MACHINE-AND-TRACTOR AGGREGATE OF THE MODULAR TYPE / MODUŁA TIPY MAŠINAS – TRAKTORA AGREGATA KUSTIBAS VADIBAS EKSPERIMENTALIE PĒTĪJUMI</b></p> <p>Ivanovs S. <sup>1)</sup>, Bulgakov V. <sup>2)</sup>, Nadykto V. <sup>3)</sup>, Ihnatiev Ye. <sup>3)</sup>, Smolinskyi S. <sup>1)</sup>, Kiernicki Z. <sup>4)</sup></p> <p><sup>1)</sup> Latvia University of Life Sciences and Technologies, Latvia  <sup>2)</sup> National University of Life and Environmental Sciences of Ukraine, Ukraine  <sup>3)</sup> Dmytro Motornyi Tavria State Agrotechnological University, Ukraine,  <sup>4)</sup> Lublin University of Technology, Poland</p>	09
2.	<p><b>RESEARCH ON CHANGES IN BIOMASS DURING GASIFICATION / ДОСЛІДЖЕННЯ ЗМІНИ МАСИ РОСЛИННОЇ БІОМАСИ В ПРОЦЕСІЇ ЇЇ ГАЗИФІКАЦІЇ</b></p> <p>Genadii Golub<sup>1)</sup>, Savelii Kukharets<sup>2)</sup>, Jonas Česna<sup>3)</sup>, Oleh Skydan<sup>2)</sup>, Yaroslav Yarosh<sup>2)</sup>, Mykolai Kukharets<sup>2)</sup></p> <p><sup>1)</sup>National University of Life and Environmental Sciences of Ukraine / Ukraine,  <sup>2)</sup>Zhytomyr National Agroecological University / Ukraine,  <sup>3)</sup>Vytautas Magnus University Agriculture Academy / Lithuania</p>	17
3.	<p><b>ONLINE PARAMETER IDENTIFICATION OF RICE TRANSPLANTER MODEL BASED ON IPSO-EKF ALGORITHM / 基于 IPSO-EKF 算法的插秧机模型参数在线辨识</b></p> <p>Yibo Li <sup>*1)</sup>, Hang Li <sup>1)</sup>, Xiaonan Guo <sup>2)</sup></p> <p><sup>1)</sup> College of Automation, Shenyang Aerospace University, Shenyang / China;  <sup>2)</sup> Shenyang Aviation Xinxing Electromechanical Co., Ltd. Shenyang / China</p>	25
4.	<p><b>AN OMNI-DIRECTIONAL ELECTRIC PRUNING SAW FOR FOREST TENDING / 全方位电动打枝锯研究</b></p> <p>Qingqing Shang*, Bin Wang, Jiawei Yang, Yizhi Lu, Tongming Yin</p> <p>Nanjing Forestry University, Nanjing / China</p>	35
5.	<p><b>LABORATORY-FIELD RESEARCH RESULTS FOR ONION CLEANING / РЕЗУЛЬТАТЫ ЛАБОРАТОРНО-ПОЛЕВЫХ ИССЛЕДОВАНИЙ МАШИНЫ ДЛЯ УБОРКИ ЛУКА</b></p> <p>Alexey Semyonovich Dorokhov, Aleksey Viktorovich Sibirev, Alexander Gennadievich Aksenov, Maxim Alexandrovich Mosyakov</p> <p>FSBSI "Federal Scientific Agronomic and Engineering Centre VIM"/ Russian</p>	41
6.	<p><b>AN EXPERIMENTAL INVESTIGATION OF SOIL LAYER COUPLING FAILURE CHARACTERISTICS ON NATURAL GRASSLAND BY PASSIVE SUBSOILER-TYPE OPENERS/ 深松铲型开沟部件作用下的天然草地耦合失效试验研究</b></p> <p>Changbin He <sup>1,2)</sup>, Yong You <sup>*2)</sup>, Decheng Wang <sup>*2,3)</sup>, Hongjian Wu <sup>2,4)</sup>, Bingnan Ye <sup>2)</sup></p> <p><sup>1)</sup> Inner Mongolia Agricultural University, College of Mechanical and Electrical Engineering, Hohhot / China;  <sup>2)</sup> China Agricultural University, College of Engineering, Beijing / China; <sup>3)</sup> China Agricultural University, Key Laboratory of Grassland Management and Rational Utilization, Beijing / China; <sup>4)</sup> Tsinghua University, Dep. of Mechanical Engineering, State Key Laboratory of Tribology, Beijing / China</p>	49
7.	<p><b>PREDICTION MODEL OF AMMONIA CONCENTRATION IN YELLOW-FEATHER BROILERS HOUSE DURING WINTER BASED ON EEMD-GRU / 基于 EEMD-GRU 的黄羽鸡舍冬季氨气浓度预测模型</b></p> <p>Zeying Xu <sup>1)</sup>, Xiuguo Zou <sup>*</sup>, Zhengling Yin, Shikai Zhang, Yuanyuan Song, Jie Zhang, Jingxia Lu</p> <p><sup>1)</sup> College of Engineering, Nanjing Agricultural University / China</p>	59
8.	<p><b>TECHNOLOGY FOR TWO SWITCHGRASS MORPHOTYPES GROWING IN THE CONDITIONS OF UKRAINE'S FOREST STEPPE ZONE / ТЕХНОЛОГІЯ ВИРОЩУВАННЯ ДВОХ МОРФОТИПІВ СВІТЧГРАСУ В УМОВАХ ЛІСОСТЕПОВОЇ ЗОНИ УКРАЇНИ</b></p> <p>Gumentyk M.Ya.<sup>1)</sup>, Chernysky V.V.<sup>1)</sup>, Gumentyk V.M.<sup>2)</sup>, Kharytonov M.M.<sup>3)</sup></p> <p><sup>1)</sup>Institute of Energy Crops and Sugar Beet of NASU  <sup>2)</sup>National University of Life and Environmental Sciences of Ukraine  <sup>3)</sup>Dnipro State Agrarian and Economics University, Ukraine</p>	71
9.	<p><b>ANALYSIS AND CALIBRATION OF QUINOA GRAIN PARAMETERS USED IN A DISCRETE ELEMENT METHOD BASED ON THE REPOSE ANGLE OF THE PARTICLE HEAP / 基于堆积试验的藜麦离散元参数分析及标定</b></p> <p>Fei Liu, Dapeng Li, Tao Zhang*, Zhen Lin</p> <p>College of Mechanical and Electrical Engineering, Inner Mongolia Agricultural University, Hohho / China</p>	77

