## Open-Ended Problems

# **Open-Ended Problems**

# A Future Chemical Engineering Education Approach

### J. Patrick Abulencia and Louis Theodore



Copyright © 2015 by Scrivener Publishing LLC. All rights reserved.

Co-published by John Wiley & Sons, Inc. Hoboken, New Jersey, and Scrivener Publishing LLC, Salem, Massachusetts.

Published simultaneously in Canada.

No part of this publication may be reproduced, stored in a retrieval system, or transmitted in any form or by any means, electronic, mechanical, photocopying, recording, scanning, or otherwise, except as permitted under Section 107 or 108 of the 1976 United States Copyright Act, without either the prior written permission of the Publisher, or authorization through payment of the appropriate per-copy fee to the Copyright Clearance Center, Inc., 222 Rosewood Drive, Danvers, MA 01923, (978) 750-8400, fax (978) 750-4470, or on the web at www.copyright.com. Requests to the Publisher for permission should be addressed to the Permissions Department, John Wiley & Sons, Inc., 111 River Street, Hoboken, NJ 07030, (201) 748-6011, fax (201) 748-6008, or online at http://www.wiley.com/go/permission.

Limit of Liability/Disclaimer of Warranty: While the publisher and author have used their best efforts in preparing this book, they make no representations or warranties with respect to the accuracy or completeness of the contents of this book and specifically disclaim any implied warranties of merchantability or fitness for a particular purpose. No warranty may be created or extended by sales representatives or written sales materials. The advice and strategies contained herein may not be suitable for your situation. You should consult with a professional where appropriate. Neither the publisher nor author shall be liable for any loss of profit or any other commercial damages, including but not limited to special, incidental, consequential, or other damages.

For general information on our other products and services or for technical support, please contact our Customer Care Department within the United States at (800) 762-2974, outside the United States at (317) 572-3993 or fax (317) 572-4002.

Wiley also publishes its books in a variety of electronic formats. Some content that appears in print may not be available in electronic formats. For more information about Wiley products, visit our web site at www.wiley.com.

For more information about Scrivener products please visit www.scrivenerpublishing.com.

Cover design by Russell Richardson

Library of Congress Cataloging-in-Publication Data:

ISBN 978-1-118-94604-6

Printed in the United States of America

Nicole, who signed up for a lifetime of addressing open-ended problems with me

(J.P.A.)

To

My two long-standing Manhattan College colleagues

Dr. John Jeris

Dr. Wally Matystik

(L.T.)

## **Contents**

	Pretace Acknowledgements		xix xxi
Pa		IntroductionIntroduction to the Open-Ended Problem Approach	1 1
_			
Pa	rt II:	: Chemical Engineering Topics	13
1	Mat	terials Science and Engineering	15
	1.1	Overview	15
	1.2	Crystallography of Perfect Crystals (CPC)	17
		1.2.1 Geometry of Metallic Unit Cells	20
		1.2.2 Geometry of Ionic Unit Cells	21
		1.2.3 Packing Factors	23
		1.2.4 Directions and Planes	23
	1.3	Crystallography of Real Crystals (CRC)	25
		1.3.1 Interstitial Impurities	26
	1.4	Materials of Construction	27
	1.5	Resistivity	28
	1.6	Semiconductors	29
	1.7	Illustrative Open-Ended Problems	30
	1.8	Open-Ended Problems	34
	Refe	erences	37
2	App	plied Mathematics	39
		Overview	39
	2.2	Differentiation and Integration	41
		Simultaneous Linear Algebraic Equations	42
	2.4	Nonlinear Algebraic Equations	43

#### viii Contents

	2.5	Ordinary and Partial Differential Equation	44
	2.6	Optimization	45
	2.7	Illustrative Open-Ended Problems	48
	2.8	Open-Ended Problems	51
	Refe	erences	56
3	Stoi	chiometry	59
	3.1	Overview	59
	3.2	The Conservation Law	60
	3.3	Conservation of Mass, Energy, and Momentum	62
	3.4	Stoichiometry	64
	3.5	Illustrative Open-Ended Problems	67
	3.6	Open-Ended Problems	72
	Refe	erences	77
4	The	rmodynamics	79
	4.1	Overview	79
	4.2	Enthalpy Effects	81
		4.2.1 Sensible Enthalpy Effects	81
		4.2.2 Chemical Reaction Enthalpy Effects	83
	4.3	Second Law Calculations	84
	4.4	Phase Equilibrium	86
	4.5	Chemical Reaction Equilibrium	88
	4.6	Illustrative Open-Ended Problems	90
	4.7	Open-Ended Problems	94
	Refe	erences	97
5	Flui	d Flow	99
	5.1	Overview	99
	5.2	Basic Laws	101
	5.3	Key Fluid Flow Equations	102
		5.3.1 Reynolds Number	102
		5.3.2 Conduits	103
		5.3.3 Mechanical Energy Equation – Modified Form	103
		5.3.4 Laminar Flow Through a Circular Tube	104
		5.3.5 Turbulent Flow Through a Circular Conduit	105
		5.3.6 Two Phase Flow	106
		5.3.7 Prime Movers	107
		5.3.8 Valves and Fittings	107

