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and Lioubov Kiwi-Minsker*

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Microstructured Devices for Chemical Processing

WILEY-VCH
Verlag GmbH & Co. KGaA

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Library of Congress Card No.: applied for

British Library Cataloguing-in-Publication Data

A catalogue record for this book is available from the British Library.

Bibliographic information published by the Deutsche Nationalbibliothek

The Deutsche Nationalbibliothek lists this publication in the Deutsche Nationalbibliografie; detailed bibliographic data are available on the Internet at <<http://dnb.d-nb.de>>.

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Print ISBN: 978-3-527-33128-4

ePDF ISBN: 978-3-527-68519-6

ePub ISBN: 978-3-527-68518-9

Mobi ISBN: 978-3-527-68523-3

oBook ISBN: 978-3-527-68522-6

Cover Design Formgeber, Mannheim, Germany

Typesetting Laserwords Private Limited, Chennai, India

Printing and Binding Markono Print Media Pte Ltd., Singapore

Printed on acid-free paper

Contents

Preface *XI*

List of Symbols *XIII*

1	Overview of Micro Reaction Engineering	1
1.1	Introduction	1
1.2	What are Microstructured Devices?	2
1.3	Advantages of Microstructured Devices	2
1.3.1	Enhancement of Transfer Rates	2
1.3.2	Enhanced Process Safety	5
1.3.3	Novel Operating Window	7
1.3.4	Numbering-Up Instead of Scale-Up	7
1.4	Materials and Methods for Fabrication of Microstructured Devices	9
1.5	Applications of Microstructured Devices	10
1.5.1	Microstructured Reactors as Research Tool	11
1.5.2	Industrial/Commercial Applications	11
1.6	Structure of the Book	13
1.7	Summary	13
	References	14
2	Basis of Chemical Reactor Design and Engineering	19
2.1	Mass and Energy Balance	19
2.2	Formal Kinetics of Homogenous Reactions	21
2.2.1	Formal Kinetics of Single Homogenous Reactions	22
2.2.2	Formal Kinetics of Multiple Homogenous Reactions	24
2.2.3	Reaction Mechanism	25
2.2.4	Homogenous Catalytic Reactions	26
2.3	Ideal Reactors and Their Design Equations	29
2.3.1	Performance Parameters	29
2.3.2	Batch Wise-Operated Stirred Tank Reactor (BSTR)	30
2.3.3	Continuous Stirred Tank Reactor (CSTR)	35
2.3.4	Plug Flow or Ideal Tubular Reactor (PFR)	39
2.4	Homogenous Catalytic Reactions in Biphasic Systems	45

2.5	Heterogenous Catalytic Reactions	49
2.5.1	Rate Equations for Intrinsic Surface Reactions	50
2.5.1.1	The Langmuir Adsorption Isotherms	51
2.5.1.2	Basic Kinetic Models of Catalytic Heterogenous Reactions	53
2.5.2	Deactivation of Heterogenous Catalysts	57
2.6	Mass and Heat Transfer Effects on Heterogenous Catalytic Reactions	59
2.6.1	External Mass and Heat Transfer	60
2.6.1.1	Isothermal Pellet	60
2.6.2	Internal Mass and Heat Transfer	69
2.6.2.1	Isothermal Pellet	69
2.6.2.2	Nonisothermal Pellet	77
2.6.2.3	Combination of External and Internal Transfer Resistances	79
2.6.2.4	Internal and External Mass Transport in Isothermal Pellets	79
2.6.2.5	The Temperature Dependence of the Effective Reaction Rate	81
2.6.2.6	External and Internal Temperature Gradient	82
2.6.3	Criteria for the Estimation of Transport Effects	83
2.7	Summary	84
2.8	List of Symbols	86
	References	87
3	Real Reactors and Residence Time Distribution (RTD)	89
3.1	Nonideal Flow Pattern and Definition of RTD	89
3.2	Experimental Determination of RTD in Flow Reactors	91
3.2.1	Step Function Stimulus-Response Method	92
3.2.2	Pulse Function Stimulus-Response Method	93
3.3	RTD in Ideal Homogenous Reactors	95
3.3.1	Ideal Plug Flow Reactor	95
3.3.2	Ideal Continuously Operated Stirred Tank Reactor (CSTR)	95
3.3.3	Cascade of Ideal CSTR	96
3.4	RTD in Nonideal Homogeneous Reactors	98
3.4.1	Laminar Flow Tubular Reactors	98
3.4.2	RTD Models for Real Reactors	100
3.4.2.1	Tanks in Series Model	100
3.4.2.2	Dispersion Model	101
3.4.3	Estimation of RTD in Tubular Reactors	105
3.5	Influence of RTD on the Reactor Performance	107
3.5.1	Performance Estimation Based on Measured RTD	108
3.5.2	Performance Estimation Based on RTD Models	110
3.5.2.1	Dispersion Model	111
3.5.2.2	Tanks in Series Model	112
3.6	RTD in Microchannel Reactors	115
3.6.1	RTD of Gas Flow in Microchannels	117
3.6.2	RTD of Liquid Flow in Microchannels	118
3.6.3	RTD of Multiphase Flow in Microchannels	122

