

THE EFFECT OF CONDITIONING ROLLS, FEED RATE
AND THE NUMBER OF PASSES ON
FORAGE DRYING RATE

By

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PREFACE

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CHAPTER I

INTRODUCTION

Relevance of the Research

Hay is produced in every state in the U.S.; in 1975 about 121 million metric tons of hay were harvested from more than 25 million hectares. The state of Oklahoma in the same year harvested 710 thousand hectares. This was a production of about 3.39 million metric tons which ranked twelfth in production and harvested area for 1975 in the U.S.

Alfalfa is the most common hay crop. In 1975, it was grown on more than 6.9 million hectares in the U.S. and 208.5 thousand hectares in the state of Oklahoma with a production of about 71 million metric tons and 1.5 million metric tons, respectively. Table I shows alfalfa and alfalfa mixture areas and production for states producing more than 1 million metric tons in the U.S.

Alfalfa cultivation amounted to about 28% of total hay acreage for 1975, and about 44% of 1976 preliminary estimates. This indicates a high demand for more hay production.

In hay making, one factor that cannot be controlled is the weather. Rainy damp weather can account for severe quality losses on windrowed or square baled hay left in the field. Curing hay without excessive loss is an important part of an efficient operation. The

TABLE I
 ALFALFA AND ALFALFA MIXTURES AREA
 AND PRODUCTION FOR STATES ABOVE
 1 MILLION TONS 1975-1976

No.	State	Area Harvested 1,000 Hectares		Production 10,000 Metric Tons	
		1975	1976*	1975	1976*
1	AZ	87	85	1,368	1,336
2	CA	453	445	6,007	6,000
3	CO	299	287	1,682	1,743
4	ID	417	413	3,465	3,292
5	IL	312	295	2,310	2,256
6	IN	170	162	1,145	1,091
7	KS	801	405	2,539	2,500
8	MI	405	397	2,500	2,316
9	MN	890	886	5,900	4,181
10	MO	214	202	1,253	1,045
11	MT	498	473	2,572	2,340
12	NB	688	688	4,173	3,864
13	NY	376	401	2,283	2,430
14	ND	668	656	2,850	1,915
15	OH	212	223	1,405	1,475
16	OK	208	202	1,475	1,455
17	OR	170	170	1,222	1,260
18	PA	332	332	2,013	2,050
19	SD	1,052	931	3,545	1,673
20	UT	186	186	1,338	1,464
21	WA	202	202	1,591	1,636
22	WI	1,222	1,218	7,825	6,020
23	WY	190	188	1,025	994
TOTAL U.S.		6,917	10,747	76,751	63,555

*Preliminary Estimates.

Source: Agricultural Statistics 1977 United States Department of Agriculture, pp. 271

usual locations used for curing hay are the field, the barn, and the dehydrator. Field-curing is prevalent in the United States and over the world because it is inexpensive, but losses in quality and quantity are greater than with the other two methods.

Work has been done at several locations in the United States. Since 1933, (Zink, 1933; Bohstedt, 1944; Jones and Dudley, 1948; Bruhn, 1955 and 1959; Casselman and Finham, 1960; Pedersen and Buchele, 1960; Kepner et al., 1960; Hellwig, 1965 and 1977; Barrington and Bruhn, 1970; Priecke and Bruhn, 1970; Straub and Bruhn, 1975) have proved the positive effect of mechanical conditioning on reducing the required field curing drying time compared to unconditioned hay.

Since the leaves of hay dry more rapidly than the stems (Pedersen, 1959); by the time the stems have reached a moisture level sufficient for storage (20 percent wb), the leaves have been over-dried. This excessive drying of the leaves only serves to increase shattering losses in subsequent operations. Studies conducted related to conditioning rolls have shown that cracking the hay stem exposes more area for moisture loss and thus speeds the drying rate of stems more than leaves. This causes an equalizing of the leaf and stem drying rate and decreases losses (Pedersen, 1959).

Manufacturers have used different ratios of cutter bar width to conditioning roller width. This changes the feed rate through the rollers significantly, as does the variation of feed rate due to variation of ground speed and yield. Information about the feed rate effect is required to know which type of roll will be more suitable for the higher "width of cutter bar/width of rollers" ratio.

Bruising of the plant stem from using a cycle mower by Shepperson et al. (1974) showed an increase in the drying rate but there was no information found about effect of such type rollers.

Scope of the Investigation

The study described in this thesis was designed to evaluate the effect of feed rate, the number of passes, the type of rollers and compare the performance of a new type of roller with four different common commercial rollers in a defined laboratory condition.

A stationary conditioning system with capability of producing single or double hay crushing, crimping and bruising by rollers of different shape and size, variable speed and feed rate and pressure was used. Samples were treated under constant pressure, different levels of feed rate, and number of passes. Five types of rolls were used. Samples were dried under controlled temperature and relative humidity conditions. The weight was recorded automatically with six cantilever beam transducers. Finally, samples were transferred to high temperature drying ovens for dry matter determination.

A factorial split-split block in time design in two seasons with two and five replications for thirty factorial treatment combination was used to determine drying rate of alfalfa and its relation with type of roll, number of passes and feed rate.

Objectives

1. To determine the most effective type of roll which increases the drying rate of the forage.
2. To determine the effect of the number of passes through the

rolls on drying rate.

3. To determine effect of feed rate on drying rate.
4. To compare the relative effect on the drying rate of forage of a bruising type of roll with crushing and crimping types.
5. To develop a prediction equation for predicting rate of drying in time.

CHAPTER II

REVIEW OF LITERATURE

Following World War II, changes in methods and equipment for hay handling began to take place rapidly and by the middle 1960's the man-power required to produce a ton of hay had been reduced to one-third of that required 25 years earlier according to Butler (1970). The farming operation required to produce a good seeding and to grow an alfalfa crop are well established. The difficult part of alfalfa production occurs in harvesting the forage so as to save the maximum feeding value. These difficulties in hay harvesting are found throughout the humid regions of the world. They are due in part to the fact that the period of time between rains is less than the time required to cure the hay and transport it to the barn.

There are two general ways to harvest and store forage crops -- making them into silage or drying them. There are two ways to dry them -- naturally (field curing) and artificially. Artificial drying is done also in two ways -- barn finishing or dehydration. Barn finishing has received a great amount of attention since 1940; the forage is partly dried in the field, then it is placed in a mow, and natural or heated air is forced through the forage to complete the drying.

In artificial dehydration, the forage is taken from the field as soon as it is cut (in some instance it is allowed to wilt), chopped

and passed through suitably constructed drying chambers where it comes in contact with heated air. This rapidly evaporates the moisture in it. The rate of drying depends on the amount of water in the forage, the temperature and humidity of the surrounding air, and the kind of forage and texture of the plant. The artificial drying generally produces forage of higher feeding value than natural drying and losses of nutrients are also somewhat smaller. The introduction of artificial aids to replace the natural drying generally adds to the costs. The relative advantages of such aids, therefore, must be weighed against the cost in individual situations.

Gray (1948) has pointed out that dehydration is naturally more expensive than when the hay is left in the field to dry for 1 or 2 days to approach a moisture content of 20 to 40 percent.

For all of the previously mentioned methods, the drying cost will decrease as higher drying rates are provided during field curing and the amount of losses will be decreased as the difference in drying rate of leaves and stems is decreased.

Several methods have been used to decrease the field curing time.

Chemical Application

Chemical application serves in two ways to decrease the field curing time.

- a. By increasing the drying rate.
- b. By increasing the maximum allowable moisture content for safe storage.

Tullberg (1976) has treated lucerne by rapid immersion in aqueous potassium carbonate solution (0.18 M) under laboratory conditions which

has resulted in a substantial increase in simulated field drying. In field experiments done by Tullberg again on lucerne, the field results have supported the laboratory results. Lucerne treated with heavy applications (3000 liters per hectares) of .18 M aqueous potassium solution has dried faster than severe mechanical conditioning. At a lower application rate (200 liter per hectares), potassium carbonate treated lucerne was significantly drier than untreated material.

Knapp et al. (1975) reported on a study conducted to determine the effectiveness of anhydrous ammonia (NH_3) as a preservative to prevent microbial activity and consequent dry matter and digestibility losses in hay that was intentionally or unintentionally stored at moisture levels above 20 percent. Alfalfa baled at 32 percent moisture content was treated with ammonia (NH_3) at 1.0 percent level of the weight of the hay and lost 5.2 percent less dry matter than did untreated alfalfa.

Manby and Shepperson (1975) has reported that if propionic acid at a 2 percent level by weight can be uniformly distributed, it seems likely that it will inhibit mold development on hay having up to 35 percent moisture content.

Also, Bush (1977) has reported that an application to hay of 20 percent propionic acid and 30 percent formalion at 1 percent rate of the weight of hay and with the hay stored at 30 percent moisture content (wb) will result in a quality of that approximately equal to any baled hay under ideal conditions, i.e., about 18-22 percent moisture content (wb).

Hot Water Blanching

In a study conducted by Priepke (1970), a blanching treatment was performed by dipping the cut alfalfa into boiling water for 10 seconds. The results indicated that for treated samples the same level of water remained after about 3 hours and it approached a point where only 20 percent of the original water content remained after five hours and forty minutes. In this same time period, the untreated sample approached about 28 percent of the original water content.

Flaming

The flaming treatment was performed manually on the cut alfalfa with a propane torch. The alfalfa was flamed such that occasionally brown scorch marks appeared on the surface. The results reported by Priepke (1970) indicated that the treated sample approached 0.2 fraction of water remaining at about three hours and forty minutes after cutting while the control was approached about .39 fraction of water remaining.

Mechanical Treatment

In 1933, Zink reported that the alfalfa hay passed through a set of rolls, one made of steel and the other steel covered with rubber, had dried faster than ordinary mowed hay. He also reported that the rate of drying in stems was much slower than leaves. Under field curing conditions when there was 30 percent moisture in the complete alfalfa plant, he observed only 16 percent moisture content (wb) in leaves while the stems had 38 percent (wb) moisture content. Kiessel-

back and Anderson (1926), earlier under laboratory conditions, had obtained similar results. They found that first cutting alfalfa hay with 20 percent moisture (wb) was composed of leaves containing 12 percent and stems containing 27 percent moisture (wb).

Zink (1933) with observed data concluded that if 25 percent moisture content is a safe moisture level for storage, the crushed hay could be stored 4 hours after cutting while non-crushed hay did not reach 25 percent moisture content until 9:50 a.m. on the second day. As a result, the rolling and crushing would have permitted cutting it in the morning and placing it into storage in the afternoon.

Salmon, et al. (1925) found that over seven seasons of cuttings, including four stages of maturity, an average of 19 percent of the leaves was lost. This loss was found to vary from 2.3 percent to as much as 34 percent.

Similar works have been carried on with crushers in the early 1930's with a machine designed by Cushman and were conducted by Alvos (1932), Madson and Bainer (1930) in cooperation with the Food Machinery Corporation, San Jose, California. The early machine was a self-propelled unit and consisted of a cutter bar and draper similar to a grain binder platform with a set of crushing rolls fed by the platform draper. The machine was equipped with a spreader to redistribute the crushed material on the ground. Corrugated rubber-covered steel rollers were used on this early machine, and it was equipped with rotating brushes to keep the rolls clean. Later, the machine was redesigned with the crushing rolls parallel to the cutter bar and of essentially the same length.

This later machine was equipped with one smooth rubber-covered roll and one smooth steel roll. Subsequent experimental works by Smith and Jones (1939), Reed (1932), and Jones and Dudley (1948) were carried on with crushers at agricultural experiment stations. These crushers picked the forage out of a swath and crushed it, some also were a combination mower-crusher. These machines varied considerably in detail, some being engine driven and some driven by tractor power take-off.

Later, experimental work was carried on with commercially available or experimental machines.

Bruhn (1955) reported seven years of investigative findings with a commercial machine and one experimental machine as follows:

- a. Greatest gains in drying rates were experienced when drying conditions are very good, and the advantage of crushing diminished gradually with poorer drying conditions until the point is reached where neither crushed nor uncrushed forage dries.
- b. Also greatest gain in drying rate was achieved with a higher number of passes, that is, 3 times crushed dried faster than did 2 times, 1 time or no crushing at all; 2 times crushed dried faster than 1 time and no crushing but slower than 3 times crushed.
- c. Roll pressure up to a certain point was effective in increasing the drying rate; as the pressure per linear centimeter of roll length was increased, a higher drying rate was achieved.
- d. An increase in the ratio of roll surface speed to ground speed had shown a trend to raise the drying rate. He also pointed out that under certain conditions, forage crushing may bring

about clipping and stripping of small stems and leaves from the main plant stem.

Bruhn (1959) reported on the effect of delayed crushing and the relationship of drying rate and clipping of leaves and small stems from the main stem as a result of crusher or conditioner action. Data collected from smooth steel-roll crusher and bar-type corrugated-roll crusher indicated that the uncrushed material and the advantage of higher drying rate of the crushed material was lost for the extent of the delay. After crushing had taken place, drying had proceeded essentially at the same rate as for a sample of comparable hay crushed immediately after cutting. The results also indicated that losses were inversely proportional to ground speed and that the amount of losses in samples treated with the smooth steel roll were higher than for the untreated hay, and were lower than for flail-type chopper conditioned hay.

Boyd (1959) classified conditioning rolls as either crusher or crimpers and from collected data from field experiments concluded that, in general, crushing was somewhat more effective than crimping timothy-brome mixtures. Flail cut material had the most rapid drying rate but he also pointed out that, one apparent disadvantage appears to be the greater overnight moisture pickup in the conditioned crop. However, this was largely offset by virtue of the more rapid loss of moisture during the morning hours.

Kurtz (1968) and Halyk (1966) reported results that were opposite of that of Boyd (above) in that crushed hay dried faster than flail mower treated hay. However, Hall (1964) had results that agreed with Boyd's results. Hall listed the advantages of hay conditioning as

follows:

- a. Speeds field curing; conditioning can reduce drying time by about 30 percent.
- 1 b. May prevent weather damage by shortening the time that hay remains in the field after cutting. This improves the chance of putting it up without damage.
- c. Field losses due to shattering are reduced as drying time and the amount of turning and tedding are reduced.
- d. Conserves color and feed value through shorter exposure to sunlight and less shattering.

Steam

Byers (1966) applied steam, crimping and steam-crimping treatments to field samples of alfalfa collected at the pre-bloom stage of maturity -- and placed the samples in a laboratory experimental dryer at 36° C and 28 percent relative humidity. Plotted data indicated that after two hours and fifty minutes of drying that the control, steamed, crimped, and steamed-crimped samples had approached about 41, 29, 25, and 9 percent moisture content (wb), respectively. He also pointed out that the steamed-crimped treatment caused the epidermis to be cracked and the cells to be split apart toward the pith. Also, the breaking of a few cells was observed; this breaking caused more cells to be exposed to the drying air. However, as soon as these exposed cells dried, the drying rate again became that of an untreated plant. This indicates that the drying rate was limited to the decreasing permeability of the cell walls, cytoplasmic membrane, and/or stomata action. He also pointed out that chemical change was another mechanism

which could be accounted for change in the cell wall permeability as an analysis of steamed and non-steamed alfalfa, after drying, indicated that the alcohol-soluble nitrogen had been doubled in non-steamed samples.

Crushing and Dipping in a Carbon Tetrachloride (CCl_4) Solution

Priepke and Bruhn (1970) reported on an experiment involving crushing, dipping in CCl_4 and a combination of crushing and dipping in CCl_4 (Table II).

Crushing with Heated Rolls

Crushing with heated rolls including three treatments was also reported by Priepke (1970). The results indicated that all treatments were dried faster than non-treated material. Hay crushed with rolls having a surface temperature of $182^\circ C$ dried the fastest but hay crushed with rolls heated to $138^\circ C$ had dried slower than crushing with rolls at ambient temperature. He pointed out that heating to $182^\circ C$ may have had the effect of melting the cuticle to expose some of the stems surface resulting in less drying resistance.

Crushed and Microwave

This experiment was reported by Priepke (1970). The samples for this treatment were first crushed and then placed in the microwave oven for 5 seconds. The results indicated that the combined treatment of crushing and microwave drying dried slightly faster than a crushed treatment dried under ambient drying conditions.

TABLE II
FRACTION OF WATER* REMAINING AFTER 3 AND 4 HOURS

	3 Hours	4 Hours
Crush and Dip in Cl ₄	0.09	0.08
Dip in Cl ₄	0.21	0.17
Control - Crush	0.19	0.11
Untreated	0.45	0.35

*Fraction of Water = $\frac{\text{Weight of water at time } t}{\text{Initial weight of water in the sample}}$

A report by Straub and Bruhn (1975) evaluated four sets of rolls under the laboratory conditions of a mean dry bulb of 32.7° C and a mean wet bulb of 20° C. This corresponded to relative humidity of 35 percent.

The results were:

- a. An increase in roll pressure caused an increase in losses.
- b. Driving only one roll of the intermeshing rubber conditioning roll pair significantly increased potential clipping losses over having both rolls driven (while others did not show the same effect).
- c. In the treatment where both rolls were driven, the rubber intermeshing rolls had the lowest amount of loss, the conventional ribbed steel and tie-cord rolls were intermediate in their losses and the tie-cord intermeshing rolls had the highest losses.
- d. An increase in roll pressure tends to increase the drying rate. This was true except in a one-roll driven situation where a tendency to decrease the drying rate was noted. The both-driven intermeshing rolls' drying rate also tends to decrease but the difference doesn't seem to be significant compared with a control treatment. In the case of rubber intermeshing rolls, Straub explains that the compliance of the rubber coating tends to reduce the effect of increase pressure. Surface deformation within the material decreases the effect of pressure. In the case of the tie-cord rolls, the conditioning is administered by two very stiff and aggressive surfaces which are continually in contact, thus having maximum

effect as pressure increases.

- e. The laboratory method allows for elimination of such factors as changing or unfavorable weather conditions.

CHAPTER III

EXPERIMENTAL EQUIPMENT AND SETUP

The System

Data for this research project were collected from a laboratory forage conditioning and drying system. The system consisted of harvesting, conditioning, partial drying, weighing and complete drying systems. To measure the samples wet weight, two scales with a sensitivity of 1 gram and .01 gram were used. The cooling system, partial drying oven and complete drying oven temperature were controlled by automatic thermostat controls. A nylon net with 2 clips was used for wrapping samples. Aluminum pans were used for the complete drying process. A brief description of the systems and equipment is presented below.

Harvesting System

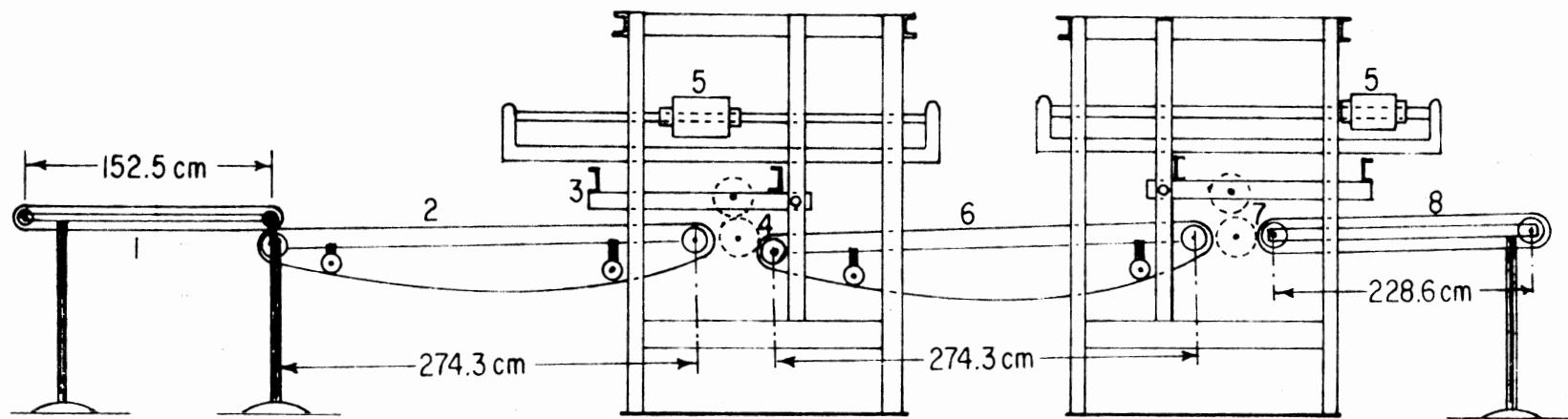
Alfalfa was mowed with a Jarri mower (Figure 1) to a common height of approximately 3.75 to 5 cm.

