

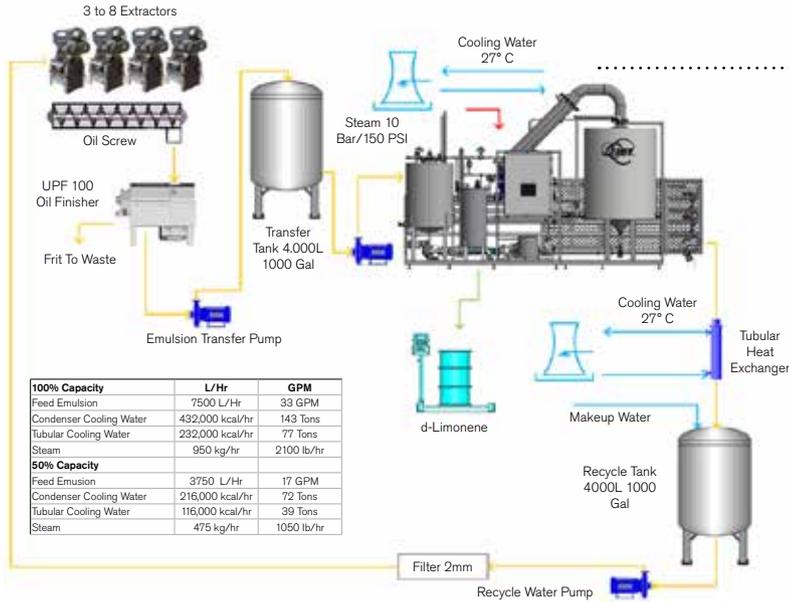


READYGo™ d-LIMONENE 33



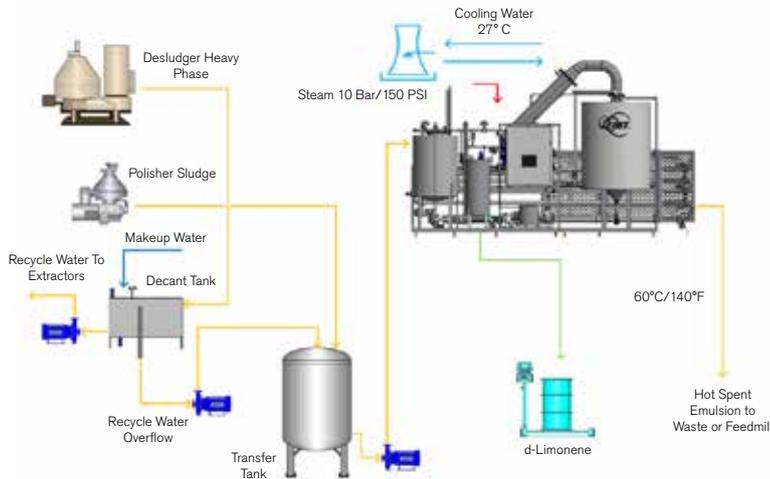
A cost effective way to clean up a waste stream and generate revenue

Primary Emulsion Application



d-Limonene, a name derived from the word “lemon,” is an active terpene compound which generally makes up approximately 95% of the chemical composition of essential citrus oils.

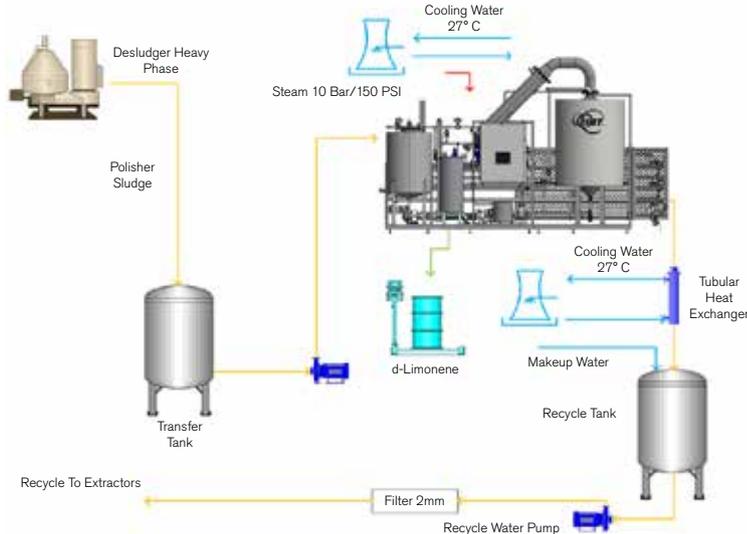
Decant Tank Recycle Overflow Application



Citrus peel can be cold-pressed to recover essential oil used for flavors and fragrances and/or to recover d-Limonene.

d-Limonene has a number of commercial applications in industrial cleaning and degreasing, removal of adhesives, circuit board cleaning, cosmetics, flavorings as well as many others. Because of the multiple applications for d-Limonene, demand for the product has steadily increased over time.

Heavy Phase Recovery Application



Citrus processors, constantly challenged to find alternative sources of revenue given the maturity of the citrus juice market, have found selling d-Limonene to be an increasingly important part of their overall business.

