



SOME COMPARISONS OF THERMAL ENERGY CONSUMPTION IN A TEMPERATE VERSUS A SUBTROPICAL ZONE

(Examples of computation of net energy needs for float heating and chamber drying)

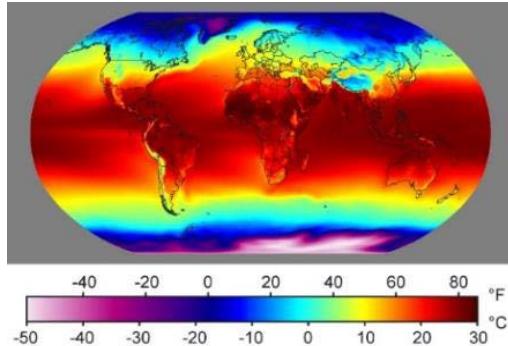
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Due to different ambient temperatures many would expect that the overall thermal energy consumption in a tannery in a hot climate zone is considerably lower than in a temperate zone. In reality it is somewhat more complex and worth comparing.
In any case, two very important factors, (i) temperature and (ii) humidity of inlet air are often overlooked in estimation of energy required for the crust and/or leather drying.

Figure 1. World climate zones – annual mean temperatures



Source: <http://www.wattsupwiththat.com>

The baseline data and/or assumptions:

The energy consumption is calculated for 1 t of wet salted hides and assuming that 1000 kg of wet salted weight corresponds to 1100 kg of pelt weight and 262 kg of grain leather and 88 kg of usable splits.

1. FLOAT HEATING

1.1. Temperate zone

1.1.1. Bating

Limed (pelt) weight: $G = 1100 \text{ kg}$, the water being 838 kg, leather substance (collagen) 262 kg

$$\begin{array}{ll} \text{Float 200\%} & G = 2200 \text{ litres} = 2200 \text{ kg} \\ \text{Inlet water temperature:} & t_w = 15^\circ\text{C} \\ \text{Process float temperature} & t_f = 35^\circ\text{C} \\ \text{Dry leather specific heat capacity:} & c_l = 1.5 \text{ kJ/kg}/^\circ\text{C} \\ \text{Water specific heat capacity:} & c_w = 4.1814 \text{ kJ/kg}/^\circ\text{C} \end{array}$$

The thermal energy necessary to heat the water for the bathing float:

$$Q_{\text{bathing, float}} = G * c * (t_f - t_w) = 2200 * 4.1814 * (35 - 15) = 2200 * 4.1814 * 20 = 184000 \text{ kJ}$$

The thermal energy necessary to warm the pelt:

$$Q_{\text{bathing, pelt}} = G * c * (t_f - t_w) = 262 * 1.5 * (35 - 15) = 262 * 1.5 * 20 = 7860 \text{ kJ}$$

The thermal energy necessary to heat the water contained in the pelt:

$$Q_{\text{bathing, water in pelt}} = G * c * (t_f - t_w) = 838 * 4.1814 * (35 - 15) = 838 * 4.1814 * 20 = 70080 \text{ kJ}$$

$$\underline{Q_{\text{bathing total}} = 184000 + 7860 + 70080 = 261940 \text{ KJ} = 262 \text{ MJ/t wet salted hides}}$$

1.1.2. Dyeing, fatliquoring

Shaved weight, grain: $G = 262 \text{ kg}$ containing about 130 kg of water, leather substance (collagen) 132 kg

| | |
|-------------------------------------|---|
| Float 200%: | $G = 524 \text{ litres} = 524 \text{ kg}$ |
| Inlet water temperature: | $t_w = 15^\circ\text{C}$ |
| Process float temperature: | $t_f = 60^\circ\text{C}$ |
| Dry leather specific heat capacity: | $c_l = 1.5 \text{ kJ/kg}/^\circ\text{C}$ |
| Water specific heat capacity: | $c_w = 4.1814 \text{ kJ/kg}/^\circ\text{C}$ |

The thermal energy necessary to heat the water for the dyeing and fatliquoring float:

$$Q_{\text{dyeing, float}} = G * c * (t_f - t_w) = 524 * 4.1814 * (60 - 15) = 524 * 4.1814 * 45 = 98600 \text{ kJ}$$