Conditioning System

The forage conditioning system (Figure 2) consists of a hydraulic drive central panel (Figure 3a-b); conveyors (Figure 4); rolls (Figure 5a - 5e); and two sets of load systems (Figure 6).



Figure 1. Jarri Mower Used for Alfalfa Harvesting



- 1. The belt conveyor.
- 2. The chain conveyor.
- 3. The upper roll frame.
- 4. The set of conditioning rolls.
- 5. The moveable weight.
- 6. The chain conveyor.
- 7. The set of conditioning rolls.
- 8. The belt conveyor.

Figure 2. The Forage Conditioning System

The Hydraulic Power System (Figure 3b) consists of two 3 phase 1780 RPM electrical motors plus one main and several small hydraulic motors. The small 3.73 kilowatt-hours electrical motor served as a starter and the 56 kilowatt-hours electrical motor served to operate the main hydraulic pump. Several small hydraulic motors were used to provide independent operation of rollers and conveyors for variable speed. The control system consists of an electro-hydraulic panel (Figure 3a) with controls for four individual hydraulic motors. For each of the two sets of conditioning system, a control was provided for the roll speed and the conveyors' speed. The control panel included a control switch for the first belt conveyor's operation. The control panel also controlled the conveyors' and rollers' speeds independent of each other and for each conditioning system.

The conveyor system consists of four conveyors. The first one was a belt type and was used for hand distribution in different concentrations to simulate different feed rates. The second one was a stainless steel chain conveyor. It was used for feeding hay through the rolls. The third one was also a stainless steel chain conveyor and it was used for stopping samples of the "one pass" treatment as well as for feeding the second set of rolls for the "two passes" treatments. The fourth conveyor was also a belt type and it served for receiving conditioned hay from the second rolls and was stopped for taking samples from the conditioned hay.

Conditioning rolls were mounted according to factorial treatment requirements. Five types of rolls shown in Figure 5a to 5e were used. The specification of these rolls is given in Table III. Types 0, 1, 2, and 3 were cut and constructed from common existing commercial rolls.

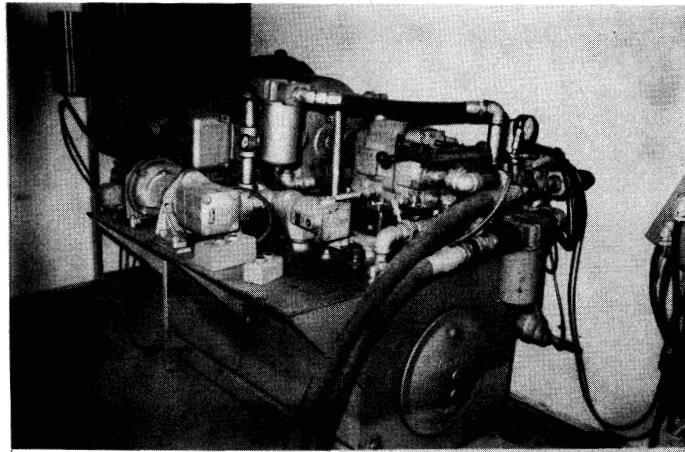


Figure 3a. The Hydraulic Power System

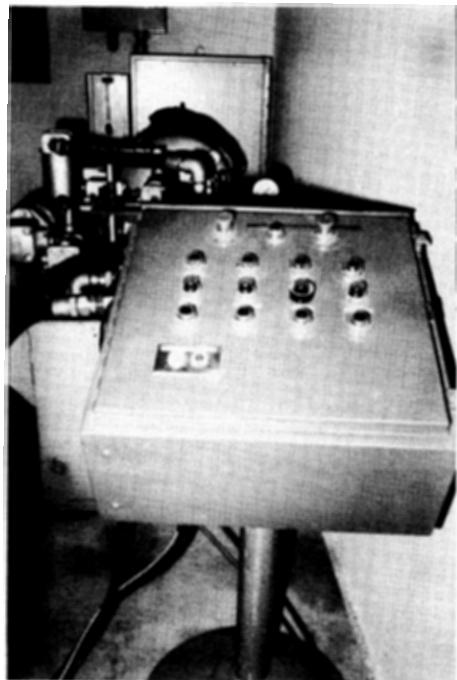


Figure 3b. The Control System
Electric-
hydraulic Panel

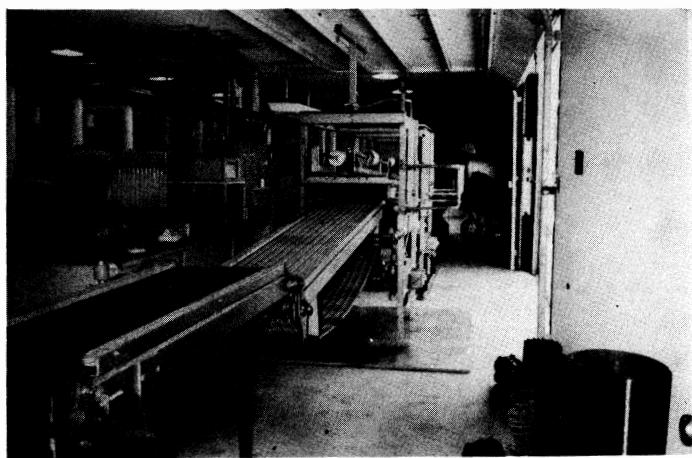


Figure 4. The Conditioning System with Belt
and Chain Conveyors

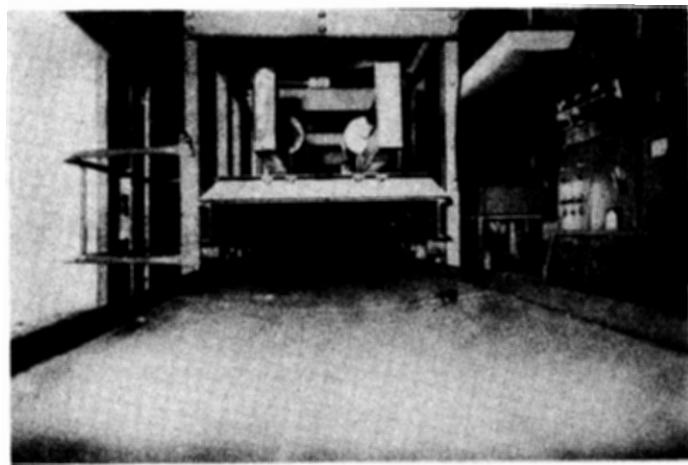


Figure 5a. Steel Tie-cord Rolls Mounted on
the Conditioning System (0)

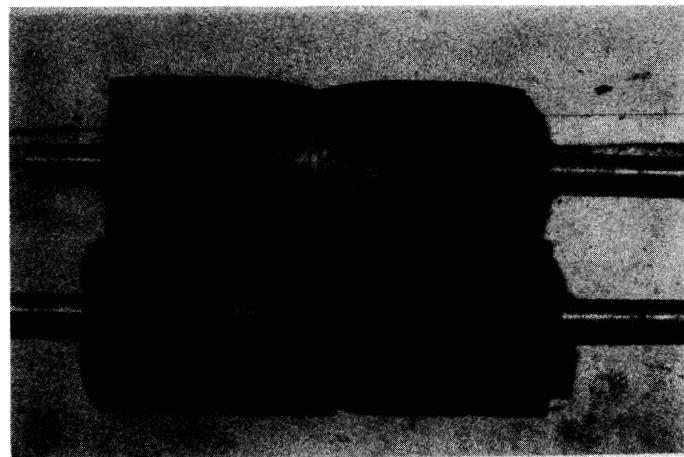


Figure 5b. Rubber Intermeshing Rolls (1)

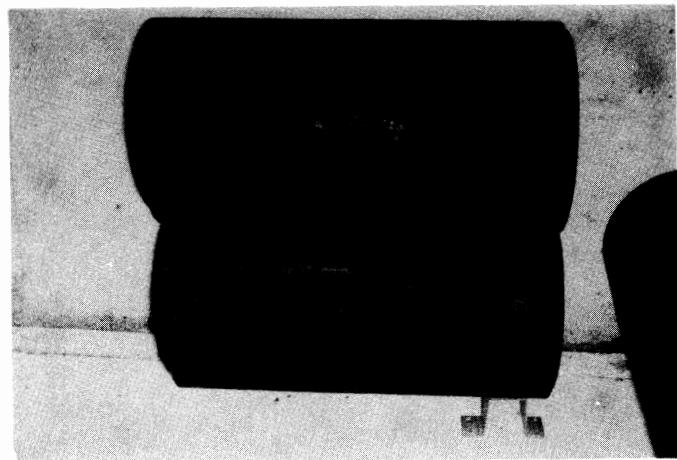


Figure 5c. Smooth Rubber Rolls (2)

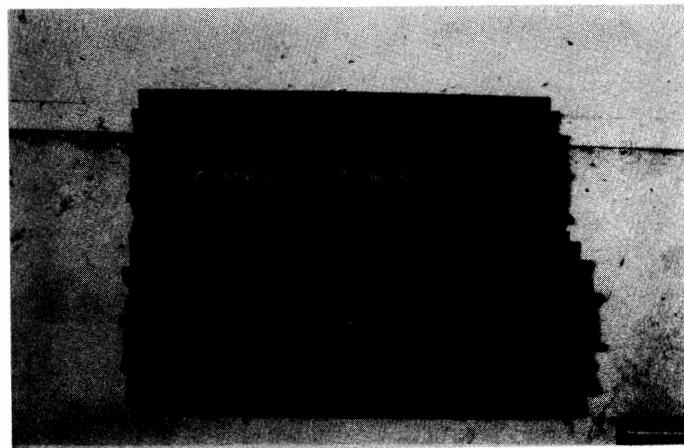


Figure 5d. Steel Crimper Rolls (3)

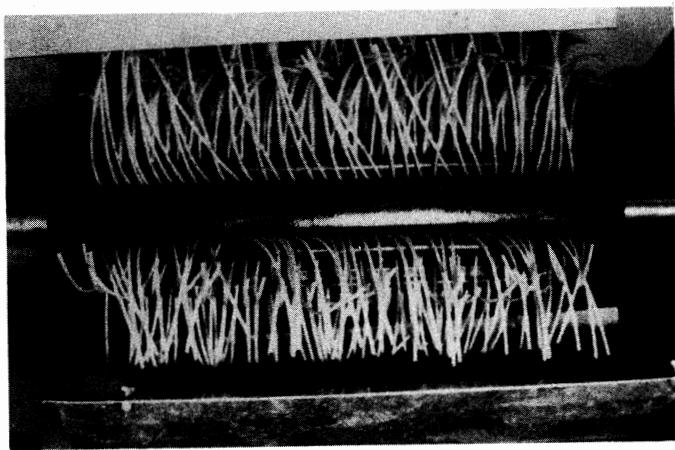


Figure 5e. Plastic Cord Rolls (4)

TABLE III
THE CONDITIONING ROLLS AND THEIR SPECIFICATION

Roll Number	Type of Roll		Width (cm)***	Do* (cm)	Di** (cm)	Roll Speed R.P.M.	Clearance cm
0	Steel - tie cord	Upper steel, channels 2.86 cm wide x 1.27 cm high	45.7	17.8	15.2	250	0.159
		Lower tiecord 4 grooves, 1.77 cm deep, 1.9 cm wide	45.7	17.8	15.2	250	0.159
1	Rubber Intermesh-ing (broken-gear type)	5.4 cm width, 1.59 cm height grooves		45.7	19.7	16.5	227
2	Smooth Rubber		45.7	24.1	--	182	0.159
3	Steel Crimper	0.635 cm wide x 2.22 cm height		45.7	19.7	15.2	227
4	Plastic Cord		45.7	39.7	7.9	500	--

*Do = Roll outer diameter

**Di = Roll inner diameter

***cm = Centimeters

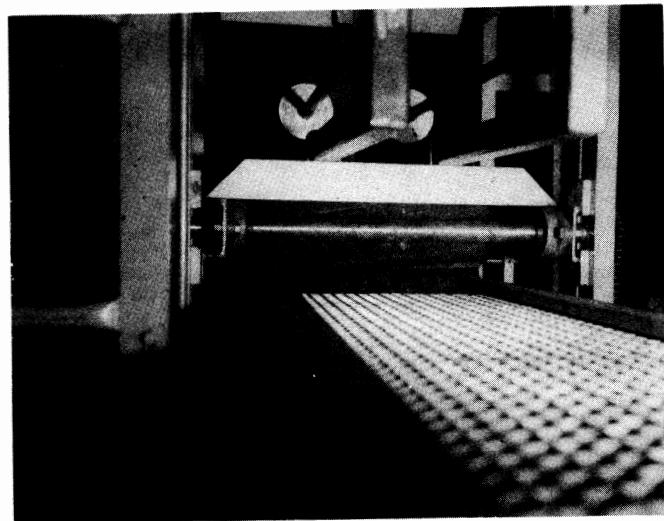


Figure 6. The Pressure Applying System with
Frame Upper Roll on It, Two
Bars, and Two Weights

The type 4, which was used as a bruising type roll, was made in the Oklahoma Cotton Research Station shop. It was made of nylon cords, each having a diameter of 3 mm. The length of each cord was 31.5 cm and were held in place using a 6.35 mm inner diameter pipe and a channel as shown in Figure 5e. These were attached to a core made of a 46 cm length of steel pipe with 8 cm outside diameter. The nylon cords were located on each bar 12.7 mm apart around the core surface. When in the conditioning system, the single roll was covered by a curved metal surface from above and with one from below. The upper cover was extended to behind the roll and was bent in a 35° angle to provide a deflector to contain the hay as it passes through the roll to provide more injury to the hay (Figure 7) as this was thought to possibly increase the drying rate.

The pressure was applied by a pivoted upper roll support frame which includes two bars, each with a moveable 22.6 kgs weight. The linear pressure per centimeter was a function of the location of the weight on the bar and the bar location on the upper roll frame.

Partial Drying System

The drying system was designed to dry six samples of alfalfa hay, up to 130 grams each, under controlled temperature and relative humidity conditions. It consisted of an air cooling unit, a fan, and the drying unit (Figure 8).

The cooling system¹ (Figure 9) had a capacity of 0.75 cubic meter

¹ Lab-Line Ambi-Hi-Lo Chamber Cat. No. 355-17-3554-18, Lab-Line Instruments, Inc., Melrose Park, Illinois 60160.



Figure 7. Plastic Cord Roll with Upper and Lower Covers



Figure 8. The Partial Drying System, (Left)
The Cooling System, (Right)
First Drying Oven, and (Middle)
The Air Pump

and it takes in conditioned air from the laboratory room at the edge of the door. The cooling unit served as a refrigerator which produced saturated cool air at a controlled temperature. The cool air exited at the lower edge of the door and was moved by fan into the dryer unit.

The fan (Figure 10) was located between the cooling and heating units to receive the saturated air and to deliver it to the top of the drying oven.

The drying unit (Figure 11) served to receive the air and heat it to an adjustable temperature by virtue of a 500 watt heater.

A fan forced the heated dry air through the forage samples hanging on the cantilever beams. The edge of the oven was opened to the laboratory room for air to exit. The laboratory room itself was also air conditioned so it served as an air reservoir for the system.

Weighing and Recording System

The weighing and recording system consisted of six cantilever beams and a Beckman Type R Dynograph². The beams (Figure 12a) were trapezoidal shaped, made of 4.76 mm 7075-T6 aluminum sheets 12.7 mm base, 8 mm top width and 28 cm length. Dual pattern strain gages were mounted on both the upper and the lower sides of the beam (Figure 13) to produce four active arm bridges thus creating a force transducer. The six cantilever beams were connected with shielded cables to the six channels of the Beckman Dynograph (Figure 12b). The system was

²Beckman Instruments, Inc., 3700 River Road, Sheiller Park, Illinois 60176.

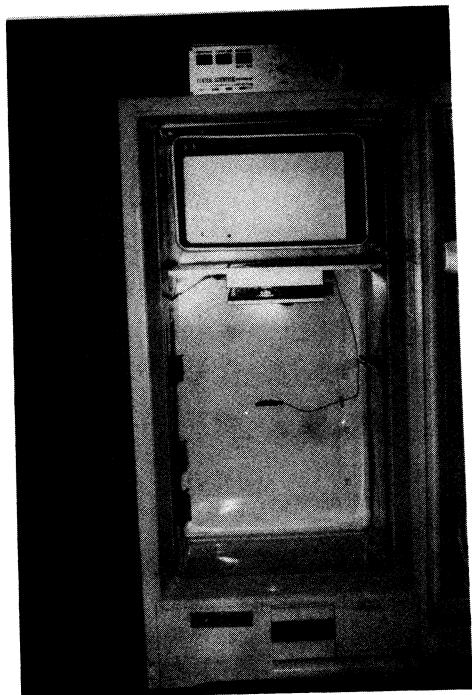


Figure 9. Cooling System with
Recirculation Fan
Below the Freezer
and Cool Air Exit
at Middle of Lower
Edge

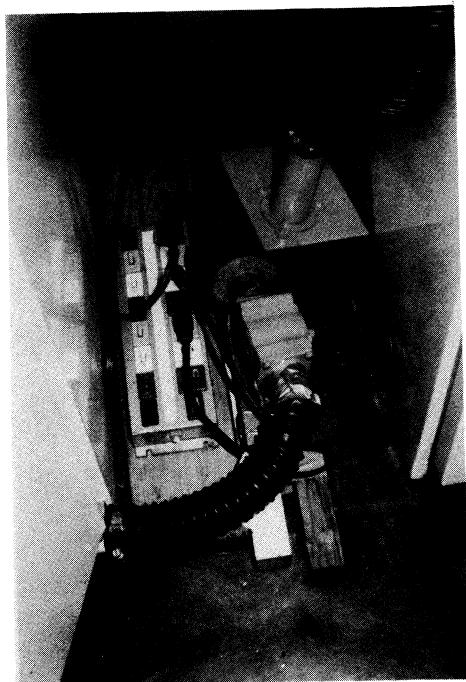


Figure 10. The Fan Located
Between Cooling
System and Oven,
The Handle Is at
Full Discharge
Location

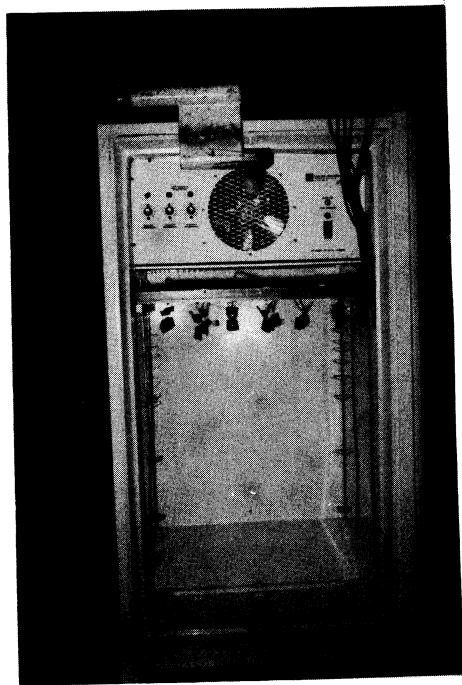


Figure 11. The Partial Drying
Oven with Recir-
culation Fan and
Cool Air Inlet,
Heating Element,
Cantilever Beams
with Six 50 Grams
Calibrated Weights
at Upper Side

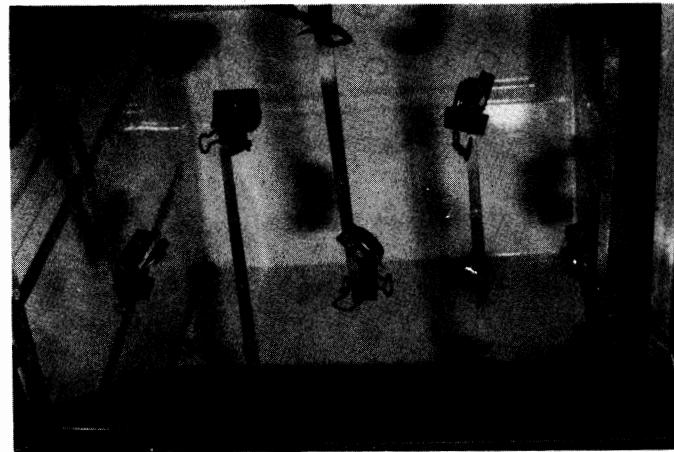


Figure 12a. The Weighing System with Six
Cantilever Beams and Six
150 Grams Calibrated Weights

