

Table of Contents

Preface	V
Organisation of the Book	VI
Acknowledgements	VIII
Nomenclature for Chapters 1 to 4.....	XVII
1 Basic Concepts	1
1.1 Modelling Fundamentals.....	1
1.1.1 Chemical Engineering Modelling.....	1
1.1.2 General Aspects of the Modelling Approach.....	3
1.1.3 General Modelling Procedure	3
1.2 Formulation of Dynamic Models	6
1.2.1 Material Balance Equations.....	6
1.2.2 Balancing Procedures.....	8
1.2.2.1 Case A. Continuous Stirred-Tank Reactor	8
1.2.2.2 Case B. Tubular Reactor.....	9
1.2.2.3 Case C. Coffee Percolator.....	11
1.2.3 Total Material Balances	20
1.2.3.1 Case A. Tank Drainage	21
1.2.4 Component Balances.....	22
1.2.4.1 Case A. Waste Holding Tank.....	23
1.2.4.2 Case B. Extraction from a Solid by a Solvent	25
1.2.5 Energy Balancing	26
1.2.5.1 Case A. Continuous Heating in an Agitated Tank.....	33
1.2.5.2 Case B. Heating in a Filling Tank.....	34
1.2.5.3 Case C. Parallel Reaction in a Semi-Continuous Reactor with Large Temperature Changes	35
1.2.6 Momentum Balances.....	37
1.2.7 Dimensionless Model Equations.....	38
1.2.7.1 Case A. Continuous Stirred-Tank Reactor (CSTR).....	39
1.2.7.2 Case B. Gas-Liquid Mass Transfer to a Continuous Tank Reactor with Chemical Reaction.....	41
1.3 Chemical Kinetics	43
1.3.1 Rate of Chemical Reaction	43
1.3.2 Reaction Rate Constant.....	45
1.3.3 Heats of Reaction.....	46
1.3.4 Chemical Equilibrium and Temperature.....	47

1.3.5	Yield, Conversion and Selectivity	47
1.4	Microbial Growth Kinetics.....	49
1.5	Mass Transfer Theory	52
1.5.1	Stagewise and Differential Mass Transfer Contacting.....	52
1.5.2	Phase Equilibria	54
1.5.3	Interphase Mass Transfer.....	55
2	Process Dynamics Fundamentals	61
2.1	Signal and Process Dynamics	61
2.1.1	Measurement and Process Response	61
2.1.1.1	First-Order Response to an Input Step-Change Disturbance	62
2.1.1.2	Case A. Concentration Response of a Continuous Flow, Stirred Tank	63
2.1.1.3	Case B. Concentration Response in a Continuous Stirred Tank with Chemical Reaction	65
2.1.1.4	Case C. Response of a Temperature Measuring Element.....	66
2.1.1.5	Case D. Measurement Lag for Concentration in a Batch Reactor....	68
2.1.2	Higher-Order Responses.....	70
2.1.2.1	Case A. Multiple Tanks in Series	70
2.1.2.2	Case B. Response of a Second-Order Temperature Measuring Element.....	72
2.1.3	Pure Time Delay	74
2.1.4	Transfer Function Representation.....	75
2.2	Time Constants.....	77
2.2.1	Common Time Constants	78
2.2.1.1	Flow Phenomena.....	78
2.2.1.2	Diffusion and Dispersion.....	79
2.2.1.3	Chemical Reaction.....	79
2.2.1.4	Mass Transfer.....	80
2.2.1.5	Heat Transfer	81
2.2.2	Application of Time Constants	82
2.3	Fundamentals of Automatic Control	83
2.3.1	Basic Feedback Control.....	83
2.3.2	Types of Controller Action.....	85
2.3.2.1	On/Off Control	85
2.3.2.2	Proportional-Integral-Derivative (PID) Control.....	86
2.3.2.3	Case A. Operation of a Proportional Temperature Controller.....	88
2.3.3	Controller Tuning	89
2.3.3.1	Trial and Error Method.....	90
2.3.3.2	Ziegler-Nichols Method	90
2.3.3.3	Cohen-Coon Controller Settings.....	91
2.3.3.4	Ultimate Gain Method.....	92
2.3.3.5	Time Integral Criteria.....	94
2.3.4	Advanced Control Strategies.....	94
2.3.4.1	Cascade Control	94
2.3.4.2	Feedforward Control	95

