

Contents

Volume 4	
Preface	V
List of Contributors	XVII
7 Activity Loss	1829
7.1 Deactivation and Regeneration	1829
	<i>Jacob A. Moulijn, Annelies E. van Diepen, and Freek Kapteijn</i>
7.1.1 Introduction	1829
7.1.2 Causes of Deactivation	1830
7.1.2.1 Poisoning	1832
7.1.2.2 Formation of Deposits	1834
7.1.2.3 Thermal Degradation	1838
7.1.2.4 Mechanical Deactivation	1840
7.1.2.5 Corrosion/Leaching	1841
7.1.3 Stability Too Low: What To Do?	1841
7.1.3.1 Measures on the Scale of the Catalyst Particle	1841
7.1.3.2 Tailored Reactor and Process Design	1842
7.1.3.2.1 Relation Between Time-Scale of Deactivation and Choice of Reactor	1842
7.1.3.2.2 Chemical Reaction Engineering Solutions Allowing for Regeneration	1842
7.1.3.3 Good Engineering Practice	1843
7.1.3.3.1 Feed Purification	1843
7.1.3.3.2 Optimizing Reaction Conditions	1844
7.1.3.3.3 Optimal Conditions as a Function of Time-on-Stream	1844
7.1.3.4 Regeneration or Replacement of the Catalyst	1844
7.1.3.4.1 Poisoning	1844
7.1.3.4.2 Deposits	1844
7.1.3.4.3 Sintering	1845
7.1.3.4.4 Leaching	1845
7.1.4 Conclusion	1845
References	1845
7.2 Recycling of Spent Catalysts	1846
7.2.1 Recycling of Spent Catalysts Containing Precious Metals	1846
	<i>Christian Hagelüken</i>
7.2.1.1 Introduction	1846
7.2.1.2 Impact of Catalysis on Precious Metals Demand and Price Development	1847
7.2.1.3 Recycling Technologies	1849
7.2.1.4 Responsible Care and Trans-Border Shipments	1853
7.2.1.4.1 Shipment of Spent Catalysts – What Has to Be Considered?	1854
7.2.1.5 Commercial Execution of a Refining Job	1855
7.2.1.6 Catalyst Lifecycles and Future Recycling Potential	1856
7.2.1.6.1 Closed Cycles – the Typical Case for Industrial Catalysts	1859
7.2.1.6.2 Open Cycles – Recycling from Automotive Catalysts and Other Consumer Durables	1860
7.2.1.6.3 Future Recycling Potential	1862
References	1863
7.2.2 Recycling of Spent Catalysts Containing Base Metals	1863
	<i>Sean A. Axon and John L. Casci</i>
7.2.2.1 Introduction	1863
7.2.2.1.1 Catalysis is “Green”	1863
7.2.2.1.2 Context: the Catalyst Industry and Market	1863
7.2.2.1.3 Base Metal Solid Catalysts	1863
7.2.2.1.4 Raw Materials	1864
7.2.2.1.5 Drivers for Recycle	1865
7.2.2.2 Catalyst Product Life Cycles	1866
7.2.2.2.1 Product Life Cycles	1866
7.2.2.2.2 Important Factors	1866
7.2.2.2.3 Legislation	1866
7.2.2.2.4 Environmental/Ecological/Health Hazards	1867

7.2.2.2.5	Societal	1867	8.1.1.6.2	Oxygen Adsorption and Formation of Surface Oxides and Their Relation to the ORR	1894
7.2.2.2.6	Economic/Commercial	1867	8.1.1.6.3	Structural and Particle Size Effects in the ORR	1897
7.2.2.2.7	SUSCHEM	1867	8.1.1.6.4	ORR Electrocatalysis for Low-Temperature Fuel Cells	1898
7.2.2.2.8	Catalyst Care Program	1868	8.1.1.6.5	Oxygen Evolution Reaction	1900