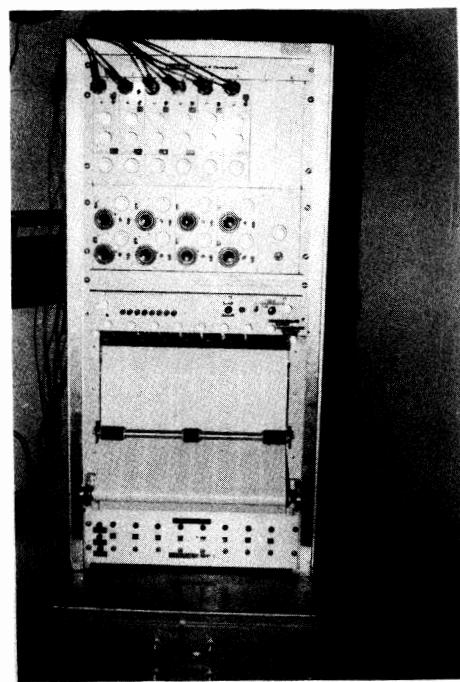


Figure 12b. The Beckman Type
R Dynograph Six
Channels Under
Use

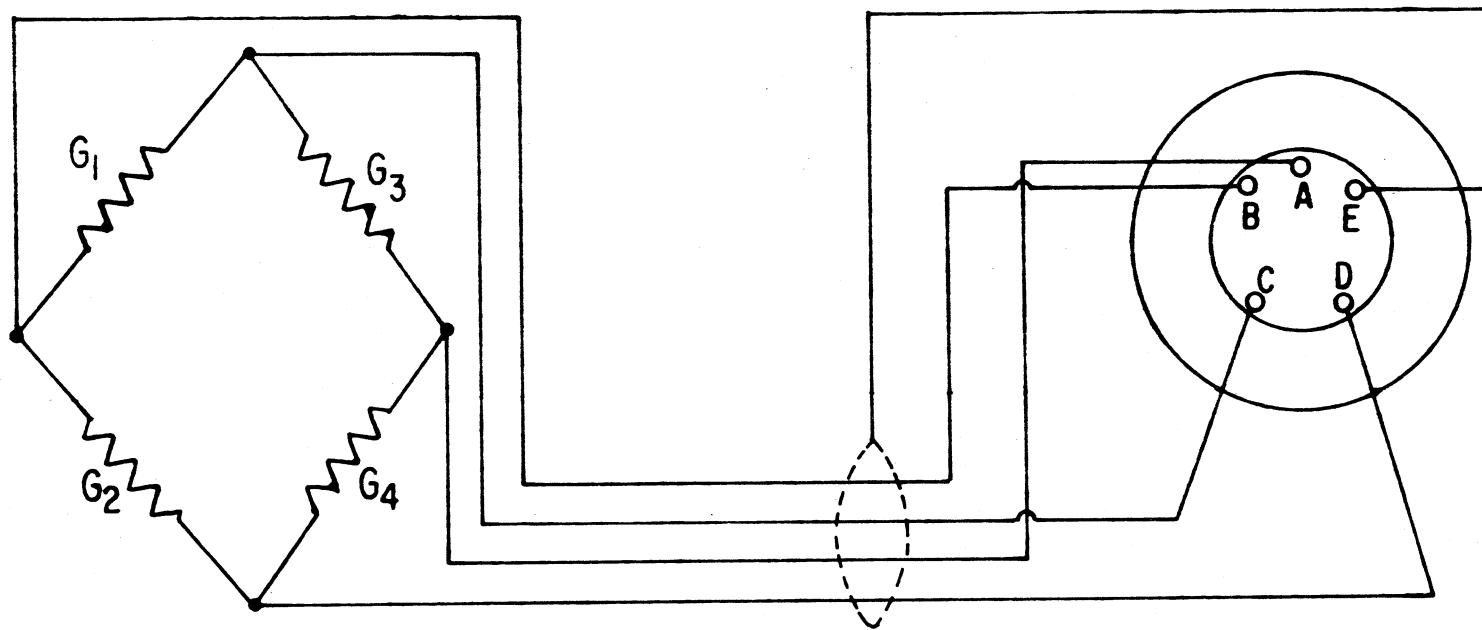


Figure 13. The Strain Gages Circuit on Each Cantilever Beam

temperature compensated by virtue of the strain gage circuit. It was calibrated to give sensitivity of 10 mv/cm which was equivalent to 50 g/cm.

Final Drying System

The final drying system includes an oven operating on 100° C temperature and aluminum pans 30 cm x 14.3 cm x 8.25 cm. This equipment was used to determine dry matter content of each sample (Figure 14).

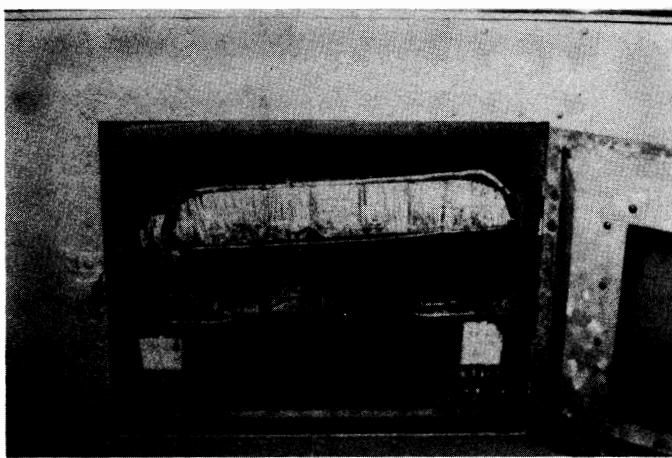


Figure 14. Aluminum Pans and Final Drying
Oven

CHAPTER IV

PROCEDURE

Experiment Design

The experiment was conducted in split-split block in time design in two seasons -- season one with two replication, season two with five replications. To achieve more accuracy for the feed rate and the number of passes effects, they were randomly applied to sub-sub plots and sub plots, respectively.

The feed rate was chosen such that to simulate a yield of 3362 kg per hectare per cutting for a cutting width over roll length ratio of 1, 2, 3, as follows:

$$\text{Rate 1} = 1614 \text{ g/m}^2$$

$$\text{Rate 2} = 3229 \text{ g/m}^2$$

$$\text{Rate 3} = 4842 \text{ g/m}^2$$

Five types of rolls shown in Figure 5a - 5e were randomly applied to the main plots. Pressure per linear centimeter, roll surface speed, ground speed (conveyors' speed), drying temperature, relative humidity, age of hay, rate of samples compaction and oven air velocity were considered as parameters and every effort was made to hold them constant.

Calibrations and Adjustments

The conditioning system was calibrated to provide 5.714 kg per linear centimeter. A digital force indicator and a load cell were used

for this calibration measurement (Figure 15). The location of the weight on the bar, and the bar location on the upper roll frame was marked for easy checking during application of other treatments. The conveyor's speed was adjusted to 8 km/hr. During operation, it was checked and readjusted if required. A positive roller chain drive for each roll was provided. Timing was, therefore, automatic for the rubber intermeshing and crimper rolls. All rolls except the nylon cord was adjusted to run at a peripheral speed of approximately 5 percent faster than the conveyor speed to insure that the rolls would be self-feeding rather than the forage material force-fed by the conveyors.

Initial runs were made with the nylon cord roll to provide information as to its operation. Based upon these initial runs, 500 RPM was chosen as it did cause bruising on the stems with less damage to the leaves.

The cooling system was adjusted to cool the laboratory room air to about 15° C and the oven was adjusted to maintain a mean dry bulb temperature of about 37° C. This corresponds to a relative humidity of about 28 percent which simulates a good field drying condition. Drying conditions were kept constant for all tests and were monitored continuously during test runs so that the drying rate could be compared for the various tests.

To find the temperature gradient in the drying chamber, a test was run with six unconditioned field samples. The result was that no statistically significant difference existed between the samples' drying rate at the 95% level of confidence. Six channels of an 8 channel Beckman Dynograph Recorder was used for recording the weight of each of six samples. The recorder was carefully calibrated before each drying

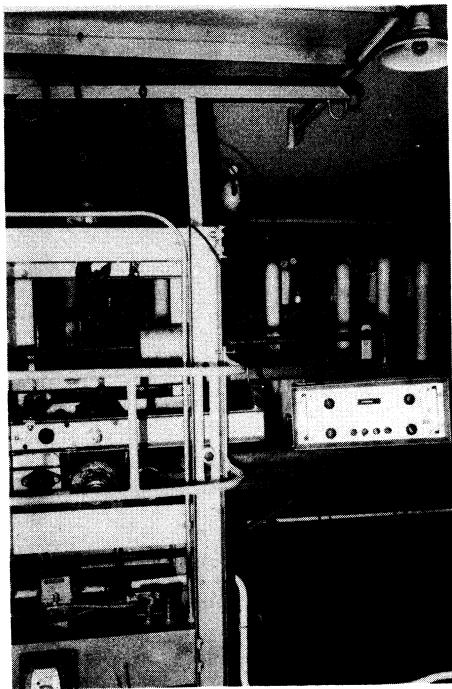


Figure 15. Equipment Setup
for Pressure
Calibration

run.

Since the minimum chart recording speed was .1 cm/sec, the paper driving motor was operated for short periods during the experiment to save on chart paper. A programmable timer system was added to the Beckman Dynograph Recorder to give short time recording signals.

The timer was adjusted such that it was cutting off the main signal after 30 seconds. The recording length per signal was about 3 cm long. To achieve full information about samples weight changes, the timer was programmed to give 13 signals with half-hour intervals for the first six hours and one signal for the final four hours of the partial drying period. This gave 14 weight recordings for each of the six samples over a 10-hour period.

Fresh Hay Supply

To provide the same age alfalfa for repeated runs of the different treatments, an area of about 46.5 square meters of alfalfa was selected -- each two to three days, a 4.6 square meters area was cut to provide hay with the same growth period for each treatment to be run. Harvest for conditioning was done when alfalfa was 33 days old and at about complete bloom stage. Since the yield of 4.6 square meters in some plots was not enough for some runs in the first two replications (Season 1), a larger area was selected, irrigation provided, and a new cutting schedule developed for the last five replications (Season 2) (Figure 16).

9-23-77	9-13-77	9-12-77	8-29-77	8-26-77
35	25	25	16	15
10-29-77	10-18-77	10-17-77	10-03-77	9-30-77
0	0	2	3	2
9-23-77	9-14-77	9-09-77	8-30-77	8-25-77
34	27	24	17	14
10-28-77	10-19-77	10-14-77	10-04-77	9-29-77
4	2	1	2	3
9-22-77	9-15-77	9-08-77	8-31-77	8-24-77
23	28	23	18	13
10-27-77	10-20-77	10-13-77	10-05-77	9-28-77
2	3	0	0	1
9-21-77	9-16-77	9-07-77	9-01-77	8-23-77
32	29	22	19	12
10-26-77	10-21-77	10-12-77	10-06-77	9-27-77
3	4	4	1	4
9-20-77	9-19-77	9-06-77	9-02-77	8-23-77
31	30	21	20	11
10-25-77	10-24-77	10-11-77	10-07-77	9-26-77
1	1	3	4	0

Figure 16. Layout of Experiment at Field; Numbers in Each Plot Are Representative of: 1st - The Date of First Cutting; 2nd - The Plot Number; 3rd - The Actual Date of Harvest; 4th - The Roll Used for Conditioning

Treatment Application

For a typical day's run the pans and the nylon sample nets were placed in both the complete and partial drying ovens (to be sure that they were dry the night before each main plot treatments were applied). In the morning, the cooling and partial drying units adjustments were checked. The Beckman Dynograph weighing and recording system was also calibrated by placing six 150 gram calibrating weights on the cantilever beams. The nylon nets and the clips were calibrated and kept associated with their respective cantilever beams. These were moved to the laboratory and placed in sequential order. The forage conditioning system adjustment was checked.

According to the randomization design, specified areas of alfalfa were harvested after dew was off. The harvested alfalfa was placed in a plastic cover to prevent moisture losses and moved to the conditioning laboratory. Measurements were made for the proper conveyor feed rate (Figure 17) and the hay was distributed uniformly on the first (belt) conveyor (Figure 18). The arrangement of hay on the conveyor was such that the alfalfa plants were fed with the stem end first and perpendicular to rollers' axes (Figure 19). The treated hay was stopped for the one pass on the third conveyor and for two passes on the fourth conveyor (Figure 20). For each sample, 130 grams of hay were randomly selected from six locations of the conditioned hay and wrapped in the nylon net with two clips for a total of 150 grams (Figure 21). Again, it was placed under a plastic cover to prevent moisture loss while waiting for other conditioning treatments to be run (Figure 22).

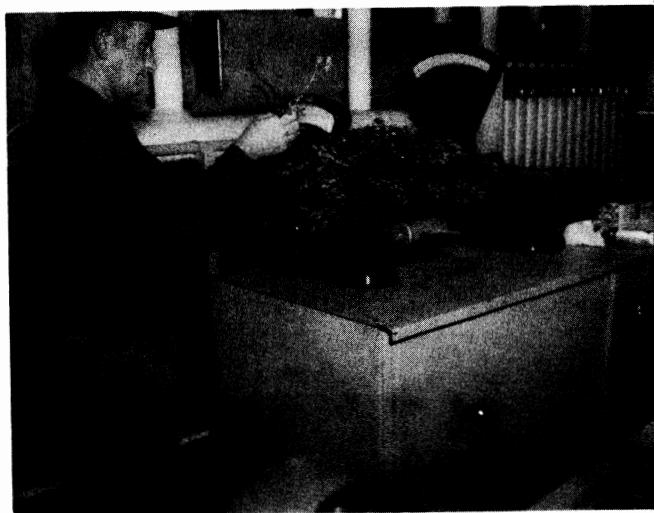


Figure 17. Weighing Hay for Uniform Distribution Over First Belt Conveyor

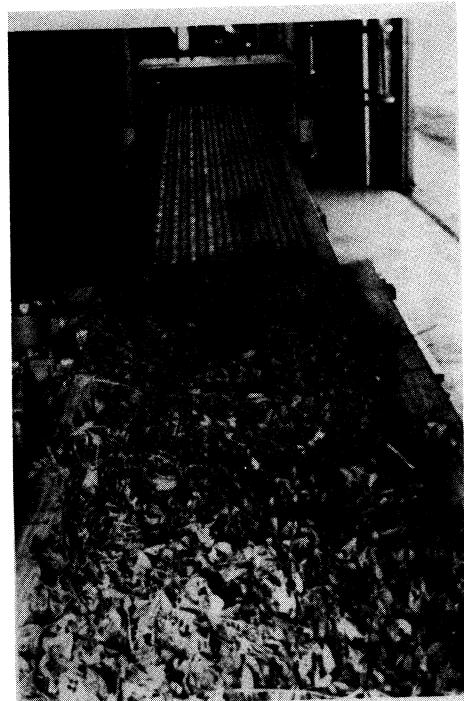


Figure 18. 1800 Grams Hay
Distributed
Uniformly Over
0.372 Square
Meters of First
Conveyor to Simu-
late Third Level
of Feed Rate

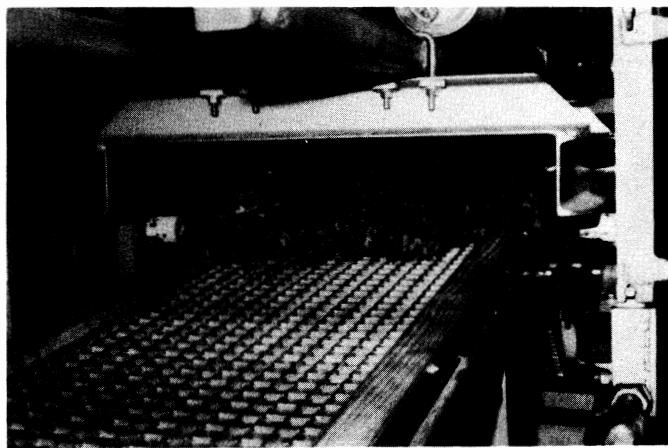


Figure 19. Orientation of Hay Passing
Through the Conditioning
Rolls

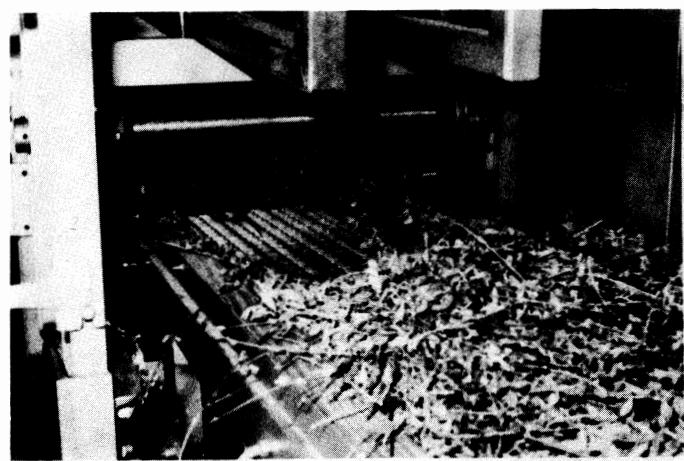


Figure 20. The Treated Sample with Steel-tiecord for One Pass, Stopped at Third Conveyor

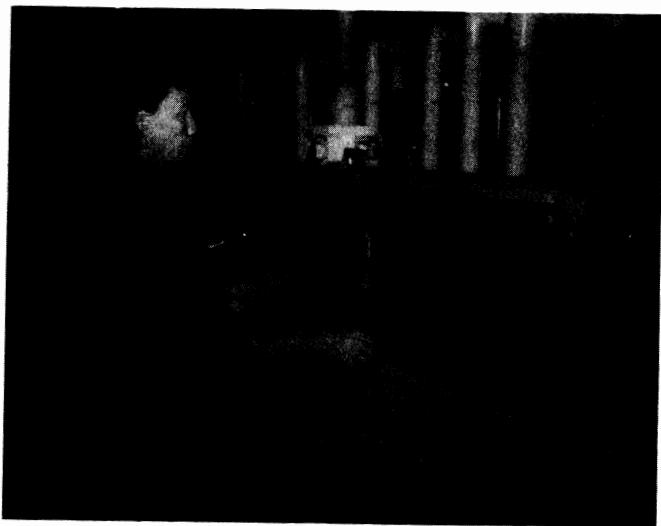


Figure 21. Weighing Hay with Nylon Net and
Clips to Nearest 150 Grams

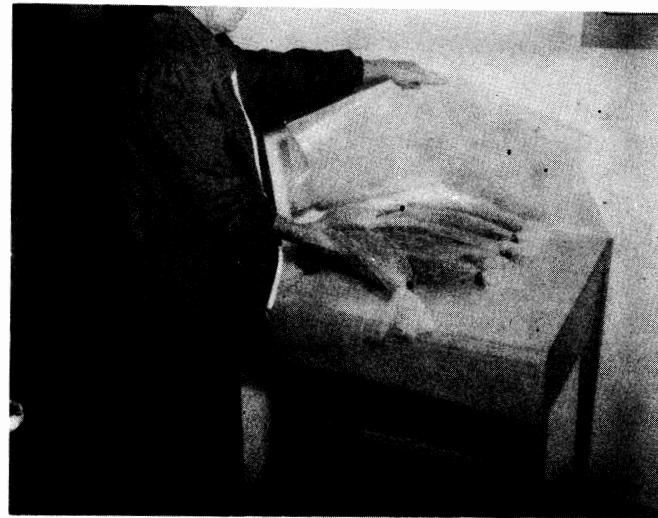


Figure 22. Covering Treated Samples with Plastic to Prevent Moisture Losses

When all six conditioning treatments (of one main plot) were completed, all were moved to the drying room and hung on the cantilever beams (Figure 23). Weight recording was done as samples were placed in the partial drying oven and the timer was adjusted as close as possible to record the samples' initial weight as soon as possible. On the chart paper, the weight of samples were recorded fourteen times during 10 hours; in one-half hour intervals. The accuracy of the recorder after a ten hour drying period was checked by weighing each sample with a sensitive scale with accuracy of .01 gram and recording this weight.