The thermal energy necessary to heat the leather:

$$Q_{\text{dyeing, leather}} = 132 * c * (t_f - t_w) = 132 * 1.5 * (60 - 15) = 132 * 1.5 * 45 = 8910 \text{ kJ}$$

The thermal energy necessary to heat the water contained in the leather:

$$Q_{\text{dyeing, water in leather}} = 130 * c * (t_f - t_w) = 130 * 4.1814 * (60 - 15) = 130 * 4.1814 * 45 = 24460 \text{ kJ}$$

$$\underline{Q_{\text{dyeing, total}} = 98600 \text{ kJ} + 8910 \text{ kJ} + 24460 \text{ kJ} = 132 \text{ MJ/t wet salted hides}}$$

1.2. Subtropical zone

1.2.1. Bating

| | |
|----------------------|---|
| Limed (pelt) weight: | $G = 1100 \text{ kg}$, the water being 838 kg, collagen 262 kg |
|----------------------|---|

| | |
|-------------------------------------|---|
| Float 200% | $G = 2200 \text{ litres} = 2200 \text{ kg}$ |
| Inlet water temperature: | $t_w = 25^\circ\text{C}$ |
| Process float temperature | $t_f = 35^\circ\text{C}$ |
| Dry leather specific heat capacity: | $c_l = 1.5 \text{ kJ/kg}/^\circ\text{C}$ |
| Water specific heat capacity: | $c_w = 4.1814 \text{ kJ/kg}/^\circ\text{C}$ |

The thermal energy necessary to heat the water necessary for the bathing float:

$$Q_{\text{bathing, float}} = G * c * (t_f - t_w) = 2200 * 4.1814 * (35 - 25) = 2200 * 4.1814 * 10 = 92000 \text{ kJ}$$

The thermal energy necessary to warm the pelt:

$$Q_{\text{bathing, pelt}} = G * c * (t_f - t_w) = 262 * 1.5 * (35 - 25) = 262 * 1.5 * 10 = 3930 \text{ kJ}$$

The thermal energy necessary to heat the water contained in the pelt:

$$Q_{\text{bathing, water in leather}} = G * c * (t_f - t_w) = 838 * 4.1814 * (35 - 25) = 838 * 4.1814 * 10 = 35040 \text{ kJ}$$

$$\underline{Q_{\text{bathing total}} = 131 \text{ MJ/t wet salted hides}}$$

1.2.2. Dyeing, fatliquoring

Shaved weight, grain: $G = 262 \text{ kg}$ containing about 130 kg of water, leather substance (collagen) 132 kg

| | |
|-------------------------------------|---|
| Float 200%: | $G = 524 \text{ litres} = 524 \text{ kg}$ |
| Inlet water temperature: | $t_w = 25^\circ\text{C}$ |
| Process temperature | $t_f = 60^\circ\text{C}$ |
| Dry leather specific heat capacity: | $c_l = 1.5 \text{ kJ/kg}/^\circ\text{C}$ |
| Water specific heat capacity: | $c_w = 4.1814 \text{ kJ/kg}/^\circ\text{C}$ |

The thermal energy necessary to heat the water for the dyeing and fatliquoring float:

$$Q_{\text{dyeing, float}} = G * c * (t_f - t_w) = 524 * 4.1814 * (60 - 25) = 524 * 4.1814 * 35 = 76700 \text{ kJ}$$

The thermal energy necessary to heat the leather for dyeing and fatliquoring:

$$Q_{\text{dyeing, leather}} = G * c * (t_f - t_w) = 132 * 1.5 * (60 - 25) = 132 * 1.5 * 35 = 6930 \text{ kJ}$$

The thermal energy necessary to heat the water contained in the leather for dyeing and fatliquoring:

$$Q_{\text{dyeing, water in leather}} = G * c * (t_f - t_w) = 130 * 4.1814 * (60 - 25) = 130 * 4.1814 * 35 = 19025 \text{ kJ}$$

$$Q_{\text{dyeing, total}} = 102.6 \text{ MJ/t wet salted hides}$$

2. LEATHER DRYING

As said earlier, the energy consumption is calculated for the input of 1 t of wet salted hides giving 262 kg of grain leather and 88 kg of usable splits; it is also assumed that both in temperate and hot climate the leather humidity before drying is 45 % and after drying 20 %.