7.2.2.3	Conventional Methods for Disposal and Recovery	1868	8.1.1.7	Outlook	1901
7.2.2.3.1	End-of-Life Options	1868		References	1902
7.2.2.3.2	End-of-Life Catalysts – Growing Issues with the Current Approach	1869	8.1.2	Electrochemical Modification of Catalytic Activity	1905
7.2.2.4	Examples of Metals Recovery	1869		<i>Constantinos G. Vayenas, Alexandros Katsaounis, Susanne Brosda, and Ahmad Hammad</i>	
7.2.2.4.1	Cu, Ni, Co, Zn	1869	8.1.2.1	Introduction	1905
7.2.2.4.2	Fe, Cr	1869	8.1.2.1.1	Catalytic and Electrocatalytic Kinetics	1905
7.2.2.4.3	Ni/Mo, Co/Mo	1869	8.1.2.1.2	Solid Electrolytes	1906
7.2.2.5	Reuse in Catalyst Manufacture	1870	8.1.2.1.3	Solid Electrolyte Potentiometry (SEP)	1907
7.2.2.6	Future Trends and Challenges	1870	8.1.2.1.4	Electrocatalytic Operation of Solid Electrolyte Cells	1908
7.2.2.7	Conclusions	1870	8.1.2.1.5	Electrochemical Promotion of Catalysis	1908
	References	1871	8.1.2.2	Selectivity Modification and Promotional Effects on Chemisorption	1909
8	Special Catalytic Systems	1873	8.1.2.2.1	Selectivity Modification	1909
8.1	Electrocatalysis	1873	8.1.2.2.2	Promotional Effects on Chemisorption	1910
8.1.1	Fundamentals of Electrocatalysis	1873	8.1.2.2.3	Basic Questions	1911
	<i>Katharina Krischer and Elena R. Savinova</i>		8.1.2.2.3	Origin of Electrochemical Promotion	1912
8.1.1.1	Introduction	1873	8.1.2.3.1	Magnitude of Electrochemical Promotion and the Sacrificial Promoter Mechanism	1914
8.1.1.2	The Electrical Double Layer and Potentials	1874	8.1.2.3.2	Mechanism of Metal–Support Interactions	1918
8.1.1.2.1	The Electrical Double Layer	1874	8.1.2.3.3	Interrelation of Promotion, Electrochemical Promotion and Metal–Support Interactions: the Double-Layer Model of Catalysis	1921
8.1.1.2.2	The Work Function of an Electrode, the Electrode Potential and the Potential of Zero Charge	1875	8.1.2.3.4	Why the “New” Supports?	1924
8.1.1.2.3	Potentials in Galvanic or Electrolytic Cells	1878	8.1.2.4	Double-Layer Approach to Catalysis	1924
8.1.1.3	Electrode Kinetics	1879	8.1.2.4.1	Why Double Layer? Rationalization and Prediction of Desired Types of Promoters and Supports	1924
8.1.1.3.1	Kinetics of One-Step Electrode Reactions	1879	8.1.2.4.2	The Four Types of Rate–Work Function Dependence and the Promotional Rules	1925
8.1.1.3.2	Multistep Reactions	1881	8.1.2.4.3	Double-Layer Isotherms and Kinetics	1927
8.1.1.4	Fundamentals of Electrocatalysis	1883	8.1.2.5	Electropromotion of Thin Films and Electropromoted Monolithic Reactors	1930
8.1.1.4.1	Primary Effects: Heat of Adsorption and Volcano Plots	1883	8.1.2.6	Summary and Perspectives	1932
8.1.1.4.2	Secondary Effects: Double Layer Structure	1885	8.1.2.7	Outlook	1934
8.1.1.5	The Hydrogen Oxidation/Evolution Reaction	1886		References	1934