Contents	ix
----------	----

	5.4	Fluid-Particle Applications	108
		5.4.1 Flow Through Porous Media	109
		5.4.2 Filtration	109
		5.4.3 Fluidization	110
	5.5	Illustrative Open-Ended Problems	110
	5.6	Open-Ended Problems	114
	Refe	rences	118
6	Hea	t Transfer	119
	6.1	Overview	119
	6.2	Conduction	121
	6.3	Convection	122
	6.4	Radiation	125
	6.5	Condensation, Boiling, Refrigeration, and Cryogenics	126
	6.6	Heat Exchangers	127
	6.7	Illustrative Open-Ended Problems	129
	6.8	Open-Ended Problems	134
	Refe	rences	139
7			
7		s Transfer Operations	141
7	7.1	Overview	<b>141</b> 141
7		Overview Absorption	
7	7.1	Overview Absorption 7.2.1 Packing Height	141
7	7.1	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter	141 143
7	7.1	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns	141 143 144
7	7.1	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping	141 143 144 145
7	7.1	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns	141 143 144 145 146
7	7.1	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption	141 143 144 145 146
7	7.1 7.2	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption 7.3.1 Adsorption Design	141 143 144 145 146 146
7	7.1 7.2	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption 7.3.1 Adsorption Design 7.3.2 Regeneration	141 143 144 145 146 146 147 148
7	7.1 7.2	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption 7.3.1 Adsorption Design 7.3.2 Regeneration Distillation	141 143 144 145 146 146 147 148 151
7	7.1 7.2	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption 7.3.1 Adsorption Design 7.3.2 Regeneration Distillation Other Mass Transfer Processes	141 143 144 145 146 146 147 148 151 152 152
7	7.1 7.2 7.3	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption 7.3.1 Adsorption Design 7.3.2 Regeneration Distillation Other Mass Transfer Processes 7.5.1 Liquid-Liquid Extraction	141 143 144 145 146 147 148 151 152 152 158 158
7	7.1 7.2 7.3	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption 7.3.1 Adsorption Design 7.3.2 Regeneration Distillation Other Mass Transfer Processes 7.5.1 Liquid-Liquid Extraction 7.5.2 Leaching	141 143 144 145 146 146 147 148 151 152 152 158 158
7	7.1 7.2 7.3	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption 7.3.1 Adsorption Design 7.3.2 Regeneration Distillation Other Mass Transfer Processes 7.5.1 Liquid-Liquid Extraction	141 143 144 145 146 147 148 151 152 152 158 158
7	7.1 7.2 7.3	Overview Absorption 7.2.1 Packing Height 7.2.2 Tower Diameter 7.2.3 Plate Columns 7.2.4 Stripping 7.2.5 Summary of Key Equations Adsorption 7.3.1 Adsorption Design 7.3.2 Regeneration Distillation Other Mass Transfer Processes 7.5.1 Liquid-Liquid Extraction 7.5.2 Leaching	141 143 144 145 146 146 147 148 151 152 152 158 158