3.7	List of Symbols	126
	References	127
4	Micromixing Devices	129
4.1	Role of Mixing for the Performance of Chemical Reactors	129
4.2	Flow Pattern and Mixing in Microchannel Reactors	136
4.3	Theory of Mixing in Microchannels with Laminar Flow	137
4.4	Types of Micromixers and Mixing Principles	143
4.4.1	Passive Micromixer	144
4.4.1.1	Single-Channel Micromixers	144
4.4.1.2	Multilamination Mixers	146
4.4.1.3	Split-and-Recombine (SAR) Flow Configurations	148
4.4.1.4	Mixers with Structured Internals	149
4.4.1.5	Chaotic Mixing	149
4.4.1.6	Colliding Jet Configurations	150
4.4.1.7	Moving Droplet Mixers	151
4.4.1.8	Miscellaneous Flow Configurations	153
4.4.2	Active Micromixers	154
4.4.2.1	Pressure Induced Disturbances	154
4.4.2.2	Elektrokinetic Instability	155
4.4.2.3	Electrowetting-Induced Droplet Shaking	156
4.4.2.4	Ultrasound/Piezoelectric Membrane Action	156
4.4.2.5	Acoustic Fluid Shaking	157
4.4.2.6	Microstirrers	157
4.4.2.7	Miscellaneous Active Micromixers	158
4.5	Experimental Characterization of Mixing Efficiency	158
4.5.1	Physical Methods	158
4.5.2	Chemical Methods	159
4.5.2.1	Competitive Chemical Reactions	159
4.6	Mixer Efficiency and Energy Consumption	171
4.7	Summary	172
4.8	List of Symbols	173
	References	173
5	Heat Management by Microdevices	179
5.1	Introduction	179
5.2	Heat Transfer in Microstructured Devices	181
5.2.1	Straight Microchannels	181
5.2.2	Curved Channel Geometry	189
5.2.3	Complex Channel Geometries	191
5.2.4	Multichannel Micro Heat Exchanger	191
5.2.5	Microchannels with Two Phase Flow	193
5.3	Temperature Control in Chemical Microstructured Reactors	195
5.3.1	Axial Temperature Profiles in Microchannel Reactors	197
5.3.2	Parametric Sensitivity	201

