

Chapter 3 Separation Processes (Unit operations)

(Refs: Geankoplis, Chapter 1 for an overview and other chapters for various separation processes; Doran: Cht 10 Unit operations. Earle: Unit Operations in Food Processing: <http://www.nzifst.org.nz/unitoperations/>).

1. Introduction

In most chemical and biochemical production processes, the desired product (s) from chemical and bioreactors is (are) in a mixture with other components, such as unconverted reactants, by-products and others required for the reaction such as catalysts, and the components of solvent or reaction media. Therefore, separation is needed to attain the products in desired purity and form.

The term "**unit operation**" has been used in the chemical industry and chemical engineering textbooks for a long time to refer to the various separation processes for the recovery and purification of products. So named is because that these separation processes can be viewed as separate and distinct steps or units in a production process, and a given unit operation will have the same principles and basic operations in different production processes. Nowadays, **separation processes** are more widely used than unit operations, especially in biotechnology. Among the common separation processes are evaporation, distillation, absorption, crystallization, filtration, centrifugation, drying and membrane processes. Separation processes are primarily based on physical means and some on physico-chemical means.

This chapter is to introduce the general concepts of separation technology and some common separation processes in chemical and bioprocess technology.

2. General concepts and characteristics of separation processes

Separation of components in a mixture is always based on the **difference** in a physical property among the mixture components. Based on the nature or physical mechanism of separation, various **separation processes can be classified into**,

- 1) *Mechanical separations*: separations based on size and/or density differences of different components in a mixture, for separation of solid from liquid (e.g. filtration and centrifugation).
- 2) *Diffusional separations (mass transfer operations)*: separations based on molecular movement toward a favourable phase, for separation of dissolved components (e.g. distillation, absorption, extraction). (Note: Mass transfer is the transfer of solute molecules from one point to another or from one phase to another.)
- 3) *Membrane separations*: use of a *semipermeable* membrane to **separate molecules** with difference in size or some other properties.

Phase equilibrium relationships are the theoretical bases for most separation processes depending on mass transfer between phases (in 2: all classified as *contact-equilibrium* processes). **Phase equilibrium** is a thermodynamic state established between two (or more) phases. For a multiple component system, at equilibrium, the concentrations of all components in each phase no longer change, and the distribution of components in the two phases is completed and will be maintained. The equilibrium state (and concentrations) may change with temperature, pressure and composition.

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Table of Contents Chapter 3 Separation Processes Unit Operations

1. Understanding the eBook Chapter 3 Separation Processes Unit Operations
 - The Rise of Digital Reading Chapter 3 Separation Processes Unit Operations
 - Advantages of eBooks Over Traditional Books
2. Identifying Chapter 3 Separation Processes Unit Operations
 - Exploring Different Genres
 - Considering Fiction vs. Non-Fiction
 - Determining Your Reading Goals
3. Choosing the Right eBook Platform
 - Popular eBook Platforms
 - Features to Look for in an Chapter 3 Separation Processes Unit Operations
 - User-Friendly Interface
4. Exploring eBook Recommendations from Chapter 3 Separation Processes Unit Operations
 - Personalized Recommendations
 - Chapter 3 Separation Processes Unit Operations User Reviews and Ratings
 - Chapter 3 Separation Processes Unit Operations and Bestseller Lists
5. Accessing Chapter 3 Separation Processes Unit Operations Free and Paid eBooks
 - Chapter 3 Separation Processes Unit Operations Public Domain eBooks
 - Chapter 3 Separation Processes Unit Operations eBook Subscription Services
 - Chapter 3 Separation Processes Unit Operations Budget-Friendly Options

6. Navigating Chapter 3 Separation Processes Unit Operations eBook Formats
 - ePub, PDF, MOBI, and More
 - Chapter 3 Separation Processes Unit Operations Compatibility with Devices
 - Chapter 3 Separation Processes Unit Operations Enhanced eBook Features
7. Enhancing Your Reading Experience
 - Adjustable Fonts and Text Sizes of Chapter 3 Separation Processes Unit Operations
 - Highlighting and Note-Taking Chapter 3 Separation Processes Unit Operations
 - Interactive Elements Chapter 3 Separation Processes Unit Operations
8. Staying Engaged with Chapter 3 Separation Processes Unit Operations
 - Joining Online Reading Communities
 - Participating in Virtual Book Clubs
 - Following Authors and Publishers Chapter 3 Separation Processes Unit Operations
9. Balancing eBooks and Physical Books Chapter 3 Separation Processes Unit Operations
 - Benefits of a Digital Library
 - Creating a Diverse Reading Collection Chapter 3 Separation Processes Unit Operations
10. Overcoming Reading Challenges
 - Dealing with Digital Eye Strain
 - Minimizing Distractions
 - Managing Screen Time
11. Cultivating a Reading Routine Chapter 3 Separation Processes Unit Operations
 - Setting Reading Goals Chapter 3 Separation Processes Unit Operations
 - Carving Out Dedicated Reading Time
12. Sourcing Reliable Information of Chapter 3 Separation Processes Unit Operations
 - Fact-Checking eBook Content of Chapter 3 Separation Processes Unit Operations
 - Distinguishing Credible Sources
13. Promoting Lifelong Learning
 - Utilizing eBooks for Skill Development
 - Exploring Educational eBooks
14. Embracing eBook Trends
 - Integration of Multimedia Elements

- Interactive and Gamified eBooks

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