

# Think Powder ...

## Think Brookfield PFT™ POWDER FLOW TESTER

for affordable testing for powder characterization



**QUICK & EASY ANALYSIS**  
of powder flow behavior  
using proven scientific  
method **ASTM D6128**

**IDEAL FOR  
MANUFACTURERS**  
who process powders daily  
and have flow problems  
with bins, hoppers, silos  
and feeders

**ACCURATE TEST  
RESULTS**  
in minutes

**R&D TOOL**  
to predict flow behavior  
for new formulations  
before scale-up

**CHOICE OF TESTS**

- Flow Function
- Wall Friction
- Bulk density
- Time Consolidation

**QC CHECK**  
for incoming materials and  
final product shipments

**CHOICE OF RESULTS**

- Flow Index
- Arching Dimension
- Rathole Diameter
- Hopper Half Angle

**COMPACT DESIGN**  
fits easily on workbench

Developed in association with  
**The Wolfson Centre for Bulk Solids Handling Technology**  
at the University of Greenwich, England.

ISO 9001 CERTIFIED  
**BROOKFIELD**

# What is powder analysis?



Particulate materials constitute a large group of solids that can range in size from submicron particles to large rocks and minerals. Brookfield's Powder Flow Tester measures the flow behavior of bulk solid materials that have a top particle size of 2mm. At least 90% of the sample should consist of particles less than 1mm in diameter. In many instances, powders with larger particles can still be characterized effectively by sieving the material at 1mm and testing the fines (the fines control the flow properties of a material with a wide size range). The generic term used by Brookfield to name these materials is "powder", therefore the name of our instrument is "Powder Flow Tester".

Unlike liquids which, under the influence of gravity, tend to have a horizontal surface, powders exhibit a structure, due to internal friction and cohesion, which allows them to form piles with angles relative to the surface on which they are placed. At ambient conditions, powders do not change flow behavior when subjected to variable shear rates, whereas most liquids do. However, pressure controls the strength of a powder (i.e., increases the resistance to flow) whereas a liquid will show limited change in rheology under pressure. In other words, the consequence of subjecting a powder to a compressive force is that the powder will flow less easily; the relationship between the compressive stress applied to consolidate the powder and the strength it obtains is the measurement of the powder flowability, or its "Flow Function".

There is a need throughout industry to characterize powder flow properties and flow behavior. The Brookfield Model PFT Powder Flow Tester is a precision instrument of robust design that satisfies this need and more.

## What are the industrial issues with powders?

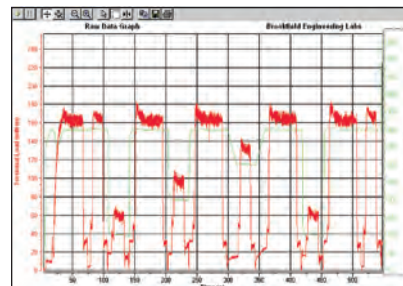
The classic problem with powders is their failure to discharge reliably from bins, hoppers, silos, etc., and poor or unpredictable flow in feeders, dosing machines, packing machines, etc. This causes unwanted interruptions in the production process, leading at times to complete plant shutdown in order to correct the flow restrictions and stoppages. It also leads to variations in pack weight, mixture, performance and sensory properties of powder products.

Quality Control Departments are constantly dealing with raw materials in powder form, which come from multiple suppliers. The variability in particle size and distribution, moisture content, and basic ingredients requires a battery of incoming inspection tests, none of which assure that proper flow will take place when loaded into the plant equipment. The Brookfield Powder Flow Tester is a single-solution instrument which can resolve this uncertainty.

R&D Departments are constantly adjusting formulations of powder products to satisfy customer demand for improved properties: better coating action for paints, enhanced taste for spices, rapid dissolving of chemicals when put into solution. New formulations do not necessarily have the same flow properties, thereby leading to production problems when the process is scaled up to high volume. The Brookfield Powder Flow Tester can predict those problems so they can be prevented.

## How can flow problems with powders be eliminated?

There is a proven scientific method, called the "Flow Function test", which can analyze powders for flow behavior. ASTM D6128 describes this procedure for compressing and shearing powder samples in a defined annular shear cell, using a well-defined methodology established years ago.