8.1.1.5.1	Reaction Kinetics and Mechanisms	1886			
8.1.1.5.2	Influence of the Electrode Material on the HER/HOR	1887			
8.1.1.5.3	Hydrogen Adsorption on Electrode Surfaces	1890			
8.1.1.6	The Oxygen Reduction and the Oxygen Evolution Reaction	1893			
8.1.1.6.1	Reaction Mechanisms: Relation to the Electrode Material	1893			

- 8.1.3 Industrial Electrocatalysis 1936
Stefan Kotrel and Sigmar Bräuninger
- 8.1.3.1 Introduction: From Industrial Electrochemistry to Electrocatalysis 1936
- 8.1.3.2 Catalysis in Organic Electrochemistry 1936
- 8.1.3.2.1 Synthesis of Adiponitrile 1937
- 8.1.3.2.2 The Simons Process 1938
- 8.1.3.2.3 Bleached Montan Wax – Regeneration of Chromic Acid 1938
- 8.1.3.2.4 Waste Water Treatment 1939
- 8.1.3.3 Catalysis in Inorganic Electrochemistry 1943
- 8.1.3.3.1 Chloralkali Electrolysis 1943
- 8.1.3.3.2 Electrolysis of Hydrochloric Acid 1946
- 8.1.3.3.3 Preparation of Oxygen-Depolarized Cathodes 1946
- 8.1.3.3.4 First Industrial HCl Electrolysis Using ODCs 1947
- 8.1.3.3.5 Oxygen-Depolarized Cathodes for Chloralkali Electrolysis 1948
- 8.1.3.3.6 Industrial Water Electrolysis 1949
- 8.1.3.4 Summary and Outlook 1954
- References 1954
- 8.2 Photocatalysis: Development of Highly Functional Titanium Oxide Photocatalysts 1958
Masato Takeuchi, Masaaki Kitano, Masaya Matsuoka, and Masakazu Anpo
- 8.2.1 Introduction 1958
- 8.2.2 Ion Engineering Techniques for the Preparation of Well-Defined TiO₂ Photocatalysts 1958
- 8.2.3 Visible Light-Responsive TiO₂ Photocatalysts 1960
- 8.2.3.1 Modification of the Electronic Properties of TiO₂ Semiconducting Fine Powder Photocatalysts by an Advanced Metal Ion Implantation Method 1960
- 8.2.3.2 Preparation of Highly Transparent TiO₂ Thin-Film Photocatalysts 1962
- 8.2.3.3 Preparation of Visible Light-Responsive TiO₂ Thin-Film Photocatalysts by RF-Magnetron Sputtering (RF-MS) Deposition in a Single Process 1964
- 8.2.4 Photo-induced Superhydrophilic Properties on the Surface of the TiO₂ Thin-Film Photocatalysts 1967
- 8.2.5 Conclusions 1967
- References 1968
- 8.3 Chemical Sensors Based on Catalytic Reactions 1969
Nicolae Barsan, Klaus D. Schierbaum, and Udo Weimar
- 8.3.1 Introduction 1969
- 8.3.1.1 Definitions and Classifications 1969
- 8.3.1.2 Typical Examples 1969
- 8.3.2 Calorimetric Sensors 1974
- 8.3.3 Electronic Conductance Sensors 1975
- 8.3.3.1 Sensing Process and Signal Transduction 1975
- 8.3.3.2 Modeling the Sensor Response 1979
- 8.3.3.3 Role of Contacts 1979
- 8.3.3.4 Materials 1981
- 8.3.3.4.1 Tin Oxide (SnO₂) 1981
- 8.3.3.4.2 Tungsten Oxide (WO₃) 1982
- 8.3.3.4.3 Chromium Titanium Oxide (Cr_{2-x}Ti_xO₃) 1982
- 8.3.3.4.4 Gallium Oxide (Ga₂O₃) 1982
- 8.3.4 Solid-State Electrochemical Sensors 1983
