



ROTARY PRESS PILOT TRIAL REPORT

***Winchester Waste Water Treatment Plant
Winchester, New Hampshire***



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Introduction

The purpose of this report is to present the results from the Fournier Rotary Press pilot trials performed at the Winchester Waste Water Treatment Plant. A Fournier Rotary Press pilot test is the most efficient way to determine and evaluate the equipment capabilities and aptitudes to perform on the actual sludge condition. Ranges of operation during the trial allow us to determine the peak performance for the following values:

- Cake Dryness
- Polymer Consumption
- Capture Rate
- Flow Throughput and Production per Channel

The dewatering trials were performed on the facilities blended secondary clarifier and septic tank sludge.

Pilot Equipment and Description

For this pilot the CV channel (2") was selected for a sludge that needs more surface area per unit volume allowing the cake to be dryer. The dewatering unit arrives inside a 48 foot trailer, hauled by truck directly to the site. Sludge from the plant was pump out of the trailer holding tank and then pumped to the flocculation tank for conditioning.

The following is a list of the components:

- Model 1-900/1000CV Rotary Press (2")
- Model 1-900/1000CVP Rotary Press (3")
- Flocculator Assembly
- Progressive Cavity Feed Pump
- Sludge Holding Tank and Mixer
- Progressive Cavity Polymer Feed Pump
- Two Polymer Preparation Tanks and Mixers
- Cake Conveyor
- Control Panel



Jar Testing and Prestart-up

One of the first steps during the pilot, that allows us to determine the best polymer for the dewatering of the different sludge, is a Jar Test. Three types of emulsion polymers were selected for the trial. A check list of the following components was performed before start-up to insure correct operation.

- Polymer Pump
- Polymer Flowmeter
- Sludge Pump
- Sludge Flowmeter
- Inlet Pressure Gauge
- Flocculator Tank and Mixer
- Recirculation Valve
- Dewatering Valve
- Rotary Press Channels and Motor

The Rotary Press start-up and shutdown procedures consist of a simple push-button operation, it is designed for unmanned operation and presents a consistent reliable operation under automatic mode.

Pilot Testing

The pilot unit achieves and demonstrates in a full scale manner the performance of the Fournier Rotary Press using actual plant sludge.

Operating parameters were adjusted in order to present variation of the following results:

- Cake Production
- Cake Dryness
- Capture Rate
- Energy Consumption
- Polymer Consumption (active Lbs.)
- Sludge Flow Rate

Date	Test Runs	Polymer
Tuesday, October 6 th	Trailer set up Trial1: Sample Sets 1A – 1P	BASF Zetag 7878
Wednesday, October 7 th	Trial 2: Sample Sets 2A – 2T Trial 3: Sample Sets 3A – 3R	Praestol 274 flx BASF Zetag 7878
Thursday, October 8 th	Trial 4: Sample Sets 4A – 4Z Trailer clean up	640 TBD
Friday, October 9 th	Trailer pick up	

Table 1: Pilot test schedule

Results

The emulsion polymers selected Zetag 7878, Praestol 274 flx, 640 TBD, formed excellent flocculation with the provided sludge. Each time a new polymer solution was prepared it was diluted down to 0.10% or 0.08% active concentration. The average polymer dosage required to adequately flocculate the sludge was 20.8 active lbs per dry ton.

The piloting trial produced excellent cake dryness, production, and the total suspended solids measured in the filtrate demonstrated a decent capture rate. The Rotary Press start-up and shutdown procedures consist of a simple push-button operation, it's designed for unmanned operation, and presents a consistent reliable operation under automatic mode making it ideal for this application. The Rotary Press obtained cake dryness up to 27.2%, a capture rate averaging 94.9%, and production as high as 91 dry Lbs/hr/channel.

Sludge	Average concentration	Average capture rate	Maximum cake dryness	Active polymer consumption	Maximum Production rate	Average Flow rate
	(%)	(%)	(%)	(Lbs/dry ton)	(Dry Lbs/hr)	(Gpm)
Trial 1	0.81	96.3	24.6	19.9	83	14.1
Trial 2	0.78	94.6	21.8	21.1	91	15.5
Trial 3	0.78	93.7	24.2	20.5	64	12.3
Trial 4	0.82	94.9	27.2	21.6	75	9.4

Table 2: Summary result of the different trials

Presented in Tables 3, 4, 5 and 6 are the results of piloting trial at the Winchester Waste Water Treatment Plant for blended secondary clarifier and septic tank sludge.