		Page(s)
10.	<p><b>EXPERIMENT ON IMPACT DAMAGE OF CASTOR CAPSULE AND ITS INFLUENCING FACTORS OPTIMIZATION / 蓖麻蒴果冲击损伤试验及影响因素优化研究</b>  <b>Hou Junming, Yang Yong, Zhu Hongjie, Hu Weixue</b>            Shenyang Agricultural University, College of Engineering / China</p>	87
11.	<p><b>PIG FACE IDENTIFICATION BASED ON IMPROVED ALEXNET MODEL / 基于改进 AlexNet 模型的生猪脸部识别</b>  <b>Hongwen Yan, Qingliang Cui*, Zhenyu Liu</b>            College of Information Science and Engineering, Shanxi Agricultural University, Taigu/China</p>	97
12.	<p><b>TEST RESEARCH ON THE IMPACT PEAK FORCE AND DAMAGE DEPTH OF POTATO / 马铃薯碰撞峰值力与损伤深度试验研究</b>  <b>Weigang Deng, Chunguang Wang*, Shengshi Xie</b>            College of Mechanical and Electrical Engineering, Inner Mongolia Agricultural University, Hohhot / China</p>	105
13.	<p><b>RESEARCH ON DESIGN AND HYBRID SLIDING MODE CONTROL OF HIGH CLEARANCE SELF-PROPELLED SPRAYER CHASSIS AIR SUSPENSION / 高地隙自走式喷雾机底盘空气悬架设计与混合滑模控制研究</b>  <b>Yu Chen<sup>1)</sup>, Jun Chen<sup>1)</sup>, Wei Li<sup>2)</sup>, Shuo Zhang<sup>*1)</sup>, Hui Xia<sup>3)</sup>, Yahui Zhu<sup>3)</sup>, Jiajun Wang<sup>3)</sup></b>  <sup>1)</sup> College of Mechanical and Electronic Engineering, Northwest A&amp;F University, Yangling / China;  <sup>2)</sup> College of Engineering, China Agricultural University, Beijing / China;  <sup>3)</sup> Jiangsu World Agriculture Machinery Co., Ltd, Danyang / China</p>	115
14.	<p><b>DESIGN AND ANALYSIS OF AN EFFICIENT SHOCK ABSORPTION SYSTEM FOR AN AGRICULTURAL ELECTRIC TRICYCLE / PROIECTAREA ŞI ANALIZA UNUI SISTEM EFICIENT DE ABSORBŢIE A ŞOCURILOR PENTRU UN TRICICLU AGRICOL ELECTRIC</b>  <b>Albert Suvac<sup>1 2)</sup>, Vasilica Stefan<sup>2)</sup>, Cristian-Gabriel Alionte<sup>3)</sup>, Liviu-Marian Ungureanu<sup>4)</sup></b>  <sup>1)</sup> Politehnica University of Bucharest, Bucharest / Romania; <sup>2)</sup> INMA Bucharest / Romania;  <sup>3)</sup> Politehnica University of Bucharest / Romania; <sup>4)</sup> Politehnica University of Bucharest / Romania</p>	127
15.	<p><b>INVESTIGATION ON DATA COLLECTION AND FRACTAL CHARACTERISTICS OF SOIL SURFACE ROUGHNESS / 土壤表面粗糙度数据采集及分形特性研究</b>  <b>Yi Qiu, Zhi Chen, Zhanfeng Hou*, Haiyang Liu, Fang Guo, Nianzu Dai</b>            Inner Mongolia Agricultural University, College of Mechanical and Electrical Engineering, Inner Mongolia, China</p>	135
16.	<p><b>SIMULATION AND TEST OF CUTTING MECHANICAL CHARACTERISTICS OF MILLET STALK BASED ON ANSYS/LS-DYNA / 基于 ANSYS/LS-DYNA 的谷子茎秆切割力学特性仿真与试验</b>  <b>Yanqing Zhang, Qingliang Cui*, Hongbo Li, Zhiyong Zhang, Yongqiang He, Deng Sun</b>            College of Engineering, Shanxi Agriculture University, Taigu/China</p>	143
17.	<p><b>TECHNOLOGICAL DEVELOPMENT OF ROBOTIC APPLE HARVESTERS: A REVIEW / 苹果收获机器人技术发展综述</b>  <b>LingXin Bu<sup>1)</sup>, ChengKun Chen<sup>1,2)</sup>, GuangRui Hu<sup>1)</sup>, Adilet Sugirbay<sup>1,3)</sup>, Jun Chen<sup>*1)</sup></b>  <sup>1)</sup> College of Mechanical and Electronic Engineering, Northwest A&amp;F University, Yangling / China;  <sup>2)</sup> Guizhou University of Traditional Chinese Medicine, Guiyang / China;  <sup>3)</sup> Technical faculty, S. Seifullin Kazakh Agro Technical University, Astana / Kazakhstan</p>	151
18.	<p><b>ENGINEERING MANAGEMENT OF MACHINE FOR FORMATION OF ARTIFICIAL SHELL ON SEED VEGETABLE CULTURES / ІНЖЕНЕРНИЙ МЕНЕДЖМЕНТ МАШИНИ ДЛЯ ФОРМУВАННЯ ШТУЧНОЇ ОБОЛОНКИ НА НАСІННІ ОВОЧЕВИХ КУЛЬТУР</b>  <b>Rogovskii I.L.<sup>1)</sup>, Titova L.L.<sup>1)</sup>, Trokhaniak V.I.<sup>1)</sup>, Marinina, L.I.<sup>1,2)</sup>, Lavrinenko, O.T.<sup>1)</sup>, Bannyi O.O.<sup>1)</sup></b>  <sup>1)</sup> National University of Life and Environmental Sciences of Ukraine / Ukraine;  <sup>2)</sup> Scientific Organization "Leonid Pogorilyy Ukrainian Scientific Research Institute of Forecasting and Testing of Machinery and Technologies for Agricultural Production" / Ukraine</p>	165
19.	<p><b>DETERMINATION OF TECHNICAL-AND-ECONOMIC INDICES OF ROOT CROP CONVEYER-SEPARATOR DURING THEIR MOTION ON CURVED PATH / ВИЗНАЧЕННЯ ТЕХНІКО-ЕКОНОМІЧНИХ ПАРАМЕТРІВ ТРАНСПОРТЕРА-СЕПАРАТОРА КОРЕНЕПЛОДІВ ПРИ ЇХ ПЕРЕМІЩЕННІ КРИВОЛІНІЙНОЮ ТРАСОЮ</b>  <b>Hevko R.B.<sup>1)</sup>, Tkachenko I.G.<sup>1)</sup>, Khomyk N.I.<sup>1)</sup>, Gumeniuk Y.P.<sup>2)</sup>, Flonts I.V.<sup>3)</sup>, Gumeniuk O.O.<sup>2)</sup></b>  <sup>1)</sup> Ternopil Ivan Puluj National Technical University / Ukraine;  <sup>2)</sup> Ternopil National Economical University / Ukraine;  <sup>3)</sup> National University of Life and Environmental Sciences of Ukraine / Ukraine</p>	175