- 8.3.5 Conclusions 1985
- References 1985
- 8.4 Heterogeneous Catalysis in Non-Conventional Solvents 1987
Roger Gläser
- 8.4.1 Introduction and Scope 1987
- 8.4.2 Non-Conventional Solvents 1987
- 8.4.2.1 Supercritical Fluids (SCFs) 1987
- 8.4.2.1.1 Properties of SCFs 1988
- 8.4.2.1.2 Opportunities for SCFs in Heterogeneous Catalysis 1990
- 8.4.2.2 Ionic Liquids (ILs) 1991
- 8.4.2.2.1 Properties of ILs 1991
- 8.4.2.2.2 Opportunities for ILs in Heterogeneous Catalysis 1992
- 8.4.2.3 Gas-Expanded Liquids (GXLs) 1992
- 8.4.2.3.1 Properties of GXLs 1993
- 8.4.2.3.2 Opportunities for GXLs in Heterogeneous Catalysis 1993
- 8.4.2.4 Other Non-Conventional Solvents 1993
- 8.4.3 Heterogeneously Catalyzed Conversions in Non-Conventional Solvents 1994
- 8.4.3.1 Conversions in Supercritical Fluids 1994
- 8.4.3.1.1 Hydrogenations and Dehydrogenations 1994
- 8.4.3.1.2 Fischer–Tropsch Synthesis 1996
- 8.4.3.1.3 Hydroformylation 1997
- 8.4.3.1.4 Oxidations 1997
- 8.4.3.1.5 Alkylations 1998
- 8.4.3.1.6 Isomerizations 1999
- 8.4.3.1.7 Miscellaneous 2000
- 8.4.3.2 Conversions in Ionic Liquids 2000

8.4.3.2.1	Hydrogenations and Oxidations	2000	9.1.5	Effect of Transport Limitations on Observed Behavior	2037
8.4.3.2.2	C–C Bond Formation	2002	9.1.6	Diagnostic Experimental Tests	2038
8.4.3.3	Conversions in Gas-Expanded Liquids	2003	9.1.6.1	Extraparticle Concentration Gradients	2038
8.4.4	Outlook	2004	9.1.6.2	Intraparticle Concentration Gradients	2038
	References	2004	9.1.6.3	Temperature Gradients	2038
8.5	Sonocatalysis	2007	9.1.7	Proper Catalyst Testing and Kinetic Studies	2039
	<i>Kenneth S. Suslick and Sara E. Skrabalak</i>		9.1.8	Current Trends in Catalyst Testing	2040
8.5.1	Introduction and the Origins of Sonochemistry	2007	9.1.8.1	Parallelization/High-Throughput Experimentation	2040
8.5.2	Effects of Ultrasound on Heterogeneous Catalysts	2009	9.1.8.2	Miniaturization	2041
8.5.2.1	Metal Powders	2009		References	2043
8.5.2.1.1	Modification of Bulk Metals	2009	9.2	Ancillary Techniques in Laboratory Units for Testing Solid Catalysts	2045
8.5.2.1.2	Amorphous and Nanostructured Metal Catalysts	2010		<i>Jens Weitkamp and Roger Gläser</i>	
8.5.2.2	Metal Oxides as Catalysts	2011	9.2.1	Introduction	2045
8.5.2.3	Metal Carbides and Sulfides	2012	9.2.2	Overall Equipment	2045
8.5.2.4	Catalyst Supports: Sonogels and Zeolites	2013	9.2.3	Generation of Feed Streams	2046
8.5.2.5	Supported Catalysts	2014	9.2.4	Devices for Product Sampling	2049
8.5.2.6	Polymerization Catalysts	2015	9.2.5	Conclusions	2052
8.5.3	Conclusion	2015		References	2053
	References	2015	9.3	High-Throughput Experimentation in Heterogeneous Catalysis	2053
9	Laboratory Testing of Solid Catalysts	2019		<i>Ferdi Schüth</i>	
