GUIDELINES FOR SETTING UP A SMALL MILLET PROCESSING UNIT

DHAN Foundation;

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IDRC Grant/ Subvention du CRDI: 108128-002-Scaling Up Small Millet Post-Harvest and Nutritious Food Products (CIFSRF Phase 2)
Guidelines for setting up a small millet processing unit

Scaling up Small Millet Post-harvest and Nutritious Food Products Project

Small Millet Foundation & DHAN Foundation
Small Millet Processing Units

Lamp Society, Jamunamarathur

Balan Millet Export, Salem

Balaji VPO, Sengapadai

CIKS Seramarathur, Jawathuhills
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Guidelines for setting up a small millet processing unit

1. Introduction

The market for healthful foods is increasing rapidly in India, as there is increasing health and nutrition awareness across the different sections of the society. As part of this growing market for healthful foods, the market for small millet foods is also on the rise. To capture this business opportunity, there is an increasing interest among the entrepreneurs to enter into the small millet processing sector in the recent past. This booklet on the 'Guidelines for setting up a small millet processing unit' has been prepared by DHAN Foundation as part of Scaling up Small Millet Post-harvest and Nutritious Food Products Project, keeping in mind the needs of new entrants to small millet processing sector. DHAN Foundation has been involved in setting up community scale small millet processing units (SMPU) and has been working with equipment manufacturers and regional level processors since 2011. This booklet has been prepared based on the learning gained during this period. The booklet covers the following:

1. Processing of small millets
2. Choosing set of equipment based on the planned scale of operation
3. Spares, accessories and tools
4. Testing the ordered equipment at the manufacturer's workshop/site
5. Installation

It also shares the support offered by DHAN Foundation for new entrants and existing small millet processing units.

2. Processing of small millets

Hulling is the process of removing the outer hull/husk from the grains, which are not human edible. It is a vital process for obtaining grain-rice and for further processing of grains for consumption. Small millets other than finger millet are well protected in glume encasements, hence the conversion of their grain to rice involve hulling
Traditionally, small millets were hulled manually by women in the production regions using pestle and mortar and/or wooden/stone grinders, as there is little-to no local processing infrastructure in the villages. This process involves significant drudgery and time. Due to this reason, the consumption of small millets has drastically declined in the production regions.

The major challenges in processing of small millets are:

1. The small size of the grains
2. Variations in the raw materials due to variation in varieties, cultivation practices and microclimate, across production regions and across the years and variations across the crops
3. Low shelf life of the processed rice and grits due to pest infestation and rancidity

Most of the small millet processing work that was done manually earlier can now be done by using equipment. But, in order to make best use of machines, correct process flow needs to be followed.

**Process flow**

The flow chart given in page no.3 explains about the steps in small millet processing to be followed in order to get optimum rice recovery and quality of output. The principles followed in the process flow are given below

**Pre-hulling**

1. Separation of Materials Other Than Grains (MOTG) namely, straw, small sticks, dust, sand, mud, pebbles and weed seeds from the grains as much as possible before hulling
2. Segregation of unfilled grains from the grains as much as possible before huling
3. Segregation of filled grains into different size and weight fractions before huling, as huling of same size/weight grains is more effective
Community Scale Small Millet Processing
Process Flow for improving quantity and quality of output

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For clarification contact: P. Saravanan - 8667566368 | G. Karthikeyan - 8144940641

Legend
- Machine
- Input material
- Manual process
- Primary product
- Secondary product
- Discard

Scaling up Small Millet Post-harvest and Nutritious Food Products Project
Post-hulling

1. Segregation of unhulled grains from the hulled fractions (grain, rice & grits)
2. Segregation of sand particles and dust from rice and grits
3. Segregation of rice and grits to use them separately

For ensuring quality output, the following machines are needed in the process line: i) Grader/Shaker with aspirator, ii) Destoner and iii) Huller. Choosing the right set of equipment is critical for optimising the investment and for effective operation.

3. Choosing set of equipment based on the planned scale of operation

This section will help the new entrant to assess his/her requirement of machines and other requirements for setting up SMPU. It will also give him/her information on the equipment available in the market with contact details of manufacturers.