		Page(s)
20.	<p><b>DETERMINATION OF THE ENERGY EFFICIENT MODES FOR BARLEY SEEDS DRYING /</b>  <b>ВИЗНАЧЕННЯ ЕНЕРГОЕФЕКТИВНИХ РЕЖИМІВ СУШІННЯ НАСІННЯ ЯЧМЕНЮ</b>  <b>Snezhkin Yu.F.<sup>1)</sup>, Paziuk V.M.<sup>2)</sup>, Petrova Zh. O.<sup>3)</sup>, Tokarchuk O.A.<sup>4)</sup></b></p> <p><sup>1)</sup> Institute of technical thermal physics NAS of Ukraine, <sup>2)</sup> Institute of technical thermal physics NAS of Ukraine, <sup>3)</sup> Institute of Engineering Thermophysics / Ukraine, <sup>4)</sup> Vinnitsia National Agrarian University/Ukraine</p>	183
21.	<p><b>MODELING OF MOBILE TMR MIXER OPERATION /</b>  <b>МОДЕЛИРОВАНИЕ РАБОТЫ МОБИЛЬНОГО КОРМОЦЕХА</b>  <b>Kupreenko A.I.<sup>1)</sup>, Isaev Kh.M.<sup>1)</sup>, Kuznetsov Yu.A.<sup>2)</sup>, Mikhailichenko S.M.<sup>1)</sup>,</b>  <b>Kravchenko I.N.<sup>3)</sup>, Kalashnikova L.V.<sup>4)</sup></b></p> <p><sup>1)</sup> Bryansk State Agrarian University / Russia; <sup>2)</sup> Orel State Agrarian University named after N.V. Parakhin / Russia; <sup>3)</sup> Russian State Agrarian University – Moscow Agricultural Academy named after K.A. Timiryazev / Russia; <sup>4)</sup> Orel State University named after I.S. Turgenev / Russia</p>	193
22.	<p><b>ADAPTIVE CYBER-PHYSICAL SYSTEM OF THE MILK PRODUCTION PROCESS /</b>  <b>АДАПТИВНА КІБЕР-ФІЗИЧНА СИСТЕМА ПРОЦЕСУ ВИРОБНИЦТВА МОЛОКА</b>  <b>Dmytriv V.T.<sup>1)</sup>, Dmytriv I.V.<sup>1)</sup>, Horodetskyi I.M.<sup>2)</sup>, Yatsunskyi P.P.<sup>1)</sup></b></p> <p><sup>1)</sup> Lviv Polytechnic National University, Institute of Engineering Mechanics and Transport, Lviv / Ukraine  <sup>2)</sup> Lviv National Agrarian University, Faculty of Mechanic and Power Engineering, Lviv-Dubliany / Ukraine</p>	199
23.	<p><b>DETERMINATION OF SOWING PRECISION IN SIMULATED LABORATORY CONDITIONS /</b>  <b>DETERMINAREA PRECIZIEI DE SEMĂNAT ÎN CONDIȚII SIMULATE ÎN LABORATOR</b>  <b>Cujbescu D.<sup>1)</sup>, Biriș S.Șt.<sup>2)</sup>, Voicu Gh.<sup>2)</sup>, Matache M.<sup>1)</sup>, Paraschiv G.<sup>2)</sup>, Vlăduț V.<sup>1)</sup>,</b>  <b>Bularda M.<sup>3,4)</sup>, Ungureanu N.<sup>2)</sup></b></p> <p><sup>1)</sup>INMA Bucharest, <sup>2)</sup> University Politehnica of Bucharest, Faculty of Biotechnical Systems Engineering / Romania; <sup>3)</sup> SCDA Brăila / Romania; <sup>4)</sup> Univ. Dunărea de Jos Galați / Romania</p>	209
24.	<p><b>IMPROVING THE EFFICIENCY OF WOOD CHIPPING OPERATIONS / ПОВЫШЕНИЕ</b>  <b>ЭФФЕКТИВНОСТИ ПРОЦЕССОВ ПРОИЗВОДСТВА ДРЕВЕСНОЙ ЩЕПЫ</b>  <b>Grigorev Igor<sup>*1)</sup>, Shadrin Anatoly<sup>2)</sup>, Voronova Anna<sup>3)</sup>, Kostyukevich Nikolay<sup>2)</sup>,</b>  <b>Levushkin Dmitry<sup>2)</sup>, Borisov Vyacheslav<sup>2)</sup>, Diev Roman<sup>2)</sup></b></p> <p><sup>1)</sup> Yakut State Agricultural Academy, Russian Federation;  <sup>2)</sup> Moscow State Technical University. N. E. Bauman (Mytishchi branch), Russian Federation;  <sup>3)</sup> Petrozavodsk State University, Russian Federation</p>	217
25.	<p><b>DEFECTS DETECTION METHOD BASED ON K-MEANS WITH PRIOR KNOWLEDGE FOR</b>  <b>BIOMASS PARTICLES / 基于先验知识的 Kmeans 聚类生物质颗粒缺陷检测方法</b>  <b>Wei Wang, YuanJuan Gong<sup>*1)</sup></b></p> <p><sup>1)</sup> Shenyang Agricultural University, College of Engineering, Shenyang / China</p>	225
26.	<p><b>STRUCTURAL ANALYSIS WITH FINITE ELEMENTS OF A SUBSOILER WORKING PART /</b>  <b>ANALIZA STRUCTURALĂ CU ELEMENTE FINITE A ORGANULUI DE LUCRU</b>  <b>AL UNUI SUBSOLIER</b>  <b>Constantin G.A.<sup>1)</sup>, Voicu Gh.<sup>*1)</sup>, Olac B.<sup>1)</sup>, Ilie F.<sup>1)</sup>, Paraschiv G.<sup>1)</sup>, Stefan V.<sup>2)</sup>, Musuroi G.<sup>1)</sup></b></p> <p><sup>1)</sup> University Politehnica of Bucharest, Faculty of Biotechnical Systems Engineering / Romania  <sup>2)</sup> INMA Bucharest / Romania</p>	233
27.	<p><b>CFD NUMERICAL SIMULATION OF TEMPERATURE AND AIRFLOW DISTRIBUTION IN PIGSTY</b>  <b>BASED ON GRID INDEPENDENCE VERIFICATION /</b>  <b>基于网格独立性验证的猪舍温度和气流分布的 CFD 数值模拟</b>  <b>Min Jin, Chunguang Wang*, Pengpeng Wang</b></p> <p>College of Mechanical and Electrical Engineering, Inner Mongolia Agricultural University, Hohhot, China</p>	241
28.	<p><b>NONDESTRUCTIVE TESTING OF SOLUBLE SOLIDS CONTENT IN CERASUS HUMILIS USING</b>  <b>VISIBLE / NEAR-INFRARED SPECTROSCOPY COUPLED WITH WAVELENGTH SELECTION</b>  <b>ALGORITHM / 可见/近红外光谱技术结合波长选择算法检测李可溶性固形物含量的无损检测</b>  <b>Bin Wang<sup>1)</sup>, Junlin He<sup>*1)</sup>, Shujuan Zhang<sup>*1)</sup>, Lili Li<sup>2)</sup></b></p> <p><sup>1)</sup> College of Engineering, Shanxi Agricultural University, Taigu/China  <sup>2)</sup> College of Information Science and Engineering, Shanxi Agricultural University, Taigu/China</p>	251
29.	<p><b>RAPID DESIGN OF MAIZE EAR HARVESTER HEADER BASED ON KNOWLEDGE</b>  <b>ENGINEERING / 基于知识工程的玉米果穗收获机割台快速设计</b>  <b>Tai Jianjian<sup>1)</sup>, Li Haitao<sup>1)</sup>, Du Yuefeng<sup>1)</sup>, Mao Enrong<sup>1)</sup>, Zhang Junnan<sup>1)</sup>, Long Xinjian<sup>1)</sup></b></p> <p><sup>1)</sup>China Agricultural University, College of Engineering, Beijing/China</p>	263
30.	<p><b>ADAPTABILITY TEST OF DRY FARMING TILLAGE TECHNIQUE IN</b>  <b>NORTHERN CHINA AND STUDY OF KEY TECHNIQUES /</b>  <b>中国北方旱作农业耕作技术适应性试验与关键技术研究</b>  <b>Yubing Guo<sup>1)</sup>, Xiaogang Zhang<sup>2)</sup>, Chong Zhang<sup>1)</sup></b></p> <p><sup>1)</sup>School of Economics and Management, Taiyuan University of Science and Technology, Taiyuan 030024, China,  <sup>2)</sup>Shanxi Agricultural Machinery Research Institute Taiyuan 030006, China</p>	273

		Page(s)
31.	<p><b>ROAD RECOGNITION TECHNOLOGY OF AGRICULTURAL NAVIGATION ROBOT BASED ON ROAD EDGE MOVEMENT OBSTACLE DETECTION ALGORITHM /</b>  <b>基于道路边缘运动障碍物检测算法的农业导航机器人道路识别技术</b>  <b>Na Yu<sup>1)</sup>, Qing Wang<sup>1)</sup>, Shichao Cao<sup>1)</sup></b>  <sup>1)</sup>Xingtai Polytechnic College, Xingtai / China</p>	281
32.	<p><b>ATOMIZATION CHARACTERISTICS OF FLAT FAN NOZZLES FOR PRECISION PESTICIDE APPLICATION AT LOW PRESSURES / 针对精准施药的平扇形喷嘴低压雾化特性</b>  <b>Shougen Li, Yaxiong Wang, Chongchong Chen, Feng Kang*, Wenbin Li</b>            School of Technology, Beijing Forestry University, Key Lab of State Forestry Administration for Forestry Equipment and Automation, Beijing / China</p>	293
33.	<p><b>DEVELOPMENT AND TEST OF SPEED CONTROL SYSTEM FOR COMBINE HARVESTER THRESHING AND CLEANING DEVICE /</b>  <b>联合收获机脱粒滚筒与清选风机速度调控系统设计及试验</b>  <b>Zhuohuai Guan<sup>1)</sup>, Zhou Zhang<sup>2)</sup>, Tao Jiang<sup>1)</sup>, Ying Li<sup>1)</sup>, Chongyou Wu<sup>1)</sup>, Senlin Mu<sup>1*)</sup></b>  <sup>1)</sup> Nanjing Research Institute for Agricultural Mechanization, Ministry of Agriculture and Rural Affairs, Nanjing, China <sup>2)</sup> School of Management &amp; Engineering, Nanjing University, Nanjing, China</p>	305
34.	<p><b>DESIGN AND EXPERIMENTAL OPTIMIZATION OF AIRFOIL-TRIANGLE SIEVE FOR HAMMER MILL /</b>  <b>锤片式粉碎机翼型三角形筛片设计与试验优化</b>  <b>Di Wang<sup>1)</sup>, Changbin He<sup>1)</sup>, Haiqing Wang<sup>1)</sup>, Fei Liu<sup>1)</sup>, Haiqing Tian<sup>*1)</sup>, Liang Ma<sup>2)</sup></b>  <sup>1)</sup> Inner Mongolia Agricultural University, College of Mechanical and Electrical Engineering, Hohhot/China;  <sup>2)</sup> Tuoketuo Senior Vocational Middle School, Hohhot/China</p>	315
35.	<p><b>THE EFFECT OF CONSERVATIVE AGRICULTURAL WORKS ON SOIL AND FIELD PLANTS AND OPTIMIZED MECHANIZATION TECHNOLOGIES /</b>  <b>EFFECTUL LUCRĂRILOR AGRICOLE CONSERVATIVE ASUPRA SOLULUI ȘI PLANTELOR DE CÂMP ȘI TEHNOLOGII DE MECANIZARE OPTIMIZATE</b>  <b>Bularda M.<sup>1,2)</sup>, Vișinescu I.<sup>1)</sup>, Ghiorghe A.<sup>1)</sup>, Vlăduț V.<sup>3)</sup>, Cujbescu D.<sup>*3)</sup></b>  <sup>1)</sup>SCDA Brăila / Romania; <sup>2)</sup>Univ. Dunărea de Jos Galați / Romania; <sup>3)</sup>INMA Bucharest / Romania</p>	323
36.	<p><b>TECHNICAL AND ECONOMIC ASPECTS OF BIOGAS PRODUCTION AT A SMALL AGRICULTURAL ENTERPRISE WITH MODELING OF THE OPTIMAL DISTRIBUTION OF ENERGY RESOURCES FOR PROFITS MAXIMIZATION /</b>  <b>ТЕХНІЧНІ ТА ЕКОНОМІЧНІ АСПЕКТИ ВИРОБНИЦТВА БІОГАЗУ НА МАЛОМУ СІЛЬСЬКОГОСПОДАРСЬКОМУ ПІДПРИЄМСТВІ З МОДЕЛЮВАННЯМ ОПТИМАЛЬНОГО РОЗПОДІЛУ ЕНЕРГЕТИЧНИХ РЕСУРСІВ ДЛЯ МАКСИМІЗАЦІЇ ПРИБУТКУ</b>  <b>Tokarchuk D.M., Pryshliak N.V., Tokarchuk O.A., Mazur K.V.</b>            Vinnitsa National Agrarian University / Ukraine</p>	339