Each table displays the ***operating parameters***:

- Polymer Type, Concentration and Active Dosage
- Flocculator Speed
- Rotary Press Speed
- Rotary Press Inlet Pressure and Outlet Pressure
- Sludge Flow and Total Solids

Also present the results obtained during the trial:

- Filtrate Total Suspended Solids
- Cake Total Solids
- Production Rate per Channel
- Capture Rate

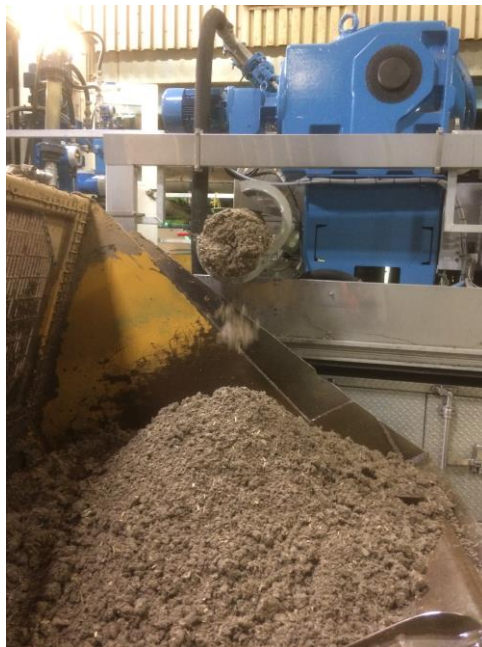




Table 3: Trial 1 Results

FOURNIER INDUSTRIES INC.

ENVIRONMENTAL DIVISION

Location: Winchester, NH

ROTARY PRESS Model 900-1000CV

(Channel OPTIMUM)

Sludge type: Blended Secondary and Septic tanks

Industrial waste: N

Color of Sludge: Brown

Sludge Temperature: 67 Deg F

Cloth Test: 12 %

Sludge PH: 6.5-7.0

Technicians: Isaac Therrien

From: October 6th - October 8th, 2020

DATE	GENERAL				OPERATING PARAMETERS						RESULTS				
	RUN #	POLYMER			FLOCCULATOR SPEED (RPM)	ROTARY PRESS					SLUDGE TS (%)	FILTRATE TSS (%)	CAKE TS (%)	PRODUCTION PER CHANNEL (dry Lbs/hr)	CAPTURE RATE TSS (%)
		TYPE	CONCEN. ACTIVE	DOSAGE (Lbs/dryton) ACTIVE		SPEED (RPM)	ENERGY USAGE (Kw-hr/ 2000 dry lbs)	INLET PRESSURE (PSI)	OUTLET PRESSURE (PSI)	SLUDGE (USGPM)					
October 6, 2020	1a	Zetag 7878	0.10%	20.8	325	0.25	3.27	4.0	55	19.7	0.77%	0.01	20.51%	74	98.3
October 6, 2020	1b	Zetag 7878	0.10%	21.1	325	0.25	3.06	4.0	55	20.2	0.76%	0.01	20.56%	76	99.3
October 6, 2020	1c	Zetag 7878	0.10%	19.9	325	0.25	6.65	4.0	55	9.2	0.80%	0.02	24.50%	36	97.8
October 6, 2020	1d	Zetag 7878	0.10%	19.8	325	0.25	7.22	4.0	55	9.0	0.81%	0.04	23.94%	35	95.7
October 6, 2020	1e	Zetag 7878	0.10%	20.4	325	0.20	7.60	4.0	55	7.4	0.79%	0.04	24.68%	28	95.4
October 6, 2020	1f	Zetag 7878	0.10%	20.4	325	0.20	7.13	4.0	55	7.3	0.79%	0.02	24.64%	28	98.1
October 6, 2020	1g	Zetag 7878	0.10%	19.6	325	0.30	8.33	4.0	55	9.2	0.82%	0.08	23.74%	34	90.1
October 6, 2020	1h	Zetag 7878	0.10%	19.4	325	0.30	6.93	4.0	55	9.4	0.82%	0.01	23.72%	38	99.4
October 6, 2020	1i	Zetag 7878	0.10%	19.5	325	0.40	7.58	4.0	55	12.8	0.82%	0.03	23.06%	50	96.3
October 6, 2020	1j	Zetag 7878	0.10%	19.5	325	0.40	7.31	4.0	55	12.0	0.82%	0.03	22.92%	48	97.0
October 6, 2020	1k	Zetag 7878	0.10%	19.5	325	0.50	6.34	4.0	55	16.0	0.82%	0.04	21.96%	62	94.9
October 6, 2020	1l	Zetag 7878	0.10%	19.5	325	0.50	6.20	4.0	55	15.9	0.82%	0.02	21.51%	63	97.1
October 6, 2020	1m	Zetag 7878	0.10%	19.6	325	0.60	7.04	4.0	55	17.4	0.82%	0.06	20.96%	65	92.3
October 6, 2020	1n	Zetag 7878	0.10%	19.5	325	0.60	6.56	4.0	55	17.6	0.82%	0.02	21.46%	70	97.4
October 6, 2020	1o	Zetag 7878	0.10%	19.6	325	0.75	6.26	4.0	55	21.0	0.82%	0.05	21.17%	80	93.8
October 6, 2020	1p	Zetag 7878	0.10%	19.6	325	0.75	5.50	4.0	55	20.8	0.82%	0.02	21.17%	83	97.4
AVERAGE		Zetag 7878	0.10%	19.9	325.0	0.41	6.44	4.0	55.0	14.1	0.81%	0.03	22.53%	54	96.3