Samples were transferred from the nylon net to aluminum pans to the complete drying oven for dry matter determination (Figure 14). The drying period was 22 hours with the oven set at 100° C.

Statistical Analysis

The drying data was recorded on the Beckman Dynograph chart paper as mv/cm and was converted to grams as associated with the time of drying. The statistical analysis included the analysis of variance for different treatments and the least significant difference in drying rate of different rolls. The general linear model (regression) with different types of dependent variables (which describes the drying pattern of conditioned hay as a function of time) was fit to the data. The prediction equation for drying curves was developed and a confidence limit interval at the 95 percent level was calculated.

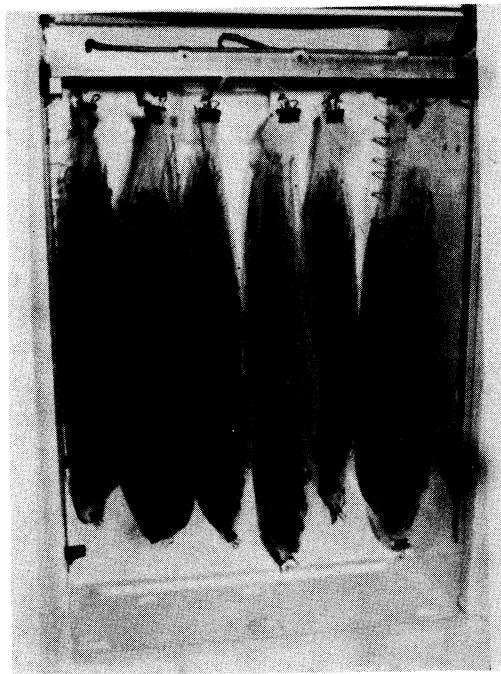


Figure 23. Treated Samples
Located on Canti-
lever Beams in
Partial Drying
Oven

CHAPTER V

ANALYSIS OF DATA AND DISCUSSION OF RESULTS

The curves of evaporation obtained from this research are shown in Figure 24a through 28b. They indicate that only when the stem surfaces were crushed, crimped or bruised, the rate of evaporation from the alfalfa was increased. The drying rate curves showed high evaporation during the first and second hour after cutting. In the third hour of drying, the rate of drying was lower but still of considerable amount. An average of 50 percent of the total moisture was evaporated during the first three hours after conditioning. Between three hours after cutting and equilibrium moisture, the evaporation rate was nearly constant and was considerably less than during the first hour of drying. The decrease in drying rate may be the result of the loss of surface opening caused by the progressive closing of stomata. Because of a decreasing turgor pressure in the guard cells, most of the stomata may be closed after two hours of drying. This is in agreement with results reported by Petersen (1959) except the drying rate was about 8 percent higher than reported by Petersen. This was thought to be due to the higher temperature and the lower relative humidity used in this experiment.

After three hours, evaporation takes place only through the cuticle and possible wounds caused by mechanical treatments. Thirty different treatment combination drying curves (percent moisture content

vs. time) are shown in Figures 24a through 28b.

Steel Tie-cord Rolls

The drying curve for the steel tie-cord rolls for one pass are shown in Figure 24a. These curves indicate that the drying rate for feeding rates one and two is nearly the same, and that they dried better than feed rate three. Figure 24b indicated that for two passes, all three feed rates have dried nearly at the same rate. This could be due to more effectiveness of the second pass on the hay than for the one pass at third level. Figure 24c shows the time required for different levels of feed rate and the number of passes to cause hay to reach a 20 percent moisture content. This moisture content was considered as a safe storage moisture content without the need for preservative types of additives.

The basic aim of conditioning is to reduce the drying time required to approach the level of moisture such that hay could be taken from the field for storage and with lowest losses. In Figure 24c, the graph for the steel tie-cord rolls indicates that samples treated at both the first and second levels of feed rate and with only one pass approached a safe storage level after 4 hours and 45 minutes of drying while third levels of feed rate had required 6 hours drying time. The graph for two passes indicated that samples for both the first and second level of feed rates dried slower than when only one pass was used. The third level of feed rate required more drying time than any other combination at only one pass. However, the third level of feed rate required less drying time for two passes than for one pass.

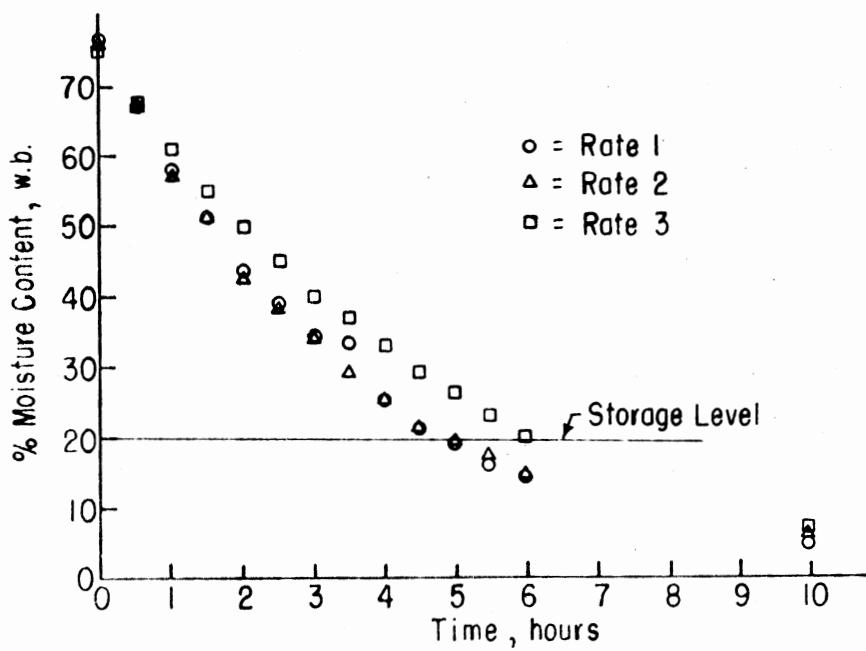


Figure 24a. Drying Curve of Alfalfa at Different Levels of Feed Rate for Steel Tie-cord Rolls for One Pass

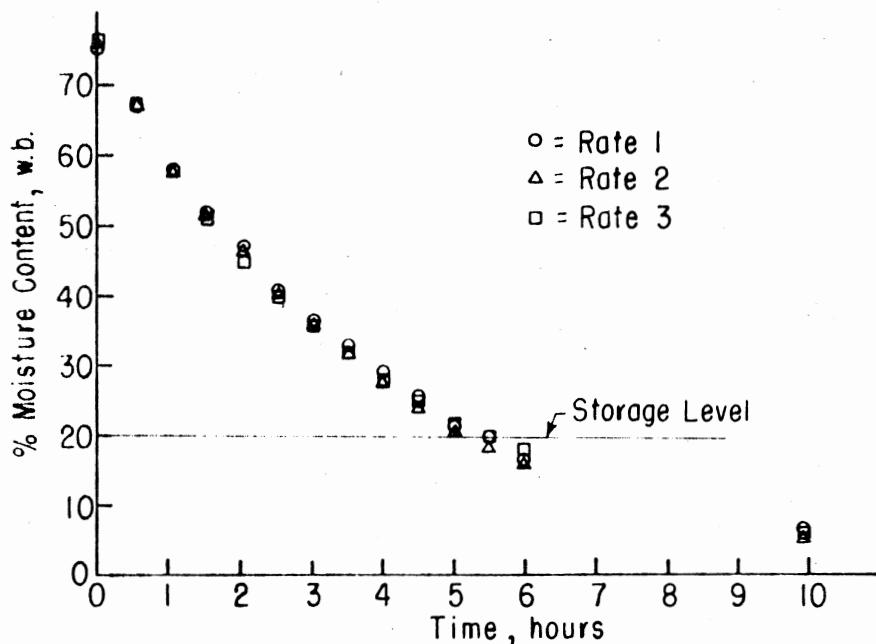


Figure 24b. Drying Curve of Alfalfa at Different Levels of Feed Rate for Steel Tie-cord Rolls for Two Passes

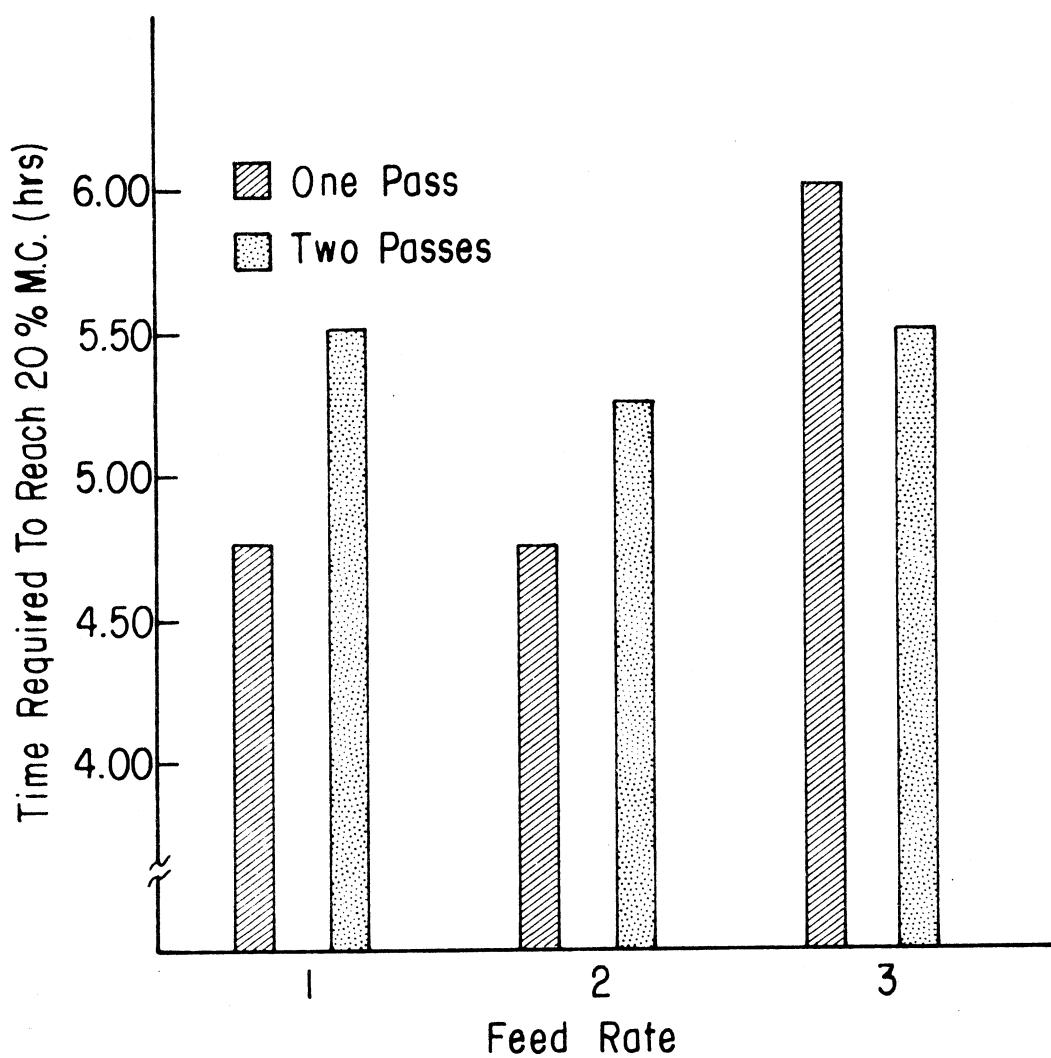


Figure 25c. Distribution of Time Required to Approach 20% M.C. Vs. Different Levels of Passes and Feed Rates for Steel Tie-cord Rolls

Rubber Intermeshing Rolls

The rubber intermeshing rolls drying curves are shown in Figures 25a and 25b. Figure 25a shows the drying rate for one pass of the hay at the three feed rate levels. The results show that there is essentially no difference among drying curves for the first, second and third levels of feed rate. Figure 25b shows the drying rates for two passes of hay at the three levels of feed rate. The curves for the 2 passes indicate that the third feed rate level dried faster than the first and second levels. However, after 5 hours of drying, the first and third levels of feed rate had reached the same moisture content. The second level of feed rate required 10 hours of drying time to achieve a moisture content equal to that for the other two levels of feed rate. Figure 25c shows time required for hay from the different combination of feed rate and number of passes for the rubber intermeshing rolls to achieve a 20 percent moisture level. The maximum variation was about 42 minutes. The time required to reach a 20 percent moisture content for one pass and two passes treatments was 5 hours and 41 minutes and 5 hours and 26 minutes, respectively, when averaged over the 3 feed rates.

Smooth Rubber Rolls

The drying curves for the smooth rubber rolls for one pass treatments at three levels of feed rate are shown in Figure 26a. The drying curves of feed rate level one and two are quite similar. While the third feed rate treatment dried at slower rates than the others. For two passes of the smooth rubber rolls (Figure 26b), the drying curves

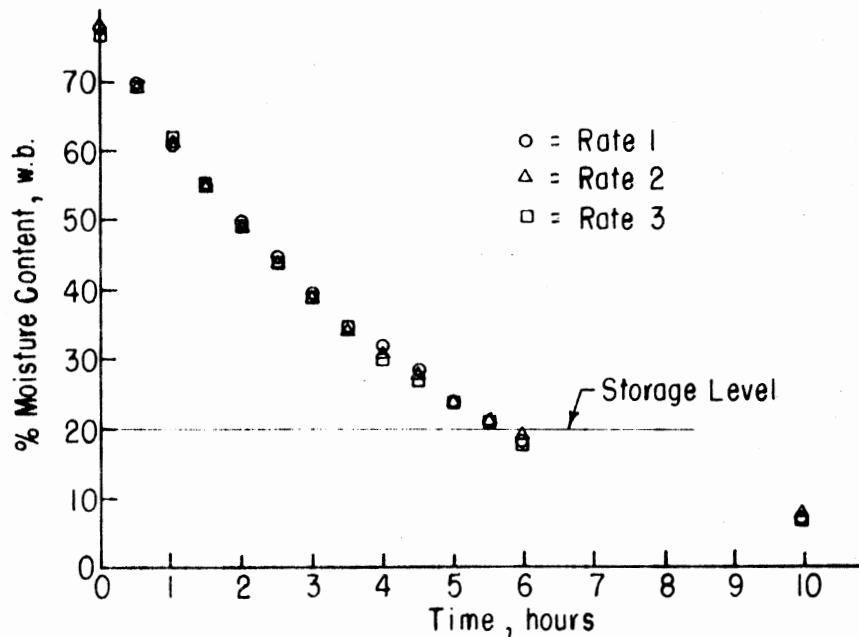


Figure 25a. Drying Curve of Alfalfa at Different Levels of Feed Rate for Rubber Intermeshing Rolls with One Pass

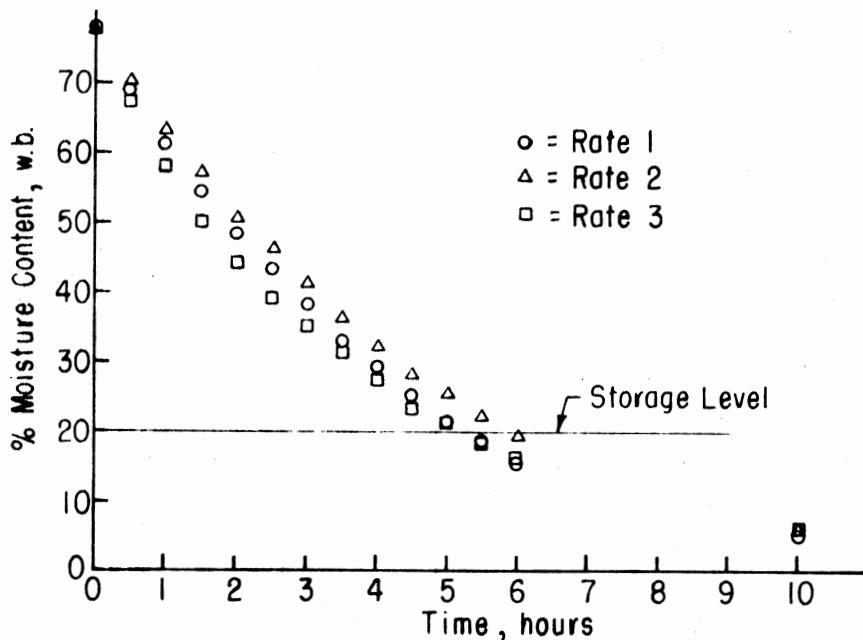


Figure 25b. Drying Curve of Alfalfa at Different Levels of Feed Rate for Rubber Intermeshing Rolls with Two Passes

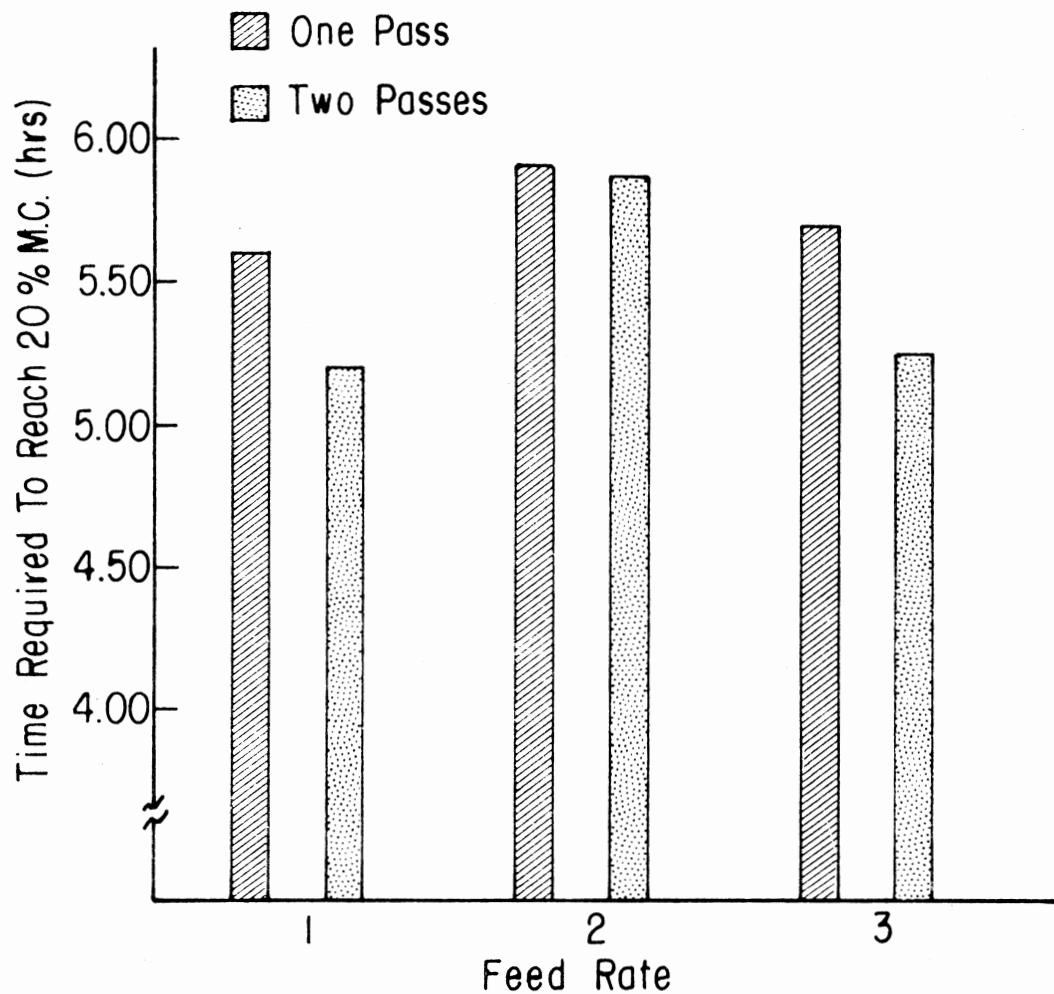


Figure 25c. Distribution of Time Required to Approach 20% M.C. Vs. Different Levels of Passes and Feed Rates for Rubber Intermeshing Rolls