5.3.3	Multi-injection Microstructured Reactors	212
5.3.3.1	Mass and Energy Balance in Multi-injection Microstructured Reactors	213
5.3.3.2	Reduction of Hot Spot in Multi-injection Reactors	218
5.4	Case Studies	221
5.4.1	Synthesis of 1,3-Dimethylimidazolium-Triflate	221
5.4.2	Nitration of Dialkyl-Substituted Thioureas	222
5.4.3	Reduction of Methyl Butyrate	223
5.4.4	Reactions with Grignard Reagent in Multi-injection Reactor	224
5.5	Summary	226
5.6	List of Symbols	226
	References	228
6	Microstructured Reactors for Fluid–Solid Systems	231
6.1	Introduction	231
6.2	Microstructured Reactors for Fluid–Solid Reactions	232
6.3	Microstructured Reactors for Catalytic Gas-Phase Reactions	233
6.3.1	Randomly Micro Packed Beds	233
6.3.2	Structured Catalytic Micro-Beds	235
6.3.3	Catalytic Wall Microstructured Reactors	238
6.4	Hydrodynamics in Fluid–Solid Microstructured Reactors	239
6.5	Mass Transfer in Catalytic Microstructured Reactors	243
6.5.1	Randomly Packed Bed Catalytic Microstructured Reactors	244
6.5.2	Catalytic Foam Microstructured Reactors	245
6.5.3	Catalytic Wall Microstructured Reactors	246
6.5.4	Choice of Catalytic Microstructured Reactors	253
6.6	Case Studies	255
6.6.1	Catalytic Partial Oxidations	255
6.6.2	Selective (De)Hydrogenations	257
6.6.3	Catalytic Dehydration	259
6.6.4	Ethylene Oxide Synthesis	259
6.6.5	Steam Reforming	260
6.6.6	Fischer–Tropsch Synthesis	261
6.7	Summary	261
6.8	List of Symbols	262
	References	262
7	Microstructured Reactors for Fluid–Fluid Reactions	267
7.1	Conventional Equipment for Fluid–Fluid Systems	267
7.2	Microstructured Devices for Fluid–Fluid Systems	268
7.2.1	Micromixers	269
7.2.2	Microchannels	271
7.2.2.1	Microchannels with Inlet T, Y, and Concentric Contactor	271
7.2.2.2	Microchannels with Partial Two-Fluid Contact	271

7.2.2.3	Microchannels with Mesh or Sieve-Like Interfacial Support Contactors	271
7.2.2.4	Microchannels with Static Mixers	272
7.2.2.5	Parallel Microchannels with Internal Redispersion Units	272
7.2.3	Microstructured Falling Film Reactor for Gas–Liquid Reactions	272
7.3	Flow Patterns in Fluid–Fluid Systems	273
7.3.1	Gas–Liquid Flow Patterns	273
7.3.1.1	Bubbly Flow	273
7.3.1.2	Taylor Flow	274
7.3.1.3	Slug Bubbly Flow	279
7.3.1.4	Churn Flow	279
7.3.1.5	Annular and Parallel Flow	280
7.3.2	Liquid–Liquid Flow Patterns	280
7.3.2.1	Drop Flow	281
7.3.2.2	Slug Flow	281
7.3.2.3	Slug-Drop Flow	282
7.3.2.4	Deformed Interface Flow	282
7.3.2.5	Annular and Parallel Flow	283
7.3.2.6	Slug-Dispersed Flow	283
7.3.2.7	Dispersed Flow	283
7.4	Mass Transfer	284
7.4.1	Mass Transfer Models	285
7.4.2	Characterization of Mass Transfer in Fluid–Fluid Systems	286
7.4.3	Mass Transfer in Gas–Liquid Microstructured Devices	287
7.4.3.1	Mass Transfer in Taylor Flow	287
7.4.3.2	Mass Transfer in Slug Annular and Churn Flow Regime	292
7.4.3.3	Mass Transfer in Microstructured Falling Film Reactors	293
7.4.4	Mass Transfer in Liquid–Liquid Microstructured Devices	296
7.4.4.1	Slug Flow (Taylor Flow)	296
7.4.4.2	Slug-Drop and Deformed Interface Flow	297
7.4.4.3	Annular and Parallel Flow	297
7.4.4.4	Slug-Dispersed and Dispersed Flow	298
7.4.5	Comparison with Conventional Contactors	299
7.5	Pressure Drop in Fluid–Fluid Microstructured Channels	300
7.5.1	Pressure Drop in Gas–Liquid Flow	301
7.5.2	Pressure Drop in Liquid–Liquid Flow	304
7.5.2.1	Pressure Drop – Without Film	304
7.5.2.2	Pressure Drop – With Film	305
7.5.2.3	Power Dissipation in Liquid/Liquid Reactors	307
7.6	Flow Separation in Liquid–Liquid Microstructured Reactors	307
7.6.1	Conventional Separators	308
7.6.2	Types of Microstructured Separators	308
7.6.2.1	Geometrical Modifications	309
7.6.2.2	Wettability Based Flow Splitters	310