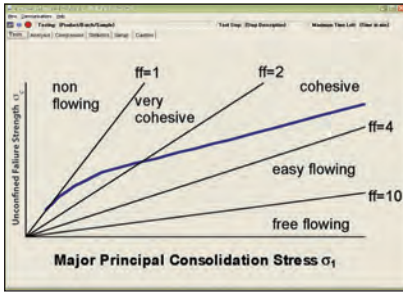


Test algorithm for powder flow analysis requires compression of the sample contained in an annular cell to a defined axial load followed by torsional shearing. Raw data output shows torsional load values in red. Compression of the sample is shown as axial load values in green.

## BROOKFIELD PFT POWDER FLOW TESTER

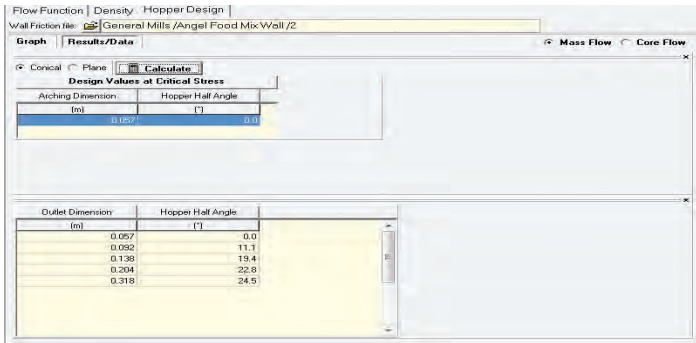


The resulting data produces a “Flow Function”, much like what is obtained for liquids when testing with a viscometer to create a “flow curve”.



Flow Function for powder sample shows “non-flowing” to “very cohesive” behavior at low consolidation stresses and “cohesive” behavior at higher consolidation stresses.

Analysis of the “Flow Function” leads to calculation of the critical outlet dimensions of feeders, hoppers, etc., through which the powder will flow. Comparing the “Flow Function”, or these critical dimensions, allows powders to be benchmarked, ranked and compared against one another for flowability. The dimensions can also be used to determine whether a particular powder will flow through an existing plant or process, or to determine what the geometry should be if purchasing new solids handling equipment.



Data output from Flow Function test provides “Arching Dimension” and “Rathole” diameter. Data output from additional Wall Friction test provides “Hopper Half Angle”.

Although ASTM D6128 has existed for many years, the instrumentation used to accomplish the test has been expensive to purchase, requires an experienced operator, and may need a technical expert to interpret the results.



## Why Choose Brookfield?

Brookfield has over 75 years experience in providing reliable, **low cost** viscosity and texture measurement instruments while offering **high quality** products and product support. We are now using this formula for success to expand our line of physical testing products to include the Powder Flow Tester .

The new Brookfield Powder Flow Tester is the simple answer to industry needs:

- A competent lab technician can run tests and collect data within minutes, eliminating the need for a powder specialist.
- The automated analysis provided by the Powder Flow Pro software calculates various properties of the powder, including the critical dimensions for reliable powder flow out of the hoppers, feeders, bins and silos.
- **The Wolfson Center for Bulk Solids Handling Technology** at the University of Greenwich, England, has worked closely with Brookfield to design the Powder Flow Tester, thereby ensuring its suitability for practical industrial use.
- The competitive purchase price is a small fraction of comparable devices available in the powder flow market.

## Applications

R&D, Incoming Materials Inspection, New Product Formulation, Quality Control, Process Plant Design

### Adhesives

### Beverages

Cocoa  
Milk Powder

### Ceramics

### Cosmetics

### Chemicals

### Construction

Cement  
Fly Ash  
Gypsum  
Hydrated Lime

### Dairy / Cheese

### Detergents

### Equipment Manufacturers

Silos / Bins / Hoppers  
Feeders

### Energy

Biomass  
Coal

### Fluxes

### Food

Biscuits / Cookies / Crackers  
Cereal  
Chocolate / Cocoa  
Flavorings / Seasonings  
Flour  
Spices  
Sugar

### Gunpowder/Ammunition

### Healthcare Products

Tablets

### Inks / Toners

### Paints / Coatings / Pigments

### Minerals

### Personal Care Products

Talcom Powder

### Pharmaceuticals

### Starch

## Properties Measured

Angle of internal friction  
Angle of wall friction  
Cohesive strength  
Bulk density  
Arching dimension

Rat hole diameter  
Flow Function (relation between consolidation stress and powder strength)  
Normalized flow function

# What's Included?

## Standard Volume

230cc Trough & 33cc Vane lid (263cc)