2.3.4.3	Adaptive Control.....	96
2.3.4.4	Sampled Data or Discrete Control Systems	97
2.4	Numerical Aspects of Dynamic Behaviour.....	97
2.4.1	Optimisation.....	97
2.4.1.1	Case A. Optimal Cooling for a Reactor with an Exothermic Reversible Reaction	98
2.4.2	Parameter Estimation.....	99
2.4.2.1	Non-Linear Systems Parameter Estimation	100
2.4.2.2	Case B. Estimation of Rate and Equilibrium Constants in a Reversible Esterification Reaction Using Madonna	102
2.4.2.3	Case C. Estimation of Rate and Equilibrium Constants in a Reversible Esterification Reaction Using ACSL-Optimize	105
2.4.3	Sensitivity Analysis.....	107
2.4.4	Numerical Integration	110
2.4.5	System Stability.....	113
3	Modelling of Stagewise Processes.....	117
3.1	Introduction.....	117
3.2	Stirred-Tank Reactors.....	117
3.2.1	Reactor Configurations.....	117
3.2.2	Generalised Model Description.....	119
3.2.2.1	Total Material Balance Equation.....	119
3.2.2.2	Component Balance Equation	119
3.2.2.3	Energy Balance Equation.....	120
3.2.2.4	Heat Transfer to and from Reactors.....	120
3.2.2.5	Steam Heating in Jackets	124
3.2.2.6	Dynamics of the Metal Jacket Wall	125
3.2.3	The Batch Reactor.....	128
3.2.3.1	Case A. Constant-Volume Batch Reactor	129
3.2.4	The Semi-Batch Reactor.....	130
3.2.4.1	Case B. Semi-Batch Reactor.....	132
3.2.5	The Continuous Stirred-Tank Reactor	132
3.2.5.1	Case C. Constant-Volume Continuous Stirred-Tank Reactor.....	135
3.2.6	Stirred-Tank Reactor Cascade.....	136
3.2.7	Reactor Stability	137
3.2.8	Reactor Control.....	142
3.2.9	Chemical Reactor Safety.....	145
3.2.9.1	The Runaway Scenario.....	145
3.2.9.2	Reaction Calorimetry.....	146
3.2.10	Process Development in the Fine Chemical Industry	147
3.2.11	Chemical Reactor Waste Minimisation	148
3.2.12	Non-Ideal Flow	151
3.2.13	Tank-Type Biological Reactors	153
3.2.13.1	The Batch Fermenter.....	155
3.2.13.2	The Chemostat	156
3.2.13.3	The Fed Batch Fermenter	158

3.3	Stagewise Mass Transfer.....	159
3.3.1	Liquid-Liquid Extraction.....	159
3.3.1.1	Single Batch Extraction.....	160
3.3.1.2	Multisolute Batch Extraction.....	162
3.3.1.3	Continuous Equilibrium Stage Extraction.....	164
3.3.1.4	Multistage Countercurrent Extraction Cascade.....	166
3.3.1.5	Countercurrent Extraction Cascade with Backmixing.....	168
3.3.1.6	Countercurrent Extraction Cascade with Slow Chemical Reaction.....	170
3.3.1.7	Multicomponent Systems.....	172
3.3.1.8	Control of Extraction Cascades.....	173
3.3.1.9	Mixer-Settler Extraction Cascades.....	174
3.3.1.10	Staged Extraction Columns.....	183
3.3.1.11	Column Hydrodynamics.....	186
3.3.2	Stagewise Absorption.....	188
3.3.3	Stagewise Distillation.....	191
3.3.3.1	Simple Overhead Distillation.....	191
3.3.3.2	Binary Batch Distillation.....	193
3.3.3.3	Continuous Binary Distillation.....	198
3.3.3.4	Multicomponent Separations.....	202
3.3.3.5	Plate Efficiency.....	203
3.3.3.6	Complex Column Simulations.....	204
3.3.4	Multicomponent Steam Distillation.....	205
4	Differential Flow and Reaction Applications.....	211
4.1	Introduction.....	211
4.1.1	Dynamic Simulation.....	211
4.1.2	Steady-State Simulation.....	212
4.2	Diffusion and Heat Conduction.....	213
4.2.1	Unsteady-State Diffusion Through a Porous Solid.....	214
4.2.2	Unsteady-State Heat Conduction and Diffusion in Spherical and Cylindrical Coordinates.....	217
4.2.3	Steady-State Diffusion with Homogeneous Chemical Reaction.....	217
4.3	Tubular Chemical Reactors.....	219
4.3.1	The Plug-Flow Tubular Reactor.....	220
4.3.2	Liquid-Phase Tubular Reactors.....	225
4.3.3	Gas-Phase Tubular Reactors.....	226
4.3.4	Batch Reactor Analogy.....	229
4.3.5	Dynamic Simulation of the Plug-Flow Tubular Reactor.....	230
4.3.6	Dynamics of an Isothermal Tubular Reactor with Axial Dispersion.....	233
4.3.6.1	Dynamic Difference Equation for the Component Balance Dispersion Model.....	234
4.3.7	Steady-State Tubular Reactor Dispersion Model.....	238
4.4	Differential Mass Transfer.....	241
4.4.1	Steady-State Gas Absorption with Heat Effects.....	241