**DETERMINATION OF THE ENERGY EFFICIENT MODES  
FOR BARLEY SEEDS DRYING****ВИЗНАЧЕННЯ ЕНЕРГОЕФЕКТИВНИХ РЕЖИМІВ  
СУШІННЯ НАСІННЯ ЯЧМЕНЮ**Snezhkin Yu.F.<sup>1)</sup>, Paziuk V.M.<sup>2)</sup>, Petrova Zh. O.<sup>3)</sup>, Tokarchuk O.A.<sup>4)</sup> <sup>1</sup><sup>1)</sup> Institute of technical thermal physics NAS of Ukraine, <sup>2)</sup> Institute of technical thermal physics NAS of Ukraine,<sup>3)</sup> Institute of Engineering Thermophysics / Ukraine, <sup>4)</sup> Vinnitsia National Agrarian University/Ukraine

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DOI: <https://doi.org/10.35633/inmateh-61-20>**Keywords:** drying, barley seeds, energy efficient modes, germination rates**ABSTRACT**

For a more accurate study of the kinetics of the barley seeds drying, a convective drying stand with a computerized system of data acquisition and processing on the change in the mass and temperature of the sample from the drying time was used.

The kinetic curves of the drying process under the action of three factors were constructed: the temperature of the coolant, heating medium movement rate and the initial moisture content of the seeds. Studies were also conducted and the germination of barley seeds under the action of these factors was analysed.

Studies have shown that all factors affect the kinetics of the drying process, but the greatest influence on the germination of seed material comes from the influence of the temperature of the coolant. A three-factor effect on the germination of barley seeds on the 7th day of germination is presented, that indicates the need for low-temperature drying at a coolant temperature of 50°C.

In order to increase the intensification and energy efficiency of the drying process, the proposed two-stage drying mode is 65/50°C, which provides intensive heating and evaporation of moisture from the material at the initial stage of the process. Studies on the germination of barley seeds in a two-stage mode showed that the specified drying mode provides a high germination rate of the material up to 99%, an intensity of 83% and an energy efficiency of 62% compared to a rational single-stage drying mode of 50°C and can be recommended for drying barley seeds.

**РЕЗЮМЕ**

Для більш точного дослідження кінетики сушіння насіння ячменю був застосований конвективний сушильний стенд із комп'ютерною системою збору та обробки даних про зміну маси та температури зразка від часу сушіння.

Проведено побудова кривих кінетики процесу сушіння від дії трьох факторів: температури теплоносія, швидкості руху теплоносія та початкової вологості насіння. Також проведені дослідження та проаналізована схожість насіння ячменю від дії зазначених факторів

Дослідження показали, що всі фактори впливають на кінетику процесу сушіння, але найбільший вплив на схожість насіннєвого матеріалу відбувається від впливу температури теплоносія. Представлений трьохфакторний вплив на схожість насіння ячменю на 7 день пророщування вказує на необхідність низькотемпературного сушіння при температурі теплоносія 50°C.

З метою підвищення інтенсифікації та енергоефективності процесу сушіння запропонований двохступеневий режим сушіння 65/50°C, що забезпечує інтенсивне прогрівання та випаровування вологи з матеріалу на початковій стадії процесу. Проведені дослідження із схожості насіння ячменю в двохступеновому режимі вказали, що зазначений режим сушіння забезпечує високу схожість матеріалу до 99%, інтенсивність на 83% та енергоефективність процесу на 62% в порівнянні з раціональним одноступеневим режимом сушіння 50°C і може бути рекомендований для сушіння насіння ячменю.

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## INTRODUCTION

Drying is the main technological operation for bringing the seeds to a stable equilibrium condition. The technology of seed drying involves knowledge of the biological properties of the grain as the object for drying, the heat stability of the grain, patterns of moisture evaporation, determining the modes of drying and equipment for the implementation of the process.

The theoretical basis of the agricultural material drying techniques has been formed in the world for two and a half centuries. Nevertheless, despite the multitude of studies well presented in the literature, the industry still lacks universally recognized methods of design calculation for the majority of drying problems (Bulgakov V., Bandura V., Arak M., Olt J., 2018). Scientists are investigating different types of drying crops: active ventilation (Gaponyuk O.I. Ostapchuk M.V, Stankevich G.M., 2014), in a monolayer tray vibration dryer based on infrared radiation (Bandura V., Mazur V., Yaroshenko L., Rubanenko O., 2019), by vibration dryer with electromagnetic energy sources (Burdo O., Bandura V., Zykov A., Zozulyak I., Levtrinskaya J., Marenchenko E. 2017), intermitted drying (Kumar C., Karim M. A., & Joardder M. U. H., 2014; Souza e Silva J. S., 2008), microwave convective drying (Ahmé L. M., Pereira N. R., Staack N. & P. Floberg), a combination of a convective method of supplying heat with the introduction of ozone drying agent (Tsurkan O. V. Necheporenko S. A., Blyznyuk M. Ya, 2013).

Having characterized the grain drying processes, we can roughly divide it into soft and rigid grain drying modes. The first is specified by the relatively low temperature and speed of the drying agent. In the soft mode, the processes of heating and drying the grain are relatively slow. For the rigid mode higher temperatures and the heating medium movement rates are characteristic (Paziuk, V.M., Liubin, M.V., Yaropud, V.M., Tokarchuk, O.A., Tokarchuk, D.M., 2018).

From the economic point of view, it is desirable to carry out the process of grain drying in a rigid mode with drying time reduction. However, under the rigid mode due to intensive heating and dehydration, grain quality deterioration takes place: cracking of seeds, discoloration, partial or complete destruction of the embryo, deformation of tissues.

The use of high temperatures at the beginning of the wet grain drying process leads to a rapid dehydration of its surface (Matkivska I. Ja., Atamanyuk V. M., Symak D., 2014), which makes the shell less permeable to moisture (the phenomenon of thermal "hardening" of the grain). Under such conditions, water vapor is formed in the surface layer, the output of which becomes difficult.

## MATERIALS AND METHODS

Drying of seeds of different crops has certain restrictions. As it is known (Lykov A.V., 1968; Stankevich G. M., Strahova T. V., Atanazevich V.I., 1997; Paziuk V.M., Petrova Zh.O., Tokarchuk O.A., Yaropud V.M.; Shchitsov S.V., Tikhonchuk P.V., Krivuta Z.F., Kolzov A.V., 2016), high temperatures have negative effect on the quality of seeds, reducing their energy for germination and growth thus impairing the quality of material for technological purposes.

By the soft drying mode there is no full confidence in preserving seed properties of the grain, thus durable low temperature drying (depending on environmental parameters) may form the mould on the surface of the grain resulting in the seed material damage.

Soares M., Jorge L., Montanuci F. (2016) in their works studied the kinetics of the barley seeds drying process at a 40-80°C temperature of the drying agent in continuous and periodic drying mode.