#### x Contents

	7.7	Open-Ended Problems	163
	Refe	rences	166
8	Che	mical Reactors	169
	8.1	Overview	169
	8.2	Chemical Kinetics	171
	8.3	Batch Reactors	174
	8.4	Continuous Stirred Tank Reactors (CSTRs)	176
	8.5	Tubular Flow Reactors	178
	8.6	Catalytic Reactors	181
		8.6.1 Fluidized Bed Reactors	183
		8.6.2 Fixed Bed Reactors	183
	8.7	Thermal Effects	184
		8.7.1 Batch Reactors	184
		8.7.2 CSTRs	185
		8.7.3 Tubular Flow Reactions	186
	8.8	Illustrative Open-Ended Problems	187
	8.9	Open-Ended Problems	192
	Refe	rences	196
9	Proc	ess Control and Instrumentation	197
	9.1	Overview	197
	9.2	Process Control Fundamentals	199
	9.3	Feedback Control	203
	9.4	Feedforward Control	204
	9.5	Cascade Control	205
	9.6	Alarms and Trips	206
	9.7	Illustrative Open-Ended Problems	207
	9.8	Open-Ended Problems	209
	Refe	rences	212
10	Ecor	nomics and Finance	213
	10.1	Overview	213
	10.2	Capital Costs	216
	10.3	Operating Costs	217
	10.4	Project Evaluation	218
	10.5	•	219
	10.6	Principles of Accounting	220

			Contents	xi
	10.7	Illustrative Open-Ended Problems		221
		Open-Ended Problems		225
	Refere	<del>-</del>		230
11	Plant	Design		233
	11.1	Overview		233
	11.2	Preliminary Studies		235
	11.3	Process Schematics		236
	11.4	Material and Energy Balances		237
	11.5	Equipment Design		238
	11.6	Instrumentation and Controls		240
	11.7	Design Approach		240
	11.8	The Design Report		242
	11.9	Illustrative Open-Ended Problems		243
	11.10	Open-Ended Problems		246
	Refere	ences		250
12	Trans	port Phenomena		253
	12.1	Overview		253
	12.2	Development of Equations		255
	12.3	The Transport Equations		256
		Boundary and Initial Conditions		257
	12.5	Solution of Equations		258
	12.6	Analogies		258
	12.7	Illustrative Open-Ended Problems		262
	12.8	Open-Ended Problems		264
	Refere	ences		267
13	Projec	ct Management		269
	13.1	Overview		269
	13.2	Managing Project Activities		271
	13.3	Initiating		272
	13.4	Planning/Scheduling		273
	13.5	Gantt Charts		275
	13.6	Executing/Implementing		276
	13.7	Monitoring/Controlling		277
	13.8	Completion/Closing		278
	13.9	Reports		279

#### xii Contents

	13.10	Illustrative Open-Ended Problems	280
	13.11	Open-Ended Problems	284
	Refere	ences	291
14	Envir	onmental Management	293
	14.1	Overview	293
	14.2	Environmental Regulations	295
	14.3	Classification, Sources, and Effects of Pollutants	296
	14.4	Multimedia Concerns	297
	14.5	ISO 14000	298
	14.6	The Pollution Prevention Concept	299
	14.7	Green Chemistry and Green Engineering	300
	14.8	Sustainability	301
	14.9	Illustrative Open-Ended Problems	302
	14.10	Open-Ended Problems	309
	Refere	ences	315
15	Envir	onmental Health and Hazard Risk Assessment	317
	15.1	Overview	317
	15.2	Safety and Accidents	319
	15.3	Regulations	320
	15.4	Emergency Planning and Response	321
	15.5	Introduction to Environmental Risk Assessment	322
	15.6	Health Risk Assessment	323
	15.7	Hazard Risk Assessment	326
	15.8	Illustrative Open-Ended Problems	329
	15.9	Open-Ended Problems	333
	Refere	ences	341
16	Energ	y Management	343
	16.1	Overview	343
	16.2	Energy Resources	345
	16.3	Energy Quantity/Availability	346
	16.4	General Conservation Practices in Industry	346
		General Domestic Conservation Applications	347
	16.6	General Commercial Real Estate Conservation	
		Applications	348
	16.7	Architecture and the Role of Urban Planning	349

		Contents	xiii
	16.8 The U.S. Energy Policy/Independence		350
	16.9 Illustrative Open-Ended Problems		352
	16.10 Open-Ended Problems		355
	References		361
17	Water Management		363
	17.1 Overview		363
	17.2 Water as a Commodity and as a Human Righ	nt	365
	17.3 The Hydrologic Cycle		366
	17.4 Water Usage		367
	17.5 Regulatory Status		367
	17.5.1 The Safe Drinking Water Act (SDWA	)	367
	17.5.2 The Clean Water Act (CWA)		369
	17.6 Acid Rain		370
	17.7 Treatment Processes		371
	17.8 Future Concerns		372
	17.9 Illustrative Open-Ended Problems		373
	17.10 Open-Ended Problems		376
	References		381
18	Biochemical Engineering		383
	18.1 Overview		383
	18.2 Enzyme and Microbial Kinetics		385
	18.3 Enzyme Reaction Mechanisms		386
	18.4 Effectiveness Factor		389
	18.5 Design Procedures		391
	18.5.1 Design of a Batch Sterilization Unit		391
	18.5.2 Design of a Continuous Sterilization	Unit	392
	18.5.3 Design of an Air Sterilizer		393
	18.5.4 Scale-Up of a Fermentation Unit		393
	18.6 Illustrative Open-Ended Problems		394
	18.7 Open-Ended Problems		399
	References		403
19	Probability and Statistics		405
	19.1 Overview		405
	19.2 Probability Definitions and Interpretations		407
	19.3 Introduction to Probability Distributions		408

