

Contents

List of contributors — XIII

Nelly Ramírez Corona and Adriana Palacios Rosas

1	Generalities about process intensification — 1
1.1	Introduction — 1
1.2	PI principles — 2
1.3	Devices and equipment in PI — 3
1.4	PI methodologies — 4
1.5	PI safety and control properties — 6
1.6	Sustainability — 7
1.7	Main drawbacks for PI implementation — 8
1.8	PI assessment examples — 9
1.9	Final remarks — 13
	References — 13

Efraín Quiroz-Pérez, Julio Armando de Lira-Flores
and Claudia Gutiérrez-Antonio

2	Microreactors: Design methodologies, technology evolution, and applications to biofuels production — 15
2.1	Introduction — 15
2.2	Design methodologies — 17
2.2.1	Design based on the analysis of parameters of microreactors performance — 18
2.2.1.1	Mixing index — 19
2.2.1.2	Mean variables — 19
2.2.1.3	Figure of merit — 20
2.2.1.4	Nonuniformity of flow — 20
2.2.1.5	Studies based on the analysis of parameters related to microreactor performance — 21
2.2.2	Design based on optimization techniques — 25
2.2.3	CFD-based studies applied to the design of microreactors for biofuels production — 27
2.3	Applications of microreactors to biofuels production — 29
2.3.1	Liquid biofuels — 29
2.3.1.1	Biomethanol — 29
2.3.1.2	Biodiesel — 30
2.3.1.3	Other processes — 31
2.3.2	Gaseous biofuels — 32
2.3.2.1	Renewable hydrogen — 32
2.3.2.2	Synthetic gas natural — 33

VI — Contents

- 2.3.2.3 Synthesis gas — 33**
- 2.4 Technological advances for biofuels production — 34**
- 2.5 Recapitulation — 43**
 - References — 45**

Martín Picón-Núñez, Jorge Luis García-Castillo and Jorge C. Melo-González

- 3 Heat transfer enhancement technologies for improving heat exchanger performance — 51**
 - 3.1 Introduction — 51**
 - 3.2 Thermal and hydraulic principles — 53**
 - 3.3 Extended surfaces — 55**
 - 3.3.1 Flat plate surfaces — 55**
 - 3.3.2 Secondary surfaces — 58**
 - 3.3.3 Extended surfaces for tubes — 59**
 - 3.4 Turbulence promoters for tubular geometries — 63**
 - 3.4.1 Benefits of the use of turbulence promoters.**
Illustrative example 1 — 64
 - 3.4.2 Benefits of the use of turbulence promoters.**
Illustrative example 2 — 65
 - 3.4.3 Thermo-hydraulic performance comparison of turbulence promoters — 66**
 - 3.5 Heat transfer intensification in heat recovery networks — 68**
 - 3.6 Conclusions — 72**
 - Nomenclature — 74**
 - Greek Letters — 75**
 - Subscripts — 75**
 - Superscripts — 75**
 - References — 76**

Massimiliano Errico, Claudio Madeddu and Roberto Baratti

- 4 Reactive absorption of carbon dioxide: Modeling insights — 79**
 - 4.1 Introduction — 79**
 - 4.2 Reactive absorption applications — 81**
 - 4.2.1 Nitric acid production — 82**
 - 4.2.2 The SCOT process — 82**
 - 4.2.3 Carbon dioxide capture and storage (CCS) — 82**
 - 4.3 CO₂ reactive absorption: Solvent selection, reaction scheme, and thermodynamic — 83**
 - 4.3.1 Solvent selection — 84**
 - 4.3.2 Reaction scheme — 84**
 - 4.3.3 Definition of the thermodynamic model — 86**
 - 4.4 Process modeling: Equilibrium stage vs rate-based model — 87**