7.6.3	Conventional Separator Adapted for Microstructured Devices	315
7.7	Fluid–Fluid Reactions in Microstructured Devices	315
7.7.1	Examples of Gas–Liquid Reactions	317
7.7.1.1	Halogenation	317
7.7.1.2	Nitration, Oxidations, Sulfonation, and Hydrogenation	318
7.7.2	Examples of Liquid–Liquid Reactions	319
7.7.2.1	Nitration Reaction	319
7.7.2.2	Transesterification: Biodiesel Production	320
7.7.2.3	Vitamin Precursor Synthesis	320
7.7.2.4	Phase Transfer Catalysis (PTC)	321
7.7.2.5	Enzymatic Reactions	322
7.8	Summary	323
7.9	List of Symbols	324
	References	325
8	Three-Phase Systems	331
8.1	Introduction	331
8.2	Gas–Liquid–Solid Systems	331
8.2.1	Conventional Gas–Liquid–Solid Reactors	331
8.2.2	Microstructured Gas–Liquid–Solid Reactors	333
8.2.2.1	Continuous Phase Microstructured Reactors	333
8.2.2.2	Dispersed Phase Microstructured Reactors	334
8.2.2.3	Mass Transfer and Chemical Reaction	336
8.2.2.4	Reaction Examples	341
8.3	Gas–Liquid–Liquid Systems	346
8.4	Summary	347
8.5	List of Symbols	347
	References	348
	Index	351

Preface

This book is written based on the potential use of microstructured devices in chemical equipment and the intensification of chemical processes. The term “microstructured devices” is coined based on their characteristic dimensions that are in the submillimeter range and on their different types such as mixers, reactors, heat exchangers, and separators. Owing to the small characteristic dimensions, diffusion times are short and the influence of transport phenomena on the rate of chemical reactions is efficiently reduced. Heat transfer is greatly enhanced compared to conventional systems, allowing a strict control of temperature and concentration gradients leading to an improved product yield and selectivity. In addition, safe reactor operation is possible under unconventional conditions such as high reaction temperatures and reactant concentrations. As a consequence, novel process windows can be opened, but not accessible with traditional systems. Therefore, microstructured devices are versatile tools for the development of sustainable chemical processes.

This book focuses on reaction engineering aspects, such as design and characterization, for homogeneous and multiphase reactions. On the basis of chemical reaction engineering fundamentals, it addresses the conditions under which these devices are beneficial, how they should be designed, and how such devices can be integrated or applied in a chemical process.

Designed as a pedagogical tool with target audience of university students and industrial professionals, it seeks to bring readers with no prior experience of these subjects to the point where they can comfortably enter into the current scientific and technical developments in the area. However, this book does not include the cross-disciplinary subjects such as fabrication techniques of these devices, integration of sensors and actuators, and their use for biological applications.

To facilitate comprehension, the topics are developed beginning with fundamentals in chemical reaction engineering with ample cross-referencing. The understanding of concepts is facilitated by clear descriptions of examples, supplied by exercises including solutions, and provided by figures and illustrations.