#### xiv Contents

	19.4	Discrete and Continuous Probability Distributions	410
	19.5	Contemporary Statistics	410
	19.6	Regression Analysis (3)	411
	19.7	Analysis of Variance	412
	19.8	Illustrative Open-Ended Problems	413
	19.9	Open-Ended Problems	418
	Refere	ences	425
20	Nano	technology	427
	20.1	Overview	427
	20.2	Early History	429
	20.3	Fundamentals and Basic Principles	429
	20.4	Nanomaterials	430
	20.5	Production Methods	431
	20.6	Current Applications	432
	20.7	Environmental Concerns	433
	20.8	Future Prospects	434
	20.9	Illustrative Open-Ended Problems	436
	20.10	Open-Ended Problems	440
	Refere	ences	443
21	Legal	Considerations	445
	21.1	Overview	445
	21.2	Intellectual Property Law	447
	21.3	Contract Law	448
	21.4	Tort Law	448
	21.5	Patents	449
	21.6	Infringement and Interferences	451
		21.6.1 Infringement	451
		21.6.2 Interferences	451
	21.7	Copyrights	452
	21.8	Trademarks	453
	21.9	The Engineering Professional Licensing Process	454
	21.10	Illustrative Open-Ended Problems	454
	21.11	Open-Ended Problems	457
	Refere	ences	460

$\sim$		
CO	NTENTS	XV

22	Ethic	S	463
	22.1	Overview	463
	22.2	The Present State	464
	22.3	Moral Issues	466
	22.4	Engineering Ethics	467
	22.5	Environmental Justice	468
		22.5.1 The Case For and Against Environmental Justice	469
	22.6	Illustrative Open-Ended Problems	470
	22.7	Open-Ended Problems	473
	Refer	ences	480
Pa	rt III: '	Term Projects	483
23	Term	<b>Projects (2): Applied Mathematics</b>	485
	23.1	Term Project 23.1	486
	23.2	Term Project 23.2	487
	Refer	ences	488
24	Term	Projects (2): Stoichiometry	489
	24.1	Term Project 24.1	490
	24.2	Chemical Plant Solid Waste	493
	Refer	ence	493
25	Term	Projects (2): Thermodynamics	495
	25.1	Estimating Combustion Temperatures	496
	25.2	Generating Entropy Data	496
	Refer	ences	497
26	Term	Projects (6): Fluid Flow	499
	26.1	Pressure Drop - Velocity - Mesh Size Correlation	500
	26.2	Fanning's Friction Factor: Equation Form	500
	26.3	An Improved Pressure Drop and Flooding Correlation	503
	26.4	Ventilation Model I	505
	26.5	Ventilation Model II	506
	26.6	Two – Phase Flow	506
	Refer	ences	507

#### xvi Contents

27	Term	Projects (4): Heat Transfer	509
	27.1	Wilson's Method	510
	27.2	Heat Exchanger Network I	511
	27.3	Heat Exchanger Network II	513
	27.4	Heat Exchanger Network III	514
	Refer	ences	515
28	Term	<b>Projects (5): Mass Transfer Operations</b>	517
	28.1	An Improved Absorber Design Procedure	518
	28.2	An Improved Adsorber Design Procedure	519
	28.3	Multicomponent Distillation Calculations	520
	28.4	A New Liquid-Liquid Extraction Process	523
	28.5	Designing and Predicting the Performance of	
		Cooling Towers	525
	Refer	ences	526
29	Term	<b>Projects (2): Chemical Reactors</b>	529
	29.1	Minimizing Volume Requirements for	
		CSTRs in Series I	530
	29.2	Minimizing Volume Requirements for	
		CSTRs in Series II	531
	Refer	ences	531
30	Term	Projects (4): Plant Design	533
	30.1	Chemical Plant Shipping Facilities	534
	30.2	Plant Tank Farms	535
	30.3	Chemical Plant Storage Requirements	536
	30.4	Inside Battery Limits (ISBL) and Process Flow Approach	538
	Refer	ences	541
31	Term	Projects (4): Environmental Management	543
	31.1	Dissolve The USEPA	544
	31.2	Solving Your Town's Sludge Problem	547
	31.3	Benzene Underground Storage Tank Leak	549
	31.4	An Improved MSDS Sheet	551
	Refer	ences	552

