

Contents

Preface — V

Chapter 1

Characteristics of Separation Processes — 1

- 1.1 Significance of separations — 1
- 1.2 Characteristics of separation processes — 4
 - 1.2.1 Categorization — 4
 - 1.2.2 Separating agents — 5
 - 1.2.3 Separation factors — 7
- 1.3 Industrial separation methods — 8
 - 1.3.1 Exploitable properties — 8
 - 1.3.2 Important molecular separations — 10
- 1.4 Inherent selectivities — 11
 - 1.4.1 Equilibrium-based processes — 11
 - 1.4.2 Rate-controlled processes — 13
 - Nomenclature — 14
 - Exercises — 14

Chapter 2

Evaporation and Distillation — 17

- 2.1 Separation by evaporation — 17
 - 2.1.1 Introduction — 17
 - 2.1.2 Vapor–liquid equilibria — 18
- 2.2 Separation by single-stage partial evaporation — 23
 - 2.2.1 Differential distillation — 23
 - 2.2.2 Flash distillation — 24
 - 2.2.2.1 Specifying T and L/V — 26
 - 2.2.2.2 Specifying T and P_{tot} — 26
- 2.3 Multistage distillation — 28
 - 2.3.1 Distillation cascades — 28
 - 2.3.2 Column distillation — 29
 - 2.3.3 Feasible distillation conditions — 31
 - 2.3.4 External column balances — 31
- 2.4 McCabe–Thiele analysis — 32
 - 2.4.1 Internal balances — 32
 - 2.4.1.1 Rectifying section — 33
 - 2.4.1.2 Stripping section — 34
 - 2.4.1.3 Feed stage considerations — 35
 - 2.4.1.4 Feed line — 36
 - 2.4.2 Required number of equilibrium stages — 37

2.4.2.1	Graphical determination of stages and location of feed stage —	37
2.4.2.2	Limiting conditions —	40
2.4.2.3	Fenske and Underwood equations —	41
2.4.2.4	Use of Murphree efficiency —	44
2.4.3	Energy requirements —	45
2.5	Advanced distillation techniques —	45
2.5.1	Batch distillation —	45
2.5.2	Continuous separation of multiple product mixtures —	47
2.5.3	Separation of azeotropes —	48
	Nomenclature —	50
	Exercises —	51

Chapter 3

Absorption and Stripping — 57

3.1	Introduction —	57
3.2	The aim of absorption —	59
3.3	General design approach —	60
3.4	Absorption and stripping equilibria —	61
3.4.1	Gaseous solute solubilities —	61
3.4.2	Minimum absorbent flow —	63
3.5	Absorber and stripper design —	64
3.5.1	Operating lines for absorption —	64
3.5.2	Stripping analysis —	68
3.5.3	Analytical Kremser solution —	69
3.6	Industrial absorbers —	72
3.6.1	Packed columns —	73
3.6.2	Plate columns —	74
3.6.3	Spray and bubble columns —	74
3.6.4	Comparison of absorption columns —	75
	Nomenclature —	77
	Exercises —	77

Chapter 4

General Design of Gas/Liquid Contactors — 81

4.1	Introduction —	81
4.2	Modeling mass transfer —	81
4.3	Plate columns —	86
4.3.1	Dimensioning a tray column —	89
4.3.2	Height of a tray column —	90
4.3.2.1	Tray spacing —	90
4.3.2.2	Tray efficiency —	90
4.3.2.3	Transfer units —	92

4.3.2.4	Overall efficiency —	93
4.3.3	Diameter of a tray column —	95
4.3.3.1	Flooding —	96
4.3.3.2	Downcomer flooding —	97
4.3.3.3	Entrainment flooding —	99
4.3.3.4	Tray diameter and pressure drop —	100
4.3.3.5	Remark on flooding charts —	100
4.4	Packed columns —	101
4.4.1	Random packing —	102
4.4.2	Structured packing —	103
4.4.3	Dimensioning a packed column —	104
4.4.4	Height of a packed column —	105
4.4.4.1	Transfer units —	105
4.4.5	Minimum column diameter —	108
4.4.6	Pressure drop —	110
4.5	Criteria for column selection —	111
	Nomenclature —	112
	Exercises —	113

Chapter 5

Liquid–Liquid Extraction — 117

5.1	Introduction —	117
5.1.1	General Introduction —	117
5.1.2	Liquid–liquid equilibria —	120
5.1.3	Solvent selection —	121
5.2	Extraction schemes —	123
5.2.1	Single equilibrium stage —	124
5.2.2	Cocurrent cascade —	125
5.2.3	Crosscurrent —	126
5.2.4	Countercurrent —	126
5.3	Design of countercurrent extractions —	127
5.3.1	Graphical McCabe–Thiele method for immiscible systems —	127
5.3.2	Analytical Kremser method for immiscible systems —	130
5.3.3	Graphical method for partially miscible systems —	131
5.3.4	Efficiency of an ideal nonequilibrium mixer —	136
5.4	Industrial liquid–liquid extractors —	137
5.4.1	Mixer–settlers —	137
5.4.2	Mechanically agitated columns —	138
5.4.3	Unagitated and pulsed columns —	139
5.4.4	Centrifugal extractors —	141

