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New Jersey Institute of Technology

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SEPARATION VIA MULTI-COLUMN PH PARAMETRIC PUMPING

by

Wei Tai Yang

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A Dissertation submitted to the Faculty of the Graduate School of the New Jersey Institute of Technology in partial fulfillment of the requirements for the degree of Doctor of Engineering Science 1981

APPROVAL SHEET

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Name of Candidate: Wei Tai Yang

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Thesis and Abstract Approved:

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ABSTRACT

Title of Thesis: SEPARATION VIA MULTI-COLUMN pH PARAMETRIC PUMPING Wei Tai Yang, Doctor of Engineering Science, 1981 Thesis directed by: Professor H. T. Chen

This thesis presents the study of multi-column pH parametric pumping, a separation technique which applies the principle of parametric pumping and uses pH as control variable. Studies emphasize the mass transfer and the capability of separation by multi-column pH parametric pumping. Many operation modes of multi-column pH parapump are developed for varied objectives of Two-pH Levels Parapump is capable of enriching separation. Α the product stream with solute components; a Three-pH Levels Parapump is capable of splitting components into two product The separation capability of multi-column parapump is streams. greatly superior to that of single-column parapump. As compared to cycling zone operation, parametric pumping gives a higher separation factor.

Hemoglobin and albumin are chosen for the experimental model system to demonstrate the separation capability of multi-column pH parametric pumping, and to verify the predictability of the models. Presented are the theoretical basis, mathematical models and methods, results of experimental studies and computer exploration, and the correlation of data with models.

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Chapter 1: Introduction

Human beings have been interested in separation principles and techniques. Thousands of years ago, separation techniques had already been applied to purify metals. In modern technology, separation has been one of the most common operations in chemical engineering application and research.

1.1: Principle of Separation

In general, separation is a process to separate components from a mixture without involving chemical reaction. The general exception is the separation by an ionic exchanger, in which a change of chemical bond between resin-counter ion and resin-solute occurs. Separation is a reverse process of mixing, which is, in the thermodynamic sense, 'sharing and spreading of available space in a system'. In most cases, mixing occurs naturally with an increase of total entropy of the system, while separation is not naturally occuring since a decrease of total entropy of the system is associated with separation.

The separation techniques most often used in chemical engineering technology are the following: distillation, adsorption, crystallization, sedimentation, filtration, extraction, and the newly developed processes such as pressure

swing adsorption, membrane separation, et cetera. Table 1 summarizes the characteristics of the most common separation processes. The separation process is analyzed with respect to its separation basis, driving force, main parameter affecting the separation basis, and the phases involved in separation process. Separation bases are the distinct properties among the components such as volatility and density. The driving force can be any force or field such as gravity field, electric field, or pressure drop. By appropiate control of the main parameter, which affects the separation basis, it is possible to enhance separation. Take distillation for an example, a separation is based on the difference in volatility of components and is caused by phase Temperature affects the volatility and eventually the change. separation, and it is possible to apply a temperature gradient on system to obtain the multiple equilibrium the stages operation(i.e. fractionation).

It is seen that the requirements for a separation process are (1) two distinct phases, (2) available separation basis, (3) available driving force. It is also seen that the control parameters are the process variables which primarily affect the separation basis. 2

TABLE 1. SEPARATION PROCESS

PROCESS	SEPARATION BASIS	DRIVING FORCES	MAIN PARAMETER AFFECT S.B.	PHASES	INV	OLVED
					2	
DISTILLATION	VOLATILITY	PHASE CHANGE	TEMPERATURE	G	L	
EVAPORATION	VOLATILITY	PHASE CHANGE	TEMPERATURE	G	L	
ADSORPTION	ADSOR BILITY	MOLECULAR FORCES	PRESSURE TEMPERATURE	F	S	
FILTRATION	PERMEABILITY	PRESSURE DROP	FLOW CHARAC- TERISTICS	F	S	(NMT)
SEDIMENTA- TION	DENSITY	GRAVITY		L	S	(NMT)
CRYSTALLI- ZATION	SOLUBILITY	PHASE CHANGE	TEMPERATURE	L	S	
ELECTROPHO- RESIS	MOBILITY	ELECTRIC FIELD	TEMPERATURE	L	L	
IONIC EXCHANGER	IONIC CHARGE	ELECTRIC FIELD	PH, IONIC STRENGTH	L	S	
PARAMETRIC PUMPING	ANY DISTINCT CHARACTERISTIC	ANY FORCE	THERMO. VARIABLI AFFECT S.B.	E F	S	

F: FLUID, G: GAS, L: LIQUID, S: SOLID NMT: NO MASS TRANSFER BETWEEN PHASES

.

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1.2: Principle of Parametric Pumping

The principle of parametric pumping was first introduced by the late R. H. Whilhem ^[30]. The separation principle is based periodic alternation of the control variable (such as (1)on pressure or temperature) to induce the interface mass transfer, coupling of interphase mass transport action with the and (2) bulk fluid flow displacement. The bottom row of Table 1 shows the separation principle of parametric pumping. As in the conventional separation processes, the above three requirements for separation have to be satisfied in order to obtain separation. The operation of parametric pumping (also called Parapump) is not restricted to any single process with any particular separation basis, neither a specific driving force nor a control variable. So parametric pumping is a separation principle rather than a separation process. For example, the principle has been applied to thermal, pressure, and pH parametric pumping, listed on Table 2. Thus parametric as pumping is a separation principle, while the thermal, pressure, and pH parametric pumping are separation processes that follow the principle of parametric pumping. Figure 1.1 shows the schematic device of pH parapump.

The differences between parametric pumping and the conventional phase exchange separation operation are grouped into two catergories: (1) the relative motion reverses periodically in





TABLE 2. PARAMETRIC PUMPING : PRINCIPLE & APPLICATION

- A SEPARATION PRINCIPLE BASED ON
- (1) PERIODIC CHANGE OF CONTROL VARIABLES.
- (2) SYNCHRONOUS COUPLING OF THE ALTERNATING VELOCITY WITH

INTERPHASE FLUX.

•

.

TYPE OF P.P.	CONTROL VARIABLE	SYSTEM EXAMPLE
THERMAL PARAMETRIC PUMPING	TEMPERATURE	N-HEPTANE - TOLUENE
PRESSURE PARAMETRIC PUMPING	PRESSURE	NORMAL-BRANCHED HYDROCABON
PH PARAMETRIC PUMPING	PH	HEMOGLOBIN ALBUMIN

•

parametric pumping, while the relative motion between phases is unidirectional in a conventional process. (2) The state variables (concentration, temperature, etc.) vary periodically with time in parametric pumping, while it is constant with respect to time at steady state in other continuous processes. These differences are intrinsic to the fact of coupling transport action with the periodic alternation of the control variables in parametric pumping.

Parametric pumping can be classified into two categories, based on the method of variation of process variables. (1) Direct Mode: The control variable in the entire column is changed simultaneously with the change of fluid flow direction. One example is heat introduced or removal from the wall of the entire column in thermal parametric pumping. (2) Recuperative Mode: The control variable is changed gradually from one end to the other of a column after the change of fluid flow direction. One example is to introduce hot fluid into the top of a column at the first half operation cycle, and cold fluid into the bottom of column at the next half operation cycle for thermal parametric pumping.

1.3: Parametric pumping literature review

During the last 2 decades, a number of investigations have

been done on parametric pumping. Separation of NaCl-Water system has been reported by Whilhem et al.^[29,30] and Gregory^[15]. Separation of Benzene-Hexane system has been reported by Wakao et al.^[26], Toluene-n-Heptane by Whilhem^[32] and Chen^{[5, 6, ^{7]}. Separation of Fructose-Glucose has been reported by Chen et al.^[8]. Separation of Albumin-Hemoglobin has been reported by Chen et al.^[9, 10, 11, 12, 13].}

One branch of pressure parametric pumping is better known by the name of Pressure Swing Adsorption. This process has been widely applied and commercialized in the separation of gas Separation of normal-branched paraffin has systems. been Breck^[3] and Union Carbide^[18]. Hydrogen by reported Skarstrom^[24] by purification been reported and has Weaver^[29].

Cycling Zone is another separation technique which is very similar to parametric pumping. The separation philosophy of cycling zone is almost the same as parametric pumping, except that the fluid flow is unidirectional in the former but reciprocating in the latter. As in parametric pumping, the separation of cycling zone is caused by a periodic alternation of the process control variables in a column. This alternate process was developed by Pigford. Work in this area has been reported by Baker^[1], Blum^[2], Busbice^[4], Dore^[14], Figford^[20], Gupta & Sweed^[16], Vlist^[25], Latty^[17], and Wankat^[27, 28].

1.4: Introduction of Contents

Most of earlier work in this area has been devoted to thermal-parametric pumping. On the contrary very little work has been done for pH parametric pumping. Most earlier work was done for a single column parametric pumping on a simple system. This thesis includes the single column P.P. for single component systems and multicomponent systems, and extends to multi-column pumping operation. Presented also are the study of parametric cycling zone, and the comparison of cycling zone with parametric pumping.

Several mathematical models and techniques have been employed to solve the parametric pumping equation and to study the separation and characteristics of pH parametric pumping. Methods included are a graphical method, an analytical solution, and the Stop and Go numerical method. Both equilibrium theory and nonequilibrium theory(finite mass transfer) have been applied to study parametric pumping.

Studies presented here are the theoretical basis, theoretical exploration results, and the experimental results for pH parametric pumping. A series of experiments studied on example systems(separation of albumin-haemoglobin liquid mixture using a Sepahrose cation and anion exchanger resin adsorbent) is carried out to verify the theoretical results. These experiments demonstrate the separation by parametric pumping and cycling zone, and also confirm the models predictive ability. Portions of this thesis have appeared in papers by Chen & Yang et al.^[11, 12, 13] Chapter 2 : Protein System and pH Parametric Pumping

2.1 : Adsorption Equilibrium

Adsorption is conventionally classified into two groups, namely, Physical Adsorption, and Chemical Adsorption. The adsorption equlibrium is strongly dependent on the thermodynamic intensive variable, such as , pH, ionic strength, temperature, and pressure. Qualitatively, physical adsorption is dependent on pressure and temperature, chemical adsorption is sensitive to temperature, and ionic exchanger adsorption is mainly dependent on the charges of molecules and the concentration of the counter ions. One of the typical quantitative treatments of adsorption equilibrium has been reported by Langmuir. In Langmuir modeling, the tendency of bonding between fluid molecule with solid surface is said to be equal to the tendency of debonding of fluid molecules from the solid surface when equlibrium is established. The Langmuir equilibrium can be written as the following equations.

$$Ka \cdot C \cdot [Csm - Cs] = Kd \cdot Cs \qquad (2.1)$$

where Ka :bounding constant Kd :debounding constant C :concentration in fluid phase Cs :concentration in solid phase

Csm:maximum concentation for solid phase

The constants of Ka,Kd,Csm are dependent on the system of interest. Equation (2.2) states that the concentration of the solid phase is nonlinearly increased with the concentration of the fluid phase, when the (Ka/Kd) •C is close to the order of solid phase concentration is a constant equal to The unity. (Ka/Kd) *Csm, when (Ka/Kd) *C is much than unity. larger The concentration in the solid phase is linear to the concentration of the fluid phase with a proportional constant(Ka/Kd).Csm, when (Ka/Kd) • C is much larger than unity. Chemical adsorption is usually well described by the Langmuir equilibrium.