Thus, the base values for grain leather are:

Dry leather substance in 262 kg of wet leather:

$$262 * 0.55 = 144.1 \text{ kg of dry leather}$$

$$\text{Water content in the leather before drying: } 262 - 144.1 = 117.9 \text{ kg}$$

$$\text{Dried leather weight with 20 \% humidity: } 144.1 / 0.8 = 180.1 \text{ kg}$$

$$\text{Water content in the dried leather: } 180.1 - 144.1 = 36.0 \text{ kg}$$

$$\text{Water evaporated: } 262 - 180.1 = \mathbf{81.9 \text{ kg}}$$

2.1. Temperate zone

The necessary data for the humid air are taken from the hx diagram and tables for humid air.

$$\text{Fresh air temperature: } t_f = 15^\circ\text{C}$$

$$\text{Fresh air relative humidity: } \varphi_f = 50 \%$$

$$\text{Fresh air absolute humidity: } x_f = 0.005 \text{ kg H}_2\text{O/kg dry air}$$

$$\text{Fresh (humid) air enthalpy: } h_f = 28 \text{ kJ/kg dry air}$$

$$\text{Volume of fresh air: } v_f = 0.833 \text{ m}^3/\text{kg humid air}$$

$$\text{Exhaust air, temperature: } t_e = 60^\circ\text{C}$$

$$\text{Exhaust air, relative humidity: } \varphi_e = 90 \%$$

$$\text{Exhaust air, absolute humidity: } x_e = 0.135 \text{ kg H}_2\text{O/kg dry air}$$

$$\text{Exhaust (humid) air, enthalpy: } h_e = 415 \text{ kJ/kg dry air}$$

$$\text{Volume of humid exhaust air: } 1.16 \text{ m}^3/\text{kg humid air}$$

The air capacity to absorb the evaporated water from wet leather:

$$x_e - x_f = 0.135 - 0.005 = 0.130 \text{ kg H}_2\text{O/kg dry air}$$

Theoretic quantity of the air (expressed as dry air) needed to absorb the evaporated water:

$$81.9 / 0.130 = \mathbf{630 \text{ kg of dry air}}$$

$$\text{The volume of fresh air needed: } 630 * 0.833 = \mathbf{525 \text{ m}^3}$$

The specific thermal energy necessary for water evaporation from the wet leather and air heating:

$$\Delta h = h_e - h_f = 415 - 28 = 387 \text{ kJ/kg dry air: } 630 * 387 = 243810 \text{ kJ} = \mathbf{243.8 \text{ MJ}}$$

$$\text{Dry leather specific heat capacity: } c_l = 1.5 \text{ kJ/kg}/^\circ\text{C}$$

$$\text{Water specific heat capacity: } c_w = 4.1814 \text{ kJ/kg}/^\circ\text{C}$$

The heat (energy) necessary to heat the leather from the ambient temperature (15 °C) to outlet temperature (60 °C) :

- fully dry leather: $144.1 * 1.5 * (60 - 15) = 144.1 * 1.5 * 45 = 9726.8 \text{ kJ} = \mathbf{9.73 \text{ MJ}}$

- remaining humidity in dried leather: $36 * 4.1814 * 45 = 6774 \text{ kJ} = \mathbf{6.77 \text{ MJ}}$

$$\text{The heat (energy) necessary for leather heating (15 - 60°C): } 9.73 + 6.77 = \mathbf{16.5 \text{ MJ}}$$

$$\text{The net amount of thermal energy needed to dry leather: } 243.8 + 16.5 = \mathbf{260.3 \text{ MJ}}$$

2.2. Subtropical zone

2.2.1. Average air temperature 30 °C, relative humidity 70%

The necessary data for the humid air are taken from the hx diagram and tables for the humid air.

| | |
|-------------------------------------|--|
| Fresh air temperature: | $t_f = 30 \text{ } ^\circ\text{C}$ |
| Fresh air relative humidity: | $\varphi_f = 70 \text{ %}$ |
| Fresh air absolute humidity: | $x_f = 0.019 \text{ kg H}_2\text{O/kg of dry air}$ |
| Fresh (humid) air enthalpy: | $h_f = 76 \text{ kJ/kg of dry air}$ |
| Volume of fresh air: | $v_f = 0.895 \text{ m}^3/\text{kg}$ |
| Exhaust air, temperature: | $t_e = 60 \text{ } ^\circ\text{C}$ |
| Exhaust air, relative humidity: | $\varphi_e = 90 \text{ %}$ |
| Exhaust air, absolute humidity: | $x_e = 0.135 \text{ kg H}_2\text{O/kg of dry air}$ |
| Exhaust air, enthalpy: | $h_e = 415 \text{ kJ/kg of dry air}$ |
| Volume of exhaust air: | $1.16 \text{ m}^3/\text{kg of air}$ |