a. Requirement of equipment for SMPU at different levels

<table>
<thead>
<tr>
<th>Description of requirement</th>
<th>Village/community scale</th>
<th>Small scale enterprise</th>
<th>Medium scale enterprise</th>
</tr>
</thead>
<tbody>
<tr>
<td>1. Capacity</td>
<td>50 kg/hr</td>
<td>100 kg/hr</td>
<td>500 -1000 kg/hr</td>
</tr>
<tr>
<td>2. Manpower</td>
<td>2 persons</td>
<td>2 to 10 persons depending on the volume of operations</td>
<td>15 to 30 persons depending on the volume of operations</td>
</tr>
</tbody>
</table>
| 3. Infrastructure          | 200 sq ft floor area    | • 1200 sq ft floor area  
• Godown to stock 2 to 4 tonnes of materials  
• 5000 to 10000 sq ft floor area  
• Godown to stock 10-20 tonnes of materials  
• Pick-up vehicle  
• Open yard for drying, sorting and cleaning grains  
• A small office room |
<table>
<thead>
<tr>
<th>Description of requirement</th>
<th>Village/community scale</th>
<th>Small scale enterprise</th>
<th>Medium scale enterprise</th>
</tr>
</thead>
<tbody>
<tr>
<td>4. Equipment</td>
<td>Decided based on locally grown small millet crops</td>
<td>Decided based on actual small millet crops to be processed</td>
<td>Decided based on actual small millet crops to be processed</td>
</tr>
</tbody>
</table>
| 4.1 Suggested basic equipment | • Destoner-1  
• Grader-1 with aspirator  
• Huller-1 | • Destoner-1 to 2  
• Grader-1 to 2  
• Huller-1 to 2 | • Destoner-4 to 8  
• Grader-4 to 8  
• Huller-2 to 4  
• Pulveriser-1  
• Semolina making machine-1  
• Elevators |
| 4.2 Additional equipment | | • Pulveriser-1 | • Polisher-1 |
| 4.3 Investment required (approximately) | • Rs.1.5 lakhs | • Rs.2.5 to 3.5 lakhs | • Rs.10 to 30 lakhs |
| 5. Accessories | • Weighing scale-100 kg  
• Weighing scale-50 gm to 5 kg  
• Air blower | • Weighing scale-100 kg  
• Weighing scale-50 gm to 5 kg  
• Packing & sealing machines - both gunny & polythene  
• Air blower | • Weighing scale- 100 kg  
• Weighing scale- 50 gm to 5 kg  
• Packing & sealing machines - both gunny & polythene  
• Hydraulic trolley  
• Air blower |
| 6. Power requirement | Single or 3 phase; 5 to 10 HP | 3 phase; 10 to 20 HP | 3 phase; 30 to 50 HP |
| 7. Specialised functions to be performed | | Purchase, record keeping & marketing | Management, purchase, record keeping, marketing & management vehicle |
### b. Manufacturers of small millet processing equipment

<table>
<thead>
<tr>
<th>Name &amp; address</th>
<th>Contact details</th>
<th>Equipment supplied</th>
</tr>
</thead>
</table>
| **1. AVM ENGINEERING INDUSTRIES,** No. 1/191, Vanniyar Nagar, Meyyanoor main road, Salem, Tamil Nadu - 636 005. | Mr. Rajasekar - 9443633131  
Mr. Jagadeesh - 7867018582  
0427-2442335  
avmengineeringindustries@gmail.com  
www.avmengineering.com | Destoners- 250 kg/hr to 500 kg/hr  
Graders - 3' to 12' Length(L) and 1' to 3' Breadth(B)  
Hullers- 50 kg/hr to 500 kg/hr  
Pulverisers- 30 kg/hr to 100 kg/hr  
Elevators as per requirement |
| **2. VICTOR AGRO SALES,** No. 162-A, Chinneri Vayalkadu, Backside New Bus Stand, P.B.No.907, Salem, Tamil Nadu - 636 009. | Mr. Mariappan - 8883961900  
Mr. Shanmugam - 9865413664  
Mr. Elumalai - 9500727272  
04272443887  
victormachinessalem@gmail.com | Destoners- 250 kg/hr to 1000 kg/hr  
Graders- 3' to 6' L and 1' to 2.5' B  
Hullers- 50 kg/hr to 200 kg/hr |
| **3. AGROMECH ENGINEERS,** No. 374, Patel Road, Coimbatore, Tamil Nadu - 641 009. | Mr. Sundarrajan - 9791766406  
agromechcbe@yahoo.com | Destoners- 250 kg/hr to 2000 kg/hr  
Graders- 3' to 12' L and 1' to 3' B  
Hullers-150 kg/hr, Pulverisers- 20 kg/hr to100 kg/hr, Elevators as per requirement |
| **4. PERFURA TECHNOLOGIES (INDIA) PRIVATE LTD,**  
No. 7, Maruthamalai Gounder Lay Out, Ganapathy, Coimbatore, Tamil Nadu - 641 006. | Mr. Udhaygopal - 098948 00009  
Ms. T.S.Sowmya  
0422 4534009  
sales@perfuratech.com  
www.perfuratech.com | Destoners-250 kg/hr to 2000 kg/hr  
Graders-3' to 6' L and 1' to 2.5' B  
Hullers-100 kg/hr, Pulveriser-20 kg/hr to 100 kg/hr, Elevator as per requirement |
| **5. KMS INDUSTRIES,** No. 514, Palani Andavar Nagar, Ranga layout ll, Nalilampalayam, Coimbatore - 641 006. | Mr. Kannan  
9894218517, 9597872888  
kovaimillstore@gmail.com  
kmsindustries888@gmail.com | Destoner-250 kg/hr to 2000 kg/hr,  
Grader-3' to 6' L and 1' to 2.5' B,  
Pulveriser-20 kg/hr to 100 kg/hr |
c. Images of small millet processing equipment

**AVM ENGINEERING INDUSTRIES**

- Destoner cum Grader with Aspirator
- Single chamber Huller
- Double chamber Huller
- Four chamber Huller

**VICTOR AGRO SALES**

- Destoner with Aspirator
- Grader
- Single chamber Huller
- Double chamber Huller
AGROMECH ENGINEERS

Grader with Aspirator

Destoner

Huller

PERFURA TECHNOLOGIES (INDIA) PVT. LTD.