The model system chosen in this thesis is Hemoglobin and Albumin mixture in buffer solution, and an ionic exchanger is used as the adsorbent. Since the ionic exchanger adsorption is classified in the group of chemical adsorption, Langmuir equilibrium is applicable in this model system. The concentration of protein solute in the feed solution is very low in this thesis. Feed concentration ranges from 0.01% to 0.02% by weight for hemoglobin and albumin, the corresponding molarity is $(1 \cdot 10^{-5})$ mole/liter. about Thus the linear equilibrium relation is applicable without introducing large error in this range of concentration.

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2.2 : Important Properties of Proteins in pH Parametric Pumping

The proteins are built from amino-acid. The amino group, -NH2, and the carboxyl group, -COOH, have an ability of binding and losing hydronium ions. In low pH solution, the hydronium ions are more concentrated and are more likely to bind with amino groups and carboxyl groups; at high pH, hydronium ions are less concentrated and are more likely to dissociate from the carboxyl group and amino groups. Figure 2.1 schematically shows the effect of pH on protein structure. At a certain pH the total positive charges equal to the total negative charges in a protein molecule and the net total charge of the molecule is zero. This pH is called the Isoelectric Point. When the pH is lower than the Isoelectric Point, the predominant protein molecules have a positive net charge. When the pH is higher than the Isoelectric point , the predominant protein molecules have a negative net charge.

+	+	
NH	NH	NH
3	3	2
	-	-
PC00H	PC00	PC00

pH < I.E.

pH = I.E.

pH > I.E.

Figure 2.1

13

Hemoglobin and Albumin are chosen as a model system in this thesis. Some of their physical properties are available from the literature and are listed in Table 3.

m .	٦.	7	_	2
та	D	Т	e	

Species	Mwt	I.E.	Dm	V-403	UV-595
Hemoglobin	63,000 - 68,000	6.7	-7 6.9*10	1.00	0.35
Albumin	69,000 - 72,000	4.9	-7 6.0*10	0.00	0.35
* adsorba unit	ance read refference for wave length = m	taken as u	$\begin{array}{rcl} H & O &= & O \\ & 2 \end{array}$		
Mwt : mo	lecular weight				
I.E.: iso	pelectric point				
Dm : mas	ss diffusivity =cm /	sec			

As shown in the above table, the molecular weights of hemoglobin and albumin are very close to each other, and thus separation methods based on molecular size will not be useful to separate hemoglobin and albumin. Since the difference in isoelectric point for these two component is about 2., we may take the advantage of this difference in isoelectric point as the separation basis in parametric pumping.

Since we know that the protein molecule consists of many charged groups, such as amino groups and carboxyl groups, an ionic exchanger will work as a good adsobent for protein molecules. For example, the cation exchanger can exchange cations with positively charged molecule as:

and the anion exchanger can exchange anions with negatively charged molecule as:

The above exchange process is actually a mass transfer of protein from liquid phase to solid phase. The protein adsorption by an ionic exchanger is reversible. The protein may be exchanged back to fluid phase by using excess counter ions, or by changing the net charges on the protein molecule, which will reduce the bonding stability. For example, if R^--P^+ stands for the protein adsorbed by cation the ion exchanger at a pH lower than its isoelectric point, when the solution changes pH to a value higher than its isoelectric point, the protein increases its negative charges and the net charges of protein will be negative. The bonding is weakened and protein has a higher tendency to be replaced by a counter ion and goes back to the fluid phase; thus the mass transfer from solid phase to liquid phase is achieved. The above information gives the idea of protein separation by pH parametric pumping, i.e. using pH as the control variable, an ionic exchanger as the adsorbent, the difference of isoelectric points as the separation basis, and the ionic electric field as the driving force. Thus the requirements of parametric pumping operation are completed.

Hemoglobin & albumin are ready to be separated by applying the principle of parametric pumping. The result of separation by parametric pumping will be discussed in Chapter 7,8,9 and 10; separation by cycling zone is included in Chapter 10. Chapter 3 : Theory and Mathematical Models in Parametric Pumping

3.1 : Equilibrium in General

For systems involving two phases, the mass distribution relationship between the phases is usually described by equilibrium theory. The theory says that apparently no change takes place in a system at an equilibrium state. In double film theory, it is assumed that two films exist in the boundary of two phases, and equilibrium is reached for these two films. We can write the following equations for the mass distribution at the equilibrium films.

Equation (3.1) expresses the equilibrium relationship between the solid phase concentration X* and the liquid phase concentration Y* , under the physical parameters PZ1,PZ2, ... PZn, which affect the equilibrium. The theory most commonly applied in parametric pumping has been the local equilibrium theory and the non-equilibrium theory, in which the system is governed by finite mass transfer.

3.2 : Local Equilibrium Theory

In local equilibrium theory, the system is considered as having equilibrium established instantaneously and locally Interpretation of local equilibrium theory between phases. is indicates that the thickness of the film zero, the bulk of fluid is equal to concentration of the the concentration of fluid film, and the film is in equilibrium with the concentration of solid phase. Thus equation (3.2)is applied. Since the adsorption occurs on the surface of the solid, the corresponding concentration of the amount of solute being adsorbed, X, is equal to the equilibrium concentration of the solid, X^* , thus equation (3.3) is applicable.

$$X = X \tag{3.3}$$

Equation (3.1) can be rewritten as equation (3.4).

$$X = f(Y, PZ1, PZ2, ..., PZn)$$
 (3.4)

3.3 Nonequilibrium theory

Nonequilibrium theory states that the concentration of the bulk fluid is not equal to that of the liquid film, where the film is in equilibrium with the solid concentration. The system is governed by a finite rate of interphase mass transfer, no instantaneous equilibrium is established. Theoretically, it would take infinite time for mass transfer to establish the exact equilibrium. Thus mass transfer rate is the control step. In this case, equation (3.2) is not applicable, while equaion (3.3) is still applicable for the same reasons as stated in the previous section. Thus equation (3.1) can be rewritten as:

$$X = f (Y, PZ1, PZ2, \dots PZn)$$
(3.5)
may further define a funiction f' inverse to function f as:
$$X = f'(X, PZ1, PZ2, \dots PZn)$$
(3.6)

3.4 : Model Equations

We

In order to describe the behavior of parametric pumping, a model for parametric pumping was set up from the theoretical background and simulated by computer. The model equations include the equation of continuity, the equation for control variable balance, the interphase mass transfer equation, and the phase equilibrium relationship. The model for pH parametric pumping is described as follows:

Equation of Continuity:

$$\frac{\partial x}{\partial t} + \frac{\partial y}{\partial t} + u \cdot \nabla Y = Dm \cdot \nabla^2 Y$$
(3.7)
Equation of interphase mass transfer

$$\frac{\partial x}{\partial t} = \lambda \cdot (Y - Y^*)$$
(3.8)

where $1/\lambda$ is the resistance

For fluid flow through porous medium with porousity = e_r , equation (3.7) can be written :

$$(1-e)\frac{\partial x}{\partial t} + \frac{\partial Y}{\partial t} + e \cdot u \nabla Y = e Dm \nabla^2 Y$$
(3.9)

For system of pH parametric pumping, the main parameter affect the phase equlibrium is the pH. The equation of (3.6) can be written :

Model of control variable: The control state variable, pH, is a function of location (x,y,z) and time, t, and can be written :

$$pH = f(x,y,z,t,constants)$$
 (3.11)

Equation (3.11) is a function to describe pH at any location and time, with given process constants such as intial pH and input pH, et cetera. The specific pH model studied in this thesis is described in chapter 10. Equations (3.8), (3.9), (3.10), and (3.11) are solved simultaneously to obtain the state variables of the system. The above 4 equations can be solved either analytically or numerically for the 4 dependent variables in terms of the independent variables, x,y,z, and t.

pH Model Equation:

One of the pH models studied in this thesis is an equation analogous to the equation of continuity(3.9). This pH model equation, as shown in equation (3.12), is used to correlate the control variable--pH--for the pH parametric pumping.

$$Cpf \cdot \frac{\partial PH}{\partial t} + Cps \cdot \frac{\partial PH}{\partial t} + Cpf \cdot u \cdot \frac{\partial PH}{\partial z} = 0 \quad (3.12)$$

In equation (3.12), the parameter Cpf and Cps stand for the pH capacity of fluid phase and solid phase, and are analogous to the volume of fluid phase and solid phase in the equation of continuity(3.9). It has to be pointed out that the equation of continuity is only valid for quantities such as mass and heat, which obey the conservation rule. Since pH is not a quantity obeying the conservation rule, equation(3.12) is an approximation model rather than an exact equation of continuity.

3.5 : Boundary Condition of Elementary Parametric Pumping

The initial condition and boundary condition are required with the equations (3.8) - (3.11) to complete a model of the system. As an illustration, we discuss the initial conditions and boundary conditions of a rather simple parapump for which the flow process is showm in Figure 3.1. As shown in Figure 3.1, there are 4 steps within a cycle, namely, (1) downward displacement, (2) downward circulation, (3) upward displacement, Since the 3 (4) upward circulation. system includes subsystems, column, top reservoir, and bottom reservoir, the inital conditions and boundary conditions are required for all 3 subsystems.

Initial Conditions:

column:	pH(z,0)	=	Po(z)	(3.13-a)
	Y(z,0)	=	Уо	(3.13-b)
	X(z,0)	=	Хо	(3.13-c)
Top Reservoir:	YTR(0)	=	Yo	(3.13-d)
Bottom Reservoir:	YBR(0)	=	Уо	(3.13-e)

Boundary Conditions:

(1)	Column:	(a)	n•tc	< t	< n•tc	+ tl	+ t2

pH(0,t) = pHR(T) (3.14-a)

$$Y(0,t) = YTR(t)$$
 (3.14-b)

pH(L,t) = finite (3.14-c)

Y(L,t) = finite (3.14-d)





(b) $n \cdot tc + t1 + t2 < t < (n+1) \cdot tc$

pH(0,t) = finite (3.15-a)

$$Y(0,t) = finite$$
 (3.15-b)

$$pH(L,t) = pHR(B)$$
 (3.15-c)

$$Y(L,t) = YBR(t)$$
 (3.15-d)

(2) Top Reservoir:
$$pHR(T)=P2$$
 (3.16)

(a) $n \cdot tc + tl + t2 < t < n \cdot tc + tl + t2 + t3$



(b)
$$n \cdot tc + tl + t2 + t3 < t < (n+1) \cdot tc + tl$$

 $YTR(t) = YTR(n tc + tl + t2 + t3)$ (3.17-b)
(c) $n \cdot tc + tl < t < n \cdot tc + tl + t2$
 $YTR(t) = 0(t)$

$$\frac{YIR(L)}{L} = \frac{Q(L)}{Vd} = \frac{Q(L)}{Vd} = \frac{Y(L,t) - YTR(t)}{Vd} = \frac{(3.17-c)}{Vd}$$

(3) Bottom Reservoir:
$$pHR(B) = P1$$
 (3.18)
(a) $n \cdot tc < t < n \cdot tc + t1$
 $Vd \cdot YTR(ntc) + \int_{n \cdot tc}^{t} Q(t) \cdot Y(1,t) \cdot dt$
 $YBR(t) = ------ (3.19-a)$
 $Vd + \int_{n \cdot tc}^{t} Q(t) \cdot dt$