The capacity to absorb evaporated water: $x_e - x_f = 0.135 - 0.019 = 0.116 \text{ kg H}_2\text{O/kg of dry air}$
 The theoretical quantity of air (expressed as dry air) needed to absorb the evaporated water:

$$81.9 / 0.116 = 706 \text{ kg of dry air}$$

The volume of fresh air needed: $706 * 0.895 = 632 \text{ m}^3$

The specific thermal energy necessary for the evaporation of the water from the wet leather and air heating:

$$\Delta h = h_e - h_f = 415 - 76 = 339 \text{ kJ/kg dry air}; 706 * 339 = 239346 \text{ kJ} = 239.3 \text{ MJ}$$

Dry leather specific heat capacity: $c_l = 1.5 \text{ kJ/kg}/^\circ\text{C}$

Water specific heat capacity: $c_w = 4.1814 \text{ kJ/kg}/^\circ\text{C}$

The heat (energy) necessary to heat the leather from the ambient temperature (30°C) to outlet temperature (60°C):

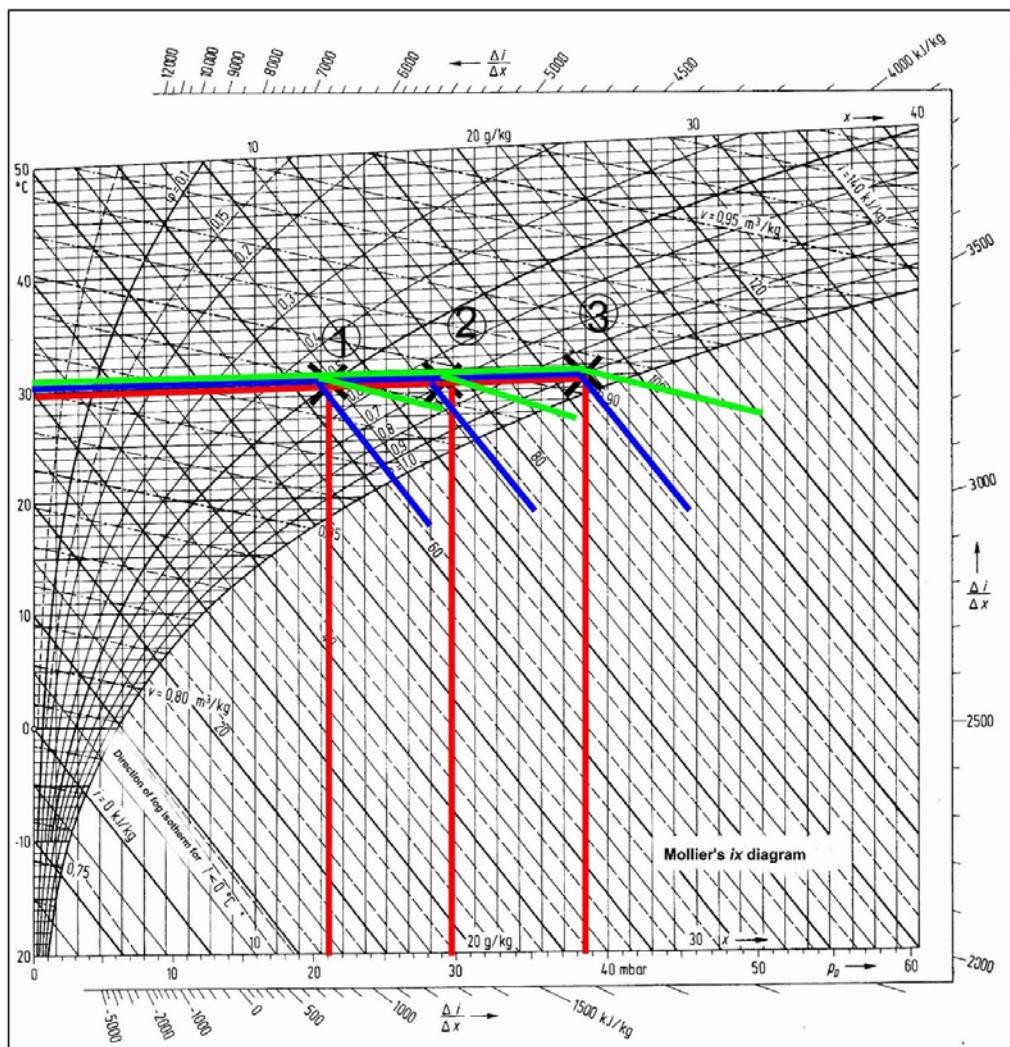
- fully dry leather: $144.1 * 1.5 * (60 - 30) = 144.1 * 1.5 * 30 = 6484 \text{ kJ} = 6.5 \text{ MJ}$
- the remaining humidity in dried leather: $36 * 4.1814 * 30 = 4516 \text{ kJ} = 4.5 \text{ MJ}$

