

Contents

List of Contributors XIII

Part I Membrane Materials and Membrane Preparation 1

S.P. Nunes and K.-V. Peinemann

1 Introduction 3

2 Membrane Market 4

3 Membrane Preparation 6

4 Presently Available Membranes for Liquid Separation 12

4.1 Membranes for reverse osmosis 12

4.2 Membranes for nanofiltration 15

4.3 Membranes for ultrafiltration 16

4.4 Solvent resistant membranes for nano- and ultrafiltration 25

4.5 Membranes for microfiltration 29

5 Surface Modification of Membranes 34

5.1 Chemical oxidation 34

5.2 Plasma treatment 35

5.3 Classical organic reactions 36

5.4 Polymer grafting 36

6 Gas Separation with Membranes 39

6.1 Introduction 39

6.1.1 Materials and transport mechanisms 39

6.1.2 Organic polymers 41

6.1.3 Background 41

6.1.4 Polymers for commercial gas separation membranes 43

6.1.5 Ultra-high free volume polymers 45

- 6.1.6 Inorganic materials for gas separation membranes 47
- 6.2 Nanoporous carbon membranes 48
- 6.3 Perovskite-type oxide membranes for oxygen separation 49
- 6.4 Mixed matrix membranes 51
- 6.5 Process design 53

Part II Current Applications and Perspectives 69

1 The Separation of Organic Vapors from Gas Streams by Means of Membranes 71

K. Ohlrogge and K. Stürken

- 1.1 Summary 71
- 1.2 Introduction 72
- 1.3 Historical background 72
- 1.4 Membranes for organic vapor separation 73
 - 1.4.1 Principles 73
 - 1.4.2 Selectivity 74
 - 1.4.3 Temperature and pressure 75
 - 1.4.4 Membrane modules 76
- 1.5 Applications 78
 - 1.5.1 Design criteria 78
 - 1.5.2 Off-gas and process gas treatment 79
 - 1.5.2.1 Gasoline vapor recovery 81
 - 1.5.2.2 Polyolefin production processes 86
- 1.6 Applications at the threshold of commercialisation 88
 - 1.6.1 Emission control at petrol stations 88
 - 1.6.2 Natural gas treatment 90
 - 1.6.3 Hydrogen/Hydrocarbon separation 92
- 1.7 Conclusions and outlook 92

2 Gas Separation Membrane Applications 95

D. J. Stookey

- 2.1 Introduction 95
- 2.2 Membrane application development 96
 - 2.2.1 Membrane selection 96
 - 2.2.2 Membrane form 99
 - 2.2.3 Membrane module geometry 101
 - 2.2.4 Compatible sealing materials 105
 - 2.2.5 Module manufacture 106

- 2.2.6 Pilot or field demonstration 106
- 2.2.7 Process design 108
- 2.2.8 Membrane system 108
- 2.2.9 Beta site 111
- 2.2.10 Cost/performance 112
- 2.3 Commercial gas separation membrane applications 112
 - 2.3.1 Hydrogen separations 112
 - 2.3.2 Helium separations 116
 - 2.3.3 Nitrogen generation 116
 - 2.3.4 Acid gas separations 119
 - 2.3.5 Gas dehydration 119
- 2.4 Developing membrane applications 121
 - 2.4.1 Oxygen and oxygen enriched air 121
 - 2.4.2 Nitrogen enriched air (NEA) 123
 - 2.4.2 Nitrogen rejection from natural gas 122

3 State-of-Art of Pervaporation Processes in the Chemical Industry 127

H. E. A. Bruschke

- 3.1 Introduction 127
- 3.2 Principles and calculations 129
 - 3.2.1 Definitions 129
 - 3.2.2 Calculation 131
 - 3.2.3 Permeate side conditions 137
 - 3.2.4 Principles of pervaporation 140
 - 3.2.5 Principles of vapour permeation 145
- 3.3 Membranes 148
 - 3.3.1 Characterisation of membranes 152
- 3.4 Modules 155
 - 3.4.1 Plate modules 155
 - 3.4.2 Spiral wound modules 156
 - 3.4.3 Envelope module 157
 - 3.4.4 Tubular modules 157
 - 3.4.5 Other modules 159
- 3.5 Applications 159
 - 3.5.1 Organophilic membranes 159
 - 3.5.2 Hydrophilic membranes 160
 - 3.5.2.1 Solvent dehydration 160
 - 3.5.2.2 Removal of water from reaction mixtures 165
 - 3.5.2.3 Organic-organic separation 168
- 3.6 Conclusion 170