(b)
$$n \cdot tc + tl < t < n \cdot tc + tl + t2 + t3$$

YBR(t) = YBR(n tc+t1) (3.19-b)
(c) $n \cdot tc + tl + t2 + t3 < t < (n+1) \cdot tc$
 $\frac{\partial YBR(t)}{\partial t} = \frac{Q(t)}{Vd}$ [Y(0,t) - YBR(t)] (3.19-c)

3.6 : Analytical Solution for Simplified Model

When the local equilibrium theory is applied, equation (3.9) can be rewritten as:

$$\frac{\partial x}{\partial t} = -\frac{\partial}{\partial t} f(Y, pH)$$
(3.20)

If we further assume a linear equilibrium relation f(Y,pH)=K(pH) Y, and Dm is small enough to neglect the effect of diffusion, then the equation of continuity can be rewritten as:

$$e \cdot \frac{\partial Y}{\partial t} + e \cdot u \cdot Y + (1-e) \cdot K(pH) - \frac{\partial Y}{\partial t} = 0 \qquad (3.21)$$

For a cylindrical packed column, the gradient in the angular direction $(\partial Y/\partial \theta)$ and the radial direction $(\partial Y/\partial r)$ are small compare to the gradient in the axial direction $(\partial Y/\partial z)$, and are negligible. Thus equation (3.21) can be rewritten as:

$$\begin{bmatrix} 1 + \frac{1-e}{e} & K(pH) \end{bmatrix} \xrightarrow{\partial Y}_{\partial t} = -u \cdot \frac{\partial Y}{\partial z}$$
(3.22)

Equation (3.22) is a first order partial differential equation, which

can be solved by the Method of Characteristic. Rewriting equation (3.22) one obtains:

$$\frac{\partial Y}{dt} = -a \frac{\partial Y}{Z}$$
(3.23)

where
$$a = ------ (3.24)$$

 $1 + K(pH)(1-e)/e$

The solution can be written as:

$$Y(z,t) = f(v(z,t))$$
 (3.25)

where: f is an arbtrary function, and

$$dz = a(z,t)$$
 (3.25-A)
 dt

When a is only dependent on t , the solution can be written as:

$$Y(z,t) = Y(zo,to)$$
 (3.26)

where : zo and to are given, and

$$z = zo + \int_{to}^{t} a dt$$
 (3.27)
and t > to

For the case where the pH is constant, K(pH) is constant in the range from 'to' to 't', and thus a = constant in that period of time. The solution can be written as :

$$Y = f[(z-zo) - a(t-to)]$$
(3.28)
for pH = constant when t > to



Figure 3.2

Equation (3.28) states that the constant concentration wave (z, t) appears as a straight line in the domain when а = shown in Figure 3.2 . This constant concentration constant, as line is called the characteristic line. By the definition of 'a' in equation 3.24, the constant concentration travels in (z, t)domain with a velocity equal to the fluid velocity times a factor 1/[1 + K (1-e)/e]. This constant velocity is often called the concentration wave velocity. Thus as long the initial as condition is known, the concentration in (z,t) domain is given by the methode of characteristic. This solution is called the Method of Characteristic since the dependent variable is constant on the characteristic line. This method has been widely applied in the direct mode of parametric pumping.

When the initial conditions and one of the boundary conditions (inlet fluid) are known, the concentration profile can be calculated for a system of parametric pumping. The solution can be solved by grapical method or by digital computer.

For a more complete model, the analytical solution is difficult. For example, when λ is not infinitely large, and Dm is not small enough to neglect the diffusive effect, no analytical solution has been reported to the best of our knowledge. Most result are obtained by applying the numerical method with digital computer calculations.

3.7 : Diffusion Effect of Protein

The diffusivities of hemoglobin and albumin are shown in table 2.1 . It is seen that both proteins have a rather small diffusivity. Since $Dm = 7 \times 10^{-7}$ (cm²/sec), and the gradient is larger than the Laplacian of Y in z direction, the convection term overwhelms the diffusion term in equation (3.9) and the diffusion effect is negligible. In chapter 8, the correlated mass transfer rate constant $\lambda = 5 \times 10^{-3}$ (l/sec), is also much larger than the diffusivity, and again demonstrates that neglecting of the diffusion term in equation (3.9) is reasonable and introduces no significant error.

Chapter 4 : Numerical Method

4.1 : Multi-Cells in Series Model:

The discussion in the last section of chapter 3 allow us to neglect the axial diffusion effect. The lowest backward finite difference of the equation of continuity with Dm=0, can be written as follows:

$$\begin{array}{ccc} Y(z,t-dt) &- Y(z-dz,t-dt) \\ + & u & ----- &= 0 \\ dz \end{array}$$
(4.1)

When we choose dt and dz in a such way that dz=u dt, equation (4.1) can be rearranged and becomes:

$$Y(z,t) - Y(z-dz,t-dt) + \frac{1-e}{e} [X(z,t) - X(z,t-dt)] = 0 \quad (4.2)$$

In order to apply equation (4.2) in parametric pumping, we divide the column (height = h), into Nz cells, thus each cell has a height of dz (dz=h/Nz). The time domain is divided into Nt increments of time and thus dt = dz/u. We define i for the series number of cells, and j for the series number of time increment. For the convenience of computer calculation, we change the notation (z,t) to (i,j) for the i-th cell and j-th time increment. As shown in Figure 4.1, (i,j) stands for cell of height from z-dz to z, and for time from t-dt to t. Equation

(4.2) can be rewritten to the form:

$$Y(i,j) - Y(i-1,j-1) + ---- [X(i,j) - X(i,j-1)] = 0 \quad (4.3)$$

Equation (4.3) states that the change of total mass is zero for the fluid flow from the (i-1)-th cell and the solid in the i-th cell. This equation is the foundation of the STOP and GO method. The Stop and Go algorithm includes the following two steps.

- (1) Go Step: fluid is instantaneuosly transfered from one cell to the next cell. No interphase mass transfer occurs because the time for fluid transfer is assumed zero.
- (2) Stop : Fluid is stagnant and interphase mass transfer is occuring for a time period dt=dz/u .

The algorithm of STOP & GO is also shown in Figure 4.1. It is seen that a column is divided into Nz cells. Figure 4.1(a) shows the STOP step at t=j-1, mass transfer is occuring between the adjacent fluid phase and solid phase at each cell (i-1, i, i+1 in the figure). Figure 4.1(b) shows, at GO step, fluid is transfered up with a displacement equal to the fluid volume of a cell. Fluid originally in (i-1) cell is transfer to i-th cell. Figure 4.1(c) again shows the STOP step after the GO step, mass transfer proceeds between the adjacent solid phase and liquid phase for a time period of dt. 30



(0)

(Ь)

Figure 4.1 Schematic of Multi-Cell Model with Stop & Go Methode.

.

⁽ C)

The interphase mass transfer equation(3.8), can be written in the same form as equation (4.3), and becomes:

$$\frac{\partial X(i,j)}{\partial t} = \lambda [Y(i,j) - Y^*(i,j)]$$
(4.4)
for (j-1) dt < t < j dt
$$Y^*(i,j) = f' [X(i,j), pH(i,j)]$$
(4.5)

pH Model Equations:

When we apply the above approach to the equation (3.12), one can obtain:

$$pH(i,j) = pH(i,j-1) \cdot B + pH(i-1,j-1) \cdot (1-B)$$
 (4.6)

where
$$B = Cpf/(Cpf+Cps)$$

Equation (4.6) is convenient to use for calculating the pH in each cell by the Stop and Go method and multi-cells model. A more general pH model, as shown in equation (4.7), is considered in multi-cells model. The new pH in thr cell after each transfer step is established according to equation (4.7), is dependent on the pH of fluid flow into the cell and the original pH of the solid phase.

$$pH(i,j) = pH(i,j-1) \cdot B + pH(i-1,j-1) \cdot C$$
 (4.7)

 $B=Bo [1 - g \cdot ABS(pH-pHRF)]$ (4.8)

The above pH wave equation is rather an empirical model, where B and C are the measures of relative buffer capacities for fluid and solid phase in cell. Note that the pH wave model has its theoretical background instead of arbtrary equation. When C=0., the solid phase buffer capacity is none, thus the pH in the column completely depends on the fluid pH. Since the buffer capacity is pH dependent, value B is correlated with pH by equation (4.7). B=Bo at the referenced pH value pHRF. g is a constant and stands for the linear sensitivity of the buffer capacity on pH varied from pHRF. When g=0, buffer capacity is independent on pH value, B=Bo=constant. Study of pH wave equation with B = 1-C = constant has been reported by Wankat.

Equations (4.3), (4.4), (4.5), and (4.7) are used to do the numerical calculation of pH(i,j), Y*(i,j), X(i,j), and Y(i,j). The algorithm used here is first to calculate pH by equation (4.7), then substitute equations (4.3) and (4.5) into equation (4.5), and X(i,j) can be solved for the time increment (j-1) dt - j dt. After X(i,j) is solved from equation (4.4), Y(i,j) can be obtained from equation (4.3) X(i,j).

When equation (4.3) is substituted into equation (4.4), we

obtain:

$$\frac{\partial X(i,j)}{\partial t} = \lambda \cdot \{Y(i-1,j-1) + \frac{1-e}{---}[X(i,j)-X(i,j-1)] - Y^*(i,j)\}$$

for (j-1).dt < t < j.dt
$$(4.9)$$

For non-linear equilibrium relation, such as Langmuir equilibrium, equation(4.9) is a non-linear differential equation with respect to X(i,j). A numerical method such as Runge Kutta method can be applied to solve equation (4.5) and(4.9) simultaneously. For linear equilibrium relation, equation (4.5) can be written as:

$$Y^{*}(i,j) = X(i,j)/K(pH)$$
 (4.10)

Substitute equation (4.10) to (4.9), and one can obtain:

$$\frac{\partial X(i,j)}{\partial t} = \lambda \{Y(i-1,j-1) - \frac{1-e}{---[X(i,j)-X(i,j-1)]} - X(i,j)/K(pH)\}$$

for (j-1).dt < t < j.dt (4.11)

The STOP & GO algorithm assumes that X(i,j) and Y(i,j) are homogeneous in the cell. The X(i,j) is only dependent on time in the time period from $(j-1) \cdot dt$ to j dt . Thus the partial derivative can be replaced by the total derivative in equation (4.11). Thus equation (4.11) becomes a first order linear ordinary differential equation with dependent variable X(i,j), independent variable t , and constants Y(i-1,j-1) and X(i,j-1), which is given in previous (t=j-1) calculation. Since the first order linear ODE always has a solution, one can obtain a solution as shown in equation (4.12) .

$$X(i,j) = \frac{Y(i-1,j-1) + R \quad X(i-1,j-1)}{RK}$$

+ [X(i,j-1) - $\frac{Y(i-1,j-1) + R \quad X(i,j-1)}{RK}$
+ [X(i,j-1) - $\frac{Y(i-1,j-1) + R \quad X(i,j-1)}{RK}$] exp(- $\lambda \cdot RK$ dt)
(4.12)
where R = (1-e)/e
RK = (1-e)/e + 1/K(pH)

4.2 : Application of Local Equilibrium Theory

When local equilibrium is applied, RANDA is infinitely large, and Y=Y*. The equilibrium of X and Y can be written: X(i,j) = f[Y(i,j),pH(i,j)] = f[Y*(i,j),pH(i,j)] (4.13) and equation (4.3) becomes : Y(i,j) = Y(i-1,j-1) $-\frac{1-e}{---} \{f[Y(i,j),pH(i,j)] - f[Y(i,j-1),pH(i,j-1)]\}$ e (4.14)

Equation (4.14) along with information of pH and equilibrium relations, f(Y,pH), will complete the requirements to calculate the concentration, Y(i,j). To obtain the information in the column, the pH, X, and Y has to be calculated for every cell at every j-th time increament. For a column has Nz cells, and operated for the total time increments equal to Nt, then the total number of calculations is Nz Nt . In chapter 9, we 35

assume the pH wave velocity is equal to the fluid velocity, B=1.0and C=0.0. In chapter 10, equation (4.7) is used to correlate the pH, and we assume the equilibrium constant K(pH) is proportional to the pH at the pH range of interest.