Finally, the authors want to highlight the complexity of microreaction engineering in particular. Therefore, this book must be viewed as a tool for stimulation of novel and meaningful solutions for the complex chemical reaction realities. It is also important to note that the growing interests and complementary developments of this subject require periodic updates.

Lausanne, Switzerland
May 2014

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List of Symbols

Commonly Used Symbols

This is a list of commonly used symbols. Besides, there are some special symbols used for each chapter which are listed chapterwise.

Symbols	Significance	Unit
A	Exchange or surface area	m^2
a	Specific interfacial area or catalytic surface area per reactor volume	$\text{m}^2 \text{m}^{-3}$
A_{cs}	Cross-section area	m^2
Bo	Bond number	—
Bo	Bodenstein number	—
Bi_m, Bi_{th}	Biot number (mass), Biot number (thermal)	—
C	Dimensionless concentration	—
Ca	Capillary (=) or Carberry (=) number	—
c_i	Concentration of molecule A_i	mol m^{-3}
c_p	Heat capacity of fluid or mixture	$\text{J kg}^{-1} \text{K}^{-1}$
DaI	First Damköhler number	—
$DaII$	Second Damköhler number	—
$DaII_{\text{mx}}$	Second Damköhler number for mixing	—
D_{ax}	Axial dispersion coefficient	$\text{m}^2 \text{s}^{-1}$
De	Dean number	—
D_{eff}, D_m	Effective molecular diffusion coefficient, molecular diffusion coefficient	$\text{m}^2 \text{s}^{-1}$
d_h	Hydraulic diameter	m
d_t	Diameter of channel (or tube)	m
E, E_a	Intrinsic activation energy, apparent activation energy of reaction j	J mol^{-1}
f	Ratio of residual concentration to initial	—
$ Fo$	Fourier number	—
g	Gravitational acceleration	$\text{m}^2 \text{s}^{-1}$
H	Height	m

(continued overleaf)

Symbols	Significance	Unit
h	Heat transfer coefficient	$\text{W m}^{-2} \text{K}^{-1}$
Ha	Hatta number	—
J_i	Molar flux of species i	$\text{mol m}^{-2} \text{s}^{-1}$
k, k_p, k_j	Reaction rate constant for homogeneous and quasi-homogenous, constant of heterogenous reaction, constant of reaction j	variable (s^{-1} $(\text{mol m}^{-3})^{-(n-1)}$)
k_0	Pre-exponential or frequency factor	variable (s^{-1} $(\text{mol m}^{-3})^{-(n-1)}$)
K_C	Reaction equilibrium constant	variable
K	thermodynamic equilibrium constant	—
k_G	Mass transfer coefficient in gas phase	m s^{-1}
k_{GL}	Mass transfer coefficient in gas–liquid system	m s^{-1}
k_L	Mass transfer coefficient in liquid phase	m s^{-1}
$k_L a$	Volumetric mass transfer coefficient	s^{-1}
k_m	Mass transfer coefficient of heterogeneous reactions	m s^{-1}
k_{ov}	Overall mass transfer coefficient	m s^{-1}
L, L_c, L_e, L_t	Length, characteristic length, length of entrance zone, length of tube or channel	m
\dot{m}	Mass flow rate	kg s^{-1}
Nu	Nusselt number	—
n_i	Reaction order with respect to species A_i	—
n	Overall reaction order	—
n_i	No of moles of molecule A_i	mol
\dot{n}_i	Molar flow rate of molecule A_i	mol s^{-1}
p	Pressure	Pa
P_i	Rate of production	mol s^{-1}
Pr	Prandtl number	—
Pe	Péclet number	—
Q	Energy	J
\dot{Q}	Rate of heat flow	W
$\dot{q}, \dot{q}_r, \dot{q}_{ex}$	Specific heat rate, of reaction, of heat exchange/transfer	$\text{J m}^{-3} \text{s}^{-1}$
R	Ideal gas law constant	$\text{J mol}^{-1} \text{K}^{-1}$
R	Radius	m
Re	Reynolds number	—
R_i	Overall reaction/transformation rate of molecule A_i	$\text{mol m}^{-3} \text{s}^{-1}$
r_j, r_{eff}	Rate of reaction/transformation of reaction j , effective reaction rate	$\text{mol m}^{-3} \text{s}^{-1}$
$r_{\text{ads}}, r_{\text{des}}$	Rates of adsorption, of desorption	—
$S_{k,i}$	Selectivity of product k with respect to reactant i	—
$s_{k,i}$	Instantaneous selectivity of product k with respect to reactant i	—
Se	Semenov number	—