Continuous drying has the advantages of the drying time reduction due to elimination of the loading and unloading operations of the dryer. But it also has its disadvantages: in a continuous heat flow a difference between the moisture on the surface and inside the grain occurs.

In periodic dryers, the product passes through the dryer several times until fully dried. Thus, the grain is subjected to a short-repeated action of heat and rest during drying. During the rest, moisture is moved from the centre to the periphery of the grain, which reduces the occurrence of cracks due to a decrease of internal stresses in the grain.

Studies of the barley seeds drying kinetics described in the work of Soares M. *et al* showed that the maximum duration of drying at a 40°C temperature of the heating medium for 12 hours corresponds to the 94-95% level of seeds germination. Increasing the temperature to 60-80°C under different drying methods reduces duration of drying and the level of seed material germination

The influence of the coolant temperature in fluidized bed dryers and infrared radiation on drying kinetics and germination rates of barley seeds is demonstrated in the work of *Markowski M. et al (2007)* Drying of barley seeds in a fluidized bed dryer takes place at a 30-45°C drying agent temperature, which corresponds to radiation in an infrared dryer with an intensity range of 0.048-0.107 W/cm<sup>2</sup>, seed germination rate was at a 91-93% level.

*Stankevich G.M. et al (1997)* in their work recommend maximal allowable heating temperature for drying barley seeds in a mine-type dryer with a 40°C drying agent temperature, but does not give data on seed germination rate.

Various authors give recommendations on determining the optimal mode of drying, which need clarification.

Many of the approaches and methods for drying barley seeds are alternative to traditional convective drying. Modern drying equipment with computerized processing of the obtained data allows to determine more precisely the necessary drying modes on the base of germination properties of the seeds.

For determining the kinetics of barley seeds drying, a convective drying stand with a computerized data acquisition and processing system was used, which allows to read experimental data 6 times per minute (*Pazyuk V. Petrova Zn., Chepeliuk O., 2018*).

Data on the barley seeds heating temperature and the weight of the material changes during the studies were obtained. The graphs of the kinetics of the drying process were built and calculations of the drying rates of barley seeds were made.

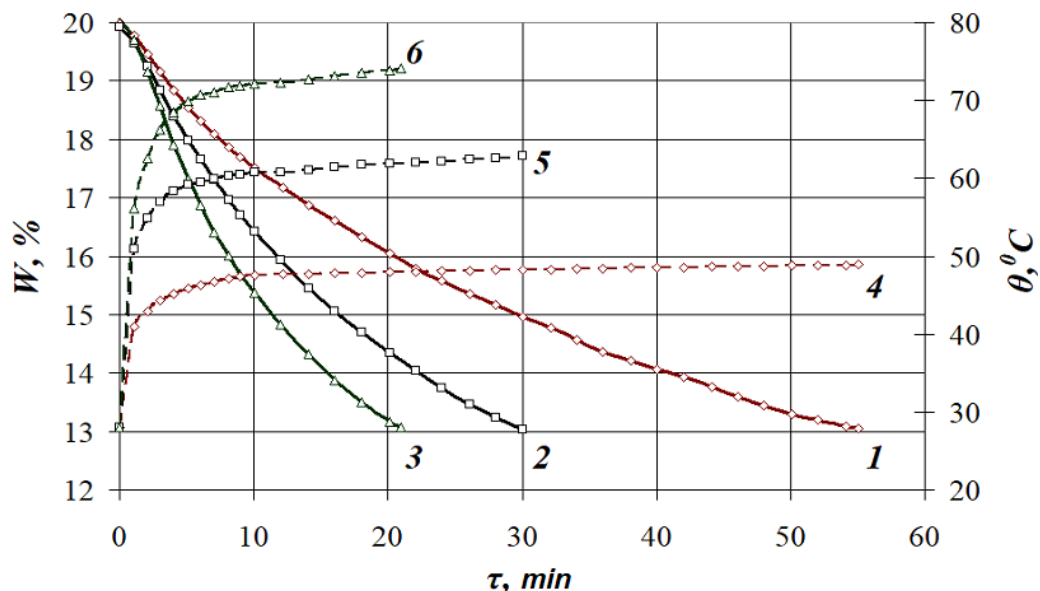
## RESULTS

Results of the authors' laboratory research on the barley seeds drying are presented in Fig. 1-3.

Shift in the temperature of the drying agent from 50 to 80°C reduces the drying time by 2.67 times.

The obtained temperature curves of heating inside the material caused by the drying agent temperature changes, indicate that it can be intensively heated for 10 minutes.

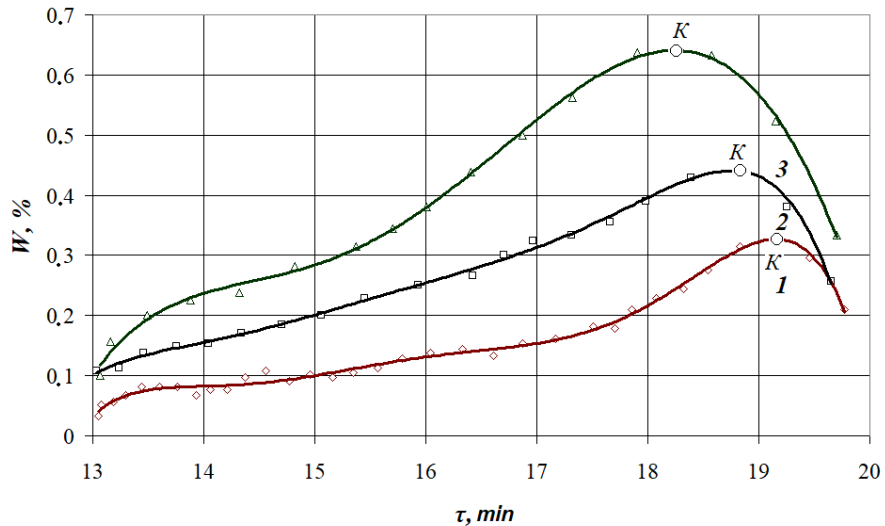
The increase in the intensity of heating of the material depends on the drying agent temperature increase, which directly affects barley seed properties (Fig. 1).



**Fig. 1 - Effect of the coolant temperature and the temperature of the material heating on the duration of barley seeds drying**

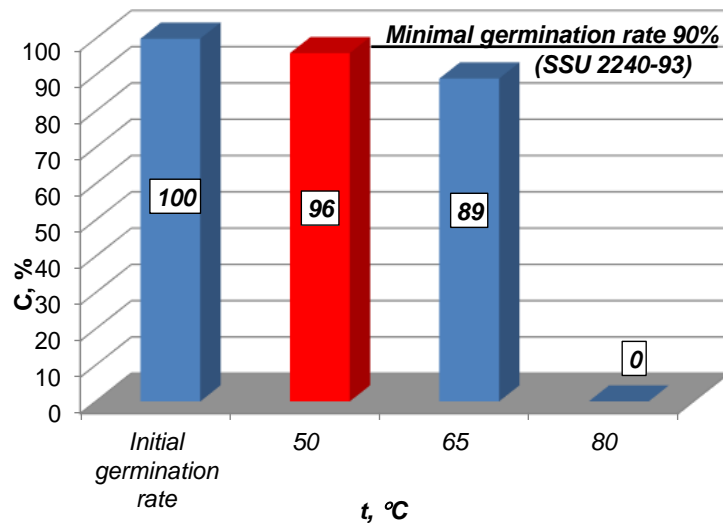
$W_n$  (initial humidity) = 20%,  $V$  (velocity of the coolant) = 1.5 m/s,  $d$  (moisture content of dry air) = 10 g/kg d.a.,  
 $\delta$  (grain layer thickness) = 2 mm:  
 1.4 – 50°C, 2.5 – 65°C, 3.6 – 80°C

The process of drying barley seeds occurs during the period of decreasing the drying rate on condition of the pre-heating of the material. The maximum drying rate at point K for the 50°C coolant temperature is 0.32% per min, and for the 80°C temperature – 0.63% per min (Fig. 2).