4.3 : Single Cell Model

When Nz=1, we consider the whole column as a uniformed cell. This single cell model is a lot simpler than multi-cell model. For a system consisting of two reservoirs and one column, we can denote the top reservoir as i=1, the column as i=2, and the bottom reservoir as i=3. Equation (4.14) can be rewritten to give equation of the single cell model, (4.17).

$$Y(2,j) = Y(1,j-1)$$

$$\frac{1-e}{----} \{f[Y(2,j),pH(2,j)] - f[Y(2,j-1),pH(2,j-1)]\}$$

$$e$$
(4.15)

Equation (4.15) gives the new equilibrium concentration of the column, Y(2,j), after the fluid of top reservoir is transfered into the column. The single cell model largely simplify the mathematical calculation and still gives qualitative accuracy. It is attractive because of its simplicity and its handiness when dealing with a complicated process. Chapter 5 : Separation of Parapump in Single Cell Model

As stated in chapter 4 , the single cell model describes the behavior of a uniform column. In the real world the column may not be completely uniform, but the single cell model is desired because of its simplicity and capability in qualitative prediction. In this chapter we will use this model to examine some simple cases of parametric pumping.

5.1 : Analytical Solution for Linear Equilibrium Iso-pH

illustration in this section, an analytical solution As an is derived from finite difference equation for an One-Column Batch Parapump. Equation (4.15) is applied to examine the behavior of the One-Column Batch Parametric Pumping, as shown in Under the single cell model, the whole column is Figure 5.1 . considered completely uniform, and the entire fluid in either is in equilibrium with the entire solid phase. We reservoir denote the total solid volume in the packed bed column as Vs , and the total fluid volume in equilibrium with the solid phase as , of which includes the void volume of column and the VR reservoir dead volume. Since a solid volume is Vs in equilibrium with the fluid volume VR, therefore е and l-e in equation (4.15) can be replaced by VR and Vs . It is convenient to write <YT>, for Y(1,j), and <YB>, for Y(3,j).

We further change j to n where n stand for the number of cycles in parametric punmping operation. It is seen in Figure 5.1 that $Y(2,j) = Y(3,j) = \langle YB \rangle_n$ for j=2 n, and $Y(2,j) = Y(1,j) = \langle YT \rangle_n$ for j=2 n-1. We can write the mass blance for the (n-1)th cycle and the n-th cycle (j from 2(n-1)-1 to 2n) as the following equations.

$$\langle YB \rangle_{n-1} K_{P1} Vs + \langle YT \rangle_{n-1} VR = \langle YT \rangle_{n-1} (VR+Vs K_{P2})$$
 (5.1)

$$\langle YT \rangle_{n} \stackrel{K}{P2} Vs + \langle YB \rangle_{n-1} VR = \langle YB \rangle_{n} (VR+Vs K_{P1})$$
 (5.2)

rearrange equation (5.2), and one obtains:

$$\langle YT \rangle_{n} = \langle YB \rangle_{n-1} \frac{-VR}{K_{P2} Vs} + \langle YB \rangle_{n} \frac{(VR+Vs K_{P1})}{K_{P2} Vs}$$
 (5.3)

For (n-1)-the cycle equation (5.3) can be rewritten as:

$$\langle YT \rangle_{n-1} = \langle YB \rangle_{n-2} \frac{-VR}{K_{P2} Vs} + \langle YB \rangle_{n-1} \frac{(VR+Vs K_{P1})}{K_{P2} Vs}$$
 (5.4)

Substitute equations (5.3) and (5.4) to (5.1) , one can obtain:

$$\langle YB \rangle_{n} + b \langle YB \rangle_{n-1} + c \langle YB \rangle_{n-2} = 0$$
 (5.7)

and

$$p = 1 + K_{p2} Vs/VR$$
 (5.10)

$$q = 1 + K_{p1} Vs/VR$$
 (5.11)

Apply the finite difference operator to equation (5.10), one obtains:



Figure 5.1 Description of An Elementary Batch Parapump at Operation Cycle (n-1) and n.

•

 $(E^2 + b E + C) \langle YB \rangle_n = 0.$ (5.14) Equation (5.14) is a second order linear finite difference equation(F.D.E.) and E is the finite difference operator. Two boundary conditions are required to obtain the complete solution for a 2nd order F.D.E.

at
$$n=0$$
, $\langle YB \rangle_{0} = Yo$ (5.15)

at n = 1, $\langle YB \rangle_n$ can be calculated from $\langle YB \rangle_o$ and $\langle YT \rangle_o$

$$\langle YB \rangle_{1} = Yo \quad (p + pq)/(p q)$$
 (5.16)

Solve equation (5.14) with (5.15) and (5.16) , one obtains the complete solution as follows:

$$\begin{array}{cccc} \langle YB \rangle & (p-1)(q+1) & q-p & -n \\ \hline & & & \\ \hline & & & \\ Yo & & p q -1 & p q -1 \end{array} \end{array}$$

By applying the same procedure for the top reservoir, one can obtain the solution for $\langle YT \rangle_n$ as:

$$\frac{\langle YT \rangle}{Y_0} = \frac{(q+1) (q-1)}{pq-1} + \frac{q (p-q)}{pq-1} - n$$
(p q) (5.18)

and the separation factor $\langle YB \rangle_n / \langle YT \rangle_n$, can be obtained by dividing equation (5.17) by equation (5.18), and becomes:

$$SFn = \frac{\langle YB \rangle_{n}}{\langle YT \rangle_{n}} (q+1) (q+1) + (q-p) (p q) (p q) (q+1) + (q-p) (p q) (q+1) (q+1) + (p q-q) (p q)$$
When n is very large, equation (5.19) becomes:

SFss =
$$-\frac{K_{P2}}{K_{P1}}$$
 (5.20)

The final separation factor is equal to the ratio of K_{p2} to K_{p1} . When K_{p1} is equal to K_{p2} , no separation will be achieved. Separation is obtainable as long as K_{p1} is not equal to K_{p2} . Equation (5.20) also gives the following important information.

$$\langle YB \rangle_{SS} = \langle YT \rangle_{SS} = \langle XT \rangle_{SS} = \langle XB \rangle_{SS}$$
 (5.20-a)

The above relations state that the final concentration is established when the solid phase equilibrates with both the fluid in top reservoir and in bottom reservoir.

5.2 : Short-Cut Steady State Solution for Single Cell Model

From the previous section, when the concentration of the solid phase reaches equilibrium with the concentration of both fluids in top and bottom reservoirs, no further mass transfer between phases occurs, and the concentration of solid phase reaches a final value. The steady state solution is obtainable without involving the transit concentration by applying the equilibrium criterion-<XT>ss = <XB>ss . The mass balance for a cycle in steady state can be written as follows:

Vs <XT>ss + VRB <YB>ss = VRB <YB>ss + Vs <XT>ss (5.21-b)

The total mass of system in steady state is equal to the initial state mass and can be written as:

$$Ws = VRT \langle YT \rangle_{o} + VRB \langle YB \rangle_{o} + Vs \langle X \rangle_{o}$$
(5.22-a)

= VRT $\langle YT \rangle$ ss + VRB $\langle YB \rangle$ ss + Vs $\langle X \rangle$ ss (5.22-b)

The steady state criterion is:

$$\langle XB \rangle ss = \langle XT \rangle ss = Xss$$
 (5.23)

The equilibrium relations of Y and X are:

$$\langle YB \rangle ss = f'(\langle XB \rangle ss) = f'(Xss, Pl)$$
 (5.24-a)

$$\langle YT \rangle ss = f'(\langle XT \rangle ss) = f'(Xss, P2)$$
 (5.24-b)

The 5 independent equations 5.23 to 5.26 can be solved for 5 unkows, <YT>ss, <YB>ss, <X>ss, <XB>ss, and <XT>ss. We then apply the following linear equilibrium relations.

$$\langle Y \rangle = f'(\langle X \rangle, pH) = \langle X \rangle / K(pH)$$
 (5.25)

$$\langle YT \rangle ss = Xss/K_{p2}$$
 (5.26)

$$\langle YB \rangle ss = Xss/K_{pl}$$
 (5.27)

We can obtain Xss by subtsituting (5.26) and (5.27) into (5.23).

$$\langle YT \rangle ss = ---- \frac{Ws/K_{P2}}{VRT - VRB}$$
(5.28-b)
$$\langle YB \rangle ss = ---- \frac{Ws/K_{P1}}{VRT - K_{P1}}$$
(5.28-c)
$$\langle YB \rangle ss = ---- \frac{Ws/K_{P1}}{VRT - VRB}$$
(5.28-c)
$$\frac{VRT}{K_{P2} - K_{P1}} + Vs$$

and the steady state separation factor is:

$$SFss = \frac{\langle YB \rangle ss}{\langle YT \rangle ss} = \frac{f'(Xss,P1)}{f'(Xss,P2)} = \frac{K_{P2}}{K_{P1}}$$
(5.29)

Here the results agree with those in the previous section. It is seen this method gives a quick result of final separation based on the single cell model. The same procedure can be applied to a two-column batch parametric pumping as shown in Figure 5.2(a). The results are as follows: results.

$$\langle YT \rangle ss = (Ws/D) K_{P2}^{+} K_{P1}^{-}/K_{P2}^{-}$$
 (5.30)



Figure 5.2 Schematic Diagram for (a) Two-Column Parapump (b) One-Column Open Parapump

$$\langle YM \rangle_{SS} = (WS/D) \cdot K_{P1}^{+} \cdot K_{P1}^{-} / K_{P2}^{-}$$
 (5.31)

$$\langle YB \rangle ss = (Ws/D) K^{+}_{P1}$$
 (5.32)

SFss =
$$\frac{\langle YB \rangle_{SS}}{\langle YT \rangle_{SS}} = \begin{pmatrix} K_{P1} \\ ------ \\ \langle YT \rangle_{SS} \end{pmatrix} \begin{pmatrix} K_{P1} \\ ----- \\ K_{P2} \end{pmatrix} \begin{pmatrix} K_{P2} \\ K_{P1} \end{pmatrix} (5.33)$$

wher Ws = (VR+Vs $\bar{K_{P1}}$)·Yo + (VR+Vs $\bar{K_{P2}}$)·Yo + VR·Yo

$$D = K_{P1}^{+} \cdot (VR + VS K_{P1}^{-}) + VR \cdot K_{P2}^{+} K_{P1}^{-} / K_{P2}^{-} + K_{P1}^{+} \cdot (VR + VS K_{P2}^{+}) K_{P1}^{-} / K_{P2}^{-}$$

and VR: fluid volume in each reservoir
Vs: solid volume in each column

Since the two column parametric pumping consists two kind of ionic exchanger, the equilibrium constant K is function of the pH and the type of ionic exchanger. The above result assumes that X=f(Y,pH, Exchanger) = K(pH,Exchanger) Y. We have also denoted K(pl, Cation Exchanger) as K_{p1}^- , K(p2, Anion Exchanger) as K_{p2}^+ , and so on. For multi-column batch parametric pumping with two pH level-pl and p2, it is easy to derive the steady state separation factor as shown in equation (5.36), in which the l, 2, 3, ... stand for the series number of columns.