4.4.1	The equilibrium stage model — 88
4.4.2	The rate-based model — 89
4.4.2.1	Interphase material transfer — 90
4.4.2.2	Modeling the bulk — 91
4.4.2.3	Modeling the film — 92
4.5	Rate-based parameters evaluation — 94
4.5.1	Wetted surface area — 94
4.5.2	Material transfer and heat transfer coefficients — 95
4.5.3	Fractional liquid hold-up — 95
4.6	Fluid dynamics analysis — 96
4.6.1	Axial diffusion/dispersion: Peclet number definition — 96
4.6.2	Back-mixing due to the countercurrent effect — 98
4.6.3	The analysis of the number of segments — 98
4.7	Model validation — 100
4.7.1	Laboratory-scale pilot-plant — 100
4.7.2	Large-scale pilot-plant — 102
4.7.3	Peclet number analysis — 102
4.7.4	Component definition — 105
4.7.5	Run T20: rate-based mode set-up — 107
4.7.5.1	Analysis of the number of segments — 108
4.7.5.2	Kinetic parameters calibration — 112
4.7.5.3	Influence of the different flow models — 113
4.7.6	Run 1-A2: extension to the large-scale plant — 114
4.8	Conclusion — 115
	Bibliography — 116
	Notation — 122

Abel Briones-Ramírez and Claudia Gutiérrez-Antonio

5	Optimal design methodology for homogeneous azeotropic distillation columns — 125
5.1	Introduction — 125
5.2	Optimal design methodology — 130
5.2.1	Calculation of number of stages — 130
5.2.2	Calculation of the minimum reflux ratio — 132
5.2.3	Location of the feed stage — 133
5.3	Cases of study — 135
5.4	Results — 136
5.4.1	Mixture acetone-isopropanol-water — 136
5.4.2	Mixture acetone-chloroform-benzene — 139
5.4.3	Mixture ethanol-water-ethylene glycol — 140
5.4.4	Mixture methanol-isopropanol-water — 141

5.5	Conclusions — 142
	Exercises — 142
	References — 143

Nima Nazemzadeh, Isuru A. Udugama, Rasmus Fjordbak Nielsen,
 Kristian Meyer, Eduardo S. Perez-Cisneros, Mauricio Sales-Cruz,
 Jakob Kjøbsted Huusom, Jens Abildskov and Seyed Soheil Mansouri

**6 Graphical tools for designing intensified distillation processes:
 Methods and applications — 145**

6.1	Introduction — 145
6.2	Shortcut methods for distillation column design — 149
6.3	Why graphical methods as shortcut design tools for distillation processes? — 151
6.3.1	Driving force approach — 154
6.3.2	McCabe-Thiele method — 155
6.3.3	Ponchon-Savarit method — 155
6.4	Intensified distillation columns: Graphical design — 156
6.4.1	Heat Integrated Distillation — 156
6.4.1.1	Graphical design methods — 156
6.4.1.1.1	McCabe-Thiele method for HIDiC — 156
6.4.1.1.2	Ponchon-Savarit method for HIDiC — 158
6.4.1.2	Graphical design of HIDiC — 161
6.4.1.2.1	HIDiC design: McCabe-Thiele application — 162
6.4.1.2.2	HIDiC design: Ponchon-Savarit application — 163
6.4.2	Cyclic distillation design — 163
6.4.2.1	Method — 164
6.4.2.2	Case study — 165
6.4.3	Reactive Distillation Design: Driving Force Approach — 167
6.4.3.1	Method — 167
6.4.3.2	Case study — 168
6.5	Discussion and perspective — 171
6.6	Concluding remarks — 173
	References — 174
	Appendix — 177

J. Rafael Alcántara-Avila

**7 Optimization methodologies for intensified distillation processes
 with flexible heat integration networks — 181**

7.1	Introduction — 181
7.2	Structures with heat integration — 182
7.2.1	Heat integration — 183
7.3	Optimization of heat-integrated structures — 184

7.3.1	Mathematical formulation —	187
7.3.2	Optimization methodology —	196
7.3.3	Iterative optimization procedure —	198
7.4	Case study —	200
7.5	Results and discussion —	202
7.5.1	Binary mixture separation —	202
7.5.2	Multicomponent mixture separation —	205
7.6	Conclusions —	208
	References —	209

Oscar Andrés Prado-Rubio, Javier Fontalvo and John M. Woodley

8	Conception, design, and development of intensified hybrid-bioprocesses —	211
8.1	Introduction —	212
8.2	Overview of hybrid technologies for bioprocesses intensification —	213
8.3	Methodologies for hybrid bioprocesses design —	216
8.4	Hybrid bioprocesses design – examples —	219
8.4.1	Hybrid fermentation and pervaporation system —	220
8.4.1.1	Mathematical model —	221
8.4.1.2	Conventional fed-batch fermenter analysis —	223
8.4.1.3	Hybrid system – Effect of when the units are integrated —	224
8.4.1.4	Hybrid system – Effect of membrane selectivity —	225
8.4.2	Hybrid fermentation and Donnan Dialysis —	227
8.4.2.1	System description —	227
8.4.2.2	System modeling —	229
8.4.2.3	Results and discussions —	232
8.5	Future perspectives —	238
	Nomenclature —	239
	Subscripts —	239
	Bibliography —	239