Symbols	Significance	Unit
Sc	Schmidt number	—
Sh	Sherwood number	—
T, T_b, T_s	Temperature, bulk temperature, surface temperature	K
$t, t_c, t_D, t_r, t_m,$ $t_{mx}, t_{ax}, t_{D, ax},$ $t_{D, rad}$	Time, characteristic cooling time, diffusion time, reaction time, mass transfer time, mixing time, axial dispersion time, axial molecular diffusion time, radial diffusion time	s
\bar{t}	Mean residence time	s
U	Overall heat transfer coefficient	$W m^{-2} K^{-1}$
U_i	Internal energy	J
U_v	Overall volumetric heat transfer coefficient	$W m^{-3} K^{-1}$
$u, u_b, u(r),$ u_G, u_L	Superficial velocity, velocity of gas bubble (slug), velocity at radial position r , superficial flow velocity of gas phase, superficial velocity of liquid phase	$m s^{-1}$
V, V_R	Volume, internal (reaction) volume	m^3
\dot{V}	Volumetric flow rate	$m^3 s^{-1}$
W	Width	m
$\dot{W}, \dot{W}_f, \dot{W}_s$	Rate of work done, by flow, by shaft	$J s^{-1}$
X	Conversion	—
$Y_{k,i}$	Yield of product k with respect to reactant i	—
Z	Dimensionless length	—
z	Length	m
<i>Greek symbols</i>		
α	Thermal diffusivity	$m^2 s^{-1}$
β	Prater number	—
$\delta(z)$	Dirac pulse	—
δ	Film thickness, catalytic layer or boundary layer	m
γ	Arrhenius number	—
$\dot{\gamma}$	Shear rate	s^{-1}
Δ	Symbol of difference	—
ΔG	Gibbs free energy	$J mol^{-1}$
$\Delta H_r, \Delta H_a$	Heat of reaction, heat of adsorption	$J mol^{-1}$
Δp	Pressure drop	Pa
ΔS	Entropy	$J mol^{-1} K^{-1}$
ΔT_{ad}	Adiabatic temperature rise	K
ε	Specific power dissipation	$W kg^{-1}$
$\varepsilon_p, \varepsilon_{bed}$	Porosity of catalyst pallet, of randomly packed bed	—
η	Efficiency factor	—
θ	Dimensionless time	—
$\lambda, \lambda_{eff}, \lambda_p,$ λ_{wall}	Thermal conductivity, effective, of fluid, of wall	$W m^{-1} K^{-1}$

(continued overleaf)

Symbols	Significance	Unit
μ	Dynamic viscosity	Pa s
ν	Kinematic viscosity	$\text{m}^2 \text{s}^{-1}$
$\nu_{i,j}$	Stoichiometric coefficient of species i in reaction j	—
ζ	Geometric factor	—
ρ	Density	kg m^{-3}
σ	Interfacial tension	N m^{-1}
$\tau, \tau_{\text{PER}}, \tau_R$	Residence time, of plug flow reactor, of reactor, residence time referred to reaction volume	s