The heat (energy) necessary for leather heating ($30 - 60^\circ\text{C}$): $6.5 + 4.5 = 11.0 \text{ MJ}$

The net amount of thermal energy needed to dry leather: $239.3 + 11.0 = 250.3 \text{ MJ}$

Water vapour with molecular mass of 18.04 g/mol is lighter than dry air (≈ 29 g/mol). Thus, the increase of water vapour content (humidity) results in lower air density because of Avogadro's law, which states "equal volumes of all gases, at the same temperature and pressure, have the same number of molecules." The higher number of water vapour molecules, the lower number of (heavier) air molecules.

Figure 2. The main parameters of wet air (Mollier's diagram) – subtropical zone



1. Fresh Air 30°C , 50 % relative humidity

- Fresh air, absolute humidity $0.0135 \text{ kg H}_2\text{O/kg of dry air}$
- Enthalpy of fresh (humid) air $65 \text{ kJ/kg of dry air}$
- Volume of fresh air $0.890 \text{ m}^3/\text{kg}$

2. Fresh Air 30°C , 70 % relative humidity

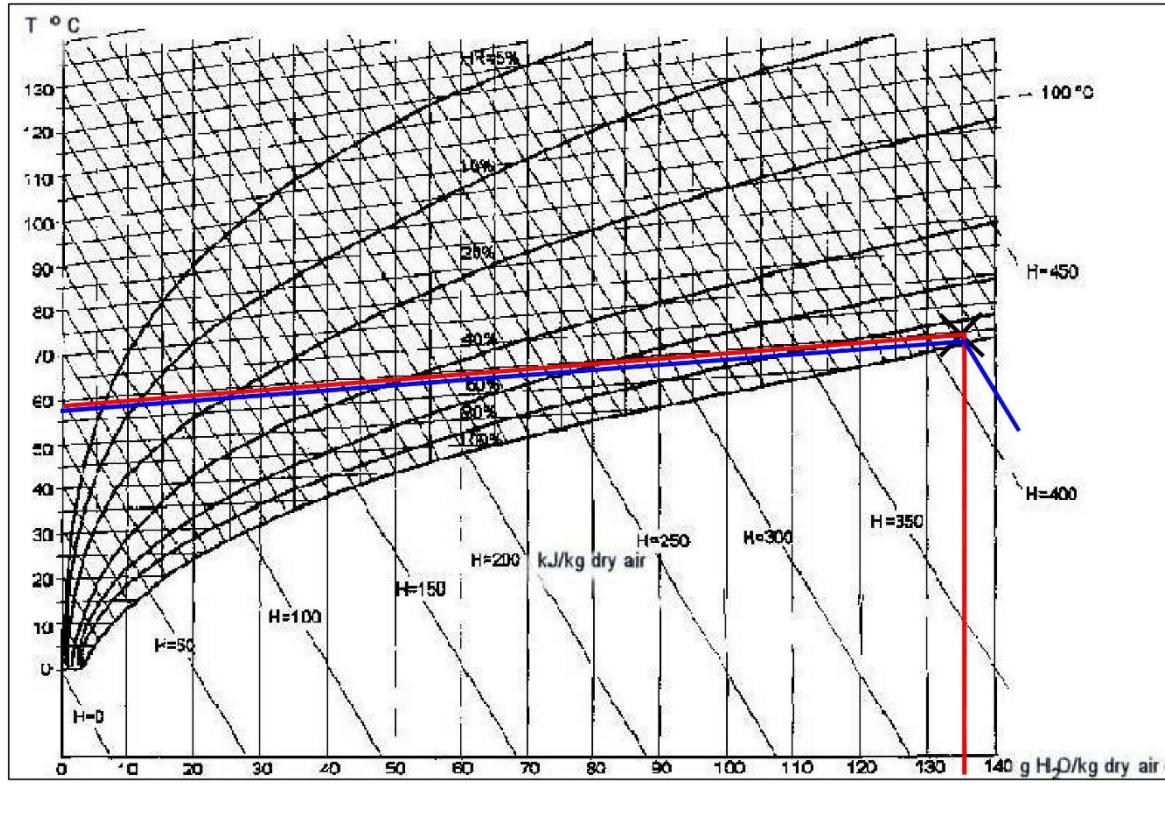
- Fresh air, absolute humidity $0.019 \text{ kg H}_2\text{O/kg of dry air}$
- Enthalpy of fresh (humid) air $76 \text{ kJ/kg of dry air}$
- Volume of fresh air $0.895 \text{ m}^3/\text{kg}$