4.4.1.1	Steady-State Design.....	242
4.4.1.2	Steady-State Simulation.....	244
4.4.2	Dynamic Modelling of Plug-Flow Contactors: Liquid-Liquid Extraction Column Dynamics.....	245
4.4.3	Dynamic Modelling of a Liquid-Liquid Extractor with Axial Mixing in Both Phases.....	249
4.4.4	Dynamic Modelling of Chromatographic Processes.....	251
4.4.4.1	Axial Dispersion Model for a Chromatography Column.....	252
4.4.4.2	Dynamic Difference Equation Model for Chromatography.....	254
4.5	Heat Transfer Applications.....	257
4.5.1	Steady-State Tubular Flow with Heat Loss	257
4.5.2	Single-Pass, Shell-and-Tube, Countercurrent-Flow Heat Exchanger.....	259
4.5.2.1	Steady-State Applications.....	259
4.5.2.2	Heat Exchanger Dynamics	261
4.6	Difference Formulae for Partial Differential Equations.....	265
4.7	References Cited in Chapters 1 to 4	266
4.8	Additional Books Recommended	270
5	Simulation Tools and Examples of Chemical Engineering Processes.....	275
5.1	Simulation Tools.....	276
5.1.1	Simulation Software	276
5.1.2	Teaching Applications.....	278
5.1.3	Introductory Madonna Example: BATSEQ-Complex Reaction Sequence.....	278
5.2	Batch Reactor Examples.....	284
5.2.1	BATSEQ – Complex Batch Reaction Sequence	284
5.2.2	BATCHD – Dimensionless Kinetics in a Batch Reactor.....	287
5.2.3	COMPREAC – Complex Reaction.....	290
5.2.4	BATCOM – Batch Reactor with Complex Reaction Sequence.....	293
5.2.5	CASTOR – Batch Decomposition of Acetylated Castor Oil.....	296
5.2.6	HYDROL – Batch Reactor Hydrolysis of Acetic Anhydride.....	300
5.2.7	OXIBAT – Oxidation Reaction in an Aerated Tank.....	303
5.2.8	RELUY – Batch Reactor of Luyben.....	306
5.2.9	DSC – Differential Scanning Calorimetry.....	312
5.3	Continuous Tank Reactor Examples.....	317
5.3.1	CSTRCOM – Isothermal Reactor with Complex Reaction	317
5.3.2	DEACT – Deactivating Catalyst in a CSTR	319
5.3.3	TANK and TANKDIM – Single Tank with nth-Order Reaction....	322
5.3.4	CSTRPULSE – Continuous Stirred-Tanks, Tracer Experiment.....	325
5.3.5	CASCSEQ – Cascade of Three Reactors with Sequential Reactions.....	329
5.3.6	REXT – Reaction with Integrated Extraction of Inhibitory Product	333
5.3.7	THERM and THERMPLOT – Thermal Stability of a CSTR.....	337

5.3.8	COOL – Three-Stage Reactor Cascade with Countercurrent Cooling.....	341
5.3.9	OSCIL – Oscillating Tank Reactor Behaviour.....	345
5.3.10	REFRIG1 and REFRIG2 – Auto-Refrigerated Reactor.....	351
5.3.11	REVTEMP – Reversible Reaction with Variable Heat Capacities ...	354
5.3.12	HOMPOLY – Homogeneous Free-Radical Polymerisation.....	361
5.4	Tubular Reactor Examples	367
5.4.1	TUBE and TUBEDIM – Tubular Reactor Model for the Steady State.....	367
5.4.2	TUBETANK – Design Comparison for Tubular and Tank Reactors	369
5.4.3	BENZHYD – Dehydrogenation of Benzene.....	372
5.4.4	ANHYD – Oxidation of O-Xylene to Phthalic Anhydride.....	376
5.4.5	NITRO – Conversion of Nitrobenzene to Aniline	381
5.4.6	TUBDYN – Dynamic Tubular Reactor	385
5.4.7	DISRE – Isothermal Reactor with Axial Dispersion.....	388
5.4.8	DISRET – Non-Isothermal Tubular Reactor with Axial Dispersion.....	393
5.4.9	VARMOL – Gas-Phase Reaction with Molar Change.....	397
5.5	Semi-Continuous Reactor Examples.....	401
5.5.1	SEMIPAR – Parallel Reactions in a Semi-Continuous Reactor	401
5.5.2	SEMISEQ – Sequential-Parallel Reactions in a Semi-Continuous Reactor.....	404
5.5.3	HMT – Semi-Batch Manufacture of Hexamethylenetriamine.....	407
5.5.4	RUN – Relief of a Runaway Polymerisation Reaction	410
5.5.5	SELCONT – Optimized Selectivity in a Semi-Continuous Reactor	417
5.6	Mixing-Model Examples.....	421
5.6.1	NOCSTR – Non-Ideal Stirred-Tank Reactor.....	421
5.6.2	TUBEMIX – Non-Ideal Tube-Tank Mixing Model.....	425
5.6.3	MIXFLO1 and MIXFLO2 – Residence Time Distribution Studies	428
5.6.4	GASLIQ1 and GASLIQ2 – Gas-Liquid Mixing and Mass Transfer in a Stirred Tank	432
5.6.5	SPBEDRTD – Spouted Bed Reactor Mixing Model.....	439
5.6.6	BATSEG, SEMISEG and COMPSEG – Mixing and Segregation in Chemical Reactors.....	444
5.7	Tank Flow Examples.....	457
5.7.1	CONFLO1, CONFLO 2 and CONFLO 3 – Continuous Flow Tank	457
5.7.2	TANKBLD – Liquid Stream Blending.....	461
5.7.3	TANKDIS – Ladle Discharge Problem.....	464
5.7.4	TANKHYD – Interacting Tank Reservoirs.....	468
5.8	Process Control Examples	472
5.8.1	TEMPCONT – Control of Temperature in a Water Heater	472
5.8.2	TWOTANK – Two Tank Level Control	475
5.8.3	CONTUN – Controller Tuning Problem.....	478
5.8.4	SEMIEX – Temperature Control for Semi-Batch Reactor.....	482
5.8.5	TRANSIM – Transfer Function Simulation	487
5.8.6	THERMFF – Feedforward Control of an Exothermic CSTR	489