9.1	Laboratory Catalytic Reactors: Aspects of Catalyst Testing	2019	9.3.1	Introduction	2053
	<i>Freek Kapteijn and Jacob A. Moulijn</i>		9.3.2	Typical Program	2054
9.1.1	Introduction	2019	9.3.3	Technology Components	2055
9.1.2	Reactor Systems	2021	9.3.3.1	Synthesis	2055
9.1.2.1	Classification	2021	9.3.3.1.1	General Remarks	2055
9.1.2.2	Types of Laboratory Reactors	2022	9.3.3.1.2	Robotics and Automation Systems	2056
9.1.2.2.1	Gas–Solid and liquid–Solid Reactions	2022	9.3.3.1.3	Impregnation	2057
9.1.2.2.2	Gas–Liquid–Solid Reactions	2024	9.3.3.1.4	Precipitation	2058
9.1.2.3	Design Equations	2025	9.3.3.1.5	Hydrothermal Synthesis	2058
9.1.2.4	CSTR	2027	9.3.3.1.6	Sol–Gel Synthesis	2059
9.1.2.5	PFR	2027	9.3.3.1.7	Other Techniques for High-throughput Synthesis of Catalytic Materials	2059
9.1.2.6	Summary of Laboratory Systems	2030	9.3.3.2	Characterization Tools	2059
9.1.3	Mass and Heat Transfer	2030	9.3.3.3	Reactors and Analytics	2060
9.1.3.1	Extraparticle Gradients	2030	9.3.3.3.1	Generic Analytical Methods	2061
9.1.3.2	Intraparticle Gradients	2032	9.3.3.3.2	Stage I Reactors and Assays	2062
9.1.3.3	Catalyst Bed Gradients	2034	9.3.3.3.3	Stage II Reactors	2065
9.1.3.4	Gas–Liquid Mass Transfer	2036	9.3.3.4	Informatics Environment	2068
9.1.4	Comparison of Criteria	2036	9.3.3.4.1	Data Management	2068
9.1.4.1	Mass Transport	2036	9.3.3.4.2	Library Design and Data Mining	2069
9.1.4.2	Heat Transport	2036	9.3.3.5	Outlook	2072
				References	2072

10	Reaction Engineering	2075			
10.1	Catalytic Fixed-Bed Reactors	2075			
	<i>Gerhart Eigenberger</i>				
10.1.1	Introduction	2075			
10.1.2	Catalyst Shapes for Fixed-Bed Reactors	2077			
10.1.2.1	Random Packings	2077			
10.1.2.2	Monoliths	2079			
10.1.2.3	Gas Flow and Pressure Drop in Fixed Beds	2080			
10.1.2.4	Heat Transfer in Catalyst-Filled Tubes	2082			
10.1.2.5	Comparison of Different Catalyst Shapes	2083			
10.1.3	Types of Fixed-Bed Reactor	2083			
10.1.3.1	Adiabatic Reactors	2083			
10.1.3.2	Multi-Stage Reactors	2085			
10.1.3.3	Cooled or Heated Multitubular Fixed-Bed Reactors	2087			
10.1.3.3.1	Heat-Transfer Media	2089			
10.1.3.3.2	Design Concepts for Exothermic Reactions	2090			
10.1.3.3.3	Design Concepts for Endothermic Reactions	2090			
10.1.3.3.4	Reaction Control by Controlling the Heat-Transfer Medium Temperature	2093			
10.1.3.3.5	Reaction Control through Catalyst Activity Profile	2094			
10.1.4	Multifunctional Fixed-Bed Reactors	2095			
10.1.4.1	Heat-Integrated Reactors	2095			
10.1.4.1.1	Heat-Integrated Reactors for Exothermic Reactions	2095			
10.1.4.1.2	Heat-Integrated Reactors for Endothermic Reactions	2099			
10.1.4.2	Sorptive and Membrane Reactor Concepts	2100			
10.1.5	Safety Issues of Fixed-Bed Reactors	2100			
10.1.5.1	Parametric Sensitivity and Run-Away	2100			