Destoner with Grader & Aspirator

Dehusker

Huller
Some tips and points to be kept in mind

1. These are general guidelines and it would be better to visit existing processing units and discuss with experts in the field before taking the plunge.
2. Analyze the market potential in the proposed area of operation and your capabilities before choosing the scale of operation.
3. The new entrant/operator should take relevant onsite/practical training before starting the operations.
4. Choose equipment only after checking its performance for the small millet crops cultivated in your place.

4. Spares, accessories and tools

It is better to get the following spares, accessories and tools while purchasing the processing equipment

1. Spanner set for all the bolts used in the equipment
2. Allen keys for the shunk nut used in the equipment
3. Wire brush for cleaning the sieves in the grader
4. Air blower for cleaning inaccessible parts of all equipment and to remove grain/rice struck in sieve holes in grader
5. Hand sieves for identifying sieves with right hole size to be used in grader for its effective use for different small millet crops and for pre and post hulling operations
6. Extra pulleys of different sizes for adjusting rpm to hull the different small millet crops
7. Spare belts
8. Portable grader for removing dust and large impurities in the grains like sticks, clothes and mud balls, etc before going for grading operations
9. Extra set of sieves for grader based on small millet crops to be processed
10. Magnifying glass for checking uniformity of grains and average size of the grains
Portable grader

Allen key set

Air blower

Extra pulley

Spare belt

Hand sieve

Wire brush
5. Testing the equipment at the manufacturers' workshop/site

Once the set of equipment is chosen, order is placed and the machines are ready for dispatch, they need to be tested at the manufacturers' workshop/site. The purpose of checking at this point of time is to see if all the parts of the equipment are functioning well and any modifications and accessories needed are taken care of before dispatch. This section explains testing procedures for grader, destoner and huller, which are the main equipment needed in SMPU.

a. Grader with aspirator

![4' X 2' Grader with aspirator](image)
**Checking the components**

<table>
<thead>
<tr>
<th>S. No.</th>
<th>Component</th>
<th>Problem(s)</th>
<th>Probable reason(s)</th>
<th>Solution(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td><strong>A. Before running the equipment</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.</td>
<td>Feed hopper</td>
<td>Does not shut properly-leakage of materials</td>
<td>Feed control valve/mechanism not working properly</td>
<td>Get it repaired</td>
</tr>
<tr>
<td>2.</td>
<td>Foundation holes in frame</td>
<td>Not drilled</td>
<td>May have forgotten</td>
<td>Get it drilled</td>
</tr>
<tr>
<td>3.</td>
<td>Safety guard for drive belts/pulleys</td>
<td>Not installed</td>
<td>May have forgotten</td>
<td>Get it installed</td>
</tr>
<tr>
<td>4.</td>
<td>Emergency switch</td>
<td>Not installed</td>
<td>May have forgotten</td>
<td>Get it installed</td>
</tr>
<tr>
<td>5.</td>
<td>Sieve sets</td>
<td>Sieve frame is not properly fixed in the grader frame</td>
<td>Minor correction of either sieve set or grader mainframe needed</td>
<td>Get it done at the fabricators place</td>
</tr>
<tr>
<td></td>
<td><strong>B. While running the equipment</strong></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.</td>
<td>Moving parts</td>
<td>Undue noise &amp; vibration</td>
<td>Not properly fitted</td>
<td>Get it fitted properly</td>
</tr>
<tr>
<td>2.</td>
<td>Screen guards</td>
<td>Undue noise &amp; vibration; the gap between the guard and the main body is high</td>
<td>Not mounted/fitted properly</td>
<td>Get it mounted/fitted properly</td>
</tr>
<tr>
<td>3.</td>
<td>Motor rotation</td>
<td>Anti-clockwise rotation</td>
<td>Wrong motor phase connection</td>
<td>Change the phase connection</td>
</tr>
</tbody>
</table>

