

# Contents

<b>1</b>	<b>Introduction</b>	<b>1</b>
<b>2</b>	<b>State of art</b>	<b>3</b>
2.1	Lignocellulosic biomass . . . . .	3
2.1.1	Cellulose and hemicellulose . . . . .	4
2.1.2	Lignin . . . . .	5
2.2	Biomass pyrolysis . . . . .	7
2.2.1	Pyrolysis in circulating fluidized bed reactors . . . . .	8
2.2.2	Lignin pyrolysis . . . . .	9
2.2.3	Influence parameters . . . . .	10
2.2.4	Product yields, spectrum, properties, and applications . . . . .	14
2.3	Process modeling . . . . .	17
2.3.1	Reaction pathway and kinetics . . . . .	17
2.3.2	Pyrolysis process modeling . . . . .	19
2.3.3	Flowsheet modeling of pyrolysis refineries . . . . .	20
<b>3</b>	<b>Scope of work</b>	<b>21</b>
<b>4</b>	<b>Experimental</b>	<b>23</b>
4.1	Pyrolysis plant . . . . .	23
4.1.1	Pyrolysis product sampling . . . . .	28
4.2	Analysis methods for used material and pyrolysis products . . . . .	30
4.2.1	Sample preparation . . . . .	30
4.2.2	Analysis methods . . . . .	31
4.3	Evaluation of experiments . . . . .	37
4.3.1	Permanent gas yield . . . . .	37
4.3.2	Pyrolysis oil yield . . . . .	38
4.3.3	Char yield . . . . .	40
4.4	Used material . . . . .	41
4.4.1	Lignin . . . . .	41
4.4.2	Quartz sand . . . . .	50
4.5	Pyrolysis experiments . . . . .	51
<b>5</b>	<b>Modeling of pyrolysis process</b>	<b>52</b>
5.1	Reactor fluid dynamics . . . . .	53
5.1.1	Dense bottom zone . . . . .	54
5.1.2	Mass transfer between phases . . . . .	55
5.1.3	Dilute upper zone and entrainment . . . . .	56
5.1.4	Solid properties . . . . .	57
5.1.5	Change of superficial velocity due to heterogeneous reactions . . . . .	58
5.1.6	Residence times . . . . .	59
5.2	Reaction model and mass balances . . . . .	59
5.2.1	Material balances . . . . .	61
5.3	Literature data used for model validation . . . . .	65



5.3.1	CFB air-blown pyrolysis of pine wood, CERTH, Greece . . . . .	65
5.3.2	Bubbling fluidized bed pyrolysis of biomass, Univ. of Waterloo, Canada . . . . .	67
5.4	Flowsheet modeling of an intg. pyrolysis-combustion process . . . . .	69
5.4.1	Flowsheet model components . . . . .	69
5.4.2	Flowsheet model of SPE plant with integrated char combustion . .	70
5.4.3	Energetic process performance ratios . . . . .	70
<b>6</b>	<b>Pyrolysis results</b>	<b>72</b>
6.1	Pyrolysis mechanism and particle size distribution . . . . .	72
6.1.1	Granulation . . . . .	79
6.2	Influence of pyrolysis parameters . . . . .	83
6.2.1	Pyrolysis temperature . . . . .	83
6.2.2	Influence of char holdup . . . . .	98
<b>7</b>	<b>Simulation results</b>	<b>105</b>
7.1	Sensitivity analyses . . . . .	105
7.1.1	Discretization . . . . .	105
7.1.2	Superficial gas velocity (residence time) . . . . .	106
7.1.3	Composition . . . . .	107
7.2	Granulation . . . . .	109
7.3	Yields & conversion . . . . .	110
7.3.1	Validation of applicability . . . . .	110
7.3.2	Kinetic improvement for lignin . . . . .	113
7.4	Energetic eval. of an integrated pyrolysis-combustion process . .	118
<b>8</b>	<b>Summary and conclusions</b>	<b>120</b>
<b>Notation</b>		<b>122</b>
<b>References</b>		<b>150</b>
<b>A APPENDIX</b>		<b>151</b>
A.1	Figures . . . . .	151
A.2	Tables . . . . .	153
A.3	Char combustion reactions . . . . .	156
A.3.1	Heterogeneous char combustion . . . . .	156
A.3.2	Homogeneous gas phase reaction . . . . .	156
A.4	Student projects . . . . .	157