Common Indices

Subscript

0	Initial value
∞	Asymptotic or infinite value
app	Apparent or observed
av	Average
Ax	Axial
b	Bulk
c	Cooling
cap	Hemispherical cap
cat	Catalyst
eff	Effective
eq	Equilibrium
ex	External
film	Wall film
gen	General
I	Phase I
II	Phase II
in	Inlet
max	Maximum
min	Minimum
out	Outlet
op	Optimum
ov	Overall
P	Pallet
s	Surface
v	Volumetric

Superscript

0	Values at standard conditions
---	-------------------------------

Dimensionless Numbers

Dimensionless number	Significance	Definition
Adiabatic temperature rise	Property of reaction mixture, represent temperature rise in worst case and is independent of reactor type/reaction rate	$\Delta T_{ad} = \frac{(-\Delta H_r)cb}{\rho c_p}$
Arrhenius number	Relative importance of activation temperature (E/R) to system bulk temperature (T_b)	$\gamma = \frac{E}{RT_b}$
Biot number (mass)	Relates external mass or heat transfer rates at catalyst pellet surface to diffusion or conduction inside the pellet	$Bi_m = \frac{tD}{t_m} = \frac{L_c^2 k_m a_p}{D_e}$
Biot number (thermal)		$Bi_{th} = \frac{h \cdot L}{\lambda_e}$
Bodenstein number	Ratio of convective transport rate to (axial) diffusion transport rate	$Bo = \frac{u \cdot L}{D_{ax}}$
Carberry number	It gives effective reaction rate over mass transfer rate in catalytic reactions where no internal (pellet) mass and heat transfer resistances are considered	$Ca = \eta_{ex} DaII$
Capillary number	Used in fluid–fluid systems. It is ratio of viscous forces to <i>surface tension</i> acting across an interface, that is, interfacial tension	$Ca_i = \frac{u_b \cdot \mu_i}{\sigma}$
First Damköhler number	Used to set design criteria – ratio of residence time in the reactor to the characteristic reaction time	$DaI = \frac{\tau}{t_r}$
Second Damköhler number	Used to set design criteria – ratio of reaction rate to mass transfer rate	$DaII = \frac{t_m}{t_r}$
Second mixing Damköhler number	Used to set design criteria – ratio of reaction rate to mixing rate	$DaII_{mx} = \frac{t_{mx}}{t_r}$
Dean number	Used to characterize the flow in curved channels – it is product of Re and square root of channel diameter to curvature radius	$De = Re \left(\frac{d_{ch}}{R''} \right)^{0.5}$
Efficiency factor (fluid–fluid system)	Ratio of effective reaction rate and the maximal rate referred to the reactor volume corresponding to the maximum concentration in the reacting phase	$\eta = \frac{r_{eff}}{r_{max}}$
Effectiveness factor (porous catalyst)	Ratio of effective reaction rate and the rate of reaction at bulk concentration and temperature	$\eta_p = \frac{J_s^{eff}}{J_s} = \frac{D_e c_s / L \cdot \varphi \tanh(\varphi)}{k_p c_s L} = \frac{\tanh \varphi}{\varphi}$

(continued overleaf)