Table 4: Trial 2 Results

FOURNIER INDUSTRIES INC.

ENVIRONMENTAL DIVISION

Location: Winchester, NH

ROTARY PRESS Model 900-1000CV

(Channel OPTIMUM)

Sludge type: Blended Secondary and Septic tanks

Industrial waste: N

Color of Sludge: Brown

Sludge Temperature: 67 Deg F

Cloth Test: 15 %

Sludge PH: 6.5-7.0

Technicians: Isaac Therrien

From: October 6th - October 8th, 2020

DATE	GENERAL				OPERATING PARAMETERS							RESULTS				
	RUN #	POLYMER			FLOCCULATOR SPEED (RPM)		ROTARY PRESS					SLUDGE TS (%)	FILTRATE TSS (%)	CAKE TS (%)	PRODUCTION PER CHANNEL (dry Lbs/hr)	CAPTURE RATE TSS (%)
		TYPE	CONCEN. ACTIVE	DOSAGE (Lbs/dryton) ACTIVE			SPEED (RPM)	ENERGY USAGE (Kw-hr/ 2000 dry lbs)	INLET PRESSURE (PSI)	OUTLET PRESSURE (PSI)	SLUDGE (USGPM)					
October 7, 2020	2a	Praestol 274 flx	0.10%	15.0	225	0.20	3.46	3.5	55	13.7	0.80%	0.02	20.51%	53	97.6	
October 7, 2020	2b	Praestol 274 flx	0.10%	15.1	225	0.20	3.57	3.5	55	13.3	0.79%	0.02	18.43%	52	97.9	
October 7, 2020	2c	Praestol 274 flx	0.10%	30.2	225	0.20	3.71	3.5	55	12.9	0.80%	0.01	21.86%	51	99.4	
October 7, 2020	2d	Praestol 274 flx	0.10%	30.2	225	0.20	4.06	3.5	55	12.4	0.80%	0.04	21.14%	47	95.0	
October 7, 2020	2e	Praestol 274 flx	0.10%	15.1	175	0.20	3.50	3.5	65	14.6	0.80%	0.03	18.41%	56	96.0	
October 7, 2020	2f	Praestol 274 flx	0.10%	15.1	175	0.20	3.61	3.5	65	13.7	0.80%	0.03	17.61%	52	96.5	
October 7, 2020	2g	Praestol 274 flx	0.10%	25.1	175	0.20	3.81	3.5	65	12.5	0.80%	0.02	18.43%	48	97.4	
October 7, 2020	2h	Praestol 274 flx	0.10%	25.1	175	0.20	4.14	3.5	65	12.0	0.80%	0.06	18.83%	44	92.3	
October 7, 2020	2i	Praestol 274 flx	0.10%	23.2	175	0.20	5.83	3.5	65	11.2	0.69%	0.05	19.31%	36	92.9	
October 7, 2020	2j	Praestol 274 flx	0.10%	20.8	175	0.20	7.24	3.5	65	10.9	0.77%	0.24	18.87%	29	69.4	
October 7, 2020	2k	Praestol 274 flx	0.10%	22.0	175	0.25	5.18	3.5	65	13.0	0.73%	0.01	21.30%	47	99.3	
October 7, 2020	2l	Praestol 274 flx	0.10%	22.0	175	0.25	4.85	3.5	65	13.8	0.73%	0.03	18.36%	48	96.3	
October 7, 2020	2m	Praestol 274 flx	0.10%	22.0	175	0.35	5.61	3.5	65	16.1	0.73%	0.03	17.65%	56	95.6	
October 7, 2020	2n	Praestol 274 flx	0.10%	22.0	175	0.35	5.49	3.5	65	16.8	0.73%	0.05	17.15%	57	93.4	
October 7, 2020	2o	Praestol 274 flx	0.10%	20.2	175	0.45	5.11	3.5	65	18.7	0.79%	0.05	17.08%	69	93.9	
October 7, 2020	2p	Praestol 274 flx	0.10%	19.8	175	0.45	5.01	3.5	65	18.2	0.81%	0.03	17.40%	71	96.3	
October 7, 2020	2q	Praestol 274 flx	0.10%	20.0	175	0.55	5.48	3.5	65	19.2	0.80%	0.02	16.91%	75	97.7	
October 7, 2020	2r	Praestol 274 flx	0.10%	20.0	175	0.55	5.54	3.5	65	18.9	0.80%	0.01	14.90%	74	98.6	
October 7, 2020	2s	Praestol 274 flx	0.10%	20.0	175	0.75	6.29	3.5	65	23.0	0.80%	0.06	16.47%	85	92.7	
October 7, 2020	2t	Praestol 274 flx	0.10%	20.0	175	0.75	5.75	3.5	65	24.1	0.80%	0.04	16.33%	91	94.6	
AVERAGE		Praestol 274 flx	0.10%	21.1	185.0	0.34	4.86	3.5	63.0	15.5	0.78%	0.04	18.35%	57	94.6	



Table 5: Trial 3 Results

FOURNIER INDUSTRIES INC.

ENVIRONMENTAL DIVISION

Location: Winchester, NH

ROTARY PRESS Model 900-1000CV
(Channel OPTIMUM)