SFss =
$$\begin{pmatrix} \frac{K_{P1}}{-1} \end{pmatrix}$$
 $\begin{pmatrix} \frac{K_{P2}}{-1} \end{pmatrix}$ $\begin{pmatrix} \frac{K_{P1}}{-1} \end{pmatrix}$ $\begin{pmatrix} \frac{K_{P1}}{-1} \end{pmatrix}$ $\begin{pmatrix} \frac{K_{P2}}{-1} \end{pmatrix}$. . . (5.36)

The steady state solution is obtainable for a one column open parapump as shown in Figure 6.2(b). The open parapump has feed introduced into the resevoir and product withdrawing from the system. When we apply the above procedures, one can obtain the following results.

$$\langle YB \rangle_{SS} = \frac{Y_{0}(1+2 \ K_{P2} \ VS/F)}{1 + (K_{P1} + K_{P2}) \ VS/F}$$
(5.37)
$$\langle YT \rangle_{SS} = \frac{Y_{0}(1+2 \ K_{P1} \ VS/F)}{1 + (K_{P1} + K_{P2}) \ VS/F}$$
(5.38)
$$SF_{SS} = \frac{1+2 \cdot K_{P1} \cdot VS/F}{1+2 \cdot K_{P1} \cdot VS/F}$$
(5.39)

Where F : the feed per half cycle = product per half cycle

The steady state solution for more complicated system in single cell model is possible. This thesis only includes the above results as illustrations. as examples.

5.3 : Graphic Method in Single Cell Model

Equation (4.15) can be rewritten as:

 $\frac{f[Y(i,j)] - f[Y(i,j-1)]}{Y(i,j) - Y(i,j-1)} = \frac{X(i,j) - X(i,j-1)}{Y(i,j) - Y(i,j-1)} = \frac{-e}{1-e}$ (5.40)

Equation 5.40 states that the mass conservation gives a straight line on the (Y,X) domain with a slope = -e/(1-e). As shown in Figure 5.3, from a given point of [Y(i-1,j-1),

X(i,j-1)], the point [Y(i,j), X(i,j)] will lie on the straight of slope = -e/(1-e) which passes through the point line [Y(i-1,j-1),X(i,j-1)]. When further constraint is applied to the system, such as the equilibrium constraint X=f(Y), then the point [Y(i,j),X(i,j)] must also lie on the equilibrium curve X = f(Y). Thus the point [Y(i,j),X(i,j)] must be the intersection point of equilibrium curve and the mass conservation line as shown in The above graphical method is applied further to Figure 5.3 . batch parapumps, and is described in more detail in chapter 7. this chapter, we has seen that 3 methods are applicable with In the single cell model to obtain a quick prediction of separation by parametric pumping.



Figure 5.3 Graphical Method in Single Cell Model

Chapter 6 : Experimental Study

The theoretical study in the previous chapter gives a theoretical demonstration and prediction of separation capability by parametric pumping. The experimental studies are carried out to test the behavior, and to demonstrate the separation by parametric pumping. Neverthless, experimental results are required to determine the parameters for a given system, and to verify the validity of the theoretical model.

6.1 : System

In this thesis, the system chosen for experimental study is hemoglobin - albumin - buffer solution - solid adsorbent. The adsorbents used are CM-Sepharose cation exchanger and Deae-Sepharose anion exchanger (manufactured by Phamacia Fine Chemical Co.). The ionic exchangers are cross linking styrene base resin, and the particle size is ranging from 40 to 160 u(micron), and porosity is about 0.75 at normal operation condition. The properties of hemoglobin and albumin have been described in more detail in Chapter 2.

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6.2 : Apparatus

A typical experimental apparatus for two-column parapump is in Figure 6.1. The apparatus consists of schematically shown Phamarcia chromatographic columns(manufactured by Fine two Chemicals Co.) and 3 reservoirs connected by the 2 columns. The temperature of the columns and reservoirs are controlled to _ 5 10 degree centigrade by circulating a heat transfer medium in the The inside diameter of the column is 16 mm. jackets. thermostat One column is packed with Deae-Sepharose anion exchanger and the other with CM-Sepharose cation exchanger (manufactured by Phamacia Fine Chemicals). The fluid flow within the columns is reciprocating and pumped by two P-3 peristaltic reversible pumps. The pumps are wired to a timer controller to control the flow direction and flow displacement. The pH level in the reservoirs is maintained constant by titrating with hydrochloric acid and sodium hydroxide solutions. Magnetic stirrers are used to ensure complete mixing with the titration in the reservoir. Three hollow fiber dialyzers(manufactured by Spectrum) were used to keep the ionic strength constant for the solution in the The dialyzer consists of membrane bundles which reservoirs. allow the small molecules such as buffer ions and water molecules to flow through the membrane while the large molecules, such as protein, can not permeate through the membrane. In operation, protein solution flows inside the hollow fiber bundles and the buffer solution flows outside of the the bundles. For



Figure 6.1 Experimental Apparatus of Two-Column Parapump

multi-column parapump, the apparatus includes more columns and reservoirs. The fundamental functions and operations of the asparauts for multi-column parapumps is same as that in two columns parapumps.

6.3 : Analytical Apparatus

The experimantal results of parapump is examed in terms of the concentration of the product stream for open parapum and the concentration of the solution in the reservoirs for batch parapump. A spectrophotometer(Bausch & Lomb-710) is used to measure the concentration of proteins. To identify the concentration of individual species from a mixture of two components, at least two independent measurement are required. The method applied in this thesis is first to determine the hemoglobin concentration directly from absorbance the at wavelength=403 mu(millimicron), and then to determine the total proteins by the Bio-Rad Protein assay at wavelenth=595 mu. The concentration of albumin is obtained by substract the hemoglobin from the total proteins.

The absorbance of hemoglobin at 403 mu is strongly dependent on the pH level of the solution. Figure 6.2 shows the relative absorbance of hemoglobin for pH range of 4.0 to 8.5, with a standard absorbance equal to unity at pH=6.0 . Figure 6.2 is



used to calculate the hemoglobin concetration for pH variance.

6.4 : Modes of Operation

Many modes of operation have been experimentally studied in single solute, such this thesis. For a system of as Solution-Adsorbent Hemoglobin-Buffer Albumin-Buffer and Solution-Adsorbent, experiments have been run by one-column and two-column parapump. System of two solutes, hemoglobin and albumin in buffer solution, has been experimentally studied in one-column and two-column parapumps. Among the two-column parapumps, there are many different operation modes. The experimental results for batch parapump is discussed in chapter 7 and 8, the semi-continuous one-column parapump in chapter 9, and the cycling zone in chapter 10. Included in chapter 7, 8, 9, and 10 are also the theoretical correlation and results by computer Experimental data for columns more than or equal exploration. to 3 is not included in this thesis.

Chapter 7 : Separation of Binary System with Single Cell Model

Studies of a binary system (1 solute in buffer solution) is presented in this chapter. Included are the graphical method, the theoretical prediction by single cell mode and the experimental results.

7.1 : One Column Batch Parapump

The one-column parapump consists of a column packed with an ion exchanger (cation or anion) and two reservoirs attached to The parapump has dead volumes VDT and VDB for the top each end. and bottom reservoirs, respectively. Initially, the mixture to separated fills the column voids, the top reservoir, and the be bottom dead volume. The top reservoir is maintained at a low Πq level(P2) by an automatic titrator while a second titrator is used to keep the bottom reservoir at a high pH level(Pl). The buffer ionic strengths of the solutions in both top and bottom reservoirs are kept at IS2 and IS1, repectively, by means of two hollow fiber dialyzer. The flow procedure(see Figure 3.1) has four distinct steps in each cycle:

(I) The low pH(P2) fluid from the top reservoir enters the top of the column, while the solution emerging from the other end enters the bottom reservoir. The displacement Qt_I is set to be equal to the void volume of the column VE; that is, Qt_T=VE . 55
- (II) Circulation between the top reservoir and the column: This will ensure a complete shift of the pH and ionic strength in the column to P2 and IS2, respectively. Also, at the end of the step, the concentrations in both top reservoir and column are identical.
- (III) The high pH(Pl) fluid from the bottom reservoir enters the bottom of the column, and the solution emerging from the other end enters the top reservoir, with the displacement Qt_{TTT}=VE, and
- (IV) Circulation between the column and the bottom reservoir: This will allow the pH and ionic strength to shift back to Pl and IS1, respectively, and at the end of the step the concentration in the column will be the same as that in the bottom reservoir.

Note that the flow rate within the column is always equal to reservoir displacement rate Q. The duration of circulation t_{II} or t_{IV} , which can be determined experimentally, depends on VE and VDB(or VDT), pH, and the ionic strength in both the column and reservoir. Figure 7.1 is a graphical solution for one-column system. The assumptions made here are:

- (1) The solute will be distributed between the solid and fluid phases according to the function,
 X = f(Y,pH) (7.1)
- (2) The duration of circulation t_{II} or t_{IV} , is long enough so that at the end of the step II or IV a phase equilibrium is established.



Figure 7.1 Graphical Solution for a One-Column Parapump

Figure 7.1 shows that a parapump consists of a column packed with cation exchanger and two reservoirs attached to each end. The pH values of the top and bottom reservoirs are maintained at given levels P2(=6.) and P1(=8.), respectively. The operation begins with the column filled with a mixture of concentration Yo, everywhere at equilibrium with the solid. The initial pH in the column is high (Pl). Also, there is fluid of the same initial concentration in the top and bottom reservoir. The dead volume of the two reservoirs are equal(VDT=VDB). Let X and Y be the of A in the solid phase and fluid concentrations phase, respectively. Using Equation 7.1, we draw two equilibrium curves f(Y,Pl), f(Y,P2) on a X-Y diagram. The initial concentration in the column (Yo; Xo) is represented by the point 0. One cycle of operation includes four steps, and the effect of the the operation for the first cycle is as follows:

(1) Transfer down: The fluid in the TR (top reservoir) is transferred to the column, and the fluid in the column is transferred to the BR(bottom reservoir). Therefore, the bottom reservoir concentration for the first cycle is Yo.

(2) Circulation and equilibration at P2: The column pH is changed from Pl to P2 . The two phases are then allowed to equilibrate at P2. This leads to a new composition in the column, [Y(Tl);X(Bl)], represented by the point Tl. The point is located at the intersection of equilibrium curve f(Y;P2) and of the operation line passing through (Yo;Xo). The slope of the operation is ST, and is obtained by the mass balance constraint, i.e.,

$$ST Y(T(n-1)) + X(Bn) = ST Y(Tn) + X(Tn)$$
 (7.2)
where $n = 1, 2, 3, - - -$

$$ST = - -----$$
(7.3)
Vs

(3) Transfer Up: The solution in the column is brought to the TR and the solution in the BR is returned to the column. The composition in the column is now (Y(B1);Y(T1)).