Juan Álvaro León, Oscar Andrés Prado-Rubio and Javier Fontalvo

9	Design of hybrid distillation and vapor permeation or pervaporation systems —	243
9.1	Introduction —	243
9.2	Basic configurations of hybrid distillation and membrane systems —	244
9.3	Basic approaches for designing hybrid distillation and membrane systems —	247
9.4	Pervaporation and vapor permeation —	248
9.5	Membrane residue curve maps —	249

- 9.6 Case studies — 252**
 - 9.6.1 Sequential membrane and distillation units — 252**
 - 9.6.2 Hybrid distillation-pervaporation system using pervaporation as a final distillate separation step — 253**
 - 9.6.3 Hybrid distillation and membrane system for reducing the number of stages — 257**
 - 9.6.4 Pervaporation or vapor permeation for multicomponent distillation — 261**
 - 9.6.5 Hybrid distillation and pervaporation systems in a single column — 264**
 - Case study: acetone-isopropanol-water mixture — 270**
- 9.7 Nomenclature — 272**
 - Symbols — 273**
 - Subscript — 273**
- 9.8 Exercises — 273**
 - References — 274**

Paola Ibarra-Gonzalez and Ben-Guang Rong

- 10 Lignocellulosic biofuels process synthesis and intensification: Superstructure-based methodology — 277**
 - 10.1 Introduction — 278**
 - 10.1.1 Worldwide transportation fuels consumption — 278**
 - 10.1.2 Biofuels projection — 280**
 - 10.2 Lignocellulosic BtL transportation fuels production processes — 282**
 - 10.2.1 Lignocellulosic biomass as source for BtL fuels — 282**
 - 10.2.2 Thermochemical conversion of lignocellulosic biomass — 283**
 - 10.2.3 Upgrading technologies to transportation fuels — 284**
 - 10.3 Systematic methodology framework: Synthesis of lignocellulosic BtL process routes — 284**
 - 10.4 Synthesis, design, and evaluation of lignocellulosic BtL process routes — 287**
 - 10.4.1 Synthesis of lignocellulosic BtL production process routes: Conceptual design — 287**
 - 10.4.1.1 Gasification- HTFT hydrocarbon production-FT hydrocarbon upgrading (PR-GHTUF) — 287**
 - 10.4.1.2 Gasification- LTFT hydrocarbon production-FT hydrocarbon upgrading (PR-GLTUF) — 289**
 - 10.4.1.3 Gasification- HTFT hydrocarbon production-FT hydrocarbon hydroprocessing (PR-GHTH) — 290**
 - 10.4.1.4 Pyrolysis-Hydroprocessing (PR-PHS) — 290**
 - 10.4.1.5 Pyrolysis-Catalytic Cracking (PR-PCC) — 291**

10.4.2	BtL process routes: Design and evaluation of process flowsheets — 291
10.4.2.1	Computational Studies: Aspen Analysis — 292
10.4.2.2	Flowsheets setup — 292
10.4.2.3	BtL process routes: process flowsheets simulation and evaluation — 295
10.5	Integrated superstructure synthesis — 296
10.5.1	Superstructure formulation: Processing blocks definition — 296
10.5.2	Detailed superstructure to simplified superstructure: Lumped process blocks definition — 297
10.5.3	Mass and energy integration — 302
10.5.3.1	Mass integration — 302
10.5.3.2	Energy integration — 303
10.6	Mathematical modeling: Superstructure setting and MINLP solution — 304
10.6.1	Superstructure setting — 304
10.6.2	MINLP solution: Global optimal scenarios — 308
10.7	Optimal scenarios evaluation with process simulator — 309
10.8	Upgrading section configuration alternatives and possible intensifications — 316
10.9	Conclusions — 320
10.10	Nomenclature — 321
	References — 323

Index — 327