Sludge type: Blended Secondary and Septic tanks

Industrial waste: N

Color of Sludge: Brown

Sludge Temperature: 67 Deg F

Cloth Test: 15 %

Sludge PH: 6.5-7.0

Technicians: Isaac Therrien

From: October 6th - October 8th, 2020

DATE	GENERAL				OPERATING PARAMETERS						RESULTS				
	RUN #	POLYMER TYPE	CONCEN. ACTIVE	DOSAGE (Lbs/dryton) ACTIVE	FLOCCULATOR SPEED (RPM)	ROTARY PRESS SPEED (RPM)	ENERGY USAGE (Kw-hr/ 2000 dry lbs)	INLET PRESSURE (PSI)	OUTLET PRESSURE (PSI)	SLUDGE (USGPM)	SLUDGE TS (%)	FILTRATE TSS (%)	CAKE TS (%)	PRODUCTION PER CHANNEL (dry Lbs/hr)	CAPTURE RATE TSS (%)
October 7, 2020	3a	Zetag 7878	0.10%	20.8	225	0.20	4.36	5.0	55	14.3	0.77%	0.04	19.09%	52	94.3
October 7, 2020	3b	Zetag 7878	0.10%	19.9	225	0.20	3.78	5.0	55	15.2	0.81%	0.02	18.08%	59	97.3
October 7, 2020	3c	Zetag 7878	0.10%	20.3	350	0.20	6.97	5.0	60	8.3	0.79%	0.01	22.03%	32	99.4
October 7, 2020	3d	Zetag 7878	0.10%	20.3	350	0.20	7.62	5.0	60	8.0	0.79%	0.01	23.04%	31	98.6
October 7, 2020	3e	Zetag 7878	0.10%	20.3	300	0.30	8.02	5.0	60	10.6	0.79%	0.03	23.33%	40	95.9
October 7, 2020	3f	Zetag 7878	0.10%	20.3	300	0.30	7.95	5.0	60	10.4	0.79%	0.04	22.88%	39	95.4
October 7, 2020	3g	Zetag 7878	0.10%	20.5	425	0.20	6.93	7.0	60	8.9	0.78%	0.06	24.23%	32	92.4
October 7, 2020	3h	Zetag 7878	0.10%	21.1	425	0.20	7.56	7.0	60	9.1	0.76%	0.08	23.88%	31	89.7
October 7, 2020	3i	Zetag 7878	0.10%	20.8	425	0.30	7.81	7.0	60	10.8	0.77%	0.02	23.23%	41	97.5
October 7, 2020	3j	Zetag 7878	0.10%	20.8	425	0.30	7.67	7.0	60	11.1	0.77%	0.03	23.73%	41	96.2
October 7, 2020	3k	Zetag 7878	0.10%	20.8	425	0.40	8.89	7.0	60	11.5	0.77%	0.04	23.20%	42	94.8
October 7, 2020	3l	Zetag 7878	0.10%	20.8	425	0.40	8.25	7.0	60	11.8	0.77%	0.03	22.98%	44	96.4
October 7, 2020	3m	Zetag 7878	0.10%	20.8	425	0.50	10.22	7.0	60	11.3	0.77%	0.02	22.80%	42	97.0
October 7, 2020	3n	Zetag 7878	0.10%	20.8	425	0.50	10.78	7.0	60	11.5	0.77%	0.07	23.34%	40	90.8
October 7, 2020	3o	Zetag 7878	0.10%	22.6	425	0.75	11.23	7.0	60	15.4	0.71%	0.08	21.68%	49	89.4
October 7, 2020	3p	Zetag 7878	0.10%	18.1	425	0.75	8.89	7.0	60	16.1	0.88%	0.13	21.04%	61	85.6
October 7, 2020	3q	Zetag 7878	0.10%	20.1	425	1.00	10.25	7.0	60	18.4	0.80%	0.10	20.23%	63	86.9
October 7, 2020	3r	Zetag 7878	0.10%	20.1	425	1.00	10.26	7.0	60	18.2	0.80%	0.09	20.68%	64	89.1
AVERAGE		Zetag 7878	0.10%	20.5	380.6	0.43	8.19	6.3	59.4	12.3	0.78%	0.05	22.19%	45	93.7



Table 6: Trial 4 Results

FOURNIER INDUSTRIES INC.

ENVIRONMENTAL DIVISION

Location: Winchester, NH

ROTARY PRESS Model 900-1000CV

(Channel OPTIMUM)