(4) Circulation and equilibration at Pl: The column pH is shifted back to Pl. A phase equilibrium is restablished. The new equilibrium point(Y(B2);XB2), represented by the point B2, is located at the intersection of the equilibrium curve f(Y,Pl) and of the operation line passing through(Y(Bl);X(Tl)) and having a slope of SB, and is obtained from the following mass balance,

SB
$$Y(B(n-1)) + X(T(n-1)) = SB Y(Bn) + X(Bn)$$
 (7.4)
where $n = 1, 2, 3, ---$

This completes the first cycle. The second cycle will start from a transfer of the fraction Y(Tl) from the TR to the column and the fraction Y(B2) to the BR. We then follow the steps described above (see Figure 7.1). If the procedures are repeated in each of the succeeding cycles, one can see that as n becomes large, the top and bottom reservoir concentrations will approach steady values, i.e., Y(Tss) and Y(Bss), respectively. At steady state, the solid phase has a constant composition which is in equilibrium with both Y(Tss) and Y(Bss), i.e.,

Xss =
$$f[Y(Bss);P1] = f[Y(Tss);P2]$$
 (7.6)
and therefore, the line Tss Bss must be paralled to the horizontal
axis.

7.2 : 2-column batch parapump

The 2-column parapump consists of two columns and three reservoirs as shown in Figure 7.2. One of the columns is packed with a cation exchanger (R^-) and the other with an anion exchanger (R^+) . The pH level for the top and bottom reservoirs is maintained at Pl(=8.) and that for the middle reservoir is kept at P2(=6.). Initially, the top reservoir and both columns are filled with a mixture of the concentration Yo. The R⁻ and R⁺ columns are respectively in equilibrium at Pl(=9.) and P2(=6.). As shown in Figure 7.2, one cycle of operation is described as follows:

(I) Pump the fluid from the top reservoir(TR) through the R⁺ column, the middle reservoir(MR) and the R⁻ column to the bottom reservoir(BR), for time t_I.
 (II) Circulation the fluid between the TR and the R⁺



4

PL

MR P2

Description of A Two-Column Parapump Operation Figure 7.2

column, and between the MR and the R column, for time t_{TT} .

- (III) Pump the fluid from the bottom reservoir through the R^- column, MR and R^+ column to the top reservoir, for time t_{TTT} , and
- (IV) Circulate the fluid between the MR and the R^+ column, and between BR and the R^- column.

The procedure is repeated for each of succeeding cycles. The graphical representation is shown in Figure 7.3. In this figure, the linear equilibrium relationship is assumed and f(Y,pH,EX) = K(pH,EX) Y. Since the parapump consists 2 types of exchanger(EX) and 2 pH levels, there are four equilibrium lines with slope respectively, K_{P1}^+ , K_{P2}^+ , K_{P1}^- , and K_{P2}^- . K_{P1} and K_{P2} are the equilibrium constants for solute A in the R column, while K_{Pl}^{+} and K_{P2}^{+} are for A in the R⁺ column. For the purpose of illustration, we further assume that $K_{P2}^- = K_{P1}^+$ and $K_{P1}^- = K_{P2}^+$. However, other conditions are conceivable. The graphical construction is similar to that described for the one column system. From Figure 7.3 Y(Tss), Y(Mss) and Y(Bss) are respectively the steady state concentrations for the top, middle, and bottom reservoirs. Connecting the points Tss Mss' Mss'', and Bss, a two step staircase is formed. Note that at steady state, the concentration in the middle reservoir is such that it is in equilibrium with both cation and anion exchangers at P2, i.e.,

$$X^{+} = K_{P1}^{+} Y(Tss) = K_{P2}^{+} Y(Mss)$$
 (7.7)





Figure 7.3 Graphical Solution for Two-Column Batch Parapump

$$X = K_{P1} Y(Bss) = K_{P2} Y(Mss)$$
 (7.8)

and,
$$Y(M\bar{s}s) = X^{-}/K_{P2}^{-} = X^{+}/K_{P2}^{+} = Y(M^{+}ss)$$
 (7.9)

In the R^+ column, the solute A migrates from the high pH end(pH=8.) toward the low pH end(pH=6.), whereas in the $R^$ column, it moves in the opposite direction. Therefore, we accumulate the solute A at the high pH end of the R^- column, i.e., the bottom reservoir. If we replot Figures 7.1 and 7.3 to show the separation factor ($\langle YB \rangle_n / \langle YT \rangle_n$) vs. n (Figure 7.4), one can see that the two-column system is much preferable.

7.3 : Experimental Results

The experimental apparatus was described in chapter 5. The systems selected to be examined experimentally were Hemoglobin-buffer and albumin-buffer. The results are shown in Figures 7.5 and 7.6. For all runs, the displacement was set approximatley equal to the void volume (VE), and the flow rate was 0.017cc/sec(lcc/min).

7.5 illustrates separation Figure the factor (<YB>,/<YT>,) vs. n for a one column parametric pump. Initially, the feed solution containing a solute (hemoglobin or albumin) was present in the reservoirs. The column and the bottom reservoir dead volume were filled with feed solution of pH=8, The buffer solutions were made from monobasic and dibasic sodium phosphate. The top and bottom reservoirs were



Figure 7.4 Separation Factor vs. n for One- and Two- Column Parapump



Figure 7.5 Experimental Results for One-Column Parapump.



Figure 7.6 Comparison of Experimental Results for One- and

respectively maintained at pH=6(P2) and pH=8(P1) so that the isoelectric point of hemoglobin would lie between the two pH levels. As a result of a change in the column pH, hemoglobin experiences a change in the net charge, and migrates toward the high pH end (the bottom reservoir). Thus, the separation factor(SF) for hemoglobin increases with n and approaches a limiting value. For the case of albumin, the isoelectric point of albumin is below P2, and the net charge is always negative during upflow and downflow. As a result, the adsorption of albumin in the pH levels(Pl and P2) is negligible, thus albumin concentration is unaffected by this parapump operation, and remains the original concentration.

Figure 7.6 shows the comparison of one- and two-column parapumps. For all cases(runs 3, 4, and 5) the solute(albumin) was present in the columns and reservoirs in concentration Yo initially. Two pH levels(4. and 6.) were chosen to bracket the isoelectric point of albumin. The buffers used for this part of experiments were mixtures of acetic acid, sodium acetate and sodium choride. As the theory predicts, Albumin is concentrated at the low pH end of the R^+ column(Run 3) and the high pH end of the R^- column (Run 4). Also, the two column parapump has much higher separation capability than the one-column units. The experimental results have demonstrated the separation capability of two column parapump, and qualitatively agree with the prediction by the single cell model.

Chapter 8 : Separation of Multi-Component System With Single Cell Model

this chapter, many modes of parapump operation are In The single cell model and the linear equilibrium studied. relationship are applied to examine the behavior of parapump and separation to guide the experimental studies. Studies of in ternary system(2 solutes in buffer solution) by 2-column batch parapump are presented in Section 8.1 and by multi-column batch Studies of open parapump(operation parapump in Section 8.2. with feed introduced to and products withdrawn from system) is presented in Section 8.3, and the separation of multiple solutes are presented in Section 8.4. Included in this chapter are also the theoretical prediction by single cell model with graphical presentation, experimental results, and the correlation of experiemental data with the single cell model. For a ternary system which consists of protein A , B, and buffer soultion, we are concerned with the separation of two proteins. The proteins, A and B, have the isoelectric points IA and IB, respectively, and P3 < IB < P2 <IA < P1, where P1, P2, and P3 are the pH levels in the reservoirs. Thus, both A and B will bear negative charges at Pl, and positive charges at P3, while A and B will bear negative charges at Pl, and positive charges at P3, while A will carry a positive charge and B will carry a negative charge at P2. Therefore, A will be taken up by a suitable cationic exchanger at

P2 or P3 and released at P1, whereas B will be taken up at P3 and released at P2 or P1. A reversed effect will occur if an anion exchanger is selected.

8.1 : 2-Column Batch Parapump

In this section, the effort is emphasized on splitting 2 proteins in buffer solution. Four modes of 2-column parapumps were studied. Figures 7.2, 8.2, 8.4, and 8.6, show the operations of Mode 1, 2, 3, and 4, respectively. The steady state concentrations in the reservoirs are graphically shown in Figures 8.1, 8.3, 8.5, and 8.7. For the purpose of simplification, it is assumed that for protein A, $K_{P2}^{-} = K_{P3}^{+}$ and $K_{P2}^{+} = K_{P3}^{+}$, and for protein B, $K_{P1}^{+} = K_{P2}^{+}$ and $K_{P1}^{-} = K_{P2}^{-}$. However, other conditions are conceivable. The four modes of of pump operations are described as follows:

Mode 1:

The 2-column parapump described in Section 7.2 is the first mode considered . Since the operations is the same as that stated in Section 7.2, here we only discuss the result of separation for two proteins in buffer solution. The graphical construction for the concentration profile is made in the same way as previously described. From the previous section, a two



Figure 8.1 Graphical Solution for Two-Column Parapump-Mode 1.

step staircase is formed for protein A (upper diagram of Figure 8.1).

In the R⁺ column, the protein A migrates from the high pH end(P1) toward the low pH end(P2), whereas in the R^- column, protein A migrates from the low pH end (P2) to the high pH end (P1), i.e., the bottom reservoir. From the lower diagram of separation occurs for protein B, i.e., Figure 8.1, no [Y(Bss)/Y(Tss)] =1. It should be pointed out that, though B carries the same charge at Pl and P2, there may be a difference in the K values at these pH levels(depending on the ionic strength), and some amount of separation may occur on B. Mode 1 works well for enriching protein A, and is attractive when the objective is to obtain a product in which one component is concentrated.

Mode 2:

The parapump contains five reservoirs, two top, one middle, and two bottom reservoirs, respectively with pH = Pl, P3, P2, Pl, and P3. As shown in Figure 8.2, the flow system has eight distinct steps in cycle:

- (I) Pump the fluid from the TR(Pl) through the R^+ colum, MR and R^- column to the BR(Pl), for time t_T .
- (II) Circulate the fluid between the TR(Pl) and R^+ column, and between the MR and the R^- column.
- (III)Pump the fluid from the BR(P3) through the R⁻ column, MR, and the R⁺ column to the TR(P1) for time t_{TTT} .



Figure 8.2 Schematic of Two-Column Parapump Operation-Mode 2

- (IV) Circulate the fluid between the BR(P3) and the R^{-1} column, and between the MR and the R^{+} column, for time t_{TV} .
- (V) Pump the fluid from the TR(P3) through the R^+ column, MR and R^- column to the BR(P3), for time t_v.
- (VI) Circulate the fluid between the TR(P3) and the R⁺ column, and between the MR and R⁻ column for time t_{VI}.
- (VII)Pump the fluid from the BR(Pl) through the R⁻ column, MR, and R⁺ column to the TR(P3), for time t_{VII} . (VIII) Circulate the fluid between the BR(Pl) and the R⁻

column, and between the MR and the R⁺ column for time ^tVIII[•]

The steady state concentrations in the reservoirs are graphically presented in Figure 8.3. At steady state (n ---> large number),

$$X^{+} = K_{P1}^{+} [Y(Tss)]_{P1} = K_{P3}^{+} [Y(Tss)]_{P3} = K_{P2}^{+}Y(Mss)$$
 (8.1)
and

$$X = K_{P1} [Y(Bss)]_{P1} = K_{P3} [Y(Bss)]_{P3} = K_{P2} Y(Mss)$$
 (8.2)

Connecting the points T_{P1} , T_{P3} , M_{P2}^+ , M_{P2}^- , B_{P3} , and B_{P1} , a two step staircase is formed for both proteins, A and B However, the concentration of A in the bottom reservoir BR(P1) is much higher than that in TR(P1), while the concentration of B in the top reservoir TR(P3) is much greater



Figure 8.3 Graphical Solution for Two-Column Parapump-Mode 2

than that in BR(P3). This separation phenomenon can be explained as follows: The pH levels, Pl, P2, and P3 bracket the isoelectric points of A and B, i.e., P2 < IA < Pl and P3 < IB < P2. Thus in the R⁻ column, A and B respectively migrate toward the BR(P1) and the MR(P2), whereas in the R⁺ column, A and B respectively, move toward the MR(P2) and TR(P3). In other words, A and B migrate in opposite directions and concentrate respectively in BR(P1) and TR(P3).