**Procedures for checking the performance**

Take 20 kg of ungraded sample (preferably sample of grains if predominant variety of the prevalent small millet crop in the location, where it is going to be installed) for checking removal of dust and light foreign material and large and small size foreign material from the grains. Take 15 - 20 kg of graded grains for checking separation of grains according to size and 10 kg of hulled fractions for checking separation of rice and grit based on size.
<table>
<thead>
<tr>
<th>S. No.</th>
<th>Description of function</th>
<th>Problem(s)</th>
<th>Probable reason(s)</th>
<th>Solution(s)</th>
<th>Remark(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td><strong>A. Pre cleaning with aspirator &amp; grader</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.</td>
<td><strong>Aspirator</strong> - Expected to remove dust and lighter materials from grains</td>
<td>Grains come out with dust and light materials</td>
<td>Dampener not adjusted</td>
<td>Adjust dampener</td>
<td>If problem is still not solved, fan rpm to be reduced</td>
</tr>
<tr>
<td>2.</td>
<td><strong>Grader</strong> - Expected to remove i. sand and smaller grains and ii. Large twigs, mud balls, straw, etc. from normal sized grains</td>
<td>Grains come mixed with MOTG</td>
<td>Sieve size is not proper</td>
<td>Use proper sized sieves</td>
<td>Suggestion: Bottom sieve- 0.8 to 1.1 mm; middle 1.4 to 1.7 mm &amp; top 2.6 to 3.0 mm</td>
</tr>
<tr>
<td><strong>B. Pre- hulling</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td><strong>Grader</strong>- Separation of grains into three grades- Large grains (10%), normal sized grains (70 to 80%) and small grains (10 to 20%)</td>
<td>Improper separation</td>
<td>Sieve size is not proper</td>
<td>Use proper sized sieves</td>
<td>Choose sieves suitable for the predominant small millet crop to be processed</td>
</tr>
<tr>
<td><strong>C. Post- hulling</strong></td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>4.</td>
<td><strong>Aspirator</strong>- Expected to remove millet husk, husk rich flour and other dust from rice</td>
<td>Not separating properly</td>
<td>Dampener not adjusted</td>
<td>Adjust dampener Use</td>
<td>If problem is still not solved, fan rpm to be reduced</td>
</tr>
<tr>
<td>5.</td>
<td><strong>Grader</strong>- Separation of un-hulled grains, shattered rice kernels from hulled whole grain rice</td>
<td>Not separating properly</td>
<td>Sieve size is not proper</td>
<td>Proper sized sieves</td>
<td>Sieve size of bottom sieve should be more than the destoner bed mesh size; Choose sieves suitable for the predominant small millet crop to be processed; Get additional sieve sets</td>
</tr>
</tbody>
</table>
b. Destoner

![Destoner principle of operation](image)

**Checking the components**

<table>
<thead>
<tr>
<th>S. No.</th>
<th>Component</th>
<th>Problem(s)</th>
<th>Probable reason(s)</th>
<th>Solution(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>A.</td>
<td>Before running the equipment</td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.</td>
<td>Feed hopper</td>
<td>Does not shut properly-leakage of materials</td>
<td>Feed control valve/mechanism not working properly</td>
<td>Get it repaired</td>
</tr>
<tr>
<td>2.</td>
<td>Holes in the frame for foundation bolts</td>
<td>Not drilled</td>
<td>May have forgotten</td>
<td>Get it drilled</td>
</tr>
<tr>
<td>3.</td>
<td>Safety guard, if aspirator is there</td>
<td>Not installed</td>
<td>May have forgotten</td>
<td>Get it installed</td>
</tr>
<tr>
<td>4.</td>
<td>Emergency switch</td>
<td>Not installed</td>
<td>May have forgotten</td>
<td>Get it installed</td>
</tr>
<tr>
<td>S. No.</td>
<td>Component</td>
<td>Problem(s)</td>
<td>Probable reason(s)</td>
<td>Solution(s)</td>
</tr>
<tr>
<td>-------</td>
<td>-----------------------------------------------</td>
<td>--------------------------</td>
<td>-------------------------------------</td>
<td>--------------------------------------------------</td>
</tr>
<tr>
<td>5.</td>
<td>Destoner bed mesh</td>
<td>Not as specified</td>
<td>Oversight</td>
<td>Get specified bed mesh installed</td>
</tr>
<tr>
<td>6.</td>
<td>Fan box door</td>
<td>Not freely moving</td>
<td>Oversight</td>
<td>Movement to be made smooth</td>
</tr>
</tbody>
</table>

### B. While running the equipment

<table>
<thead>
<tr>
<th>S. No.</th>
<th>Component</th>
<th>Problem(s)</th>
<th>Probable reason(s)</th>
<th>Solution(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Moving parts</td>
<td>Undue noise &amp; vibration</td>
<td>Not properly fitted</td>
<td>Get it fitted properly</td>
</tr>
<tr>
<td>2.</td>
<td>Motor rotation</td>
<td>Anti-clockwise rotation</td>
<td>Motor phase connection wrong</td>
<td>Change the phase connection</td>
</tr>
<tr>
<td>3.</td>
<td>Air pressure in destoner bed</td>
<td>Not sufficient</td>
<td>1. Air leakage from sides or unintended openings</td>
<td>1. Get leakages plugged</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2. Fan speed not enough</td>
<td>2. Fan should be properly fixed to the shaft</td>
</tr>
<tr>
<td>4.</td>
<td>Belt tension, in the case of destoner with grader &amp; aspirator</td>
<td>Undue slip of the belt</td>
<td>1. Wrong size belts</td>
<td>1. Check belt tension in pulley drivers and rectify/ replace with suitable belt.</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2. Distance between pulleys not as required</td>
<td>2. Fine adjustment between pulleys to be done.</td>
</tr>
</tbody>
</table>