4 Nanofiltration of Charged Organic Molecules in Aqueous and Non-aqueous Solvents: Separation Results and Mechanisms 173

J. A. Hestekin, C. N. Smothers and D. Bhattacharyya

- 4.1 Introduction 174
- 4.2 Background and theory 175
 - 4.2.1 Aqueous systems 175
 - 4.2.2 Non-aqueous systems 177
- 4.3 Experimental 178
- 4.4 Results and discussion 180
 - 4.4.1 PABA separation characteristics in aqueous systems 180
 - 4.4.2 Rejection and flux behavior of positively and negatively charged dyes 183
 - 4.4.3 Pure solvent and water-solvent flux 184
- 4.5 Conclusions 187

5 Industrial Membrane Reactors 191

M. F. Kemmere and J. T. F. Keurentjes

- 5.1 Introduction 191
- 5.2 Membrane functions in reactors 194
 - 5.2.1 Controlled introduction of reactants 194
 - 5.2.2 Separation of products 201
 - 5.2.3 Catalyst retention 203
- 5.3 Applications 204
 - 5.3.1 Pervaporation-assisted esterification 204
 - 5.3.2 Large-scale dehydrogenations with inorganic membranes 210
 - 5.3.3 OTM syngas process 212
 - 5.3.4 Membrane recycle reactor for the acylase process 213
 - 5.3.5 Membrane extraction integrated systems 215
- 5.4 Concluding remarks and outlook to the future 216

6 Electromembrane Processes 222

T. A. Davis, V. Grebenyuk and O. Grebenyuk

- 6.1 Ion exchange membranes 223
- 6.2 Ion exchange membrane properties 226
 - 6.2.1 Swelling 226
 - 6.2.2 Electrical conductivity 227
 - 6.2.3 Electrochemical performance 231
 - 6.2.4 Diffusion permeability 233

6.2.5	Hydraulic permeability	233
6.2.6	Osmotic permeability	234
6.2.7	Electroosmotic permeability	234
6.2.8	Polarization	235
6.2.9	Chemical and radiation stability	238
6.3	Electromembrane process application	238
6.3.1	Electrodialysis	238
6.3.2	Electrodeionization	245
6.3.3	Electrochemical regeneration of ion exchange resin	246
6.3.4	Synthesis of new substances without electrode reaction participation. Bipolar membranes applications	247
6.3.5	Isolation of chemical substances from dilute solutions	249
6.3.6	Electrodialysis applications for chemical solution desalination	250
6.4	Electrochemical processing with membranes	251
6.4.1	Electrochemistry	251
6.4.2	Chlor-alkali industry	255
6.4.3	Perfluorinated membranes	256
6.4.4	Process conditions	258
6.4.5	Zero-gap electrode configurations	258
6.4.6	Other electrolytic processes	260
6.4.7	Fuel cells	262
6.4.8	Electroorganic synthesis	264
6.4.9	Electrochemical oxidation of organic wastes	264

7 Membrane Technology in the Chemical Industry: Future Directions 268

R. Baker

7.1	The past: basis for current membrane technology	268
7.1.1	Ultrathin membranes	268
7.1.2	Membrane modules	269
7.1.3	Membrane Selectivity	271
7.2	The present: current status of the membrane industry	272
7.2.1	Reverse osmosis	272
7.2.2	Ultrafiltration	275
7.2.3	Gas separation	276
7.2.4	Pervaporation	287
7.2.5	Ion-conducting membranes	288
7.3	The future: predictions for 2020	290

Subject Index 297