Sludge type: Blended Secondary and Septic tanks

Industrial waste: N

Color of Sludge: Brown

Sludge Temperature: 67 Deg F

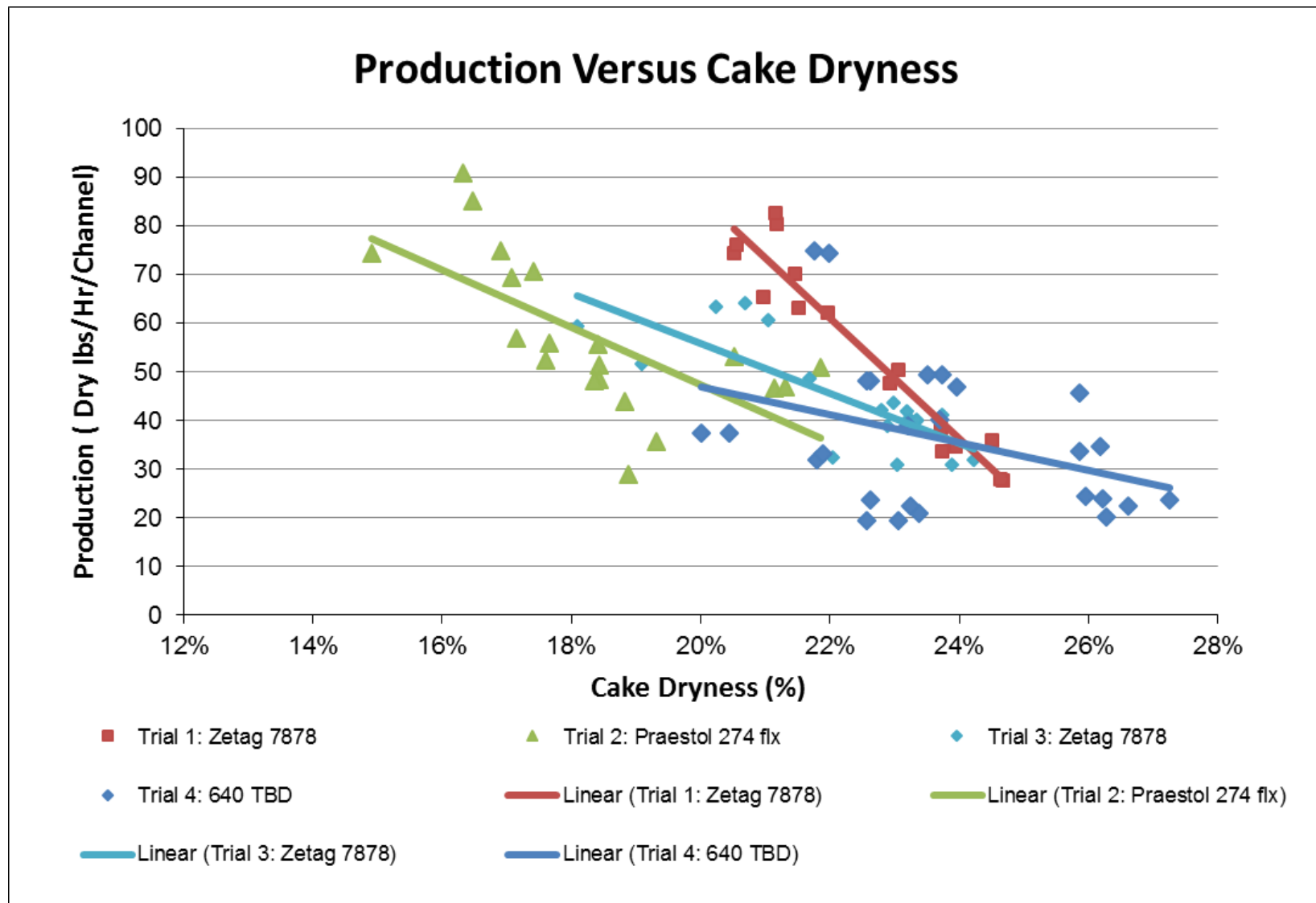
Cloth Test: 15 %

Sludge PH: 6.5-7.0

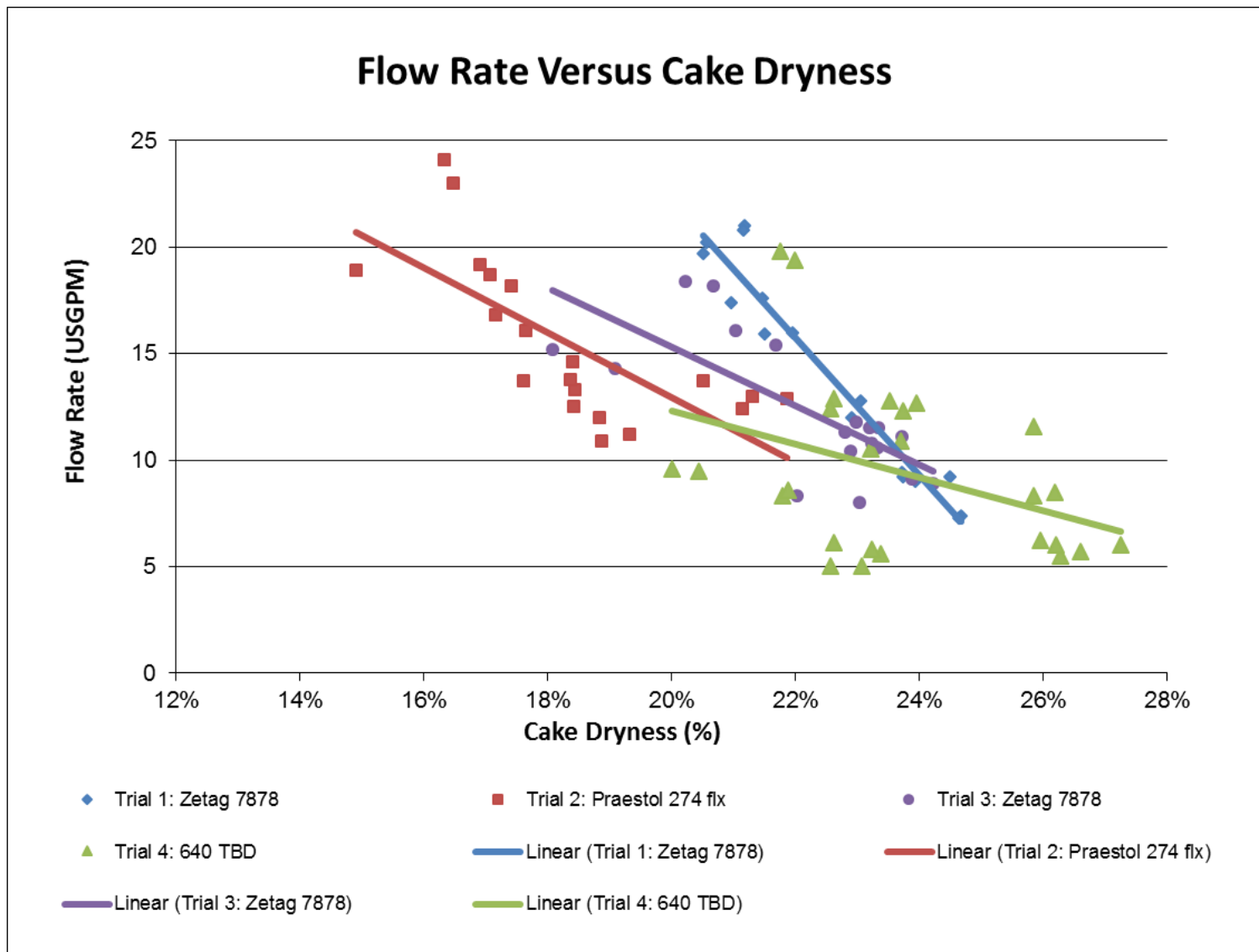
Technicians: Isaac Therrien

From: October 6th - October 8th, 2020

Sludge type: Dried Secondary and Septic tanks	GENERAL				OPERATING PARAMETERS						RESULTS				
	DATE	RUN #	POLYMER		FLOCCULATOR	ROTARY PRESS					SLUDGE TS (%)	FILTRATE TSS (%)	CAKE TS (%)	PRODUCTION PER CHANNEL (dry Lbs/hr)	CAPTURE RATE TSS (%)
			TYPE	CONCEN. ACTIVE		DOSAGE (Lbs/dryton) ACTIVE	SPEED	(RPM)	SPEED (RPM)	ENERGY USAGE (Kw-hr/ 2000 dry lbs)					
October 8, 2020	4a	640 TBD	0.08%	16.2	425	0.20	5.28	7.0	60	8.3	0.79%	0.02	21.80%	32	97.7
October 8, 2020	4b	640 TBD	0.08%	15.6	425	0.20	4.78	7.0	60	8.6	0.82%	0.04	21.89%	33	94.9
October 8, 2020	4c	640 TBD	0.08%	15.9	425	0.20	8.24	5.0	65	5.6	0.80%	0.06	23.38%	21	93.0
October 8, 2020	4d	640 TBD	0.08%	15.9	425	0.20	7.65	5.0	65	5.8	0.80%	0.03	23.24%	22	96.6