		Cont	ents xvii
32	Term Projects (4): Health and Hazard Risk Assessment		553
	32.1	Nuclear Waste Management	554
	32.2	An Improved Risk Management Program	555
	32.3	Bridge Rail Accident: Fault and Event Tree	
		Analysis	557
	32.4	HAZOP: Tank Car Loading Facility	558
	References		560
33	Term Projects (3): Unit Operations Laboratory Design		
	Projects		561
	33.1	Hand Pump	562
	33.2	Rooftop Garden Bed	563
	33.3	Hydration Station Counter	564
	Reference		566
34	Term Projects (4): Miscellaneous Topics		567
	34.1	Standardizing Project Management	568
	34.2	Monte Carlo Simulation: Bus Section Failures in	
		Electrostatic Precipitators	569
	34.3	Hurricane and Flooding Concerns	570
	34.4	Meteorites	571
	References		573
T 3	Index		

### **Preface**

Chemical engineering is one of the fundamental disciplines of engineering, and contains many practical concepts that have been utilized in the past in countless real-world industrial applications. However, the profession is changing. Therefore, the authors considered writing a text that highlighted open-ended material since chemical engineers in the future will have to be innovative and creative in order to succeed in their careers. One approach to developing the chemical engineer's ability to solve unique problems is by employing open-ended problems. Although the term "open-ended problem" has come to mean different things to different people, it describes an approach to the solution of a problem and/or situation where there is usually not a unique solution. The authors of this text have applied this approach by including numerous open-ended problems in several of their courses. Although the literature is inundated with texts emphasizing theory and theoretical derivations, the goal of this book is to present the subject of open-ended problems from a pragmatic point-of-view in order to better prepare chemical engineers for the future.

This book is the result of much effort from the authors, and has gone through classroom testing. It was difficult to decide what material to include and what to omit, and every attempt was made to offer sufficient chemical engineering course material at a level that could enable chemical engineers to better cope with original and unique problems that will be encountered later in practice. It should be noted that the authors cannot claim sole authorship to all of the essay material in this text. Although much of the material has been derived from sources that both of the authors have been directly involved, every effort has been made to acknowledge material drawn from other sources.

The book opens with an Introduction (Part I) to the general subject of open-ended problems. This is followed by 22 chapters (Part II), each of which addresses a traditional chemical engineering (or chemical engineering related) topic. Each of these chapters contain a brief overview of the subject matter of concern, e.g., thermodynamics, which is followed by three open-ended problems that have been solved by the authors, employing one of the many potential possible approaches to the solution. This is then followed by approximately 30-40 open-ended problems with *no* solutions. A reference section complements the chapter's contents. Part III is concerned with term projects. Twelve chapter topics, including a total of 42 projects, are provided.

It is hoped that the book will describe the principles and applications of open-ended chemical engineering problems in a thorough and clear manner for academic, industrial, and government personnel. Upon completion of the text, the reader should have acquired not only a working knowledge of the principles of chemical engineering, but also (and more importantly) experience in solving open-ended problems. The authors strongly believe that, while understanding the traditional basic concepts is of paramount importance, this knowledge may be rendered virtually useless to future engineers if he/she cannot apply these concepts to unique real-world situations.

Last, but not least, the authors believe that this modest work will help the majority of individuals working and/or studying in the field of engineering to obtain a more complete understanding of chemical engineering. If you have come this far and read through the Preface, you have more than just a passing interest in this subject. The authors strongly suggest that you take advantage of the material available in this book and believe that it will be a worthwhile experience.

January 2015 J. Patrick Abulencia Bronx, NY

Louis Theodore East Williston, NY

## Acknowledgements

The authors were assisted during the preparation of this book by several individuals that we wish to acknowledge. Rita D'Aquino served as our executive editor, and spent many days proofing the manuscript and preparing the index. Colleen Kavanagh and Xi Chu are two Manhattan College students who assisted with preparing the manuscript and figures. The authors are sincerely grateful for all of your contributions.