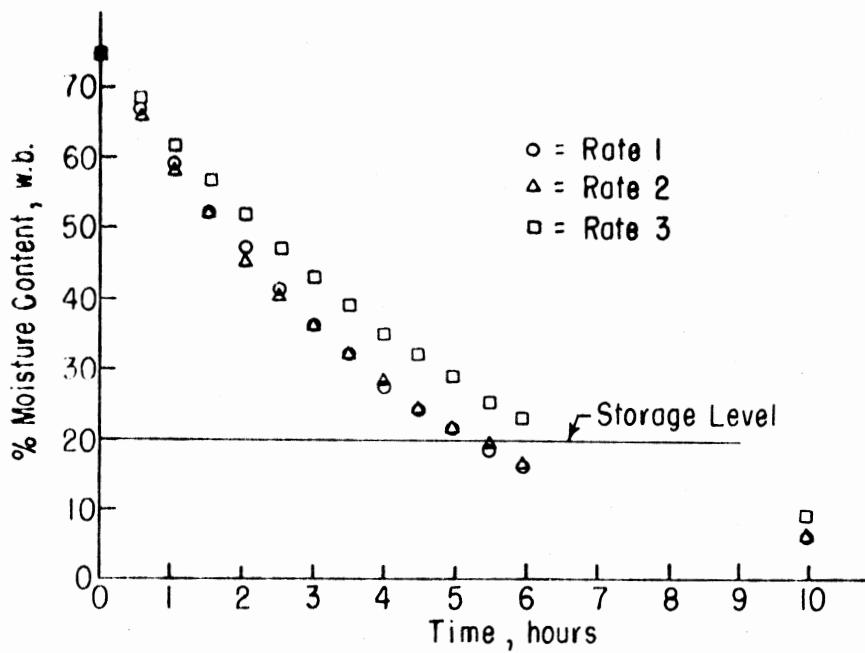


Figure 26a. Drying Curve of Alfalfa at Different Levels of Feed Rate for Smooth Rubber Rolls with One Pass

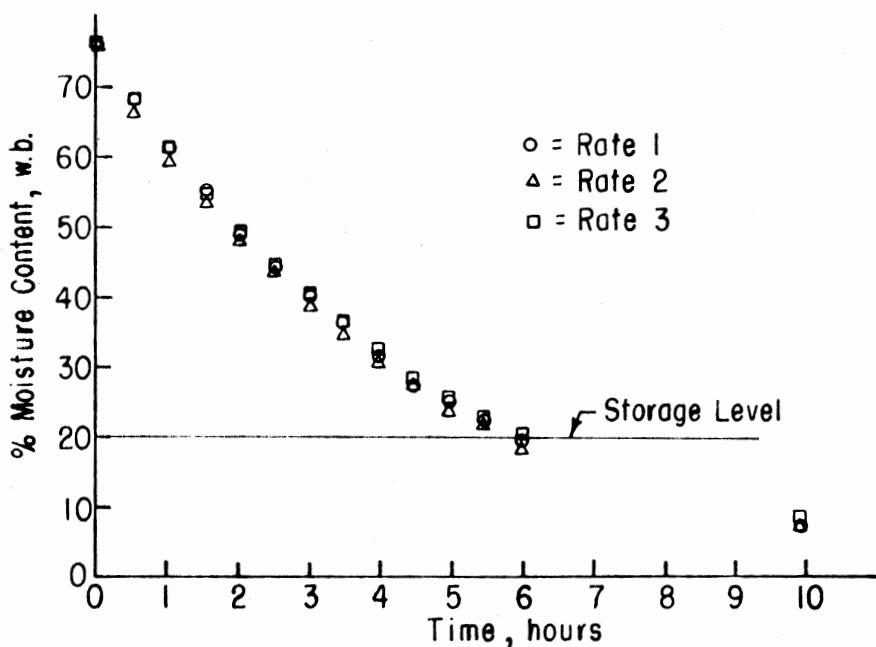


Figure 26b. Drying Curve of Alfalfa at Different Levels of Feed Rate for Smooth Rubber Rolls with Two Passes

indicate that the difference in drying rate among the different levels of feed rate has been reduced. All three feed rate levels have shown nearly the same drying rate. The time required for conditioned hay to reach the 20 percent moisture content level with one pass for feed rates 1, 2, and 3 is 5 hours and 8 minutes, 5 hours and 15 minutes, and 6 hours and 44 minutes, respectively. For two passes at the three feed rates, the time is 5 hours and 48 minutes, 6 hours and 22 minutes, and 6 hours, respectively. The average drying time for one pass was 5 hours and 42 minutes while for two passes, it was 6 hours and 3 minutes (Figure 26c).

Steel Crimper Rolls

The drying curves for the steel crimper rolls are shown in Figure 27a and 27b. The drying curve of different levels of feed rate for one pass is compared in Figure 27a and indicates that all three treatments have dried nearly at the same rate. Figure 27b shows a little higher drying rate for third level of feed rate than two other levels when 2 passes were used.

The required time to dry the hay samples to the 20 percent moisture content level for the different treatment combination is shown by Figure 27c. The required time to reach the desired moisture level for the third level of feed rate used with two passes was 4 hours and 30 minutes and for all other treatment combinations, the time varied only between 4 hours and 58 minutes and 5 hours and 24 minutes. The average required drying time to achieve the 20 percent moisture level for one and two passes was 5 hours and 40 minutes and 5 hours, respectively.

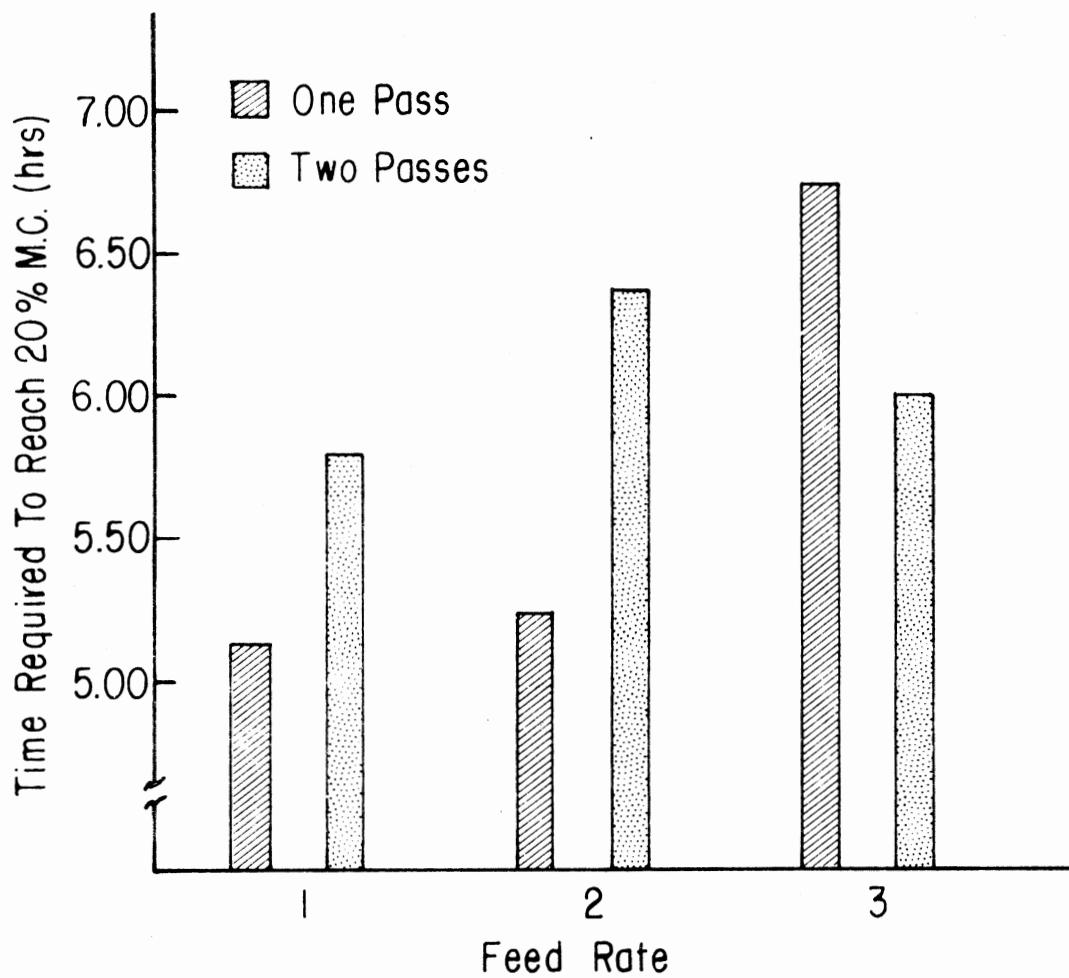


Figure 26c. Distribution of Time Required to Approach 20% M.C. Vs. Different Level of Passes and Feed Rate for Smooth Rubber Rolls

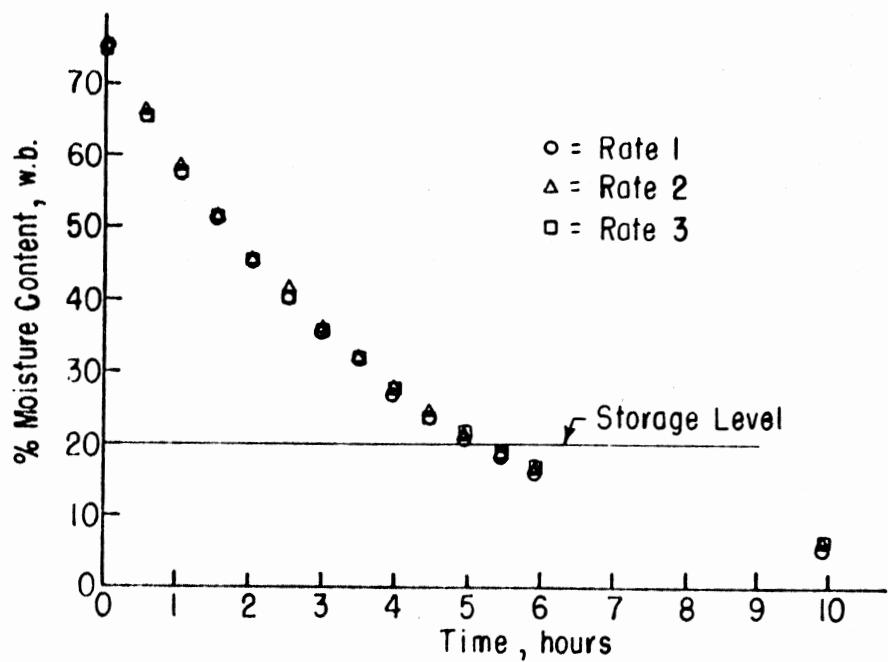


Figure 27a. Drying Curve of Alfalfa at Different Levels of Feed Rate for Steel Crimper Rolls with One Pass

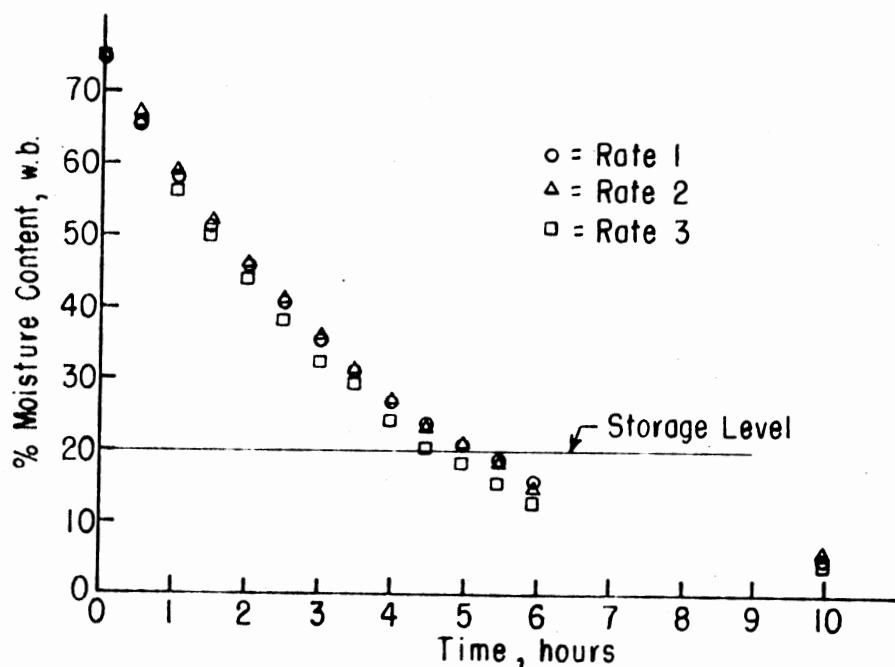


Figure 27b. Drying Curve of Alfalfa at Different Levels of Feed Rate for Steel Crimper Rolls with Two Passes

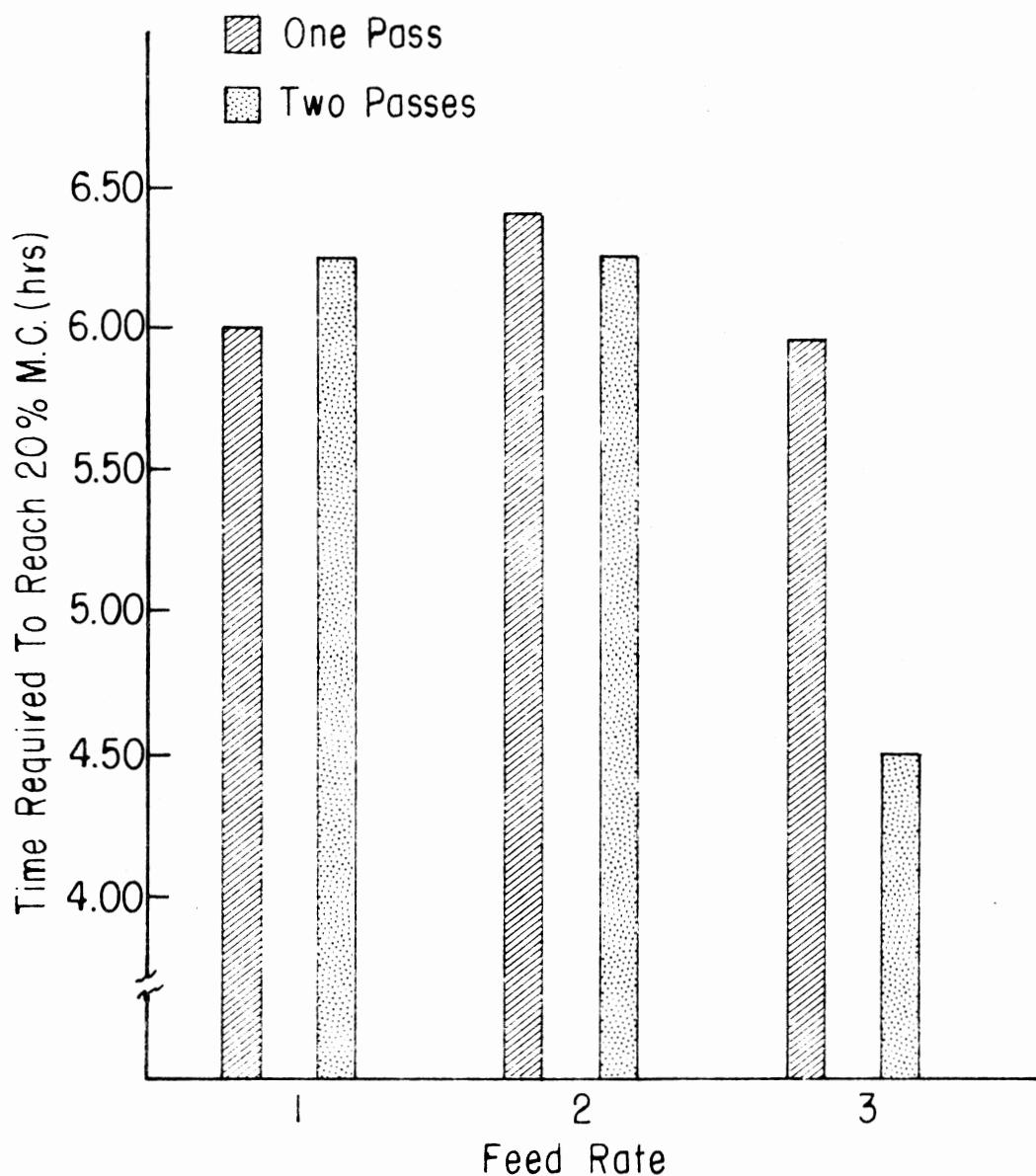


Figure 27c. Distribution of Time Required to Approach 20% M.C. Vs. Different Levels of Passes and Feed Rate for Steel Crimper Rolls

Plastic Cord Rolls

The drying curves obtained for plastic cord rolls are shown in Figure 28a and 28b. This roll was designed to study the bruising effect on the alfalfa stem. It was expected that the plastic cord when used at a fast speed would tend to remove the wax off the stem and aid in increasing the drying potential. It was thought that the use of many cords would damage the stem of the alfalfa more severely than would the other type of rolls. The drying curve for the different levels of feed rate and with one pass is presented in Figure 28a. The results indicate that hay from the third level of feed rate dried faster than from the first and second feed rate levels. The drying rate for the second and third feed rate were nearly the same, however, the second feed rate had a tendency to dry faster than did the first feed rate. The curves for the two pass treatment combinations are shown in Figure 28b. The drying rate of second level of feed rate dried at the same rate as third feed rate level. The drying rate for the first level of feed rate was the slowest.