- 5.4.5 Selection of an extractor — **143**
 - Nomenclature — **147**
 - Exercises — **147**

Chapter 6

Adsorption and Ion Exchange — 155

- 6.1 Introduction — **155**
- 6.2 Adsorption fundamentals — **158**
 - 6.2.1 Industrial adsorbents — **158**
 - 6.2.2 Equilibria — **164**
 - 6.2.3 Kinetics — **168**
- 6.3 Fixed-bed adsorption — **171**
 - 6.3.1 Bed profiles and breakthrough curves — **171**
 - 6.3.2 Equilibrium theory model — **173**
 - 6.3.3 Modeling of mass transfer effects — **175**
- 6.4 Basic adsorption/desorption cycles — **177**
 - 6.4.1 Temperature swing — **179**
 - 6.4.2 Pressure swing — **180**
 - 6.4.3 Inert and displacement purge cycles — **181**
- 6.5 Principles of ion exchange — **182**
 - 6.5.1 Ion exchange resins — **183**
 - 6.5.2 Equilibria and selectivity — **184**
- 6.6 Ion exchange processes — **185**
 - Nomenclature — **187**
 - Exercises — **188**

Chapter 7

Drying of Solids — 195

- 7.1 Introduction — **195**
- 7.2 Humidity of carrier gas — **196**
 - 7.2.1 Definitions — **196**
 - 7.2.2 Air–water system: a special case — **198**
 - 7.2.3 Psychrometric charts — **199**
- 7.3 Moisture in solids — **201**
 - 7.3.1 Bound and unbound water — **201**
- 7.4 Drying mechanisms — **206**
 - 7.4.1 Constant drying rate — **207**
 - 7.4.2 Falling drying rate — **208**
 - 7.4.3 Estimation of drying time — **208**
- 7.5 Classification of drying operations — **210**
 - 7.5.1 Direct-heat dryers — **211**
 - 7.5.1.1 Batch compartment dryers — **212**

7.5.1.2	Belt dryers —	212
7.5.1.3	Rotary dryers —	213
7.5.1.4	Flash dryers —	214
7.5.1.5	Fluidized bed dryers —	214
7.5.1.6	Spray dryers —	216
7.5.2	Contact dryers —	217
7.5.2.1	Rotary and agitator dryers —	217
7.5.2.2	Vacuum dryers —	217
7.5.2.3	Fluid bed dryers —	218
7.5.3	Other drying methods —	219
	Nomenclature —	220
	Exercises —	221
	Appendix —	223

Chapter 8

Crystallization — 227

8.1	Introduction —	227
8.2	Crystal quality parameters —	232
8.2.1	Crystal size distribution —	233
8.2.2	Morphology —	234
8.2.3	Crystal form —	235
8.2.4	Purity —	236
8.2.5	Interdependency among crystal quality parameters —	237
8.3	Phase diagrams —	237
8.3.1	Predicting solubility curves —	241
8.3.2	Measuring solubility curves —	241
8.4	Kinetics of crystallization —	242
8.4.1	Metastable zone limit —	242
8.4.2	Measuring metastable zone width —	244
8.4.3	Supersaturation —	244
8.4.4	Theory of crystallization —	245
8.4.5	Nucleation —	247
8.4.6	Crystal growth —	252
8.4.7	Population balance equations for the MSMPR crystallizer —	255
8.5	Methods of supersaturation generation —	259
8.5.1	Cooling —	259
8.5.2	Evaporation —	260
8.5.3	Vacuum crystallization —	260
8.5.4	Precipitation —	261
8.5.5	Anti-solvent crystallization —	262
8.5.6	Melt crystallization —	263

