

# Contents

**Preface to the 2nd edition — V**

**Preface — VII**

<b>1</b>	<b>Process Integration and Intensification: An Introduction — 1</b>
1.1	Process Intensification — 1
1.2	Process Systems Engineering and Process Integration — 3
1.3	Contributions to PIs and PI to energy and water saving — 4
1.4	What is Process Integration? — 4
1.5	A short history of the development of Process Integration — 5
1.6	The aim and scope of this textbook — 8
<b>2</b>	<b>Setting energy targets and Heat Integration — 13</b>
2.1	Introduction — 13
2.1.1	Initial development of Heat Integration — 14
2.1.2	Pinch Technology and targeting Heat Recovery: The thermodynamic roots — 14
2.1.3	Supertargeting: Full-fledged HEN targeting — 15
2.1.4	Modifying the Pinch Idea for HEN Retrofit — 16
2.1.5	Benefits of Process Integration — 16
2.2	Pinch Analysis for maximizing energy efficiency — 17
2.2.1	Introduction to Heat Exchange and Heat Recovery — 17
2.2.2	Basic principles — 19
2.2.3	Basic Pinch Technology — 28
2.3	Summary — 65
<b>3</b>	<b>Synthesis of Heat Exchanger Networks — 71</b>
3.1	Introduction — 71
3.2	HEN synthesis — 71
3.2.1	The Pinch Design Method — 72
3.2.2	Methods using mathematical programming — 93
3.3	Grassroots and retrofits; impact of economic criteria — 97
3.3.1	Network optimization — 97
3.3.2	The Network Pinch — 98
3.4	Summary — 100
<b>4</b>	<b>Total Site Integration — 103</b>
4.1	Introduction — 103
4.2	What is a Total Site and what are the benefits? — 104

4.2.1	Total Site definition —	<b>105</b>
4.2.2	Total Site Analysis interfaces —	<b>106</b>
4.3	HI extension for Total Sites: Data extraction for Total Sites —	<b>107</b>
4.3.1	The algorithm —	<b>107</b>
4.3.2	Step-by-step guide —	<b>107</b>
4.3.3	Working session —	<b>113</b>
4.4	Total Site Profiles and Total Site Composite Curves —	<b>116</b>
4.5	Site Utility Grand Composite Curve (SUGCC) —	<b>123</b>
4.6	Modeling of Utility Systems —	<b>124</b>
4.6.1	A flexible steam turbine model for cogeneration evaluation —	<b>124</b>
4.6.2	Utility network modelling: Simulation and optimization —	<b>130</b>
4.6.3	Utility system: An illustrative example —	<b>132</b>
4.7	Targeting of Combined Heat and Power generation (CHP, Cogeneration) during process design —	<b>135</b>
4.7.1	Targeting CHP using the SUGCC —	<b>135</b>
4.7.2	Choice of optimal steam pressure levels —	<b>137</b>
4.8	Advanced Total Site developments —	<b>139</b>
4.8.1	Introduction of process-specific minimum allowed temperature differences —	<b>139</b>
4.8.2	Retrofit of industrial energy systems at the site level —	<b>140</b>
4.8.3	Numerical tools for Total Site Heat Integration —	<b>141</b>
4.8.4	Power Integration —	<b>147</b>
4.8.5	Targeting for Low CO <sub>2</sub> Emissions with CO <sub>2</sub> Emission Pinch Analysis —	<b>159</b>
4.9	Summary —	<b>166</b>
<b>5</b>	<b>An Integrated Pinch Analysis Framework for Low CO<sub>2</sub> Industrial Site Planning —</b>	<b>171</b>
5.1	Introduction —	<b>171</b>
5.2	Framework for Low CO <sub>2</sub> Emissions Industrial Site Planning —	<b>171</b>
5.3	Case Study —	<b>174</b>
5.3.1	Stage 1: Baseline study —	<b>175</b>
5.3.2	Stage 2: Targeting for Total Site Heat Recovery with cogeneration using TSHI (Tool 1) —	<b>177</b>
5.3.3	Stage 3: Targeting for hybrid power system integrating RE resources with PoPA (Tool 2) —	<b>179</b>
5.3.4	Stage 4: Targeting for low CO <sub>2</sub> emission with CEPA (Tool 3) —	<b>181</b>
5.3.5	Summarized network diagram —	<b>186</b>
5.4	Conclusion —	<b>186</b>
<b>6</b>	<b>Introduction to Water Pinch Analysis —</b>	<b>191</b>
6.1	Water management and minimization —	<b>191</b>

6.2	History and definition of Water Pinch Analysis —	192
6.3	Applications of Water Pinch Analysis —	193
6.4	Water Pinch Analysis steps —	194
6.5	Analysis of water networks and data extraction —	195
6.5.1	Analysis of water networks —	195
6.5.2	Data extraction —	197
6.5.3	Example —	198
<b>7</b>	<b>Setting the maximum water recovery targets —</b>	<b>205</b>
7.1	Introduction —	205
7.2	Maximum water recovery target for single pure freshwater —	209
7.2.1	Water Cascade Analysis technique —	209
7.2.2	Source/Sink Composite Curves (SSCC) —	212
7.2.3	Significance of the Pinch region —	213
7.3	Maximum water recovery target for a single impure freshwater source —	214
7.3.1	Pinched problems —	214
7.3.2	Threshold problems —	221
7.4	Maximum water recovery targets for multiple freshwater sources —	221
7.5	Working session —	225
7.6	Solution —	225
<b>8</b>	<b>Water network design/retrofit —</b>	<b>231</b>
8.1	Introduction —	231
8.2	Source/Sink Mapping Diagram (SSMD) —	231
8.3	Source and Sink Allocation Curves (SSAC) —	233
8.3.1	Example of network design using SSCC for utility purity superior to all other streams —	236
8.3.2	Freshwater purity not superior to all other streams —	240
8.3.3	Simplification of a water network or constructing other network possibilities —	244
8.4	Working session —	247
8.5	Solution —	247
8.6	Optimal Water <sup>®</sup> software —	249
<b>9</b>	<b>Design of Cost-Effective Minimum Water Network (CEMWN) —</b>	<b>253</b>
9.1	Introduction —	253
9.2	Water Management Hierarchy —	253
9.3	Cost-Effective Minimum Water Network (CEMWN) —	255
9.4	Industrial case study – a semiconductor plant —	265
9.4.1	Using CEMWN targets as reference benchmarks —	279

<b>10</b>	<b>Conclusions and sources of further information — 287</b>
10.1	HEN targeting, synthesis, and retrofit — 287
10.2	Total Site Integration — 288
10.3	Total Site methodology addressing variable energy supply and demand — 289
10.4	Utility system optimization accounting for cogeneration — 290
10.5	Maximum water recovery targeting and design — 291
10.5.1	Recommended books for further reading — 291
10.5.2	State-of-the-art review — 293
10.6	Analysing the designs of isolated energy systems — 294
10.7	PI contribution to supply chain development — 295
10.8	Hydrogen networks design and management — 295
10.9	Oxygen Pinch Analysis — 296
10.10	Pressure drop considerations and heat transfer enhancement in Process Integration — 297
10.11	Power (Electricity) and Hybrid Pinch — 299
10.12	Computational and modeling tools suitable for applying PI — 300
10.12.1	Heat and power PI applications — 300
10.12.2	Water Pinch software — 301
10.13	Challenges and recent developments in Pinch-based PI — 302
10.14	PRES Conferences on Process Integration, Modelling and Optimisation for Energy Saving and Pollution Reduction — 303
<b>Index — 309</b>	