**Procedures for checking the performance**

Take 20 kg of raw material sample and fill the feed hopper for checking destoning efficiency. Take 15 –20 kg of graded grains for checking separation of grains according to weight/ density. Take 10kg of hulled and graded fractions for checking separation of fractions based on weight. Take 10 kg of hulled and grader fractions for checking separation of rice and grit into hulled rice and unhulled grains.
<table>
<thead>
<tr>
<th>S. No.</th>
<th>Description of function</th>
<th>Problem(s)</th>
<th>Probable reason(s)</th>
<th>Solution(s)</th>
<th>Remark(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>A. Pre-hulling cleaning and segregation</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.</td>
<td><strong>Destoning first phase</strong> - Expected to segregate heavier materials- stones, mud balls, sand and others in the back and grains in the front</td>
<td>Stones and heavier materials not adequately segregating</td>
<td>Adjustment of destoner settings-bed angle and fan box opening- not done properly</td>
<td>Make necessary adjustments to get desired results</td>
<td>Choose destoner settings, suitable for the predominant small millet crop to be processed</td>
</tr>
<tr>
<td>2.</td>
<td><strong>Destoning second phase</strong> - Expected to segregate unfilled and lighter grains in the front and other normal grains in the back</td>
<td>Unfilled and light grains not adequately segregating</td>
<td>Adjustment of destoner settings-bed angle and fanbox opening- not done properly</td>
<td>Make necessary adjustments to get desired results</td>
<td>Get the proper mesh size suitable for small millet crop to be processed</td>
</tr>
<tr>
<td>B. Post-hulling cleaning and segregation</td>
<td></td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>3.</td>
<td><strong>Destoning</strong> (post hulling &amp; grading-first phase) - Expected to segregate unhulled grains in the front and hulled rice in the back</td>
<td>Unhulled grains not segregated adequately</td>
<td>Adjustment of destoner settings-bed angle and fan box opening- not done properly</td>
<td>Make necessary adjustments to get desired results</td>
<td>See that destoner mesh size is smaller than the sieve size of bottom sieve of the grader, which is used before destoning in the post-hulling phase</td>
</tr>
<tr>
<td>4.</td>
<td><strong>Destoning</strong> (post hulling &amp; grading-second phase) - Expected to segregate lighter hulled fractions in the front from the heavier hulled fractions(rice) in the back</td>
<td>Hulled fractions are not segregated properly</td>
<td>Adjustment of destoner settings-bed angle and fan box opening- not done properly</td>
<td>Make necessary adjustments to get desired results</td>
<td></td>
</tr>
</tbody>
</table>
c. Impact huller with aspirator

![Centrifugal Huller - (Double Chamber)](image)

<table>
<thead>
<tr>
<th>S. No.</th>
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<th>Solution(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>A.</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>1.</td>
<td>Feed hopper</td>
<td>Does not shut properly-leakage of materials</td>
<td>Feed control valve / mechanism not working properly</td>
<td>Get it repaired</td>
</tr>
<tr>
<td>2.</td>
<td>Holes in frame for foundation bolts</td>
<td>Not drilled</td>
<td>May have forgotten</td>
<td>Get it drilled</td>
</tr>
<tr>
<td>3.</td>
<td>Safety guard</td>
<td>Not installed</td>
<td>May have forgotten</td>
<td>Get it installed</td>
</tr>
<tr>
<td>4.</td>
<td>Emergency switch</td>
<td>Not installed</td>
<td>May have forgotten</td>
<td>Get it installed</td>
</tr>
<tr>
<td>S. No.</td>
<td>Component</td>
<td>Problem(s)</td>
<td>Probable reason(s)</td>
<td>Solution(s)</td>
</tr>
<tr>
<td>-------</td>
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<td>------------------------------------------------</td>
<td>--------------------------</td>
<td>--------------------------------------------------</td>
</tr>
<tr>
<td>5.</td>
<td>Pulley bolt position</td>
<td>In the machine side</td>
<td>Oversight</td>
<td>To be changed to the outer side</td>
</tr>
<tr>
<td>6.</td>
<td>Pulley alignment</td>
<td>Not aligned properly</td>
<td>Oversight</td>
<td>To be aligned</td>
</tr>
<tr>
<td>7.</td>
<td>Dampener</td>
<td>Not freely moving</td>
<td>Oversight</td>
<td>Movement to be made smooth</td>
</tr>
</tbody>
</table>

**B. While running the equipment**

<table>
<thead>
<tr>
<th>S. No.</th>
<th>Component</th>
<th>Problem(s)</th>
<th>Probable reason(s)</th>
<th>Solution(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Moving parts</td>
<td>Undue noise &amp; vibration</td>
<td>Not properly fitted</td>
<td>Get it fitted properly</td>
</tr>
<tr>
<td>2.</td>
<td>Screen guards</td>
<td>Undue noise &amp; vibration; the gap between the guard and the main body is more</td>
<td>Not mounted /fitted properly</td>
<td>Get it mounted/fitted properly</td>
</tr>
<tr>
<td>3.</td>
<td>Motor/impeller/aspirator fan rotation</td>
<td>Anti-clockwise rotation</td>
<td>Wrong phase connection</td>
<td>Change the phase connection and/or make change in wiring</td>
</tr>
<tr>
<td>4.</td>
<td>Belt tension</td>
<td>Undue slip between pulleys</td>
<td></td>
<td>1. Check belt tension in pulley drives and rectify/replace with suitable belt</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>1. Wrong size belts</td>
<td>2. Fine adjustment between pulleys to be done</td>
</tr>
<tr>
<td></td>
<td></td>
<td></td>
<td>2. Distance between pulleys not as required</td>
<td></td>
</tr>
</tbody>
</table>