5.9	Mass Transfer Process Examples	494
5.9.1	BATEX – Single Solute Batch Extraction.....	494
5.9.2	TWOEX – Two-Solute Batch Extraction with Interacting Equilibria.....	496
5.9.3	EQEX – Simple Equilibrium Stage Extractor	499
5.9.4	EQMULTI – Continuous Equilibrium Multistage Extraction.....	501
5.9.5	EQBACK – Multistage Extractor with Backmixing.....	505
5.9.6	EXTRACTCON – Extraction Cascade, Backmixing and Control...	508
5.9.7	HOLDUP – Transient Holdup Profiles in an Agitated Extractor...	512
5.9.8	KLADYN, KLAFIT and ELECTFIT – Dynamic Oxygen Electrode Method for $K_L a$	515
5.9.9	AXDISP – Differential Extraction Column with Axial Dispersion.	521
5.9.10	AMMONAB – Steady-State Absorption Column Design	525
5.9.11	MEMSEP – Gas Separation by Membrane Permeation.....	530
5.9.12	FILTWASH – Filter Washing.....	534
5.9.13	CHROMDIFF – Dispersion Model for Chromatography Columns	538
5.9.14	CHROMPLATE – Stagewise Model for Chromatography Columns.....	541
5.10	Distillation Process Examples	545
5.10.1	BSTILL – Binary Batch Distillation Column.....	545
5.10.2	DIFDIST – Multicomponent Differential Distillation.....	548
5.10.3	CONSTILL – Continuous Binary Distillation Column	551
5.10.4	MCSTILL – Continuous Multicomponent Distillation Column...	556
5.10.5	BUBBLE – Bubble Point Calculation for a Batch Distillation Column.....	559
5.10.6	STEAM – Multicomponent, Semi-Batch Steam Distillation.....	564
5.11	Heat Transfer Examples	567
5.11.1	HEATEX – Dynamics of a Shell-and-Tube Heat Exchanger	567
5.11.2	SSHEATEX – Steady-State, Two-Pass Heat Exchanger.....	572
5.11.3	ROD – Radiation from Metal Rod	575
5.12	Diffusion Process Examples	578
5.12.1	DRY – Drying of a Solid.....	578
5.12.2	ENZSPLIT – Diffusion and Reaction: Split Boundary Solution....	582
5.12.3	ENZDYN – Dynamic Diffusion with Enzymatic Reaction.....	587
5.12.4	BEAD – Diffusion and Reaction in a Spherical Catalyst Bead.....	592
5.13	Biological Reaction Examples	597
5.13.1	BIOREACT – Process Modes for a Bioreactor.....	597
5.13.2	INHIBCONT – Continuous Bioreactor with Inhibitory Substrate ..	602
5.13.3	NITBED – Nitrification in a Fluidised Bed Reactor.....	606
5.13.4	BIOFILM – Biofilm Tank Reactor.....	611
5.13.5	BIOFILT – Biofiltration Column for Removing Ketone from Air.	615

Appendix: Using the Berkeley Madonna Language 621

1. A Short Guide to Madonna 621

2. Screenshot Guide to Madonna..... 627

Index 635