3. Fresh Air 30°C , 90 % relative humidity

- Fresh air, absolute humidity $0.025 \text{ kg H}_2\text{O/kg of dry air}$
- Enthalpy of fresh (humid) air $93 \text{ kJ/kg of dry air}$
- Volume of fresh air $0.900 \text{ m}^3/\text{kg}$

Chart reading by M. Bosnić

Figure 3. The main parameters of wet (exhaust) air – 60 °C, relative humidity 90 %



— Exhaust air, absolute humidity 0.135 kg H_2O /kg of dry air
— Exhaust air, enthalpy 415 kJ/kg of dry air

Chart reading by M. Bosnić

The following table contains a summary of data and the corresponding computations.

Table 1: Comparative overview of thermal energy needs for leather drying for different ambient temperatures and air humidity

| PARAMETER | AMBIENT/INLET AIR TEMPERATURES AND HUMIDITY | | | |
|--|---|------------------|-------|-------|
| | TEMPERATE ZONE | SUBTROPICAL ZONE | | |
| Fresh air temperature, t_f | 15 °C | 30 °C | 30 °C | 30 °C |
| Fresh air relative humidity, φ_f | 50 % | 50 % | 70 % | 90 % |
| Fresh air absolute humidity, x_f , kg H_2O /kg of dry air | 0.005 | 0.0135 | 0.019 | 0.025 |
| Fresh (humid) air enthalpy, h_f , kJ/kg of dry air | 28 | 65 | 76 | 93 |
| Volume of fresh air, v_f , m ³ /kg | 0.833 | 0.890 | 0.895 | 0.900 |
| Exhaust air, temperature, t_e | 60 °C | 60 °C | 60 °C | 60 °C |
| Exhaust air, relative humidity, φ_e | 90 % | 90 % | 90 % | 90 % |
| Exhaust air, absolute humidity, x_e , kg H_2O /kg of dry air | 0.135 | 0.135 | 0.135 | 0.135 |
| Exhaust air, enthalpy, h_e , kJ/kg of dry air | 415 | 415 | 415 | 415 |