**Procedures for checking the performance**

Take at least 10 to 20 kg of cleaned and graded grains of each intended variety and have test run of the huller. As the size and other features of varieties vary a lot, it is better to bring grains from the area of installation.
<table>
<thead>
<tr>
<th>S. No.</th>
<th>Description of function</th>
<th>Problem(s)</th>
<th>Probable reason(s)</th>
<th>Solution(s)</th>
<th>Remark(s)</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>Hulling</td>
<td>More broken rice &amp; grits with hulled rice</td>
<td>High impeller rotation per minute</td>
<td>Get rpm of huller reduced by changing either drive or driven pulley or both</td>
<td></td>
</tr>
<tr>
<td></td>
<td>Hulling</td>
<td>High share of un-hulled grains in output along with rice</td>
<td>Low impeller rpm</td>
<td>Get rpm of huller increased by changing either drive or driven pulley or both</td>
<td></td>
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<tr>
<td></td>
<td>Hulling</td>
<td>Huller pillow block / bearing gets very hot</td>
<td>1. Wrong alignment of impeller and pulleys in the shaft</td>
<td>1. Get it aligned properly</td>
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<tr>
<td></td>
<td>Hulling</td>
<td></td>
<td>2. Bearings held too tight in casing and/or not matching for the rpm of shaft</td>
<td>2. Change with suitable bearing</td>
<td></td>
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<tr>
<td></td>
<td>Hulling</td>
<td></td>
<td>3. Impeller defect</td>
<td>3. Change Impeller</td>
<td></td>
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<tr>
<td></td>
<td>Hulling</td>
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<td>Hulling</td>
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<td></td>
<td>Hulling</td>
<td></td>
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<tr>
<td></td>
<td>Husk removal with aspirator</td>
<td>Rice, grits &amp; other usable material come out with husk</td>
<td>Dampener not adjusted</td>
<td>Adjust dampener</td>
<td>If problem is still not solved, fan rpm to be reduced and/or length of dampener to be increased</td>
</tr>
</tbody>
</table>
Huller performance

Huller performance can be measured by calculating hulling efficiency, rice recovery percentage grain shattering percentage and through put/capacity.

1. **Hulling efficiency**: How many unhulled grains come through in 100 grains of the output after one pass through the huller.

2. **Rice recovery percentage**: Weight of the rice fraction in the output as a percentage of input material.

<table>
<thead>
<tr>
<th>S.No.</th>
<th>Small millet</th>
<th>Rice recovery %</th>
</tr>
</thead>
<tbody>
<tr>
<td>1.</td>
<td>Little millet</td>
<td>70 - 75</td>
</tr>
<tr>
<td>2.</td>
<td>Barnyard millet</td>
<td>60 - 65</td>
</tr>
<tr>
<td>3.</td>
<td>Kodo millet</td>
<td>60 - 64</td>
</tr>
<tr>
<td>4.</td>
<td>Foxtail millet</td>
<td>70 - 75</td>
</tr>
</tbody>
</table>

3. **Grainshattering percentage**: The weight of the shattered grains in the output as a percentage of the input material.

4. **Through put/Capacity**: What is the maximum quantity of input grains it can process in an hour?

**N.B:** a) Percentage of broken rice to be calculated after grading the hulled rice fractions in grader. 
   b) Moisture content of the grains affects the broken rice percentage and it should be below 12%.  
   c) For the processing equipment that is expected to process multiple small millets, if possible test at least three of them – either foxtail or little millet, kodo millet, and either proso millet or barnyard millet.

Source: Dwijendra Nath Guru
Common aspects to be checked for all the machines

1. Earthing points
2. Loose wires

6. Installation

a. Selection of location

1. The unit should be as far as possible constructed above ground level, preferably at an elevated place.
2. For ease of transportation, it should be approachable by road and any vehicle should be able to load and unload easily from the unit.
3. The unit should not be constructed near the river bed or at places where natural calamities recur frequently.

b. Indicative floor plan

Indicative ideal floor plan for village/community scale unit & small scale enterprise level unit is given, which may help the new entrant to plan placing of machinery at his/ her site.

Important points to be considered during installation

1. A minimum of 3 to 4 feet clear space should be maintained between any two equipment; this would allow for smooth movement of material.
2. The output from aspirator vents of both the grader/destoner and the huller should be collected and disposed outside the room.
   - Individual windows/ports can be made for this purpose.
   - A flexible canvas like material stitched into a tube-like shape can be used to collect and convey the dust & husk out of the room.
3. As far as possible, an air draft should be set up — a place for air to enter and a place for air to go out.
4. A clear and unambiguous board should be displayed in all local languages saying NO WATER allowed inside the room.
Indicative floor plan

a. For village/community scale SMPU

b. For small scale enterprise level SMPU

N.B: Figures given are not to scale
Additional points to be considered for Entrepreneur/Small and Medium-sized Enterprises(SME) level SMPU.

Ease of material flow is an important factor to be taken into account when deciding the plant layout for entrepreneur/SME level SMPU. Given the process flow diagram detailed in page 3 and using other principles of plant design, the following recommendations are being made for the floor plans/equipment layout in an enterprise level SMPU.