Mode 3:

This parapump has four reservoirs; one top, two middle, and one bottom reservoirs, respectively with pH= P2, P1, P3, and P2. Flow sequences(Figure 8.4) for one cycle are:

- (I) Pump the fluid from TR through the R^+ column to the MR(P1), and at the same time, pump the fluid from the MR(P3) through the R^- column to the BR, for t_T .
- (II) Circulate the fluid between the TR and the R^+ column, and between the MR(P3) and the R^- column for time t_{TT} .
- (III) Pump the fluid from the BR and R column, and between the MR(P3) and R⁺ column to TR, for time t_{III}.
- (IV) Circulate the fluid between the BR through the R⁻ column, and between the MR(P3) and R⁺ column for time t_{IV} .
- (V) Pump the fluid from the TR through the R^+ column to

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the MR(P3), and at the same time pump the fluid from the MR(P1) through the R⁻ column to BR, for time t_v .

- (VI) Circulate the fluid between the TR and the R⁺ column, and between the MR(Pl) and the R⁻ column, for time $t_{\rm VI}$.
- (VII) Pump the fluid from the BR through the R⁻ column, MR(Pl), and R⁺ column to TR for time t_{VII} .
- (VIII) Circulate the fluid between the BR and the R column, and between the MR(Pl) and the R⁺ column for time t_{VIII}.

Figure 8.5 shows the steady state concentrations in the reservoirs. At steady state, the average concentration of the middle reservoirs(MR(P1) and MR(P3)] is such that:

$$X^{+} = K_{P2}^{+} Y(Tss) = 0.5 [K_{P1}^{+}Y(MR^{+})_{P1} + K_{P3}^{+}Y(MR^{+})_{P3}]$$
 (8.3)

$$X = K_{P2} Y(Tss) = 0.5 [K_{P1} Y(MR_{-})_{P1} + K_{P3} Y(MR_{-})_{P3}]$$
 (8.4)

 $Y(M^{-}ss)$ and $Y(M^{+}ss)$ in Figure 8.5 is defined as: $Y(M^{+}ss) = 0.5[Y(MR^{+})_{P1} + Y(MR^{+})_{P3}] = Y(M^{-}ss) = 0.5[Y(MR^{-})_{P1} + Y(MR^{-})_{P3}]$ (8.5)

where $Y(MR^+)_{Pl}$ and $Y(MR^+)_{P3}$ are the seady state solute concentrations from the R^+ column to MR(P1) and MR(P3) respectively, respectively, whereas $Y(MR^-)_{Pl}$ and $Y(MR^-)_{P3}$ are those from the R^- column to MR(P1) and MR(P3) respectively.

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The results shown in Figure 8.5 are very similar to those fro Mode 2. A and B imove in opposite directions, but for this case, protein A migrates upward to the top reservoir(pH=P2), while B moves downward to the bottom reservoir(PH=P2).

Mode 4 :

This mode includes four reservoirs, TR, MR, SR(Side Reservoir), and BR, respectively with pH = Pl, P2, P3, and Pl. One cycle of operation is described as follows:

- (I) Pump the fluid from TR through the R^+ column to SR, and at the same time pump the fluid from the MR through the R^- column to the BR, for time t_T .
- (II) Circulate the fluid between the TR and R^+ column, and between the MR and the R^- column, for time t_{TT} .
- (III) Pump the fluid from the BR through the R⁻ column, MR, and R⁺ column to the TR, for time t_{III} .
- (IV) Circulate between the BR and R⁻ column, and between the MR and R⁺ column, for time t_{TV}.
- (V) Pump the fluid from the SR through the R^+ column to the MR, for time t_v.
- (VI) Circulate between the SR and R^+ column for $t_{\rm VI}$.

The steady state concentrations are shown in Figure 8.7. Proteins A and B are enriched in the BR and SR, respectively. Note that by this mode, protein B has no separation in the R^- column, and thus only one step staircase is formed.



Schematic of Tw0-Column Parapump Operation-Mode 4 Figure 8.6







Experimental Results of a Two Protein System:

The expermental results are presented in Figures 8.8 to for Mode 1, 2, 3, and 4, respectively. 8.11, Note the experimental results in Figure 8.11 are obtained from the modified Mode 3(i.e., Mode 3-A; see Figure 8.12). Table 4 summarizes the experimental and model parameters. These plots show the top and bottom reservoir concentration (also the side reservoir concentrations for Mode 4) versus number of cycles. Curves computed from the theory described above are also given. The calculated results agree reasonably well with the observed values.

Figure 8.8 and 8.11 show that by the use of modes 1 or 4, the hemoglbin concentration in the bottom reservoir builds up from cycle to cycle, and approaches a steady value as n becomes large. However, albumin migrates toward the side reservoir when Mode 4 is used, whereas no separation occurs when Mode 1 is applied. The concentration profiles for Mode 2 are presented in Figure 8.9 . As the model predicts both the hemoglobin and albumin migrate in the opposite direction, and concentrate in the bottom(P1) and top(P3) reservoirs respectively. Figure 8.10 shows the concentration profile of the proteins for Mode 3-A operation. It is seen that hemoglobin moves toward the top reservoir and albumin moves toward the bottom reservoir. As a result, hemoglobin is concentrated and albumin is depleted in the top reservoir; albumin is concentrated and hemoglobin is depleted in the bottom reservoir.





Experimental Results-Mode 3 Figure 8.10



















Figure 8.12 Schematic of Two-Column Parapump-Mode 3A.

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TABLE 4 EXPERIMENTAL AND MODEL PARAMETERS $Q = 1.67 \times 10^{-8}$; Feed: Haemoglobin = 0.02 wt % Albumin = 0.02 wt % m³/s $P_1 = 8.5; P_2 = 6.2$ Tris.-NaOH 0.15M -Maleate NaCl 0.05M Tris.-NaOH 0.15M -Maleate NaCl 0.05M $lS_1 =$ $lS_2 =$ ł: Haemoglobin: $k_{\mu_1} = 1.4$; $k_{\bar{\rho}_2} = 2.0$ $k_{\nu_1}^+=3.0;\ k_{\nu_2}^+=1.0$ $k_{\mu_1}^- = 1.5; \ k_{\mu_2}^- = 1.5$ $k_{\mu_1}^+ = 2.5; \ k_{\mu_2}^+ = 2.5$ Albumin: Mode 1 Mode 2 Mode 4 $\frac{(V+V_{T}^{*})}{P_{3}}/\overline{V}$ 1.5 L5 1.88 4.2 3.8 4 IS₃ Acetic Acid- Na-Acetate NaCl 0.2M 0.15M 0.2M 0.05M $Qt_1 = Qt_{111} = Qt_v =$ $Qt_{v11} = 15$ $Qt_{11} = Qt_{1v} = Qt_{v1} =$ $Qt_{v11} = 30$ $Qt_{v11} = 30$ $m^3 \times 10^6$ $Qt_1 = Qt_{111} = 15$ $Qt_1 = Qt_{111} = Qt_V = 15$ $Qt_{ii} = Qt_{iv} = Qt_{vi} = 30$ $Qt_{II} = Qt_{IV} = 30$ Mode 1 Mode 2 Mode 4 . Haemoglobin ~ $k_{\nu_3}^+$ $k_{\nu_3}^+$ Albumin 4.0 -----1.0 0.3 _

4.5

20

1.5

 $V_{\gamma} = V_{\theta} = V_{MB} = V_{SR}$

k 103 k 103 The equilibrium constants K used for computations(Table 4) were determined experimentally. Note that K is a function of ionic strength and pH. In subsequent chapters, we will discuss the procedure for determining the K value.

8.2: M-Column Batch Parapump

The two column system described above can be extended to multi-column systems (Figures 8.13 to 8.15). The systems consist of a series of M columns. The columns with odd numbers are packed with anion exchanger, and the remaining columns are with cation exchangers. The graphical construction for concentration profile can be made in the same way as described for the one- and two-column parapump systems.

Mode 5:

This system is the extention of mode 1. The pH in both top and bottom reservoirs are maintained at Pl. The pH values for the middle reservoirs, MR1,MR2, - - -, MR_{M-1} are repectively P2, P1, P2, - - - P2. For protein A, an M-Step staicase is formed and a very high separation factor (Y(Bss)/Y(Tss)) can be obtained when M becomes large. Thus, this parapump system operating with pH levels of Pl and P2 (P2 < IA < Pl), is capable of removing protein A from the top reservoir and concentrating it in the bottom reservoir. However, protein B remains unaffected.



Graphical Solution for Multi-Column Parapump-Mode 5.


Figure 8.14 Graphical Solution for Multi-Column Parapump-Mode 6

Mode 6:

As one can see from Figure 8.14, this mode is a combination of modes 2 and 3. As a result, this mode gives an M-Step staircase for both protein A and B on X-Y diagram. Furthermore, protein A migrates upward and concentrates in the top reservoir, while protein B moves downward. Thus, A and B split from each other. As M becomes larger, SF (Y(Tss)/Y(Bss)) approaches infinity for protein A, while SF approaches zero for protein B.

Mode 7:

As shown in Figure 8.15, the system is a generalization of Mode 4. There are top and bottom reservoirs, and (M-1) middle reservoir and (M/2) side reservoirs. The side reservoirs, and are maintained at pH=P3, and the remaining remaining reservoirs have the same pH values as those for Mode 5. As shown in Figure 8.15, for protein A, an M-step staircase is formed and the separation factor increases as M increases. It is also shown, that A is concentrated in the bottom reservoir and Protein B moves toward the side reservoir. Since the reservoirs are so arranged that only one staircase is obtained for protein B.

Figure 8.16 shows the dependence of the steady state separation factor (SF) of M. For all three modes(Modes 5, 6, and 7), SF for protein A increases as the M increses. For protein B, SF decreases as M increases for a parampup operating with Mode 6, and remains constant for Mode 8. However, no separation will take place for B when Mode 5 is used.







Figure 8.16 Steady State SF_{SS} VS. Number of Column

8.3: Open Parametric Pumping

In this section, we shall discuss the open parapump with the The open parapump includes feed stream single cell model. introduced to, and product stream withdrawn from, the parapump. Figure 8.17 shows the operation procedure in a cycle for 2-column open parapump. It is seen that the operation is similar to that is added to of Mode 3 of batch parapump. An additional step withdraw the products and to introduce feed into the reservoir. The displacement is adjusted unevenly corresponding to the feed so that the reservoir volume is unchanged after an location. operation cycle. For example, we may feed the top reservoir 12 СC per cycle, and displace 18cc down from the top reservoir to the bottom reservoir in the first step, and then 12 cc for the other displacement steps as shown in Figure 8.18. Thus the gained 6 cc in the bottom reservoir is withdrawn as product, and the volume of the bottom reservoir is unchanged at the end of the cycle. For the top reservoir, the loss of 6 cc in displacement and 6 cc in product is balanced with 12cc feed to this The effect of feed location on separation is studied reservoir. on two-column and four-column open parapumps with the parameters: feed=12cc/cycle, resevoirs volume=30cc, and the height of each packed bed = 8 cm. The results are shown in Figures 8.18 and 8.19. The values of K for each component at each ionic exchanger and pH level is also listed in Figure 8.18. One can see from Figure 8.18 that the best feed location is the middle





Figure 8.18 Effect of Feed Location on Separation for 2-Column Parapump.