10.1.5.2	Wrong-Way Behavior and Transient Run-Away	2102			
10.1.5.3	Decoking of Fixed-Bed Reactors	2103			
10.1.5.4	Other Safety Aspects	2104			
10.1.6	Conclusions	2105			
	References	2105			
10.2	Fluidized-Bed Reactors	2106			
	<i>Joachim Werther</i>				
10.2.1	Introduction	2106			
10.2.1.1	The Fluidization Principle	2106			
10.2.1.2	Forms of Fluidized Beds	2107			
10.2.1.3	Advantages and Disadvantages of the Fluidized-Bed Reactor	2108			
10.2.2	Fluid-Mechanical Principles	2108			
10.2.2.1	Minimum Fluidization Velocity	2108			
10.2.2.2	Fluidization Properties of Typical Bed Solids	2110			
10.2.2.3	Gas Distribution	2110			
10.2.2.4	Gas Jets in Fluidized Beds	2111			
10.2.2.5	Bubble Development	2111			
10.2.2.6	Elutriation	2113			
10.2.2.7	Circulating Fluidized Beds	2114			
10.2.2.8	Catalyst Attrition	2115			
10.2.3	Gas Mixing in Fluidized-Bed Reactors	2117			
10.2.3.1	Gas Mixing in Bubbling Fluidized Beds	2117			
10.2.3.2	Gas Mixing in Circulating Fluidized Beds	2118			
10.2.4	Gas–Solid Separation	2118			
10.2.5	Injection of Liquid Reactants into Fluidized Beds	2119			
10.2.6	Industrial Applications	2119			
10.2.6.1	Heterogeneous Catalytic Gas-Phase Reactions	2119			
10.2.6.2	Polymerization of Alkenes	2121			
10.2.7	Modeling of Fluidized-Bed Reactors	2122			
10.2.7.1	Bubbling Fluidized-Bed Reactors	2122			
10.2.7.2	Circulating Fluidized-Bed Reactors	2123			
10.2.7.3	New Developments in Fluidized-Bed Reactor Modeling	2124			
10.2.8	Scale-Up	2126			
10.2.8.1	Bed Diameter	2126			
10.2.8.2	Grid Design	2126			
10.2.8.3	Internals	2127			
10.2.8.4	Catalyst Particle-Size Distribution	2127			
10.2.8.5	Secondary Reactions in the Freeboard	2127			
10.2.8.6	Catalyst Attrition	2127			
10.2.8.7	Other Factors	2127			
10.2.9	Conclusions	2127			
	References	2129			
10.3	Slurry Reactors	2132			
	<i>Stoyan Nedeltchev and Adrian Schumpe</i>				
10.3.1	Introduction	2132			
10.3.2	Types of Slurry Reactor	2132			
10.3.2.1	Slurry Bubble Column Reactor	2133			
10.3.2.2	Other Reactor Types	2134			
10.3.3	Hydrodynamics of Slurry Reactors	2134			
10.3.3.1	Flow Regimes	2134			
10.3.3.2	Minimum Suspension Conditions	2136			
10.3.3.3	Average Bubble Diameter	2136			
10.3.3.4	Backmixing	2136			
10.3.3.5	Gas Holdup	2138			
10.3.3.6	Bubble Rise Velocity	2140			

10.3.4	Mass Transfer in Slurry Reactors	2141	10.4.10.4	NO _x Storage Reduction Systems	2172
10.3.4.1	Volumetric Liquid-Side Mass-Transfer Coefficient ($k_L a$)	2142	10.4.11	Stabilization of Unstable Steady States	2172
10.3.4.1.1	$k_L a$ in the Slurry Bubble Column	2142		References	2172
10.3.4.1.2	$k_L a$ in the Stirred Tank	2143	10.5	Short Contact-Time Reactors	2174
10.3.4.2	Gas–Liquid Specific Interfacial Area (a)	2144		<i>Götz Vesper</i>	