The time required for the hay samples treated with the various treatment combinations of the plastic cord to reach the safe level of moisture content (20% wb) averaged about 6 hours and 50 minutes for the feed rate levels of one and two when used with one pass and for two passes was about 6 hours and 18 minutes. The third feed rate level used with one pass required about 5 hours and 18 minutes and the two passes required about 5 hours and 15 minutes. This indicates that the second pass did not improve the drying rate for the third feed rate. When averaging over the feed rate levels, the average required time in

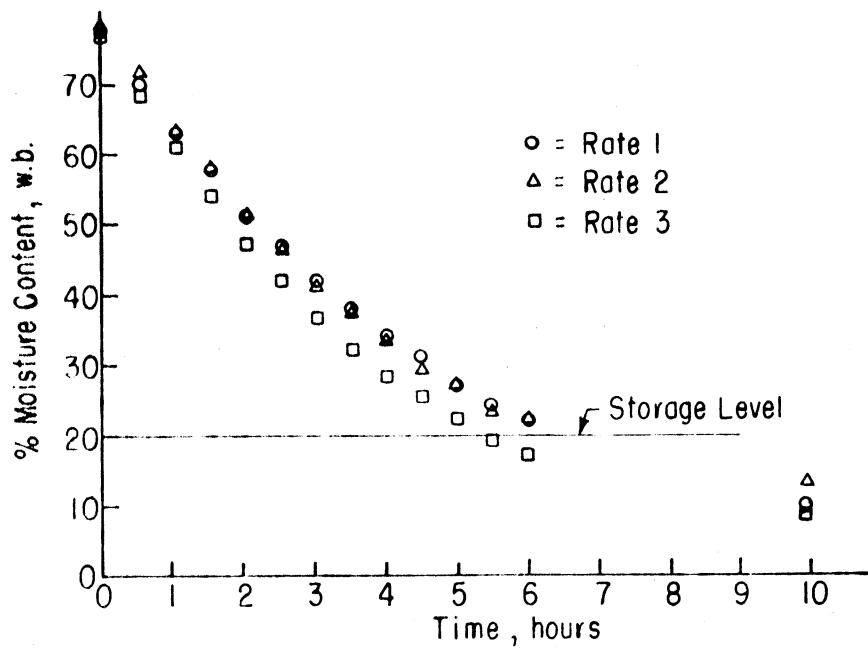


Figure 28a. Drying Curve of Alfalfa at Different Levels of Feed Rate for Plastic Cord Rolls with One Pass

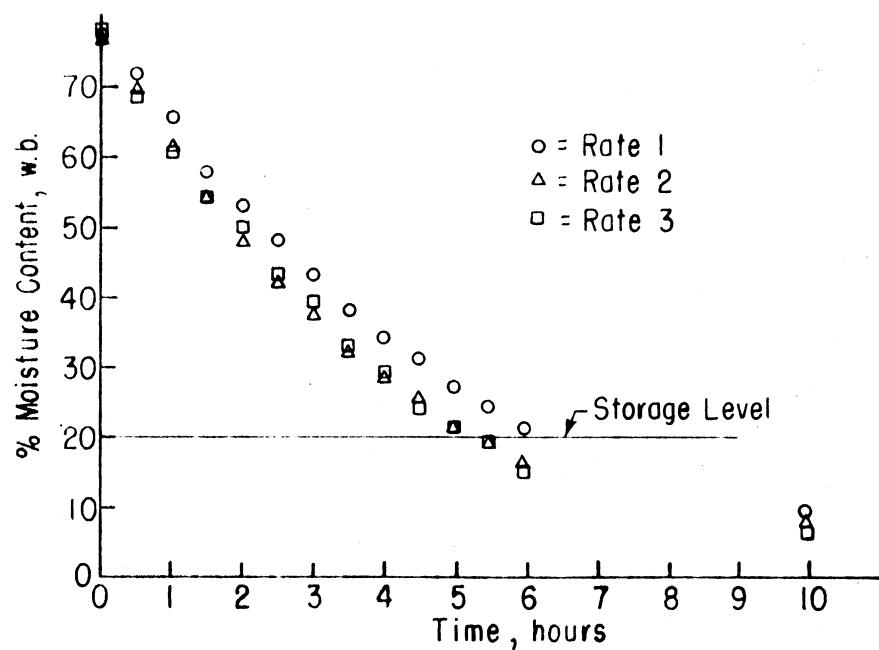


Figure 28b. Drying Curve of Alfalfa at Different Levels of Feed Rate for Plastic Cord Rolls for Two Passes

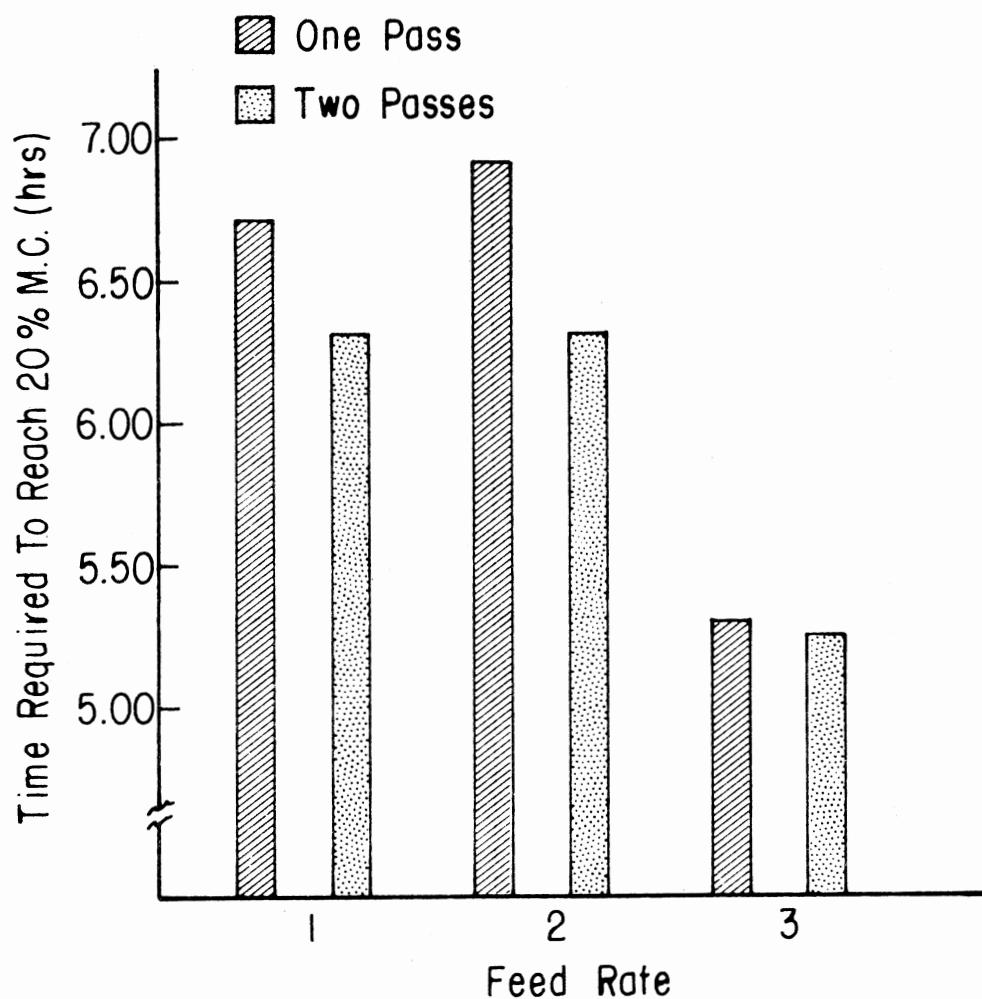


Figure 28c. Distribution of Time Required to Approach 20% M.C. Vs. Different Levels of Pass and Feed Rates for Plastic Cord Rolls

one pass was about 6 hours and 18 minutes and for two passes was 5 hours and 57 minutes.

The data presented in the discussion was averaged over five replications for 30 factorial treatments. These combinations were the result of five rolls, two levels of passes and three levels of feed rates. The average time for hay samples from different levels of feed rates and at one or two passes to dry to the 20 percent moisture content level is given in Table IV for the different type of rolls. The numbers in the parentheses indicate the rank of each roll within the group.

The treatment combinations that resulted in the shortest drying time to achieve the 20 percent moisture level was the steel crimper roll at third feed rate level and with two passes. The second fastest drying would be for the steel tie-cord at first and second feed rates with one pass. The plastic cord roll was the lowest effective roll when used at the second and first level of feed rate and with one pass. It has quite improved results with an increase in the number of passes and feed rates. It may be that it would be suitable for higher cutter bar/roll width ratio designs. The other roll-feed rate-pass combinations appear to be about average in effectiveness.

Statistical Analysis Results

The change in weight of the hay samples due to the drying effect was recorded as mv/cm on the Beckman Dynograph output. The chart data was recorded (each millimeter deflection equal to 5 grams weight change) as the weight of the sample in grams at specified times (0.0, 0.5, ... 10 hours) and punched on computer cards for statistical

TABLE IV

AVERAGE REQUIRED TIME OVER DIFFERENT LEVELS OF FEED
RATES FOR EACH ROLL WITH ONE OR TWO PASSES
TO REACH 20 PERCENT MOISTURE CONTENT

Type of Roll	One Pass Hours	Two Passes Hours
Steel Tie-cord	5.17 (1)	5.42 (2)
Rubber Intermeshing	5.74 (4)	5.58 (3)
Smooth Rubber	5.70 (3)	6.05 (5)
Steel Crimper	5.45 (2)	5.34 (1)
Plastic Cord	6.30 (5)	5.95 (4)

analysis.

The analysis of variance was obtained by using the Statistical Analysis System (SAS) with procedures on three different bases (using equation 1, 2, and 3).

$$F = ((Wt - D) \times 100)/(Wi - Drymat), \quad (1)$$

$$Mw = ((Wt - D) \times 100)/Wi, \quad (2)$$

$$Md = ((Wt - D) \times 100)/D, \quad (3)$$

where:

F is the percent fraction of water remaining at drying sample at time "t" or $\frac{\text{weight of water at time } "t"}{\text{initial weight of water}} \times 100$.

Wt is the weight of the drying hay at time "t".

D is the weight of sample after complete drying (dry weight).

Wi is the original weight of the sample before drying (wet weight).

Mw is the percent moisture content wet base.

Md is the percent moisture content on dry base.

The result of all basis analysis indicates that time was highly significant with an $\alpha = .001$.

The observed significant level for roll effect using equation 1 and 2 were 0.0512 and 0.771, respectively, which indicates that rolls were effective at drying (with 90 percent confidence level). Feed rate and the number of passes effects were statistically not significant. For more information, the reader is referred to Appendix A. The least significant difference method was used to identify which mean effect of the rolls were statistically significantly different. The only significant difference in drying rate (at $\alpha = .05$) was noticed between the steel crimper and plastic cord with steel crimper having a higher drying effect.

The data was plotted on different bases to observe the relationship of the data. The results of plotting (Data in Appendix B) indicates that the relationship between drying time and either $\log_{10} M_w$, $\log_{10} M_d$ or $\log_{10} F$ results in a straight line plot. Data for each replication were plotted as a separate curve. From these plots, it was apparent that there was high variation between replication for the treatment combination that was plotted. This same result was clearly shown by Straub (1975). For the control treatments after six hours of drying, he reported percent moisture (wb) varied from about 25 percent up to 50 percent.

The general linear models (SAS) procedure was used to develop the equation to predict the required time to reach a specified percent moisture content for the wet and dry bases as well as for percent evaporation. The model for M_w as dependent variable indicated that the model fits the data with $R^2 = 0.86$ and C.V. = 19.7179. It also indicates that both linear and quadratics are highly significant. The prediction equation for data of season 2, roll 0, pass 1, rate 1 results in equation 4.

$$M_w = 76.36 - 14t + .718t^2 \quad (4)$$

Using M_d as dependent variable, it shows a very low correlation coefficient and a high coefficient of variation. Using F as a dependent variable, it shows a higher correlation coefficient $R^2 = .909$ and lower coefficient of variation.

When using $\log_{10} F$ as a dependent variable, it fits the model with correlation coefficient and a coefficient of variance to 0.88 and 6.43, respectively, and indicates that there is no significant curvature. The prediction equation is as follows:

$$\log_{10} F = 2.007 - 0.103 t - 0.0005 t^2 \quad (5)$$

Because of a very small coefficient for the quadratic portion, it reduces to equation 6:

$$\log_{10} F = 2. - .103 t \quad (6)$$

The predicted equation estimates with a very large confidence interval because of a significant difference existing among replications as mentioned previously. For detailed information, the reader is referred to Appendix C.

CHAPTER VI

SUMMARY OF RESULTS

Hay is the most important forage crop in the United States. Since field curing may subject hay to weather damage and as a result causes considerable loss of nutrients, it is important to find the best possible and most economical method of curing the hay.

Thirty treatment combinations involving 5 conditioning rolls, 3 feed rates of alfalfa, and one or two passes of the hay through the rolls were evaluated as to the effect of these treatments on the forage drying rate. This experiment showed that the fastest evaporation was obtained when the plants were hard crushed, crimped and bruised. This is possible with increasing the number of passes; but, it varies by feed rate and the type of roll. The drying rate was improved by increasing the feed rate for the plastic cord roll and the steel-crimper rolls. The SAS prediction equation resulted in a wide confidence interval due to the variation between replications. Assuming that the drying curves are parallel, removing the replications effects the results in a more acceptable prediction confidence interval.

Conclusions

The conclusions that can be drawn from this research of the mechanically treating alfalfa to increase the drying rate can be stated in the following points:

1. The difference in drying rate of conditioning rolls was not statistically significant. The only significant difference at $\alpha = .05$ level was observed for the use of the steel crimper and the plastic cord rolls; the steel crimper rolls were more effective in increasing the drying rate.
2. The one pass and two passes treatments do not show statistically significant differences when averaged over all rolls and the three levels of feed rate.
3. The different levels of feed rate are not statistically significantly different when averaged over all passes and rolls. However, the plotted curves show that an increase in feed rate may increase or not increase the drying rate, depending on the type of rolls used.
4. The plastic cord roll was the least effective type in increasing the drying rate but it shows more effectiveness when the feed rate was increased.
5. The "best fit" model was achieved by considering the log of the ratio of the percent moisture remaining over initial moisture content as a dependent variable and time as an independent variable.

Recommendations for Future Research

1. Perform extensive tests to learn what is the basic factor which causes the high variation in replication.
2. Determine the performance of each roll, independent from the others, in conditions very close to field operation. Then, compare the best achieved condition of each roll to evaluate

the drying effects.

3. The losses associated with the mechanical treatments are needed to provide more information concerning rolls, passes, and rate of feed.
4. A combination of mechanical treatments and preservatives may be very effective in reducing the required drying time and to improving the quality of hay.

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APPENDICES

APPENDIX A

ANALYSIS OF VARIANCE

TABLE V
 ANALYSIS OF VARIANCE FOR VARIABLE
 Mw (PERCENT MOISTURE
 CONTENT (wb))

	Degree of Freedom	Sum of Squares	Mean Square	F Value	Probability > F
Among Rolls	4	3211.82	802.93	2.47	0.0771
Within Rolls	20	6498.67	324.93		
Between Pass	1	538.13	538.13	2.08	0.1582
Within Pass	25	6458.73	258.35		
Among Rate	2	117.45	58.72	0.20	0.8186
Within Rate	100	28938.00	289.38		
Among Time	13	1157981.11	89075.74	10000.00	0.0001
Within Time	1950	19367.12	7.37		

TABLE VI
ANALYSIS OF VARIANCE FOR VARIABLE
F (PERCENT FRACTION WATER
REMAIN)

	Degree of Freedom	Sum of Squares	Mean Square	F Value	Probability > F
Among Rolls	4	2790.63	697.66	2.83	0.0512
Within Rolls	20	4922.82	246.14		
Between Pass	1	891.41	891.41	2.06	0.1604
Within Pass	25	70818.49	432.74		
Among Rate	2	157.82	78.91	0.17	0.8430
Within Rate	100	45794.51	457.95		
Among Time	13	1973111.68	151777.82	10000.00	0.0001
Within Time	1950	26197.73	13.44		

TABLE VII
 ANALYSIS OF VARIANCE FOR VARIABLE
 Md (PERCENT MOISTURE
 CONTENT (Db))

	Degree of Freedom	Sum of Squares	Mean Square	F Value	Probability > F
Among Rolls	4	289046.6	72261.64	1.32	0.2952
Within Rolls	20	1092280.5	54614.03		
Between Pass	1	13607.4	13607.37	2.42	0.1293
Within Pass	25	140887.3	5635.49		
Among Rate	2	6221.8	3110.89	0.39	0.6811
Within Rate	100	789797.8	7897.78		
Among Time	13	22682090.8	1744776.22	4031.31	0.0001
Within Time	1950	843973.0	432.81		

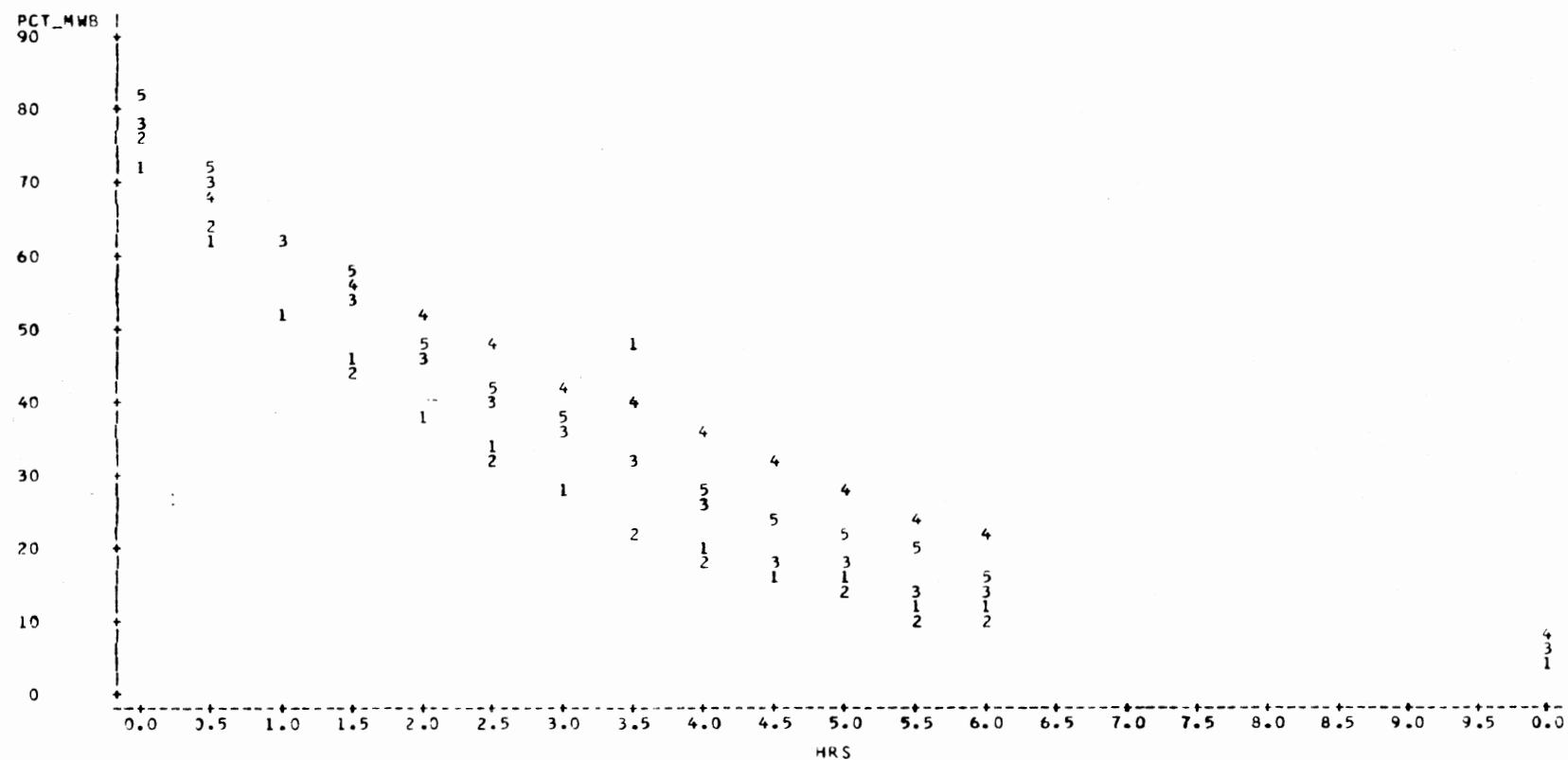
APPENDIX B

PLOTS OF DRYING TIME VERSUS MOISTURE
FOR SEASON 2, ROLL 0, AND PASS 1

SEA=2 HAY CONDITIONING ROLLS
ROLLS=1 PASS=1 RATE=1*

21:03 THURSDAY, MARCH 23, 1978 11+9

PLOT OF PCT_MWB#HRS SYMBOL IS VALUE OF REP



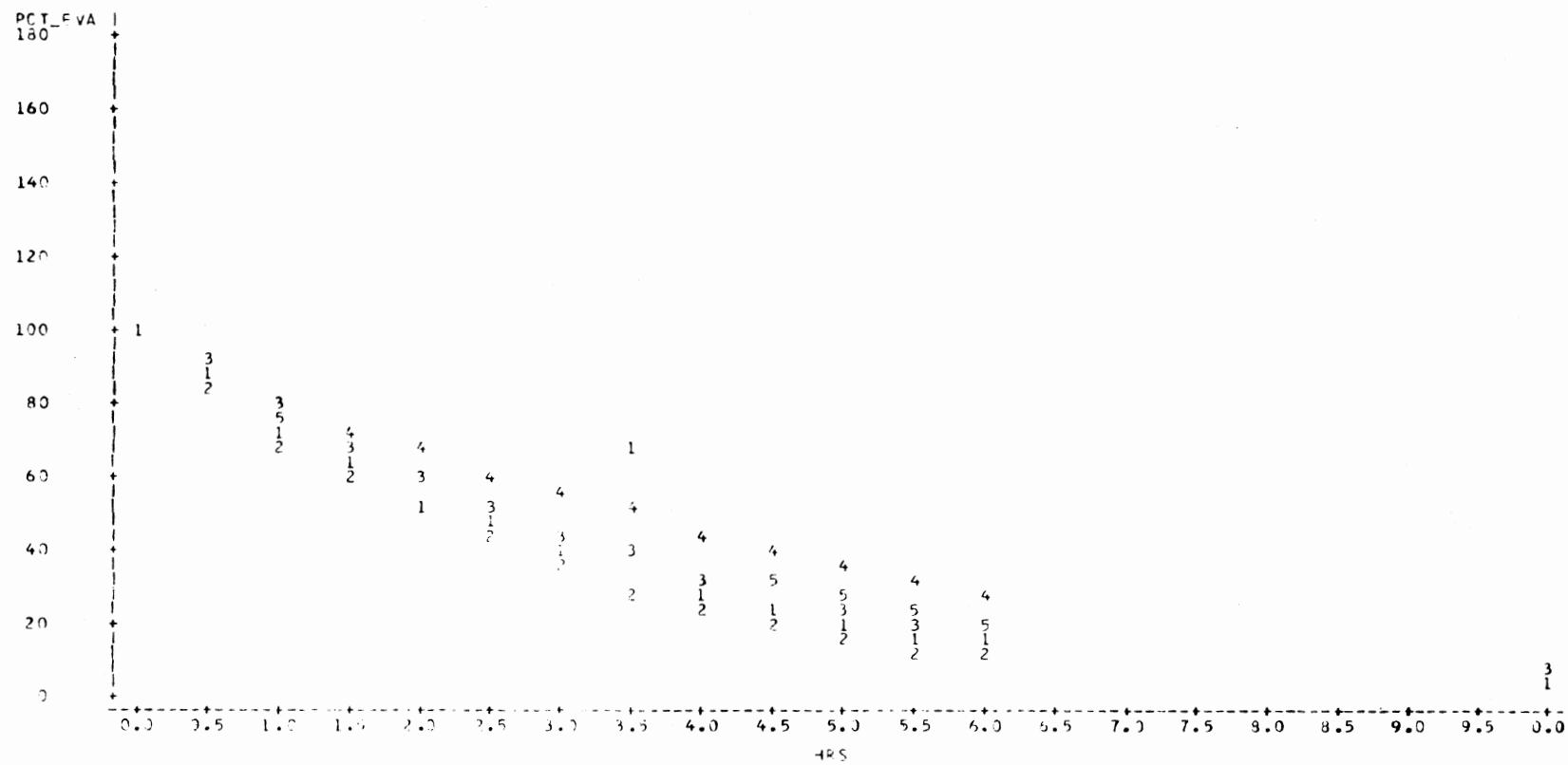
NOTE: 10 OBS HIDDEN

*Typical data for one roll.