October 8, 2020	4e	640 TBD	0.08%	15.9	425	0.20	8.95	5.0	65	5.0	0.80%	0.02	23.06%	20	97.5
October 8, 2020	4f	640 TBD	0.08%	15.9	425	0.20	8.96	5.0	65	5.0	0.80%	0.02	22.56%	20	97.6
October 8, 2020	4g	640 TBD	0.08%	23.9	425	0.20	4.99	5.0	65	9.5	0.80%	0.02	20.43%	37	98.1
October 8, 2020	4h	640 TBD	0.08%	23.9	425	0.20	4.97	5.0	65	9.6	0.80%	0.02	20.01%	38	97.6
October 8, 2020	4i	640 TBD	0.08%	23.9	425	0.20	8.47	4.0	65	6.1	0.80%	0.03	22.62%	24	96.8
October 8, 2020	4j	640 TBD	0.08%	23.9	425	0.20	8.21	4.0	65	6.2	0.80%	0.02	25.96%	24	98.1
October 8, 2020	4k	640 TBD	0.08%	23.1	425	0.20	8.19	4.0	65	6.0	0.83%	0.04	27.25%	24	95.2
October 8, 2020	4l	640 TBD	0.08%	23.3	425	0.20	8.68	4.0	65	5.7	0.82%	0.04	26.60%	22	95.6
October 8, 2020	4m	640 TBD	0.08%	23.2	425	0.20	5.85	5.0	65	8.3	0.83%	0.02	25.85%	34	98.2
October 8, 2020	4n	640 TBD	0.08%	23.2	425	0.20	5.66	5.0	65	8.5	0.83%	0.01	26.19%	35	99.2
October 8, 2020	4o	640 TBD	0.08%	23.2	425	0.20	4.35	6.0	65	11.6	0.83%	0.04	25.85%	46	95.4
October 8, 2020	4p	640 TBD	0.08%	23.2	425	0.20	4.02	6.0	65	12.3	0.83%	0.02	23.74%	49	97.5