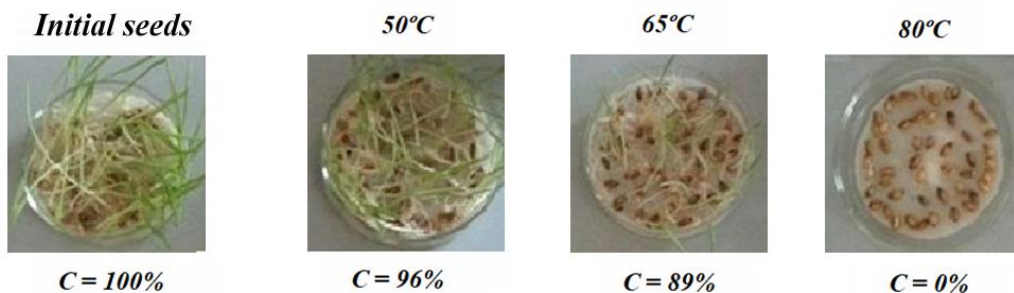
**Fig. 2 - Effect of the coolant temperature on the barley seeds drying rate**  
 $W_n = 20\%$ ,  $V = 1.5$  m/s,  $d = 10$  g/kg d.a.,  $\delta = 2$  mm  
 1 – 50°C, 2 – 65°C, 3 – 80°C

It has been established that the best germination rate of barley seeds is observed at a 50°C heating medium temperature and 48.9°C temperature of the material heating, namely 96%. Further increase of the drying agent temperature to 80°C considerably reduces barley seed properties (Fig. 3).



**Fig. 3 - Effect of the coolant temperature on the germination rate of barley seeds on the 7th day of germination:**  $V = 1.5$  m/s,  $W_n = 20\%$ ,  $d = 10$  g/kg d.a.

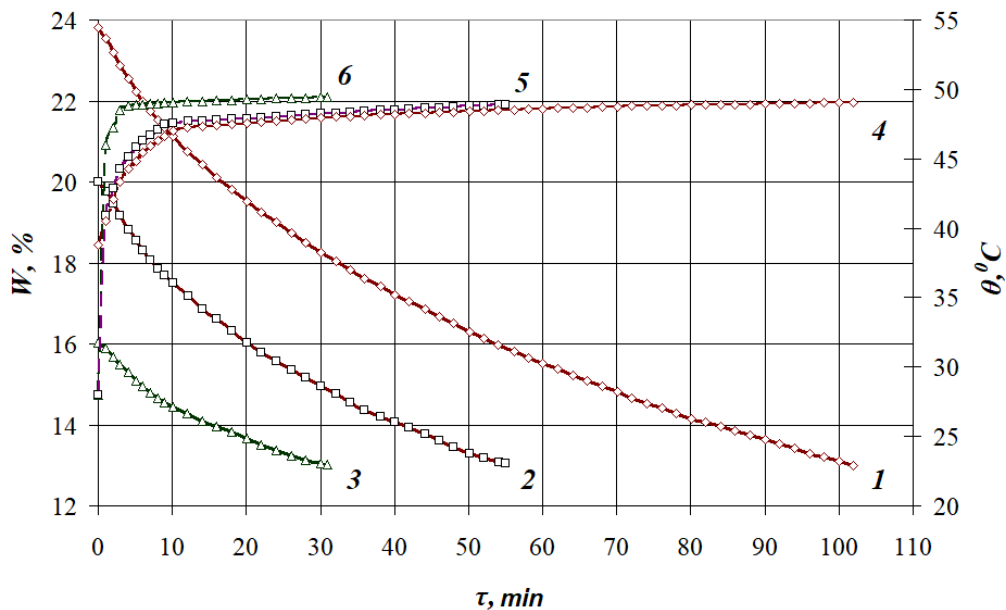
The results of the laboratory studies on the seed germination rate on the 7<sup>th</sup> day of germination can be seen in Fig. 4, they confirm the data of the experiment on the dependence of germination rates on the drying modes shown in Fig. 3.



**Fig. 4 - Barley seeds germination rates in accordance with drying modes**  
 $V = 1.5$  m/s,  $W_n = 20\%$ ,  $d = 10$  g/kg d.a.

Another factor that influences the kinetics of the drying process is the initial moisture content of barley seeds selected in the range of  $W=16-24\%$ , which corresponds to the moisture content of the seeds when harvested under different climatic conditions.

Kinetics of the barley drying process shows that increase in the initial moisture content from 16% to 24% lengthens duration of drying by 3.29 times (Fig. 5).

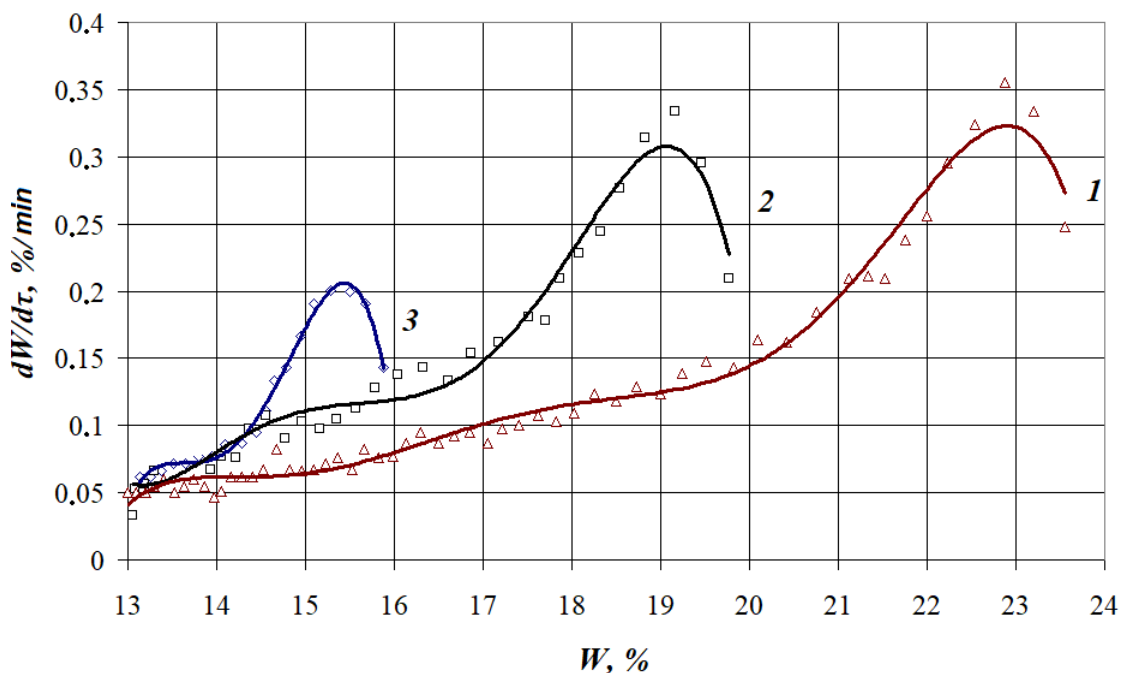


**Fig. 5 - Effect of initial moisture content and material heating temperature on duration of barley seeds drying**

$t = 50^{\circ}\text{C}$ ,  $V = 1.5 \text{ m/s}$ ,  $d = 10 \text{ g/kg d.a.}$ ,  $\delta = 2 \text{ mm}$ :  
 1 – 24%; 2 – 20%; 3 – 16%

The final barley seeds heating temperature decreases as a result of the initial humidity of the material increase at a temperature of  $50^{\circ}\text{C}$  and lies within the limits of  $48.9-49.6^{\circ}\text{C}$  (Fig. 5).

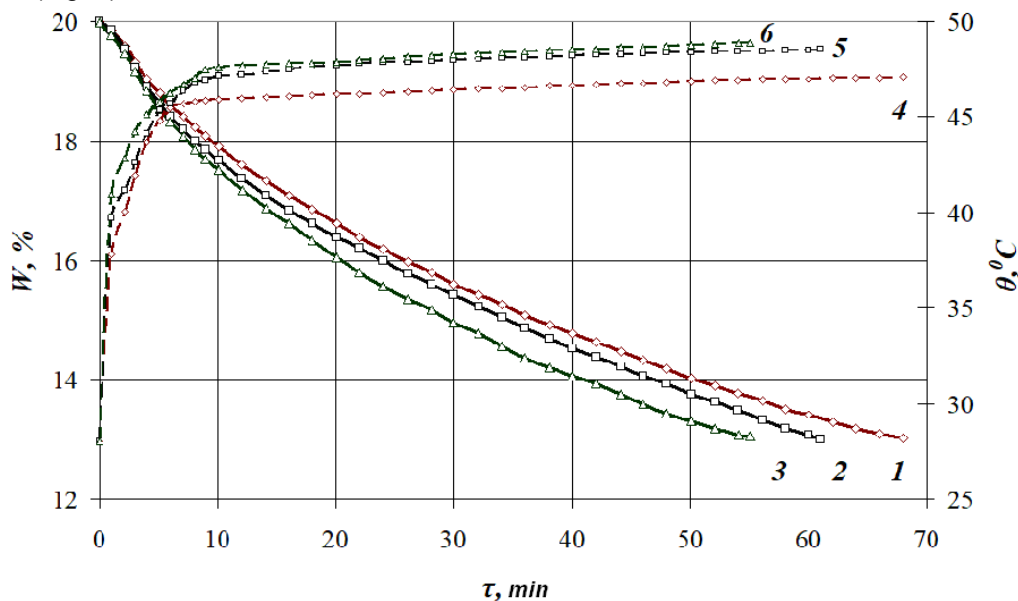
The drying rate curves are similar to the drying curves shown in Fig.2. The rate of the barley seeds drying increases with the increase of the initial moisture content of the material (Fig. 6).



