Contents

Abstract i

Kurzfassung iii

Preface and Acknowledgements v

List of Symbols xiii

List of Abbreviations xxiii

List of Figures xxvii

List of Tables xxxi

List of Listings xxxv

1. Introduction 1

2. Theoretical Background and Literature Review 3

2.1. Distillation and Separation Fundamentals . . . 3

2.1.1. Equilibrium Thermodynamics . . . 3

2.1.2. Continuous Distillation . . . 6

2.1.3. Multistage Distillation Apparatus . . . 8

2.2. Separation Quantification . . . 11

2.2.1. Number of Theoretical Stages . . . 11

2.2.1.1. Fenske Equation . . . 11

2.2.1.2. McCabe-Thiele Method . . . 12

2.2.1.3. Stage-to-Stage Calculations and MESH Equations . . . 17

2.2.2. Height Equivalent to a Theoretical Plate (HETP) . . . 19

2.2.3. Non-Equilibrium and Mass Transfer Models . . . 21

2.2.3.1. Murphree Efficiency . . . 21

2.2.3.2. The Concept of Transfer Units (HTU/NTU) . . . 22

2.2.3.3. Connecting HETP and HTU/NTU . . . 27

2.2.3.4. HETP vs. HTU/NTU . . . 30

2.2.3.5. Delft Mass Transfer Model . . . 32

2.2.4. Influence of Reflux Ratio . . . 37

2.3. Separation Performance Measurements 38
2.3.1. Test Mixtures 38
2.3.2. Experimental Procedures and Plant Setups 41
2.3.2.1. General Considerations and Total Reflux 41
2.3.2.2. Partial Reflux and Non-Volatile Mixture Components 45
2.3.3. Sources of Uncertainties 46

3. Alternative Method for Separation Performance Experiments 49
3.1. Necessity for an Alternative Approach 49
3.2. Research Hypotheses and Objectives 50
3.3. Distillation Plant 50
3.3.1. Development 50
3.3.2. Description 52
3.3.3. Operation 57
3.3.3.1. Operational Characteristics 57
3.3.3.2. Identifying Steady-State Operation 60
3.3.4. Experimental Investigations 61
3.4. Sample Analysis 64
3.5. Data Processing and Evaluation 64
3.5.1. Liquid Samples 65
3.5.2. Operating Data and Operating Parameters 65
3.5.3. Material Balances 69
3.5.4. Separation Performance 69
3.5.4.1. Using Theoretical Stages 69
3.5.4.2. Using the Delft Mass Transfer Model 73
3.5.4.3. Comparing Theoretical Stages and Transfer Units 75

4. Results and Discussion 77
4.1. Plant Operation 77
4.1.1. Molar Stream Ratio as an Additional Degree of Freedom 77
4.1.2. Column Load and Operating Regime 79
4.1.3. Material Balances 80
4.1.4. Mid-Bed Conditions 81
4.1.4.1. Pressures, Temperatures and Feed Subcooling 82
4.1.4.2. Mid-Bed and Feedstock Compositions 84
4.2. Separation Performance 86
4.2.1. Using Theoretical Stages 86
4.2.1.1. Data Evaluation with Monte Carlo Methods 86
4.2.1.2. Considering Fractional Equilibrium Stages 88
4.2.1.3. Number of Theoretical Stages and HETP 90

4.2.2. Delft Mass Transfer Model . . . 99
4.2.3. Comparison of Theoretical Stages and Transfer Units . . . 105
4.3. Method Evaluation and Future Improvements . . . 113
4.3.1. General Applicability . . . 113
4.3.2. Plant Concept . . . 113
4.3.3. Plant Setup and Experimental Method . . . 114
4.3.4. Data Processing and Evaluation . . . 117

5. Conclusion and Outlook **119**

A. Distillation Plant **123**
A.1. Piping and Instrumentation Diagram . . . 123
A.2. Equipment, Sensors and Instrumentation . . . 126
A.3. Sensor Measuring Ranges and Accuracies . . . 135
A.4. Data Acquisition . . . 137
A.5. Temperature Sensor Calibration . . . 137
A.6. Stream Ratio . . . 143
A.6.1. Binary Mixture . . . 143
A.6.2. Ternary Mixture with Non-Volatile Component . . . 144
A.7. Identifying Steady-State Operation . . . 146
A.8. Relations between Stream and Column Load Ratios . . . 148

B. Chemicals **151**

C. Pure Component and Mixture Properties **153**
C.1. Tabulated Properties . . . 153
C.2. Molar Mass . . . 153
C.3. Density . . . 154
C.3.1. Calibration Curve for Sample Analysis . . . 154
C.3.2. Liquid . . . 160
C.3.3. Vapor . . . 160
C.4. Heat Capacity . . . 160
C.5. Enthalpy of Vaporization . . . 161
C.6. Dynamic Viscosity . . . 162
C.6.1. Liquid . . . 162
C.6.2. Vapor . . . 162
C.7. Surface Tension . . . 163
C.8. Diffusion Coefficient . . . 164
C.8.1. Liquid . . . 164
C.8.2. Vapor . . . 165
C.9. Excess Volume and Redlich-Kister Parameters . . . 166

C.10. Vapor Pressure 168
C.11. NRTL Equations and Parameters 169
C.12. Boiling Point and Activity Coefficients 170
C.13. VLE and Relative Volatility 171

D. Deviations and Uncertainties **175**
D.1. Brief Introduction to Uncertainty Quantification 175
D.1.1. Core Concepts of GUM 175
D.1.2. GUM Supplement 1: Monte Carlo Method 178
D.1.3. Combining Type A and Type B Uncertainties 179
D.1.4. Identifying and Reporting Uncertainty 179
D.2. Uncertainty Quantification and Propagation 180
D.2.1. Software-Assisted Uncertainty Quantification and Propagation 180
D.2.2. Sample Analysis and Mixture Composition 181
D.2.3. Molar Mass of Mixtures 186
D.2.4. Excess Volume 186
D.2.5. Column Geometry and Packing Specification 186
D.2.6. Operational Parameters 187
D.2.6.1. Liquid Feed Density (Inline Measurement) 187
D.2.6.2. Temperatures and Pressures 188
D.2.6.3. Feed Flow 192
D.2.6.4. Distillate and Bottom Product Flows 192

E. Data Evaluation **195**
E.1. Algebraic Integration for NTU 195
E.1.1. Total Reflux 196
E.1.2. Partial Reflux 196
E.2. Outlier Removal with IQR 198
E.3. Mass Flow Determination with Linear Regression 201
E.4. Constructability Check for McCabe-Thiele Approach 202
E.5. Software 202
E.5.1. Data Evaluation Workflow 202
E.5.2. Package Dependencies and Installation 209
E.5.3. Usage 209
E.5.4. Execution Time and Scalability 210
E.5.5. Data Files 211
E.5.6. Software and Directory Structure 212
E.5.6.1. Root Directory 212
E.5.6.2. Codebase 213
E.5.6.3. Data Storage 216

F. Experimental Results **217**
F.1. Tabulated Results 217
F.2. Diagrams 226
F.2.1. Plant Operation 226
F.2.2. Mixture Compositions 231
F.2.3. Pressures and Temperatures 238
F.2.4. McCabe-Thiele Stage Constructions with Solution Space from Monte Carlo Methods 242
F.2.5. Separation Performance Predicted with Delft Mass Transfer Model . . 249

G. Scientific Dissemination **255**
G.1. Journals 255
G.2. Conferences 255
G.3. Research Data 256

H. Supervised Students **257**
H.1. Student Assistants 257
H.2. Student Theses 258

Bibliography **259**