| PARAMETER | AMBIENT/INLET AIR TEMPERATURES AND HUMIDITY | | | |
|--|---|--------------------------|--------------------------|--------------------------|
| | TEMPERATE ZONE | SUBTROPICAL ZONE | | |
| Volume of exhaust air, m ³ /kg of air | 1.16 | 1.16 | 1.16 | 1.16 |
| The capacity to absorb water, x _e - x _f , kg H ₂ O/kg of dry air | 0.130 | 0.1215 | 0.116 | 0.110 |
| The theoretical quantity of air needed (expressed as dry air), kg of dry air | 630 kg | 674 kg | 706 kg | 745 kg |
| Thermal energy needed for water evaporation, Δh = h _e - h _f | 243.8 | 236 MJ | 239.3 MJ | 240 MJ |
| The volume of fresh (humid) air needed | 525 m³ | 600 m³ | 632 m³ | 671 m³ |
| Dry leather specific heat capacity, kJ/kg/°C | c _l = 1.5 | c _l = 1.5 | c _l = 1.5 | c _l = 1.5 |
| Water specific heat capacity, kJ/kg/°C | c _w = 4.18 | c _w = 4.18 | c _w = 4.18 | c _w = 4.18 |
| The energy needed to heat the leather from the ambient to the outlet temperature of 60 °C and humidity 20 %: | | | | |
| - fully dry leather | 9.73 MJ | 6.5 MJ | 6.5 MJ | 6.5 MJ |
| - the remaining humidity in leather | 6.77 MJ | 4.5 MJ | 4.5 MJ | 4.5 MJ |
| The energy needed for leather heating | 16.5 MJ | 11.0 MJ | 11.0 MJ | 11.0 MJ |
| The total amount of thermal energy needed to dry leather | 260.3 MJ | 247.0 MJ | 250.3 MJ | 251.0 MJ |

3. THE COMPARISON OF NET THERMAL ENERGY NEEDS

3.1. Float heating

3.1.1. Bating

Q_{bating} total subtropical zone = 131 MJ/t of wet salted hides

Q_{bating} total temperate zone = 262 MJ/t of wet salted hides

Ratio: 131/262 = 50 % or 1: 2

3.1.2. Dyeing, fatliquoring

Q_{dyeing} total, subtropical zone = 103 MJ/t of wet salted hides

Q_{dyeing}, fatliquoring total, temperate zone = 132 MJ/ of wet salted hides

Ratio: 103/132 = 0.78 = 78 % i.e. nearly 20 % less

Table 2. The comparison of net thermal energy needs for chamber drying

| | AMBIENT/INLET AIR TEMPERATURES AND HUMIDITY | | | |
|--|---|--------------------|--------------------|--------------------|
| | TEMPERATE ZONE | SUBTROPICAL ZONE | | |
| | | 15 °C, 50 % | 30 °C, 50 % | 30 °C, 70 % |
| The total thermal energy needed to dry leather | 260.3 MJ | 247.0 MJ | 250.3 MJ | 251.0 MJ |
| The ratio subtropical vs. temperate climate | - | 95 % | 96.2 % | 96.4% |
| The volume of fresh air needed, m ³ /t of w. s. hides | 525 m ³ | 600 m ³ | 632 m ³ | 670 m ³ |
| The ratio subtropical vs. | - | 114 % | 120 % | 128 % |

The energy needs computed here are net amounts, i.e. regardless of the source and without taking into account any losses. Thus, the total energy needs are much higher.

The ratios computed for grain leather are valid for split leather as well.

Figure 4. A pole-drying tunnel



Source: Demaksan

CONCLUSIONS

A simple computation based on estimated average yearly fresh water and air (ambient) temperatures shows that the amount of net thermal energy needed for heating the float in (sub)tropical zone (South India) is from 20% (dyeing) to about 50 % (bating) of that in the temperate zone (Middle Europe).

Chamber drying in (sub)tropical zone benefits from the higher ambient (air) temperature but at the same time it is negatively affected by high relative humidity and consequently much higher volume of fresh air required. However, the fact that the energy required for water evaporation¹ does not change much with water temperature ultimately prevails over parameters such as ambient (air) temperature and air humidity. Accordingly, energy consumption for chamber drying in (sub)tropical zone with average air temperature of 30°C and relative humidity in the span of 50-90 % is only about 5 % less than in the temperate zone.

However, if the solar energy is used to support water heating, the conditions in the tropic zone are substantially more favourable, due to two factors:

- insolation
- efficiency factor (depends on the temperature difference of the *final* vs. *inlet water temperature*)

The insolation in the temperate zone (Europe) is approx. 1500 kWh/m²/y (4.1 kWh/m²/d), and in the tropical zone (South India) approx. 2200 kWh/m²/y (6.0 kWh/m²/d), so that the factor of proportionality is 1.5. Since the efficiency ratio case can be estimated as 1.05 it means that the solar

¹ **The (latent) heat of vaporization** is the amount of energy (enthalpy) that must be added to a liquid substance to transform a quantity of that substance into a gas. The enthalpy of vaporization is a function of the pressure at which that transformation takes place.

based production of thermal energy in a hot climate country is about 1.6 times more favourable than in temperate climate.

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