OR

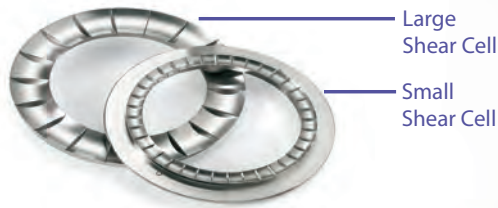
## Small Volume

38cc Trough & 5cc Vane lid (43cc)

Instrument, choice of 115 or 230 V  
 Powder Flow Pro Software with USB Cable  
 Trough (230 cc)  
 Vane Lid (33cc)  
 Wall Friction Lid: 304 s/s with 2B finish  
 Outer Catch Tray  
 Inner Catch Tray with Scraping Tool  
 Powder Scoop  
 Cleaning Brush

## Optional Accessories

Temperature Probe  
 Humidity Sensor  
 Wall Friction Lid: mild steel or Tivar 88



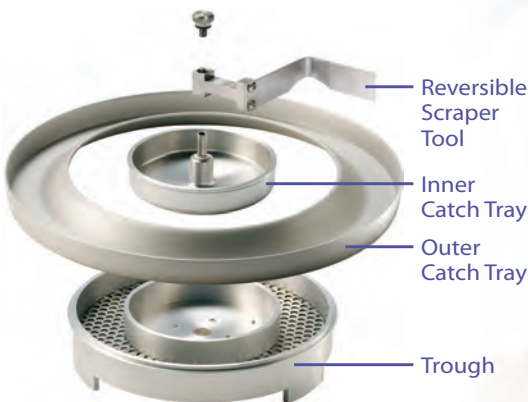
Large Shear Cell  
 Small Shear Cell



Vane Lid used for Flow Function Test



Wall Friction Lid

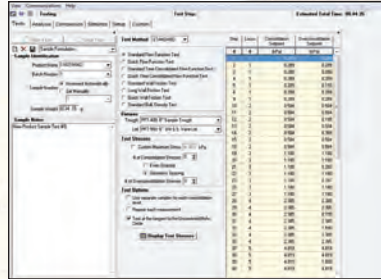


Reversible Scraper Tool  
 Inner Catch Tray  
 Outer Catch Tray  
 Trough

Inner and Outer Catch Trays with Scraper Tool for Sample Preparation in Trough

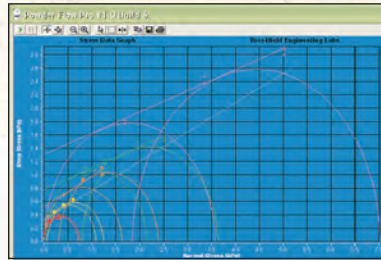
# Powder Flow Pro Software (Included)

Operation and control of the Powder Flow Tester is accomplished with Powder Flow Pro Software.

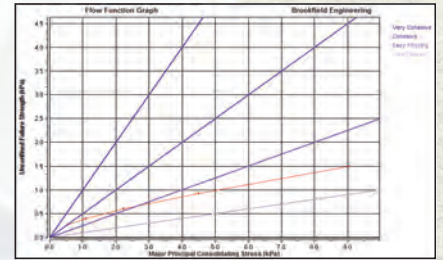


Main screen provides choice of basic tests:

- Flow Function
- Wall Friction
- Time Consolidated Flow Function
- Bulk Density



Stress data output screen captures "normal stress" and "shear stress" values and plots data in graphical format (calculates Mohr Circle Failure Loci).



Flow Function test produces graph of powder flow behavior which shows Unconfined Failure Strength vs. Major Principal Consolidating Stress

## PFT Powder Flow Tester Specifications

Load for Vertical Axis Compression:	7 kg	Accuracy ±0.6% FSR
Axial Speeds:	1mm/second up to 5mm/second	
Distance:	Accuracy ±0.3mm	
Torque:	±7.0 N·m	Accuracy ±1.2% FSR
Trough Rotational Speeds:	1 revolution/hour (RPH) up to 5 RPH	
Temperature Sensing:	-20°C to 120°C*	
Humidity Sensing:	10% to 95% RH ±5%†	
Dimensions (wxdxh):	(cm)	36.2 x 39.7 x 67.6
	(in)	14 1/4 x 15 5/8 x 26 5/8
Weight:	34 kg (75 lb)	

\* Requires Part No. DVP-94Y

† Requires Part No. PFT-607Y

## Computer Specifications for Powder Flow Pro Software

2GHz processor with 512 MB of RAM and 30 MB hard drive space available  
 1024x768 video resolution with 128 MB of graphics memory  
 Windows XP or Vista with one USB or RS-232 port



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