Dimensionless number	Significance	Definition
Effectiveness factor (mass transfer) or trade-off index	Used to access mass transfer performance with energy input	$\eta_m = \frac{DaI_m}{Eu} = \frac{k_m a_R \cdot L}{u_s} \cdot \frac{\rho \cdot u_s^2}{\Delta p}$
Euler number	It is ratio of pressure drop in a given reactor length to kinetic energy.	$Eu = \frac{\Delta p}{\rho \cdot u^2}$
Fourier number	It is ratio of residence time to diffusion time	$Fo = \frac{\tau}{t_D}$
Hatta number	Used for fluid–fluid systems and signifies whether the reaction takes place in the bulk or near the interface (of reaction phase). It is ratio of reaction rate to interfacial mass transfer rate	$Ha = \sqrt{\frac{t_{im}}{t_r}} = \delta_{II} \sqrt{\frac{k'_r}{D_{i,II}}} = \frac{\sqrt{k'_r D_{i,II}}}{k_{L,II}}$
Nusselt-number	Use to characterize relative importance of convective heat transfer over conductive heat transfer	$Nu = \frac{h \cdot d_h}{\lambda}$
Peclet number	Ratio of rate of convection to rate of diffusion/dispersion	$Pe_{ax} = \frac{u \cdot d_t}{D_{ax}} \text{ (tube)}$ $Pe_{ax} = \frac{u \cdot d_p}{\epsilon_{bed} D_{ax}} \text{ (packed bed)}$
Prandtl number	Used to characterize momentum and heat diffusion – ratio of momentum (viscous) diffusion to molecular diffusion	$Pr = \frac{\nu}{\alpha} = \frac{\nu}{\lambda / (\rho c_p)}$
Prater number	Ratio of maximum temperature difference catalyst center and surface temperature to the surface temperature	$\beta = \frac{\Delta T_{max}}{T_s} = \frac{(-\Delta H_r) c_s D_c}{T_s \lambda_e}$
Reynolds number	Most commonly used to characterize the fluid flow – gives relative importance of inertial forces over viscous forces	$Re = \frac{\rho u d_t}{\mu}$
Reynolds number (particle)		$Re_p = \frac{(u \cdot d_p)}{\nu}$
Reynolds number (foam)		$Re_{foam} = \frac{u \cdot d_s \cdot \rho}{\mu}$
Schmidt number	Used to characterize momentum and mass diffusion – ratio of momentum (viscous) diffusion to molecular diffusion	$Sc = \frac{\nu}{D_m}$
Sherwood number (particle)	Use to characterize relative importance of convective mass transfer over diffusional mass transfer	$Sh_p = \frac{d_p k_m}{D_m}$
Sherwood number		$Sh = \frac{k_m \cdot d_h}{D_m}$

Dimensionless number	Significance	Definition
Thiele modulus	Ratio of characteristic diffusion time in the catalyst and the characteristic reaction time	$\varphi^2 = \frac{t_D}{t_r} = \frac{L^2}{D_e} k$ $\varphi = L \sqrt{\frac{k_r}{D}}; \text{ first order reaction;}$ $\varphi_{\text{gen}} = \frac{V_p}{A_p} \sqrt{\frac{k_r c_s^{(n-1)}}{D_e}} \cdot \sqrt{\frac{n+1}{2}}$
Weisz modulus	Used to measure influence of transport process on reaction kinetics experimentally – ratio of effective reaction rate to (effective) diffusion rate	$\psi_s^2 = \frac{t_D}{t_{r,\text{eff}}} = \frac{R_{\text{sphere}}^2}{D_e} \frac{c_s}{r_{p,\text{eff}}} = \eta_p \varphi_s^2$ $\psi_{\text{gen}}^2 = \frac{t_D}{t_{r,\text{eff}}} = \left(\frac{V_p}{A_p} \right)^2 \frac{n+1}{2} \frac{r_{p,\text{eff}}}{D_e c_s} = \eta_p \varphi_{\text{gen}}^2$
Bond number	Relates body forces to surface tension forces	$BO = \frac{\rho g d_h^2}{\sigma}$
First Damköhler number (mass transfer)	Ratio of residence time in the reactor to the characteristic mass transfer time	$DaI_m = \frac{\sigma}{t_m} = \frac{k_m a_R L}{u}$

Abbreviations

BSTR	Batchwise-operated stirred tank reactor
CSTR	Continuously-operated stirred tank reactor
CVD	Chemical vapor deposition
LIGA	Lithography, galvanization, and molding
MASI	most abundant surface intermediate
MSR	Microstructured reactors
PFR	Plug flow reactor
PRL	Power rate law
PVD	Physical vapor deposition
RTD	Residence time distribution
SMF	Sintered metal fiber
SLPC	Supported liquid phase catalyst
SCR, SAR, SHR	Serpentine channel reactor, split and recombine reactor, staggered herringbone reactor