10.3.4.3	Liquid-Side Mass-Transfer Coefficient at the Gas–Liquid Interface (k_L)	2145	10.5.1	Introduction	2174
10.3.4.4	Gas-Side Mass-Transfer Coefficient (k_G)	2146	10.5.2	Brief History	2174
10.3.4.5	Liquid-Solid Mass-Transfer Coefficient (k_S)	2146	10.5.3	Short Contact-Time Reactions	2175
10.3.4.6	Enhancement of Gas–Liquid Mass Transfer	2147	10.5.3.1	Hydrogen and Syngas Formation from Methane	2175
10.3.4.6.1	Adsorptive Transport (“Shuttle Mechanism”)	2147	10.5.3.2	Hydrogen and Syngas from Higher Alkanes	2176
10.3.4.6.2	Absorption with Heterogeneous Catalytic Reaction	2148	10.5.3.3	Production of Olefins	2176
10.3.4.6.3	Reactive Particles	2148	10.5.3.4	Production of Oxygenates	2177
10.3.4.7	Optimum Catalyst Size	2148	10.5.3.5	Ketenes from Carboxylic Acids	2177
10.3.5	Heat Transfer in Slurry Reactors	2149	10.5.4	Reaction Mechanisms and Catalysts for SCTR	2178
10.3.6	Concluding Remarks	2150	10.5.4.1	Catalysts for Syngas Formation	2178
	References	2152	10.5.4.2	Syngas Formation: The Reaction Mechanism	2179
10.4	Unsteady-State Reactor Operation	2156	10.5.4.3	Catalysts and Reaction Mechanism for Olefin Production	2180
	<i>Grigori A. Bunimovich, Peter L. Silverston, and Yurii S. Matros</i>		10.5.4.4	Catalysts and Reaction Mechanism for Oxygenate Production	2181
10.4.1	Introduction	2156	10.5.5	Reactor Concepts	2182
10.4.2	Dynamic Kinetic Model	2158	10.5.6	Summary and Outlook	2184
10.4.3	General Approaches to Reactor Modeling	2159		References	2186
10.4.4	Analysis and Optimization of Cyclic Processes	2162	10.6	Catalytic Distillation	2188
10.4.5	Inlet Composition and Temperature Modulation	2164		<i>Ivano Miracca, Arvids Judzis, Jr., Nishit Sahay, and Domenico Sanfilippo</i>	
10.4.6	Partial Oxidation in Fluidized-Bed and Riser Reactors	2165	10.6.1	Introduction	2188
10.4.7	Dynamic Phenomena in a Fixed-Bed Reactor	2166	10.6.2	Potential versus Constraints	2189
10.4.8	Forced Unsteady-State Processes in Fixed-Bed Reactors	2167	10.6.3	Practical Realization of Catalytic Distillation	2190
10.4.8.1	Reverse-Flow Operation	2167	10.6.3.1	Tray Towers	2190
10.4.8.2	Migration of a Reaction Zone through a Reactor Network	2169	10.6.3.2	Packed Towers	2191
10.4.8.3	Inlet Temperature Modulation	2169	10.6.4	Modeling Catalytic Distillation	2193
10.4.9	Flow Modulation in Three-Phase Reactors	2169	10.6.4.1	Equilibrium-Stage Models	2193
10.4.10	Periodically Operated Adsorptive Reactors	2170	10.6.4.2	Rate-Based Models	2193
10.4.10.1	Chromatographic Reactors	2170	10.6.5	Selected Processes	2194
10.4.10.2	Flow-Reversal Adsorptive Reactors	2171	10.6.6	Future Perspectives	2197
10.4.10.3	Pressure-Swing Reactors	2171		References	2197
			10.7	Catalytic Membrane Reactors	2198
				<i>Roland Dittmeyer and Jürgen Caro</i>	
			10.7.1	Introduction	2198