SE=2 HAY CONDITI^N = 3 SLS₁ ST=1★

21:03 THURSDAY, MARCH 23, 1978 1141

RESULT OF PCT_EVA(HRS) SYMBOL IS VALUE OF HRS



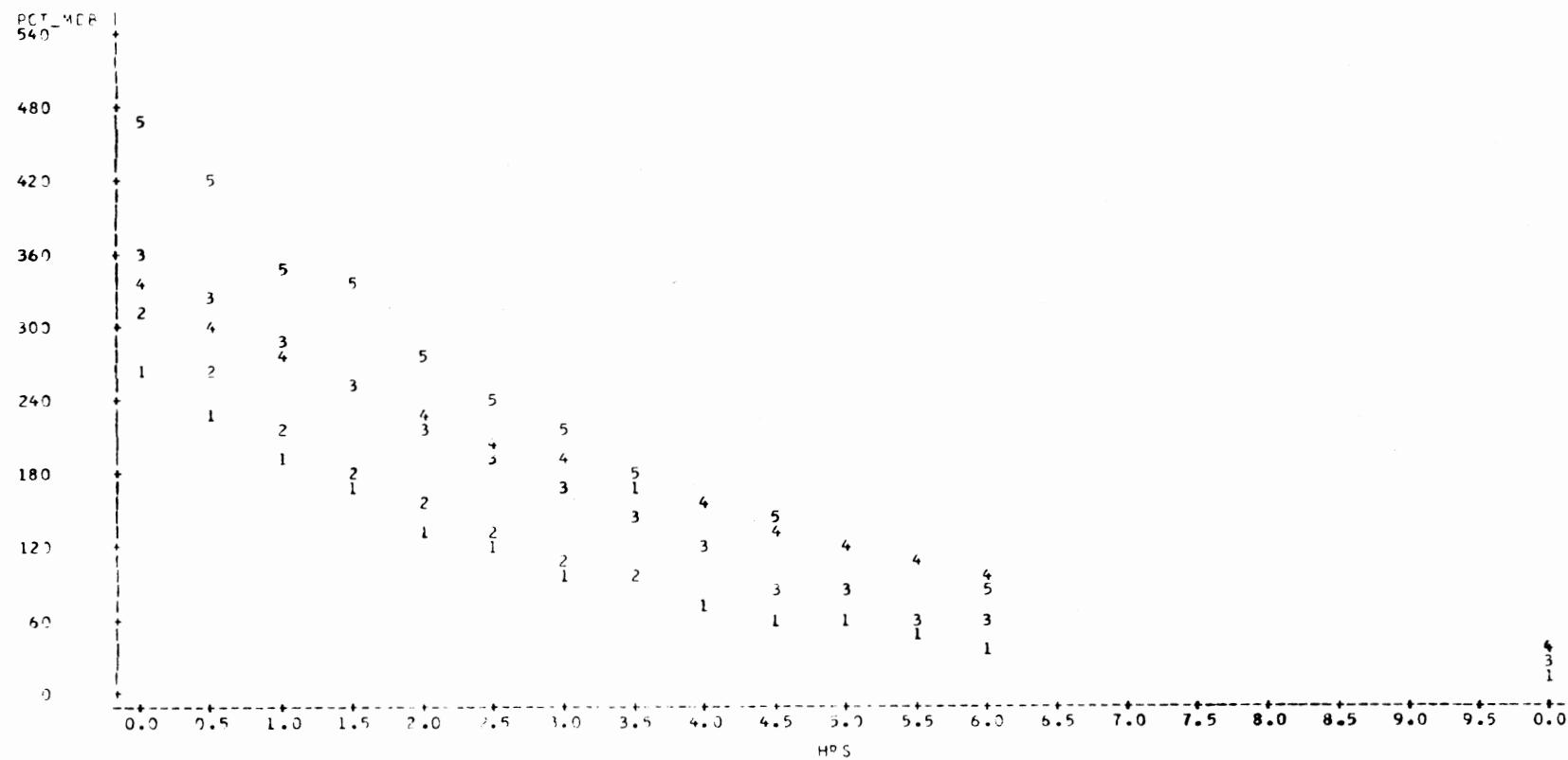
NOTE: 19 080 HIDDEN

*Typical data for one roll.

SEA=2 HAY CONDITION=2 ROLLS RATE=1 *

21:03 THURSDAY, MARCH 23, 1978 1145

PLOT OF PCT_MOB*HRS SYMBOL IS VALUE OF REP



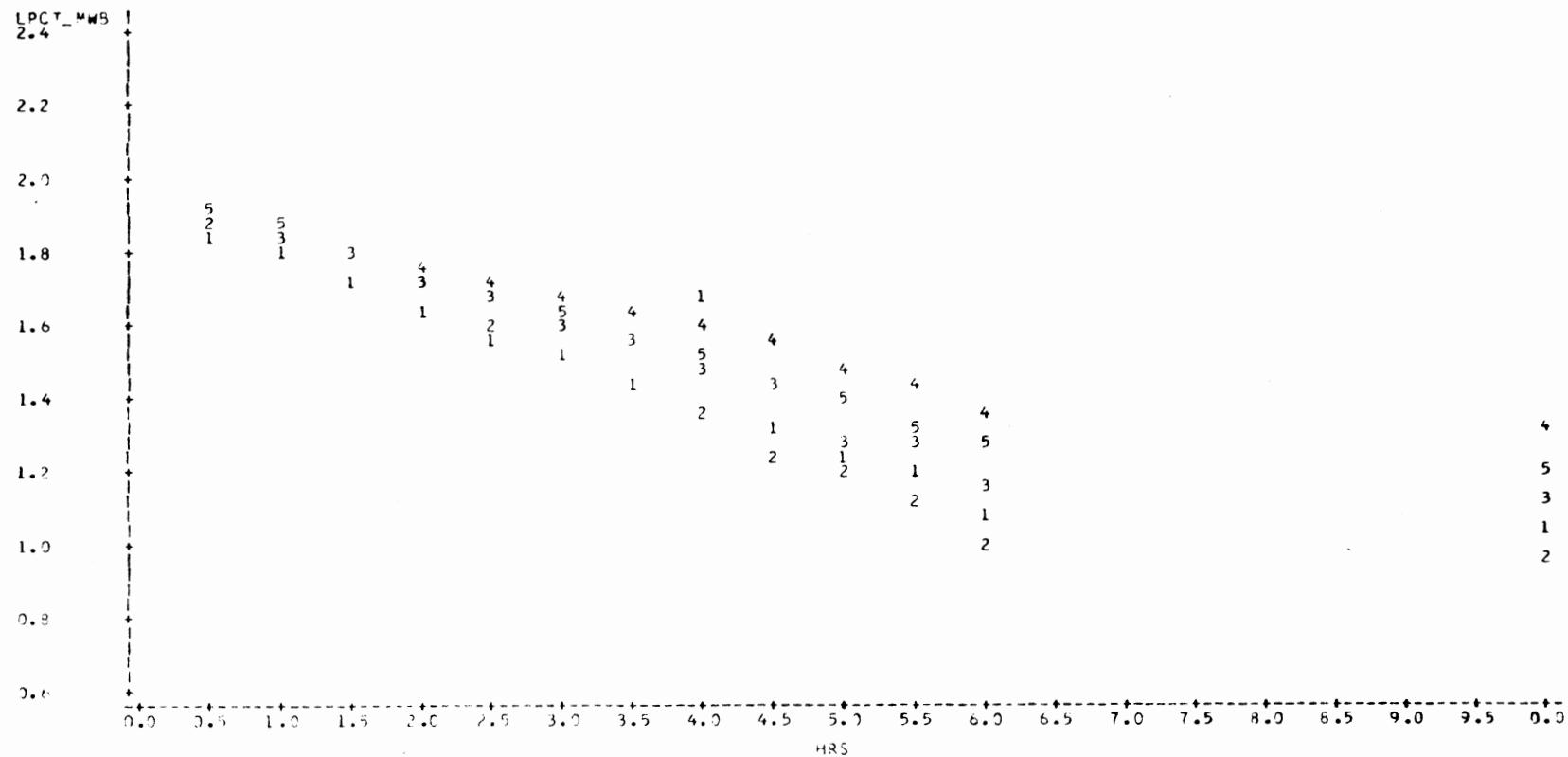
NOTE: 12 OBS HIDDEN

*Typical data for one roll.

SEA=2 HAY CONDITIONING ROLL RATE=1 *

21:03 THURSDAY, MARCH 23, 1978 1151

PRINT FILE LPCT_MWB*HRS SYMBOL IS VALUE OF REP



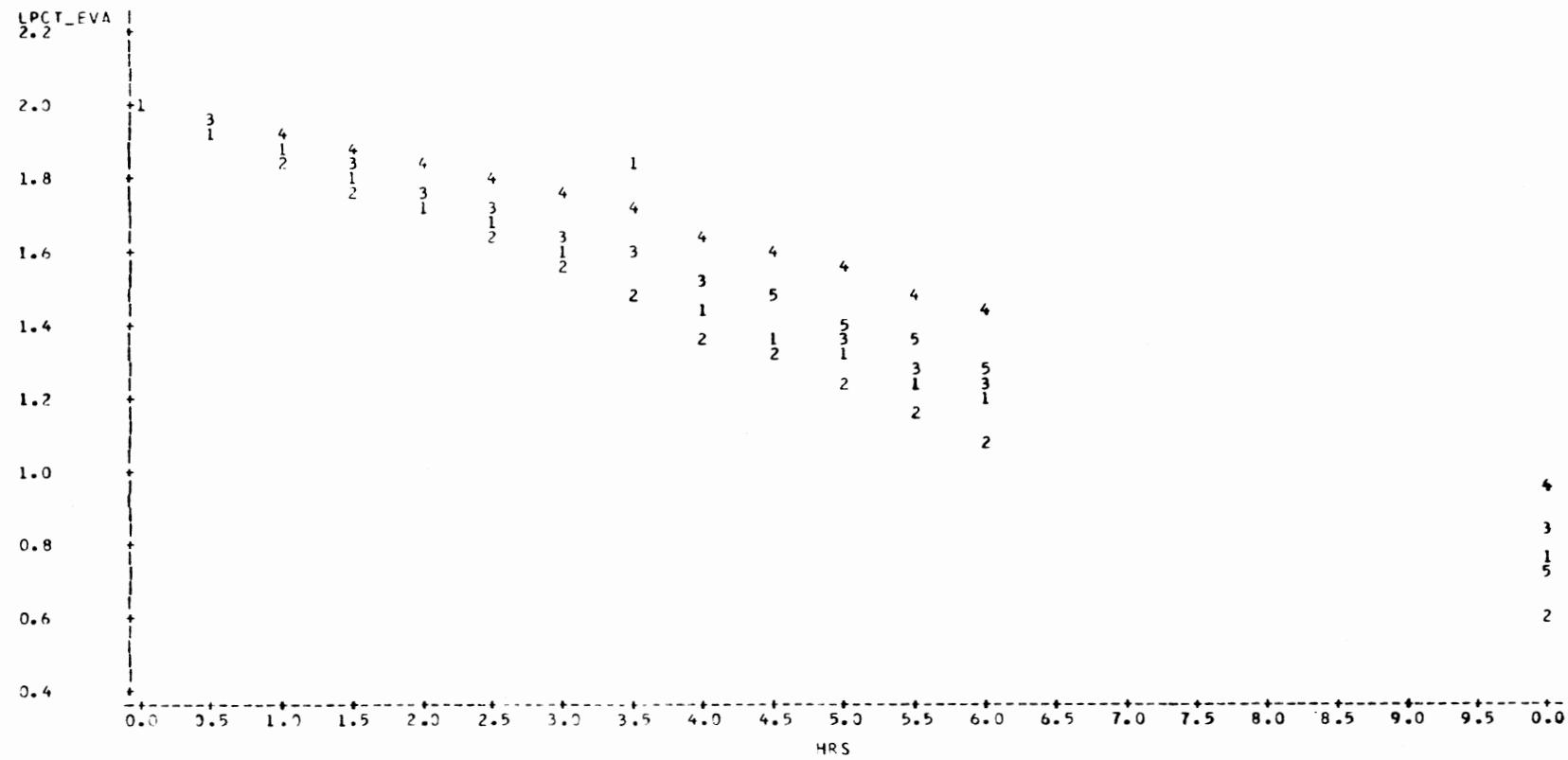
NOTE: 5 OBS HAD MISSING VALUES 14 OBS HIDDEN

*Typical data for one roll.

SEA=2 HAY CONDITIONING ROLLS
ROLL=0 PISS=1 RATE=1*

21:03 THURSDAY, MARCH 23, 1978 1143

PLOT OF LPCT_EVA*HRS SYMBOL IS VALUE OF RE?



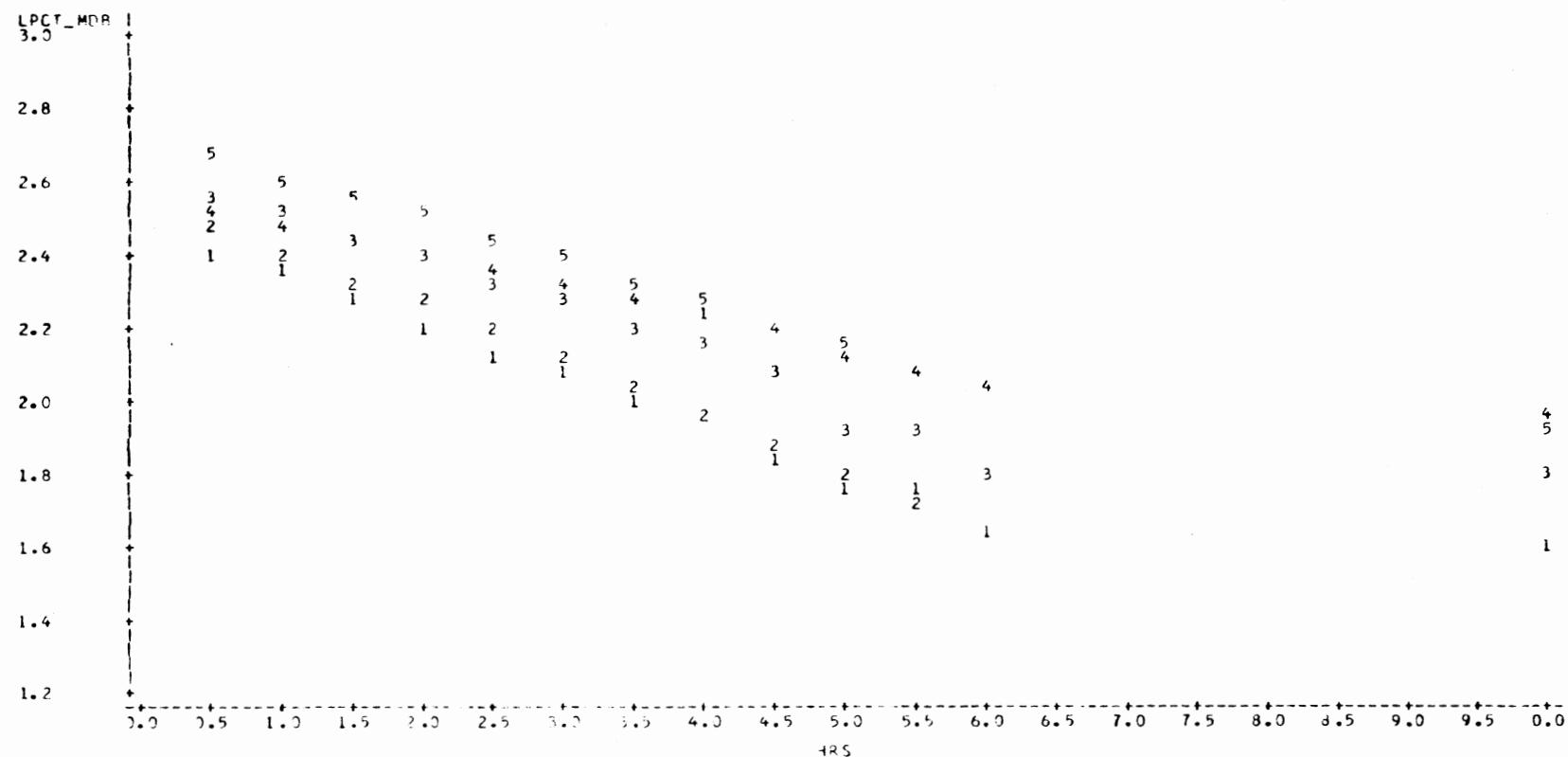
NOTE: 17 OBS HIDDEN

*Typical data for one roll.