**Fig. 6 - Influence of the material initial moisture content on the barley seeds drying rate**

$t = 50^{\circ}\text{C}$ ,  $V = 1.5 \text{ m/s}$ ,  $d = 10 \text{ g/kg d.a.}$ ,  $\delta = 2 \text{ mm}$ :  
 1 – 24%; 2 – 20%; 3 – 16%

Increase in the heating medium movement rate from 0.5 to 1.5 m/s increases duration of barley drying by 1.24 times (Fig. 7).



**Fig. 7 - Influence of the heating medium movement rate and the material heating temperature on the barley seeds drying duration:**  
*t = 50°C, W<sub>n</sub> = 20%, d = 10 g/kg d.a., δ = 2 mm:*  
 1 – 0.5 m/s; 2 – 1.0 m/s; 3 – 1.5 m/s

When evaluating and selecting the drying mode, it is necessary to proceed from the qualitative characteristics of seed germination.

The three-factor effect on germination of barley seeds on the 7<sup>th</sup> day of germination is presented in Table 1.

**Table 1**

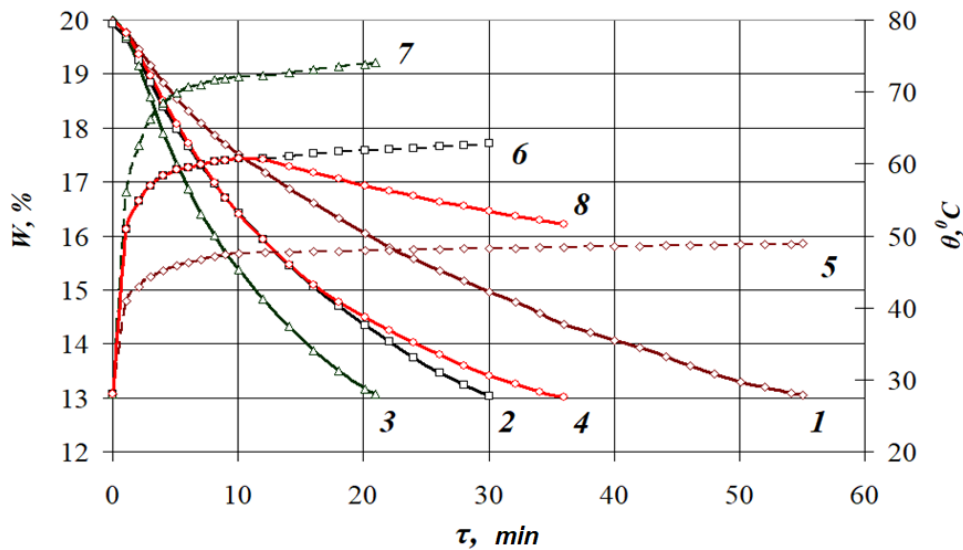
**Influence of drying parameters on germination rates of barley seeds on the 7th day of germination**

Drying parameters			Germination rates [%]
Temperature of the coolant, [°C]	Initial moisture content of the seeds [%]	Heating medium movement rate [m/s]	
Output	-	-	100
50	16	1.5	98
50	20	0.5	98
50	20	1.5	98
50	24	1.5	96
65	16	1.5	95
65	20	0.5	90
65	20	1.5	90
65	24	1.5	89
80	16	1.5	18
80	20	0.5	18
80	20	1.5	18
80	24	1.5	0

Drying mode with high seed germination rate is a 50°C heating medium temperature, where the influence of initial moisture content and heating medium movement rate is not significant.

The temperature of the heating medium 65°C at the initial moisture content above 16% is close to the minimum seed germination rate (92%) and is 89-90%, which does not meet the requirements for seed grain. The influence of the heating medium movement rate on the germination rate of seeds is more significant at the 80°C temperature mode, and when the initial moisture content makes up 24%, all seed properties of grain disappear.

In order to increase energy efficiency of drying and to improve the rate of barley seeds germination, it is proposed to use a 65/50°C temperature stepwise drying method. Comparison of the 65/50°C drying mode with the one-stage modes is demonstrated in Fig. 8.

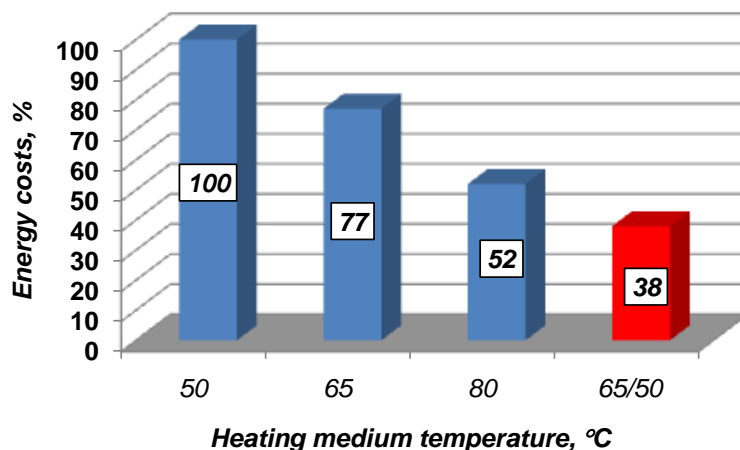


**Fig. 8 - Influence of the heating medium temperature and the material heating temperature on duration of barley seeds drying**

$W_n = 20\%$ ,  $V = 1.5 \text{ m/s}$ ,  $d = 10 \text{ g/kg d.a.}$ ,  $\delta = 2 \text{ mm}$ :  
 1.5 – 50°C, 2.6 – 65°C, 3.7 – 80°C, 4.8 – 65/50°C

As can be seen from Fig. 8, at the beginning of the drying process, the heating temperature of the barley seeds in the two-stage drying mode of 65/50°C had been keeping for 5 minutes and after that the coolant temperature was sharply reduced to 50°C. The maximum temperature of the material heating at the beginning of the process at a 65°C coolant temperature was 59.18°C and then it gradually decreased to the 51.32°C final value.

Duration of the 65/50°C two-stage drying process is reduced by 35% compared to the 50°C drying mode. Low energy consumption for the drying process in the stepwise drying mode is associated with the rapid heating of the material in the drying chamber at a temperature of 65°C and a gradual decrease in the temperature of the coolant to a temperature of 5°C and in duration by 35% (Fig. 9).

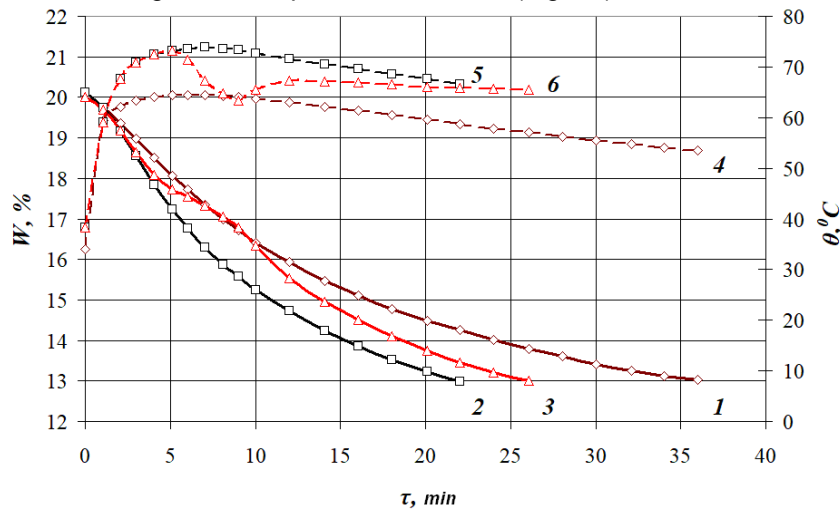


**Fig. 9 - Dependence of the process of barley seeds drying energy consumption on the heating medium temperature:**

$W_n = 20\%$ ,  $V = 1.5 \text{ m/s}$ ,  $d = 10 \text{ g/kg d.a.}$ ,  $\delta = 2 \text{ mm}$

To evaluate objectively the stepwise drying modes for barley seed drying, the influence of 65/50, 80/65, and 80/resting/65°C modes on the kinetics of the drying process and the qualitative characteristics of the seed material was investigated. The presented drying modes are within the proposed 50-80°C range.