1. The storage space for received grains should be close to or one side of the doorway.
2. The aspirator cum grader, which is to be used for dust removal, needs to be located nearest to the storage space for received grains.
3. On the other side of the aspirator cum grader would be the destoner. Both aspirator cum grader and destoner are used for cleaning and segregating the grains to make them ready for hulling.
   - The sequence of placement of grader and destoner will change if aspirator is attached to destoner
4. The storage space for huller-ready grains should be clearly separated and demarcated from the space where received material is stored; preferably on the other end of the room. Each of the sacks with huller ready grain grades should be clearly and visibly marked.
5. Then the huller and post-hulling equipment need to be placed.
6. The post hulling intermediate products should not be stored; once a material has been dehusked, it should be processed to its terminal state (rice, grits, etc.) and packed away at the end of the shift.
7. The hulled ready for dispatch material should not be stored in the same room in which equipment have been installed.
8. A proper space needs to be identified to store the grader sieves – either hung on walls, or arranged on a rack made for that purpose.
9. Storage space should be away from windows and close to where the ceiling level ventilator is located.

c. Guidelines for laying the foundation for equipment

1. Mark the intended place of equipment in the floor bed as per floor plan.
2. Take the foundation details from the fabricator and prepare a foundation bed with bolts as specified at least a week before installation of the equipment. This is in order to get the foundation bed properly cured and ready for installation of equipment.
3. The level of foundation bed should be higher than the floor level of the building as indicated in the picture.
Foundation bed for processing equipment

Concrete foundation

Above the bed 1 1/2"

Bed width 4"

Foundation bolt length 18"

Below the ground 12 1/2"

Foundation bolt

N.B: Figures given are not to scale
d. Steps in installation

Once the floor plan is finalised, the purchased equipment needs to be installed. Steps on how to go about installing the equipment are shared below:

1. Once the foundation is ready, place each equipment in the intended place and connect it to the EB main box properly; Avoid loose wiring, as otherwise the wires may hamper easy movement during operation of the equipment.
2. Do the electrical wiring neatly and with concealed piping from the mains to each equipment.
3. Have an EB main box with Voltmeter & Ammeter and three bulbs for each phase of current.
4. Give proper earthing to each equipment.
5. A proper space needs to be marked for the tool box or tool board and another for spares and components' box / rack within the room.
6. After installation do the following:
   a. Check all the wire connections and see that the machines are in firm foundation with proper earthing.
   b. Start each machine individually (idle run) and see if any loose parts/guards are vibrating or the machine is making undue noise and rectify it if so.
   c. Check idle run of each equipment for undue heating.
   d. See the direction of the rotation of impeller in huller and fan box in aspirator and make corrections in wiring if needed.
   e. Check belt tension in pulley drives and rectify it if there is undue slip.

7. Testing the SMPU equipment after installation

Purposes:
1. Ensuring the smooth functioning of the equipment
2. Basic training for the operator/ owner; it will cover how to operate and get good quality output, all adjustments in the equipment, do's and don'ts, regular maintenance, troubleshooting, etc.; So the presence of such persons is to be ensured.

General procedure:
If detailed testing of the equipment at the manufacturers' site has already been done, then the following can be undertaken for testing the SMPU equipment at the site after installation; otherwise follow the instructions given in the section on 'Testing the equipment at the manufacturers' workshop/site'
1. Take sample grains (small millet varieties to be processed), at least 20 kgs of each variety, and have a trial run of the aspirator cum grader, destoner and huller.

2. Demonstrate to the operator how to get higher output and to ensure the quality of the output by operating each equipment, in terms of steps in operating and adjustments to the control parameters to be made based on necessity.
   a. With the help of the aspirator, remove lighter materials like dust, mud, husks, straw and hollow grains.
   b. With the help of the grader, remove bigger & heavier materials like twigs & big stones.
   c. Then use the grader to separate the cleaned grains into different sizes.
   d. Put the different size grains separately in the destoner. Now adjust destoner settings with the help of fan box opening such that stones and heavier materials are removed from the back side, and grains are collected in the front side.
   e. Then adjust the fan box setting and put the grains without stones to get heavier grains from back and lighter ones at the front outlet of destoner.
   f. Take the cleaned and graded grains from the destoner and do test run of the hulter.
   g. Tell the operator how to change the flow rate based on the hulter output; increase the flow rate if the broken is more and vice versa.
   h. Check hulter aspirator exhaust pipe assembly to see if grains/broken rice kernals are coming out along with husk. Adjust aspirator dampener accordingly.
   i. Tell the operator about the need for the final manual cleaning and how to go about it.
   j. Tell the operator about the different kind of primary outputs and how to use the same.
   k. While checking the equipment, teach him how to observe the equipment output and make adjustments in the fan box opening and angle of destoner bed, sieve size selection in graders, dampener control in aspirators and feed hopper adjustment in hulter for getting good quality output.
   l. More details on operating the equipment can be seen in Audio-visual Training Manual on Community Scale Small Millet Processing, which can be accessed at http://www.dhan.org/smallmillets2/sm-resources-processing.html