October 8, 2020	4q	640 TBD	0.08%	23.2	425	0.20	9.69	4.5	65	5.5	0.83%	0.09	26.27%	20	88.8
October 8, 2020	4r	640 TBD	0.08%	23.2	425	0.20	8.21	4.5	65	6.0	0.83%	0.03	26.21%	24	96.7
October 8, 2020	4s	640 TBD	0.08%	23.2	425	0.20	5.32	5.5	65	12.8	0.83%	0.05	23.51%	49	93.5
October 8, 2020	4t	640 TBD	0.08%	23.2	425	0.20	5.58	5.5	65	12.7	0.83%	0.09	23.95%	47	89.5
October 8, 2020	4u	640 TBD	0.08%	23.2	425	0.40	9.01	5.5	65	10.5	0.83%	0.08	23.21%	39	90.1
October 8, 2020	4v	640 TBD	0.08%	23.2	425	0.40	9.02	5.5	65	10.9	0.83%	0.09	23.69%	40	89.5
October 8, 2020	4w	640 TBD	0.08%	23.2	425	0.50	8.64	5.5	65	12.9	0.83%	0.08	22.62%	48	90.7
October 8, 2020	4x	640 TBD	0.08%	23.2	425	0.50	8.52	5.5	65	12.4	0.83%	0.05	22.57%	48	94.2
October 8, 2020	4y	640 TBD	0.08%	23.2	425	0.75	7.11	5.5	65	19.4	0.83%	0.06	21.98%	74	93.0
October 8, 2020	4z	640 TBD	0.08%	23.2	425	0.75	7.03	5.5	65	19.8	0.83%	0.07	21.75%	75	91.8
AVERAGE		640 TBD	0.08%	21.6	425.0	0.28	7.13	5.2	64.6	9.4	0.82%	0.04	23.70%	36	94.9



Graphic 1 : Production vs cake dryness



Graphic 2 : Flow rate vs cake dryness

Conclusion

The pilot test has proven the capability of the Fournier Rotary Press to efficiently dewater sludge from the Winchester Waste Water Treatment Plant.

The CVP channel (2") demonstrated very good performance, produced an excellent cake dryness, and provided a satisfactory production rate with a excellent capture rate thru the duration of the trials.

The Rotary Press is the most advanced dewatering technology available. The piloting trials performed at the facility demonstrated its reliability and consistency to produce a good cake dryness using very little power. The press is designed to operate with minimal operator assistance. The equipment is capable of shutting down and washing itself without operator assistance. It can be commanded to stop dewatering at a specific time or based on low sludge level availability. The Rotary Press is an extendable technology allowing other channels to be added to the unit in order to accommodate future increases in the flow. Up to eight (8) channels can be mounted on the same Press.





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