Processors generally weigh the operating expenses of the oil recovery system against the potential gross revenue when determining which oil recovery technique to implement. Historically, only larger citrus processors who could justify the investment in waste heat evaporation technology took advantage of the d-Limonene market opportunity.

With the development of the JBT READYGo™ d-LIMONENE 33 recovery



system, now even smaller processors can recover this valuable product stream.

The complete, skid-mounted system for the recovery of d-Limonene from various oil-rich streams can help processors in a number of ways:

- As a cost-effective method to recover d-Limonene for processors who are not prepared to make the significant investment required for a cold-pressed oil recovery system
- As a supplement for existing cold-pressed systems, eliminating the need to invest in a costly expansion
- To remove residual d-Limonene remaining in the discharge of cold-pressed oil systems and other waste streams, thus providing assistance to waste treatment or disposal systems

Our READYGo d-LIMONENE 33 can easily be integrated into a fully automated plant, saving processors the investment needed to implement a fully engineered system. Multiple skids can be added where more capacity is needed.

Due to its design, the system has the ability to recover more terpenes than traditional cold-pressed systems, potentially increasing overall revenue.

The READYGo d-LIMONENE 33 system is designed to process up to 33 gpm (7.5 m³/hr) of oil-bearing emulsion.

The oil-bearing emulsion is created during extraction using the same method as for cold-pressed oil processing except that less water is used in order to create a more concentrated emulsion. The emulsion is diverted to the d-Limonene skid via the finisher emulsion transfer pump coming from the emulsion feed tank.

The emulsion from the Primary Emulsion Application sketch is pumped from the feed tank

and mixed with live steam. Back pressure is maintained on the emulsion stream mixture and the liquid is flashed off into a vapor tank. A liquid level is maintained in the vapor tank using a centrifugal pump and a flow control valve. Vapor rises upwards and condenses in a water-cooled condenser.

The condensed liquid is pumped to a decant tank where the water and the d-Limonene are separated by gravity. The spent emulsion from the vapor tank is then pumped and cooled through a tubular heat exchanger and can be recycled back to the decant tank for use at the extractor or pumped off-skid. The finished d-Limonene is then pumped to storage.

The READYGo d-LIMONENE 33 Recovery System is:

- A fully automatic operation, including CIP
- Capable of recovery efficiencies of 85% or higher from the feed stream
- Capable of 63% to 70% total plant recovery from the fruit

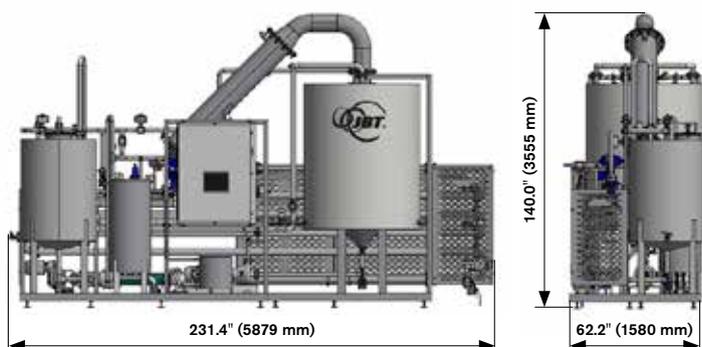
In other words, with our READYGo d-LIMONENE 33 recovery system, citrus processors no longer have to watch potential earnings go down the drain.

The READYGo d-LIMONENE 33 recovery system is the newest addition to the READYGo family. Built on skids, READYGo products are shipping container-ready for easy transport around the globe.

Complete with electrical motor starters and instrumentation, READYGo products require minimal field engineering and installation - simply hook up the utilities and the system is ready to go!



READYGo™ d-LIMONENE 33 - Approximate Specifications



TECHNICAL SPECIFICATIONS

ELECTRICAL SUPPLY	50Hz-3P-380V 35A	60Hz-3P-480V 35A
MOTOR POWER	6kW	8 hp
AIR FLOW	3.5Nm ³ /hr	6 scfm
AIR PRESSURE	6 bar	85 psi
STEAM FLOW (MIN-MAX)	1150 kg/hr	2550 lb/hr
STEAM PRESSURE (MIN-MAX)	10 - 12.5 bar	120 - 180 psi
FEED FLOW RATE (MIN-MAX)	7.5 m ³ /hr	33 gpm
FEED D-LIMONENE CONCENTRATION	0.1% - 5%	
COOLING WATER	10~15m ³ /h a 27°C max	432,000 kcal/h (143 TR)
COOLING WATER FLOW RATE (OFF-SKID)	8m ³ /h a 27°C máx	232,000 kcal/h (77 TR)
MAXIMUM COOLING WATER TEMPERATURE	27°C	80°F
CIP SOLUTION REQUIRED	750 l/cycle	200 gal/cycle

COUNT ON JBT TO HELP PROTECT YOUR INVESTMENT

JBT's greatest value in PRoCARE® services comes from preventing unexpected costs through smart, purposeful, and timely maintenance based on unmatched knowledge and expertise. PRoCARE service packages are offered as a maintenance agreement in various service levels, depending on your production and cost management requirements.



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