3. While running the equipment, see if undue heating of the bearings and moving parts is there and rectify it.

4. Tell the operator about regular and periodic maintenance works to be done.
8. Support from DHAN Foundation

DHAN Foundation will help the purchaser in the following ways:

a. Arrange for exposure visit to equipment offered by manufacturers and to successfully operating SMPU
b. Give hands-on training to operators/proprietors/mechanics on operating SMPU

Training on small millet processing, Koraput, Odisha

Rubber roller type huller being developed by McGill

Pneumatic grain cleaner prototype

Vernacular names of small millet crop

<table>
<thead>
<tr>
<th>English</th>
<th>Tamil</th>
<th>Kannada</th>
<th>Telugu</th>
<th>Oriya</th>
<th>Hindi</th>
<th>Marathi</th>
</tr>
</thead>
<tbody>
<tr>
<td>Foxtail millet</td>
<td>Thinai</td>
<td>Navane</td>
<td>Korra</td>
<td>Kanghu</td>
<td>Kakum</td>
<td>Kang</td>
</tr>
<tr>
<td>Kodo millet</td>
<td>Varagu</td>
<td>Haarka</td>
<td>Arikelu</td>
<td>Kodua</td>
<td>Kodon</td>
<td>Kodra</td>
</tr>
<tr>
<td>Barnyard</td>
<td>Kuthiraivali</td>
<td>Oodhalu</td>
<td>Udhalu</td>
<td>Khira</td>
<td>Sanwa</td>
<td>Morbardi</td>
</tr>
<tr>
<td>Little Millet</td>
<td>Saamai</td>
<td>Same</td>
<td>Samalu</td>
<td>Suan</td>
<td>Kutki</td>
<td>Sava</td>
</tr>
<tr>
<td>Proso millet</td>
<td>Panivaragu</td>
<td>Baragu</td>
<td>Variga</td>
<td>Bachari</td>
<td>Chena</td>
<td>Vari</td>
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</tbody>
</table>
Also see other publications of DHAN Foundation on small millets

Processing of small millets
1. Protocol for Assessment of the Existing Small Millet Processing Units
2. Assessment of Existing Small Millet Processing Equipment in India
3. Audio-visual Training Manual on Community Scale Small Millet Processing
   - All three can be accessed at http://www.dhan.org/smallmillets2/sm-resources-processing.html

Small millet food products
1. Technical Bulletin on Value Added Products from Small Millets
2. Protocol for Training of Trainers (ToT) on Small Millet Recipe Demonstration
   - Both can be accessed at http://www.dhan.org/smallmillets2/sm-resources-food.html

Promoting consumption of small millets
1. Film on cooking show covering 28 small millet recipes
   http://www.dhan.org/smallmillets2/sm-recipe-videos.html
2. Nam Unave Nam Marabu- A small millet recipe book on small millets
3. Awareness posters on small millets
   http://www.dhan.org/smallmillets2/sm-poster.html
4. Small Millet Music Treat- A music album in Tamil
5. Puthayal (Treasure) - An effort to revive lost food habits - Ten episodes of radio programme

Policy
1. Small Millets, Big Potential: Diverse, Nutritious and Climate Smart – A Policy Brief
2. Small Millets, In Mainstream Diets: Promoting Decentralised Processing Infrastructure- A Policy Paper by Mr. M. Karthikeyan
   - Both the papers can be accessed at http://www.dhan.org/smallmillets2/sm-resources-policy.html
DHAN Foundation

DHAN Foundation is a Pan-Indian development NGO working with 1.6 million poor families across 14 states in India. The two main goals of DHAN Foundation are i) Poverty reduction and ii) Promoting grassroots democracy. Currently, it is implementing seven major thematic development programs on Microfinance, Tankfed Agriculture, Rainfed Farming, Development Education, Panchayat Raj, Coastal Livelihoods and ICT for Poor.

Scaling up Small Millet Post-harvest and Nutritious Food Products Project

DHAN Foundation has been promoting production and consumption of small millets in various parts of the country since 2011. It has identified and promoted location-specific varieties and other production technologies; developed improved huller and appealing small millet food products developed small millet recipe films and book; undertaken large-scale promotional events and marketing of small millet value added products. It has initiated small millet foundation to scale up the technologies, practices and working models developed across India for bringing back small millets in the mainstream diets.

DHAN Foundation is currently implementing 'Scaling up Small Millet Post-harvest and Nutritious Food Products Project', which aims at scaling up the reach of small millet processing equipment and value added food products to reduce the drudgery of women and improve the food security in India. This project is implemented in collaboration with Tamil Nadu Agriculture University and McGill University, Canada. This project is supported by International Development Research Centre (IDRC) and Global Affairs Canada (GAC). Our initiatives on small millets can be viewed at www.dhan.org/smallmillets/ & www.dhan.org/smallmillets2/

For more details contact

<table>
<thead>
<tr>
<th>For machine related queries</th>
<th>For general queries</th>
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<tbody>
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<td>Mr. M. Karthikeyan</td>
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<tr>
<td>Project Executive</td>
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</tr>
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<td>Cell: 9488054514, 8144940641</td>
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