Kinetics of the barley seeds drying in stepwise modes indicates the peculiarity of the process and the rate of heating the material with a gradual temperature decrease (Fig. 10).



**Fig. 10 - Influence of the heating medium temperature and the heating of the material temperature on barley seeds drying duration in stepwise modes:**

$W_n = 20\%$ ,  $V = 1.5 \text{ m/s}$ ,  $d = 10 \text{ g/kg d. a.}$ ,  $\delta = 2 \text{ mm}$ :  
 1.4 – 65/50°C, 2.5 – 80/65°C, 3.6 – 80/resting/65°C

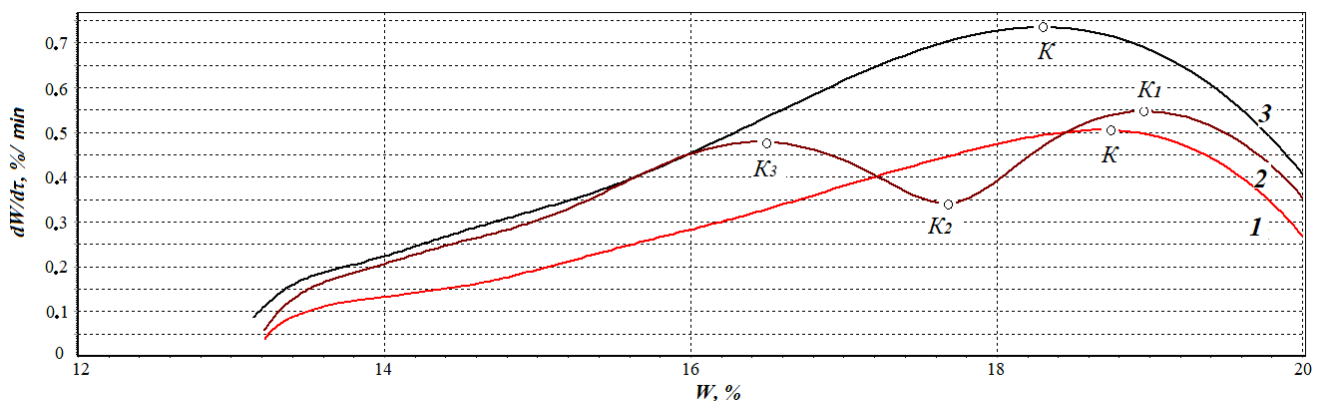
The most intensive 80/65°C stepwise drying mode differs from the 80/resting/65°C drying mode by 5 minutes, that is, by the time of the seed resting. During the resting movement of the heating medium in the drying chamber stops and a significant slowdown in the removal of moisture from the seeds is observed, while redistribution of heat and moisture in the seed itself becomes the main process. It can also be seen that, in the resting mode, the drying kinetics curve shifts toward the 65/50°C drying curve, into the area of high germination rates of the material.

In the 80°C/65°C stepwise drying mode in addition to the other processes, the process of resting is present, which is observed as a “temperature pit” on the curves, the decrease in temperature takes place from the 74°C of the seed heating temperature by 15°C after 5 min from the start. On the 9th minute it is switched to the 65°C drying mode – the temperature rises sharply and then gradually decreases.

The curves of barley seeds drying rate in the stepwise drying modes are presented in Fig. 11.

The nature of the 65/50 and 80/65°C drying curves does not differ from the previously described single-stage drying curves. The 80/65°C drying mode is the most intensive one, it is more intensive than the 65/50°C drying mode by 0.24% per min.

In the 80/resting/65°C stepwise drying mode, there is a twofold fall in the heating period and the drying rate with a decrease in the drying rate with critical humidity K1-K3.

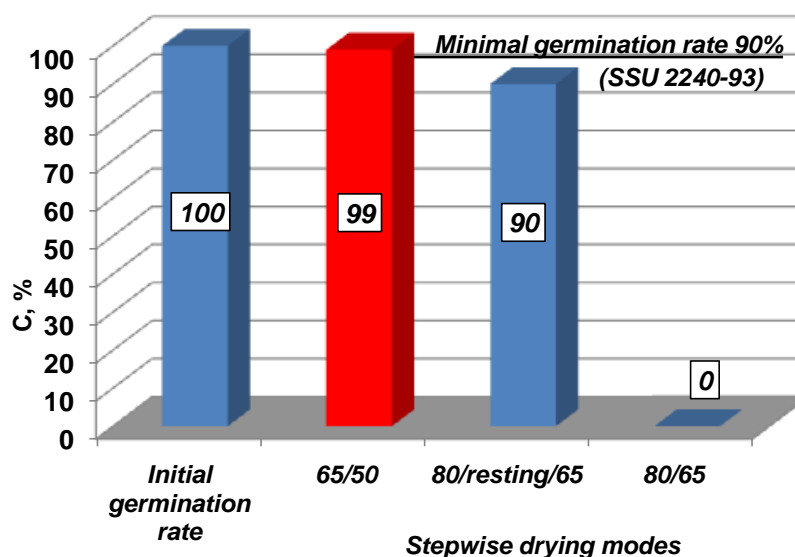


**Fig. 11 - Influence of the heating medium temperature on the barley seeds drying rate in stepwise modes:**

$V = 1.5 \text{ m/s}$ ,  $d = 10 \text{ g/kg d.a.}$ ,  $\delta = 2 \text{ mm}$ :  
 1 – 65/50°C, 2 – 80/resting/65°C, 3 – 80/65°C



The barley seeds germination rates in the stepwise drying modes are shown in Fig. 12.

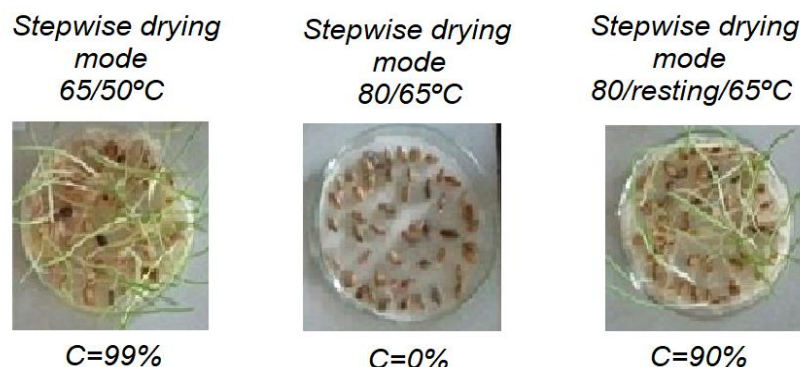


**Fig. 12 - Influence of the stepwise drying modes on the barley seeds germination rates on the 7th day of germination:**

$V = 1.5 \text{ m/s}$ ,  $W_n = 24\%$ ,  $d = 10 \text{ g/kg d.a.}$

The results of germination rates prove the effectiveness of drying in the 65/50°C mode. After drying under the 80/65°C mode the seeds of barley do not germinate, but after the stepwise 80/resting/65°C mode of drying there was observed a rather high germination rate at the level of 90%, which testifies to the positive effect of resting on the seed properties of the material.

The strongest sprouts were observed in the 65/50°C stepwise mode of drying. As can be seen from Fig. 13 all seed properties disappear in the 80/65°C stepwise mode. An 80/65°C stepwise drying mode shows that the influence of the 80°C temperature heating medium for 10 minutes completely destroys all seed properties.



**Fig. 13 - Germination rates of "Barvystyi" variety barley seeds depending on the drying mode on the 7th day of germination**

## CONCLUSIONS

The developed modes of drying allow making the drying of barley seeds more efficient with higher quality of seed material. The most appropriate mode for drying barley seeds is a two-stage drying mode 65/50°C which differs from the drying mode 50°C in that it increases the intensity of the process by 35%, germination rate – by 98% and reduces energy consumption by 62%.

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