SFA=2 DAY PREDICTION, ROLLS RATE=1 *

21:03 THURSDAY, MARCH 23, 1976 1147

PLOT OF LPCT_MDR#HRS SYMBOL IS VALUE OF REP



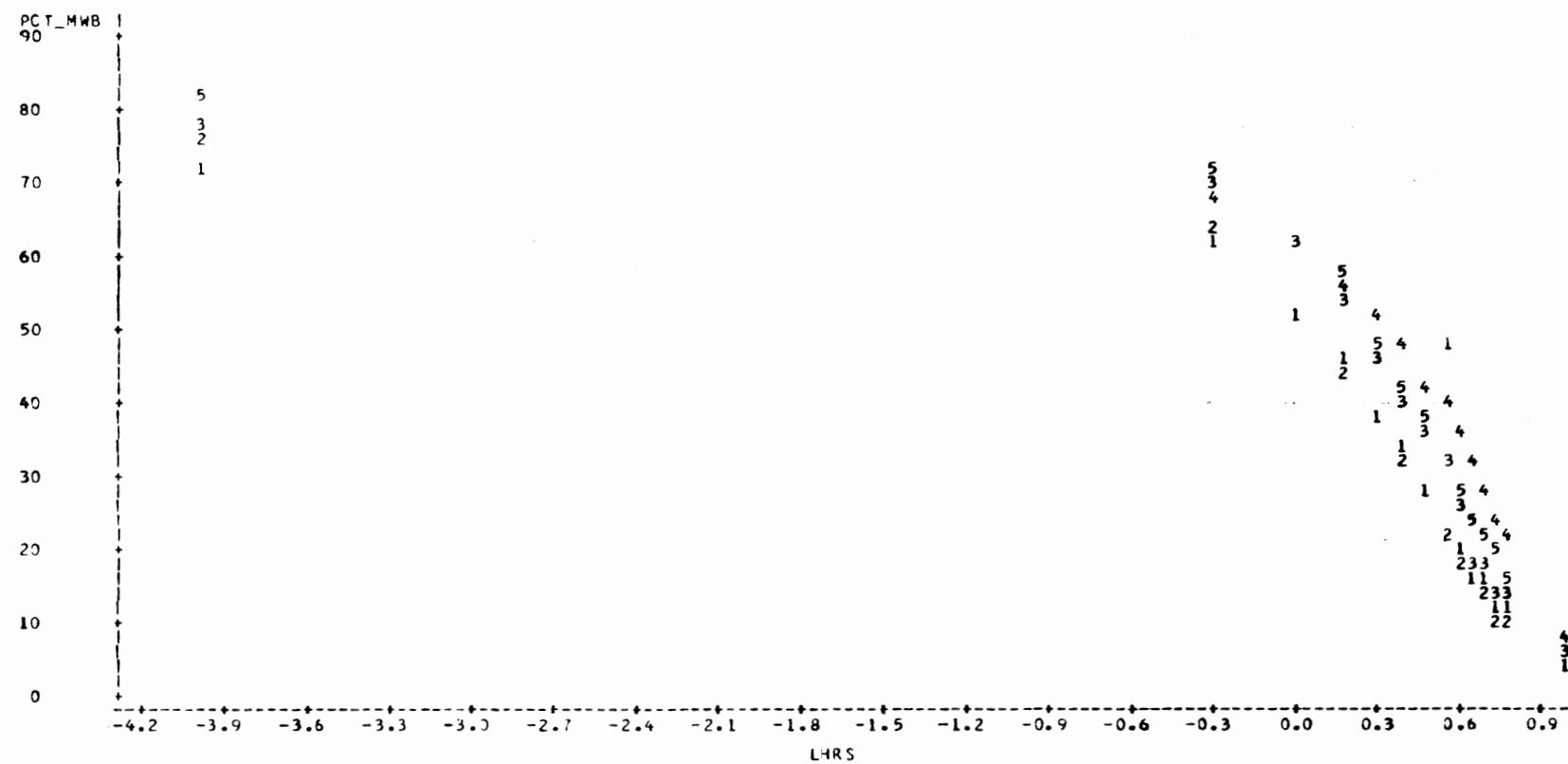
NOTE: 6 OBS HAD MISSING VALUES 8 OBS HIDDEN

*Typical data for one roll.

SEA=2 MAY ROLL=5 PASS=1 VOL RATE=1 *

PLT OF PCT_MWB*LHRS SYMBOL IS VALUE OF REP

21:03 THURSDAY, MARCH 23, 1978 1150

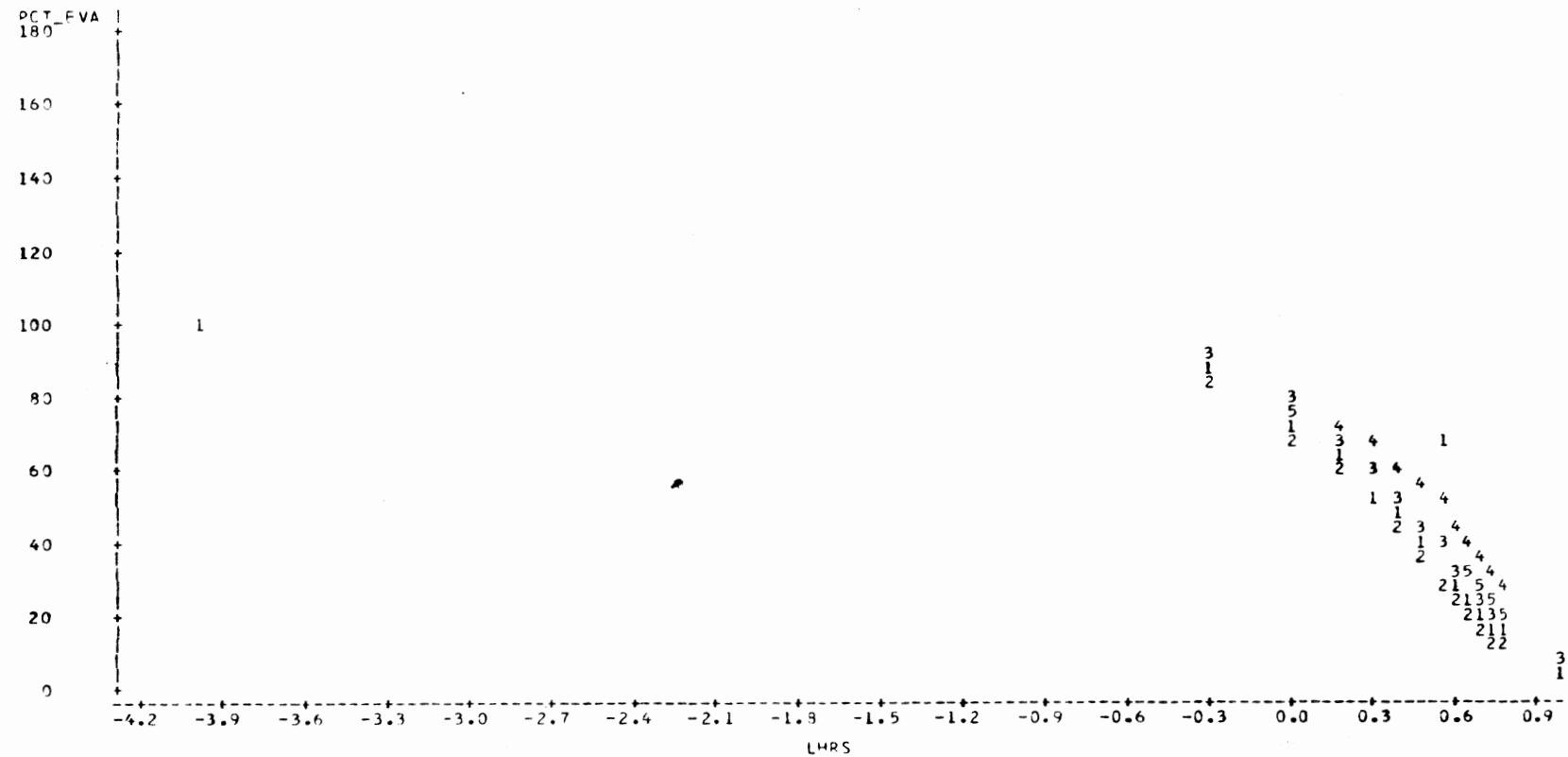


NOTE: 10 OBS HIDDEN

*Typical data for one roll.

SEA=2 HAY SELL=6 DOLLARS RATE=1*
PLOT OF PCT_EVA*LHRS SYMBOL IS VALUE OF REP

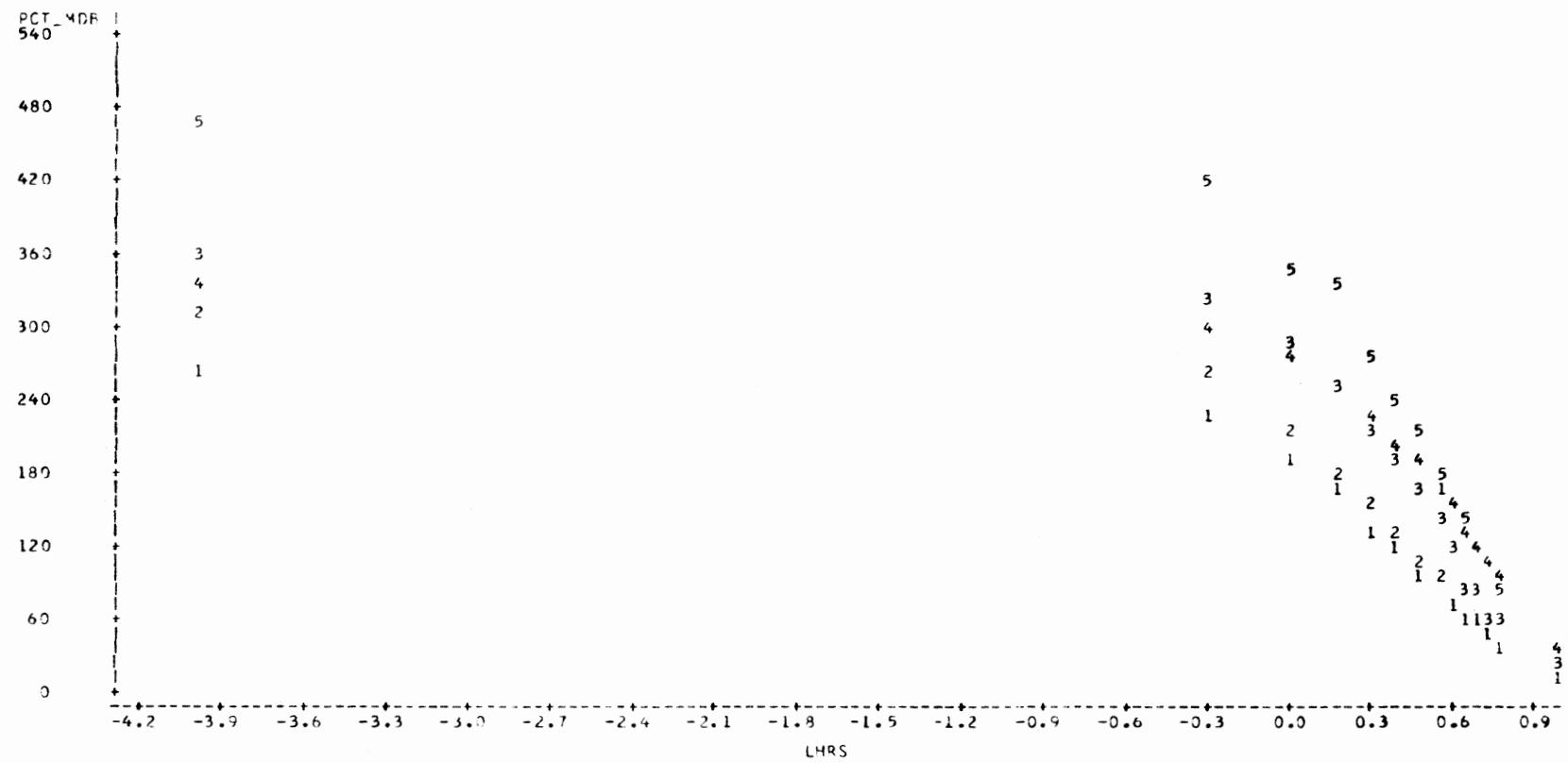
21:03 THURSDAY, MARCH 23, 1978 1142



SEA=2 HAY CONDITIONING ROLLS PASS=1 RATE=1 *

PLOT OF PCT_MDR*LHRS SYMBOL IS VALUE OF REP

21:03 THURSDAY, MARCH 23, 1978 1146



NOTE: 12 OBS HIDDEN

*Typical data for one roll.

APPENDIX C

PREDICTIONS OF THE CONFIDENCE INTERVAL

LIMITS FOR SEASON 2, ROLL 0,

PASS 1 AND RATE 1

APPENDIX D
CALCULATED MOISTURE CONTENT (wb)
FROM ORIGINAL DATA FOR
SEASON 1 AND SEASON 2

OBS	TREAT	TIME	DRMT	MCMB	OBS	TREAT	TIME	DRMT	MCMB	OBS	TREAT	TIME	DRMT	MCMB
225	11212	0.0	33.1	74.2	281	11022	0.0	24.1	81.0	337	11412	0.0	22.4	82.1
226	11212	0.5	33.1	65.7	282	11022	0.5	24.1	73.7	338	11612	0.5	22.9	75.2
227	11212	1.0	33.1	59.1	283	11022	1.0	24.1	68.0	339	11412	1.0	22.9	61.4
228	11212	1.5	33.1	52.5	284	11022	1.5	24.1	62.7	340	11412	1.5	22.9	54.0
229	11212	2.0	33.1	47.4	285	11022	2.0	24.1	55.7	341	11412	2.0	22.9	46.4
230	11212	2.5	33.1	43.5	286	11022	2.5	24.1	51.8	342	11412	2.5	22.9	43.0
231	11212	3.0	33.1	38.8	287	11022	3.0	24.1	45.5	343	11412	3.0	22.9	34.5
232	11212	3.5	33.1	33.8	288	11022	3.5	24.1	41.7	344	11412	3.5	22.9	29.8
233	11212	4.0	33.1	30.3	289	11022	4.0	24.1	37.2	345	11412	4.0	22.9	25.4
234	11212	4.5	33.1	25.2	290	11022	4.5	24.1	33.1	346	11612	4.5	22.9	21.4
235	11212	5.0	33.1	20.3	291	11022	5.0	24.1	29.5	347	11412	5.0	22.9	18.7
236	11212	5.5	33.1	20.2	292	11022	5.5	24.1	27.5	348	11412	5.5	22.9	15.1
237	11212	6.0	33.1	16.3	293	11022	6.0	24.1	24.3	349	11412	6.0	22.9	13.5
238	11212	10.0	33.1	5.8	294	11022	10.0	24.1	9.0	350	11412	10.0	22.9	5.0
239	11222	0.0	30.0	75.8	295	11023	0.0	23.5	81.5	351	11411	0.0	22.9	82.1
240	11222	0.5	30.0	66.5	296	11023	0.5	23.5	75.4	352	11411	0.5	22.9	74.3
241	11222	1.0	30.0	56.0	297	11023	1.0	23.5	69.3	353	11411	1.0	22.9	66.5
242	11222	1.5	30.0	48.6	298	11023	1.5	23.5	64.6	354	11411	1.5	22.9	58.7
243	11222	2.0	30.0	40.7	299	11023	2.0	23.5	59.8	355	11411	2.0	22.9	52.8
244	11222	2.5	30.0	36.3	300	11023	2.5	23.5	55.1	356	11411	2.5	22.9	47.0
245	11222	3.0	30.0	30.2	301	11023	3.0	23.5	50.4	357	11411	3.0	22.9	43.0
246	11222	3.5	30.0	29.4	302	11023	3.5	23.5	45.1	358	11411	3.5	22.9	38.0
247	11222	4.0	30.0	21.4	303	11023	4.0	23.5	41.7	359	11411	4.0	22.9	32.5
248	11222	4.5	30.0	16.1	304	11023	4.5	23.5	33.2	360	11411	4.5	22.9	29.6
249	11222	5.0	30.0	16.1	305	11023	5.0	23.5	35.4	361	11611	5.0	22.9	26.7
250	11222	5.5	30.0	12.5	306	11023	5.5	23.5	33.1	362	11411	5.5	22.9	22.3
251	11222	6.0	30.0	11.3	307	11023	6.0	23.5	29.1	363	11411	6.0	22.9	19.3
252	11222	10.0	30.0	6.0	308	11023	10.0	23.5	13.4	364	11411	10.0	22.9	9.1
253	11012	0.0	21.5	82.7	309	11021	0.0	27.0	73.2	365	11413	0.0	22.9	41.5
254	11012	0.5	21.5	73.9	310	11021	0.5	27.0	69.0	366	11413	0.5	22.9	41.6
255	11012	1.0	21.5	66.5	311	11021	1.0	27.0	61.3	367	11613	1.0	22.9	37.7
256	11012	1.5	21.5	57.5	312	11021	1.5	27.0	54.8	368	11413	1.5	22.9	32.3
257	11012	2.0	21.5	49.1	313	11021	2.0	27.0	49.8	369	11413	2.0	22.9	26.9
258	11012	2.5	21.5	46.9	314	11021	2.5	27.0	42.7	370	11413	2.5	22.9	23.7
259	11012	3.0	21.5	38.6	315	11021	3.0	27.0	39.7	371	11413	3.0	24.1	42.1
260	11012	3.5	21.5	33.1	316	11021	3.5	27.0	33.9	372	11413	3.5	24.1	73.4
261	11012	4.0	21.5	28.1	317	11021	4.0	27.0	29.8	373	11413	4.0	24.1	65.5
262	11012	4.5	21.5	24.8	318	11021	4.5	27.0	25.0	374	11413	4.5	24.1	57.7
263	11012	5.0	21.5	21.3	319	11021	5.0	27.0	22.6	375	11413	5.0	24.1	53.0
264	11012	5.5	21.5	19.8	320	11021	5.5	27.0	19.0	376	11413	5.5	24.1	46.8
265	11012	6.0	21.5	15.6	321	11021	6.0	27.0	15.5	377	11413	6.0	24.1	18.6
266	11012	10.0	21.5	7.2	322	11021	10.0	27.0	5.0	378	11413	10.0	24.1	38.2
267	11013	0.0	22.9	81.7	323	11011	0.0	25.5	79.3	379	11422	0.0	22.9	40.1
268	11013	0.5	22.9	40.9	324	11011	0.5	25.5	71.1	380	11422	0.5	22.9	37.0
269	11013	1.0	22.9	64.9	325	11011	1.0	25.5	63.0	381	11422	1.0	24.0	66.8
270	11013	1.5	22.9	57.7	326	11011	1.5	25.5	55.9	382	11422	1.5	24.0	60.5
271	11013	2.0	22.9	51.7	327	11011	2.0	25.5	50.8	383	11422	2.0	24.0	53.1
272	11013	2.5	22.9	45.7	328	11011	2.5	25.5	45.9	384	11422	2.5	24.0	48.2
273	11013	3.0	22.9	40.9	329	11011	3.0	25.5	40.2	385	11422	3.0	24.0	42.1
274	11013	3.5	22.9	35.3	330	11011	3.5	25.5	34.0	386	11422	3.5	24.0	36.8
275	11013	4.0	22.9	29.7	331	11011	4.0	25.5	30.5	387	11422	4.0	24.0	32.8
276	11013	4.5	22.9	25.7	332	11011	4.5	25.5	26.4	388	11422	4.5	24.0	27.9
277	11013	5.0	22.9	23.3	333	11011	5.0	25.5	22.4	389	11422	5.0	24.0	24.6
278	11013	5.5	22.9	21.7	334	11011	5.5	25.5	13.7	390	11422	5.5	24.0	17.7
279	11013	6.0	22.9	17.7	335	11011	6.0	25.5	17.1	391	11422	6.0	24.0	16.5
280	11013	10.0	22.9	9.7	336	11011	10.0	25.5	5.1	392	11422	10.0	24.0	6.3

OBS	TREAT	TIME	DRMT	MCWB	OBS	TREAT	TIME	DRMT	MCWB	OBS	TREAT	TIME	DRMT	MCWB	OBS	TREAT	TIME	DRMT	MCWB
2913	25012	0.0	22.0	82.1															
2914	25012	0.5	22.0	72.0															
2915	25012	1.0	22.0	63.0															
2916	25012	1.5	22.0	55.7															
2917	25012	2.0	22.0	49.6															
2918	25012	2.5	22.0	45.5															
2919	25012	3.0	22.0	42.3															
2920	25012	3.5	22.0	35.8															
2921	25012	4.0	22.0	33.3															
2922	25012	4.5	22.0	30.1															
2923	25012	5.0	22.0	26.4															
2924	25012	5.5	22.0	24.8															
2925	25012	6.0	22.0	21.1															
2926	25012	10.0	22.0	8.1															
2927	25011	0.0	22.0	82.4															
2928	25011	0.5	22.0	73.0															
2929	25011	1.0	22.0	61.4															
2930	25011	1.5	22.0	58.5															
2931	25011	2.0	22.0	48.2															
2932	25011	2.5	22.0	42.9															
2933	25011	3.0	22.0	37.5															
2934	25011	3.5	22.0	32.6															
2935	25011	4.3	22.0	27.6															
2936	25011	4.5	22.0	24.7															
2937	25011	5.0	22.0	21.4															
2938	25011	5.5	22.0	19.4															
2939	25011	6.0	22.0	15.3															
2940	25011	10.0	22.0	4.2															

OBS is the observation number associated with a particular piece of data.

TREAT is a five digit code where the 1st digit is season number, 2nd is the replication number, 3rd is the roll number, 4th is the pass number and 5th is the feed rate number.

TIME is given as hours of drying time in the partial drying oven.

DRMT is the dry matter content on a weight basis of the original sample and is in grams.

MCWB is the moisture content of the sample on a wet weight base at the time indicated.

VITA

Freidoun Saatlou Aviki

Candidate for the Degree of
Master of Science

Thesis: THE EFFECT OF CONDITIONING ROLLS, FEED RATE AND THE NUMBER OF PASSES ON FORAGE DRYING RATE

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Biographical:

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