8.5.7	Choosing a method of supersaturation generation —	263
8.6	Basic design for industrial crystallizers —	264
8.6.1	Process and design specifications —	266
8.6.2	Thermodynamic and lab-scale kinetic information —	266
8.6.3	Design decisions —	267
8.6.3.1	Selecting method of supersaturation generation —	267
8.6.3.2	Operation modes: Batch versus Continuous operation —	268
8.6.3.3	Number of stages: single- and multistage operation selection —	270
8.6.3.4	Selecting the crystallizer type —	270
8.6.3.5	Stirred tank and cooling disk crystallizer —	271
8.6.3.6	Forced circulation crystallizers —	272
8.6.3.7	Draft tube baffle crystallizer —	273
8.6.3.8	Fluidized bed crystallizers —	273
8.6.3.9	Melt crystallizers —	274
8.6.3.10	Vacuum crystallizers —	276
8.7	Crystallizer calculations —	277
8.7.1	Mass balance —	277
8.7.2	Basic yield calculations —	278
8.7.3	Enthalpy balance —	279
8.7.4	Crystallizer dimensions —	280
8.8	Final design procedure —	281
8.8.1	Economic evaluation —	281
8.8.2	Detailed design with production scale kinetic data —	282
	Nomenclature —	283
	Exercises —	284

Chapter 9

Sedimentation and Settling — 289

9.1	Introduction —	289
9.2	Gravity sedimentation —	290
9.2.1	Sedimentation mechanisms —	291
9.2.2	Dilute sedimentation —	293
9.2.3	Hindered settling —	296
9.2.4	Continuous sedimentation tank (gravity-settling tank) —	296
9.2.5	Gravity sedimentation equipment —	299
9.2.6	Brownian motion and its influence on sedimentation —	300
9.2.7	Colloidal stability —	302
9.3	Centrifugal sedimentation —	303
9.3.1	Particle velocity in a centrifugal field —	304
9.3.2	Sedimenting centrifuges —	304
9.3.3	Bowl centrifuge separation capability —	307

- 9.3.4 The sigma concept — 308
- 9.3.5 Capacity of disk centrifuges — 310
- 9.3.6 Hydrocyclones — 311
- 9.4 Electrostatic precipitation — 315
- 9.4.1 Principles — 315
- 9.4.2 Equipment and collecting efficiency — 317
- Nomenclature — 319
- Exercises — 320

Chapter 10

Filtration — 325

- 10.1 The filtration process — 325
- 10.2 Filtration fundamentals — 328
- 10.2.1 Flow through packed beds — 328
- 10.2.2 Cake filtration — 329
- 10.2.3 Constant pressure and constant rate filtration — 331
- 10.2.4 Compressible cakes — 332
- 10.3 Filtration equipment — 333
- 10.3.1 Continuous large-scale vacuum filters — 334
- 10.3.2 Batch vacuum filters — 337
- 10.3.3 Pressure filters — 338
- 10.4 Filter media — 340
- 10.5 Centrifugal filtration — 342
- 10.5.1 Centrifugal filters — 342
- 10.5.2 Filtration rates in Centrifuges — 344
- 10.6 Interceptive filtration — 347
- 10.6.1 Deep bed filtration — 347
- 10.6.2 Impingement filtration of gases — 348
- 10.6.3 Interception mechanisms — 350
- 10.6.4 Lamellar plate separators — 352
- Nomenclature — 353
- Exercises — 353

Chapter 11

Membrane Filtration — 359

- 11.1 Introduction — 359
- 11.2 Membrane selection — 360
- 11.3 Membrane filtration processes — 362
- 11.4 Flux equations and selectivity — 365
- 11.4.1 Flux definitions — 366
- 11.4.2 Permeability for diffusion in porous membranes — 367

11.4.3	Permeability for solution-diffusion in dense membranes —	369
11.4.4	Selectivity and retention —	370
11.5	Concentration polarization —	372
11.6	Membrane modules —	375
11.6.1	Design procedure —	379
11.7	Concluding remarks —	380
	Nomenclature —	381
	Exercises —	382
	Appendix —	384

Chapter 12

Separation Method Selection — 385

12.1	Introduction —	385
12.1.1	Industrial separation processes —	385
12.1.2	Factors influencing the choice of a separation process —	387
12.1.2.1	Economics —	387
12.1.2.2	Feasibility —	388
12.1.2.3	Product stability —	389
12.1.2.4	Design reliability —	389
12.2	Selection of feasible separation processes —	390
12.2.1	Classes of processes —	390
12.2.2	Initial screening —	391
12.2.3	Separation factor —	392
12.3	Separation of homogeneous liquid mixtures —	394
12.3.1	Strengths of distillation —	394
12.3.2	Limitations of distillation —	397
12.3.3	Low relative volatilities —	399
12.3.4	Overlapping boiling points —	401
12.3.5	Low concentrations —	402
12.3.6	Dissolved solids —	403
12.4	Separation systems for gas mixtures —	404
12.4.1	General selection considerations —	404
12.4.2	Comparison of gas separation techniques —	406
12.4.2.1	Absorption —	406
12.4.2.2	Adsorption —	407
12.4.2.3	Membrane separation —	407
12.5	Separation methods for solid-liquid mixtures —	408
	Exercises —	410

Appendix Answers to Exercises — 413

References and Further Reading — 425

Index — 429