			10.7.2	Types of Membrane Reactor	2199

10.7.3	Catalytic Reactors with Hydrogen-Selective Membranes	2202	10.7.5.1	Distributed Feeding through Membranes	2233
10.7.3.1	Membrane Types	2202	10.7.5.2	Catalytic Membrane Contactors	2234
10.7.3.1.1	Organic Polymers	2202	10.7.5.2.1	Gas–Liquid Applications	2234
10.7.3.1.2	Solid Polymer Electrolytes	2202	10.7.5.2.2	Liquid–Liquid Applications	2237
10.7.3.1.3	Metals	2202	10.7.5.2.3	Gas–Gas Applications	2237
10.7.3.1.4	Microporous Membranes	2203	10.7.5.3	Perspectives	2238
10.7.3.1.5	Ceramic Proton Conductors and Cermets	2205	10.7.6	Design of Catalytic Membrane Modules	2238
10.7.3.1.6	Final Remarks	2206	10.7.6.1	Novel Inorganic Membrane Supports	2238
10.7.3.2	Selective Removal of Hydrogen	2206	10.7.6.2	High-Temperature Membrane Reactor Design	2238
10.7.3.2.1	Dehydrogenation	2208	10.7.7	Concluding Remarks	2240
10.7.3.2.2	Water Gas Shift Reaction	2215		References	2241
10.7.3.2.3	Reforming	2217			
10.7.3.3	Selective Supply of Hydrogen	2223	10.8	Microstructured Reactors	2248
10.7.3.3.1	Hydrogenation	2223		<i>Lioubov Kiwi-Minsker and Albert Renken</i>	
10.7.3.3.2	Hydroxylation by <i>In-Situ</i> H ₂ O ₂ Formation	2224	10.8.1	Introduction	2248
10.7.3.4	Perspectives	2225	10.8.2	Microstructured Reactors for Gas-Phase Catalytic Reactions	2249
10.7.4	Reactors with Oxygen-Selective Membranes	2226	10.8.2.1	Packed-Bed Reactors	2249
10.7.4.1	Membrane Types	2226	10.8.2.2	Catalytic Wall Microstructured Reactors	2249
10.7.4.1.1	Mixed Oxygen-Ion- and Electron-Conducting Membranes	2226	10.8.3	Main Characteristics of Microstructured Reactors	2253
10.7.4.1.2	Solid Electrolytes for Electrochemical Operation	2227	10.8.3.1	Pressure Drop	2253
10.7.4.1.3	Membranes for Selective Removal of Oxygenates	2227	10.8.3.2	Residence Time Distribution (RTD)	2254
10.7.4.1.4	Pore Membranes for Non-Selective Oxygen Feeding	2228	10.8.3.3	Mass Transfer Performance	2257
10.7.4.2	Selective Supply of Oxygen	2228	10.8.3.3.1	Internal Mass Transfer	2257
10.7.4.2.1	Production of Pure Oxygen and of Oxygen-Enriched Air	2228	10.8.3.3.2	External Mass Transfer	2258
10.7.4.2.2	Partial Oxidation of Methane to Synthesis Gas	2229	10.8.3.4	Heat Transfer Performance	2259
10.7.4.2.3	Oxidative Dehydrogenation of Light Alkanes to Olefins	2230	10.8.4	Design Criteria for Microstructured Multichannel Reactors	2259
10.7.4.2.4	Oxidative Coupling of Methane to C ₂ -Hydrocarbons	2231	10.8.4.1	Heterogeneous Catalytic Reactions Limited by Chemical Transformation	2260
10.7.4.3	Solid Electrolyte Membrane Reactors	2232	10.8.4.2	Heterogeneous Catalytic Reactions Limited by Mass Transfer	2261
10.7.4.4	Perspectives	2232	10.8.5	Conclusions and Outlook	2261
10.7.5	Catalytic Reactors with Non-Selective Membranes	2233		References	2263