Figure 8.19 Effect of Feed Location on Separation for 4-Column Open Parapump

reservoir(curve 1 and 2). Separation is poor for the feed introduced into the top and bottom resevoir (curve 3 and 4). The study of feed location on 4-column open parapump is shown in Figure 8.19. It is also seen that the best separation is obtained when feed is introduced into the central reservoir The computation parameters used in (curve 1 in Figure 8.19). Figure 8.19 are the same values as those in Figure 8.18. These results are explained as follows. When feed is introduced into the middle reservoir, the fluid has even chance to be an separated by the two columns; when feed is introduced into the top or bottom reservoir, feed solution mixes with product and causes poor separation. This phenomenon is similar to that in usually not introduced to distillation in which feed is the condenser or to the reboiler. Figure 8.20 shows the separation of 2-column open parapump with uneven product stream. Feed the middle reservoir(pH=Pl) with 12 cc per cycle, and products are withdrawn from the top and bottom reservoir in 5 patterns as It is seen that the best separation is shown in Figure 8.20. obtained when the volumes for top and bottom products are equal (curve 3). It is also seen that when one product stream is zero, separation is very poor, and no separation at steay state the (Curves 1,5). The separation factor for uneven product stream is defined in equation (8.6) .

 $SF = \begin{bmatrix} YA & YB & PDT PDB \\ -- &] & [--] & ----- \\ YB & PDT & YA & PDB & (F/2) & (F/2) \end{bmatrix}$ where PDT: volume of top product per cycle PDB: volume of bottom product per cycle

Curve	CC PDT	PDB	Total Recovery
1	12.	О.	.515
2	9.	3.	.629
3	6.	6.	.651
4	3.	9.	.618
5	0.	12.	.507





Figure 8.20 Effect of Product Taken on Separation for 2-Column Open Parapump.

F = PDT + PDB : volume of feed per cycle

It is seen in equation 8.17, that the 3rd term of the right hand side is maximum when PDT=PDB=(F/2). It has to be pointed out that equation 8.17 is not applicable when one of the product streams is equal to zero. The total recovery, as defined in equation (8.7), is listed on the 4th column of the insert table.

The maximum recovery is obtained when the sizes of top and bottom products are equal for the values of K listed in the figure. It is understood that, for particular interest the uneven product stream may be desired. For example, when we are only interested in the top product stream, optimization will be emphasized on the top product stream.

The Effect of Equilibrium Constant :

It is understood that the separation of parapump is caused by the shift of equilibrium distribution as the control variable changes. The effect of the value K on separation is studied on the 4-column open parapump. Feed solution is introduced into the center reservoir and products are withdrawn from the top and bottom reservoirs. The amount of feed is equal to half of the void volume of a column, VE, .ie., (F/2)=PDT=PDB=(VE/4). The

parapump is operated with 3 pH levels, Pl, P2, and P3, and P1 > For illustration, the K values are grouped IA > P2 > IB > P3.into two values, Kl and K2, for all components in the 3 Hα two ionic exchangers. Kl stand for the adsorption levels and favor equilibrium constant, and K2 for the adsorption unfavor We denote Kl for proteins at pH higher equilibrium constant. than I.E. in the anion column and for proteins at pH lower than in the cation column; K2 for proteins at pH lower than I.E. I.E. in the anion column and for proteins at pH higher than I.E. in the cation column.

$$K1=K(P1, An, A) = K(P2, An, B) = K(P2, An, B) = K(P2, C, A) = K(P3, C, A) = K(P3, C, B)$$

$$K2=K(P3,An,A)=K(P2,An,A)=K(P3,An,B)=K(P1,C,A)=K(P1,C,B)=K(P2,C,B)$$

where: An = Anion Exchanger ; C = Cation Exchanger

Figure 8.21 plots the calculated steady state separation factor on the Kl and K2 domain. The curves in the figure stand for constant separation factor. For given Kl and K2, one can use this figure to estimate the separation results by interpolating these constant separation curves. Note that Figure 8.21 is symmetric to the diagonal line (SFss=1.). Above the diagonal line, where SFss is higher than 1., is the region of normal operation. Below the diagonal line, SFss is less than unity, and the parapump is operated in the region of reverse separation. For



Figure 8.21 Calculated Separation Factor in K1 and K2 Domain

convenience, Figure 8.22(a;b) plots the separation factor versus (K1/K2) with fixed parameter K1. Figure 8.22(a) is ploted for the normal separation and Figure 8.22(b) is for reverse separation region. The two Figures are mirror images to each other.

8.4 : Separation of Multiple-Solute System Via Open Parapump

A system of multiple components mixture is studied on 6-column open parapump. It is assumed that there is no interferece between the components. The feed consists of 6 components, namely, A, B, C, D, E, and F, and the corresponding isoelectric points are IA, IB, IC, ID, IE, and IF. The arrangement of the three pH levels will affect the separation significantly. Two cases of pH arrangement have been studied.

Case 1: Choose three pH levels P1, P2, and P3, such that,

P1 > IA > IB > IC > P2 > ID > IE > IF > P3

For the purpose of illustration, we grouped the equilibrium constants of each component into 2 values as shown in Tables 5 and 6. For each component a higher K value is assigned to pH > I.E. in anion column and to pH < I.E. in cation column; a smaller value of K is assigned to pH < I.E. in anion column and to pH > I.E. in anion column.





Figure 8.22 Calculated Separation Factor with Fixed K1

Table 5: Case l	
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	anion exchanger			cat	cation exchanger		
Comp.	Pl	P2	P3	P1	P2	P3	
 А	1.6	0.5	0.5	0.5	1.6	1.6	
В	1.5	0.5	0.5	0.5	1.5	1.5	
С	1.4	0.5	0.5	0.5	1.4	1.4	
D	1.3	1.3	0.5	0.5	0.5	1.3	
Е	1.2	1.2	0.5	0.5	0.5	1.2	
F	1.1	1.1	0.5	0.5	0.5	1.1	

Figure 8.23 shows the calculated <Yi>_{PDT} /<Yi>_{PDB} versus the number of cycle operation. The computation is based on an equal molarity feed F=6cc/cycle, the two product streams PDT=PDB=F/2, height of each column = 8cm, and reservoir volume = 20cc. It is seen in Figure 8.23, that components A, B and C are more concentrated in the top product stream, and components D, E, and F are more concentrated in the bottom product stream.

Case 2: Choose three pH levels Pl, P2, and P3, such that,

IA > P1 > IB > IC > P2 > ID > IE > P3 > IF

The equilibrium constants used for calculation are listed in Table 6.



Figure 8.23 Separation of Multiple Components System-Case 1

	anion exchanger			cation exchanger		
Comp.	Pl	P2	P3	Pl	P2	P3
A	0.5	0.5	0.5	1.6	1.6	1.6
В	1.5	0.5	0.5	0.5	1.5	1.5
С	1.4	0.5	0.5	0.5	1.4	1.4
D	1.3	1.3	0.5	0.5	0.5	1.3
E	1.2	1.2	0.5	0.5	0.5	1.2
F	1.1	1.1	1.1	0.5	0.5	0.5

Table 6 : Case 2

The results for case 2 are shown in Figure 8.24. As one can see, components B and C are concentrated in the top product stream; component D and E are concentrated in the bottom prooduct stream; component A and F are equally distributed in the top and bottom product streams. No separation is predicted for components A and F because the 3 pH levels are all higher than the isoelectric point of component F and lower than that of component A.

 $IA > P_I > IB > IC > P2 > ID > IE > P3 > IF$



Figure 8.24 Separation of Multiple Components System-Case 2

Chapter 9 : Multi-Cell Model and Semi-Continuous One-Column Parapump

The multi-cell in series model , as described in Chapter 4, is used to examine a semi-continuous one column parapump. In this chapter, equations (4.3), (4.5), linear equilibrium relationship, and equation (4.7) with B=1 are applied simultaneously to solve the pH, X, and Y. Since B=1 in equation 4.7, the change of pH is assumed sharply and as quickly as the bulk fluid flow velocity. The emphasis of this chapter is to examine the dynamic characteristics of the column of the Parapump. Included are the distribution profile of state variables, kinetic parameters, equilibrium parameters in the one-column open parapump.

9.1: Process Description of One-Column Semi-Continuous Parapump

Figure 9.1 shows the operation of a semi-continuous one-column parapump. The one-column parapump studied here has been described in previous chapters. It has already been shown that protein A can be separated from a mixture provided that its isoelectric point, IA, lies between the two pH levels, i.e., P2 < IA < P1 . The flow system of the semi-continuous parapump has eight distinct stages in each cycle(Figure 9.1):

(I) Pump the low pH(P2) fluid from the top reservoir to the



Figure 9.1 Column Diagram for Semi-Continusous Parapump

top of the column for time t_I, while the solution emerging from the other end enters the bottom reservoir.

- (II) Circulate the fluid between the top reservoir and the column for time t_{II}. During this step the pH in the column is ensured to change from Pl to P2. As a result, the counter ions(S+) are exchanged for the positively charged protein(A+) originated from the top reservoir.
- (III) Feed at the bottom of the column with the mixture of pH=P2 for time t_{III}, and simultaneously a top product free of A is removed from the column at the same rate. In addition, the solute isinitially presents in the bottom feed is exchanged for S+ .
- (IV) Circulate the fluid between the top reservoir and the column for time t_{IV} . This will allow the concentration in the column and the top reservoir to become uniform.
- (V) Pump the fluid with pH=Pl from the bottom reservoir to the bottom of the column for time t_V, and at the same time the solution free of protein A flows out of the column to the top reservoir.
- (VI) Circulate the fluid between the bottom reservoir and the column for time t_{VI}. This will insure that the pH in the column is shifted back to Pl, and desorption of A occurs. S+ shifts back to the bed and the ion

exchanger is then regenerated.

- (VII) Feed at the top with the mixture of pH = Pl for time t_{VII}, while a product rich in A is withdrawn from the bottom of the column.
- (VIII) Circulate the fluid between the column and the bottom reservoir. This will result a uniform concentration between the column and the bottom reservoir. One cycle is thus completed.

By repeating the process described above in the succeeding cycles, one may see that in the limit of a large number of cycles, the system is capable of removing A from the feed streams and transferring it to the bottom product stream. Note that the flow rate, Q, within the column is always identical to the reservoir displacement rate. The volumes of the bottom and top feed (Qt_{III} and Qt_{VII}) are respectively equal to those of the top and bottom products. Also, the upward and downward flow have the same displacement, i.e. $Qt_{III}=Qt_{VII}$.

9.2 : Determination of Equilibrium and Mass Transfer

To implement the computation of concentration profiles, we must have the equilibrium constants, Kl and K2, and the rate constant, λ . These parameters can be determined experimentally via the following modes of parapump operation: Mode 8: No circulation (tc = $t_{II} = t_{IV} = t_{VI} = t_{VIII} = 0$)

Figure 9.2 shows the calculated separation $factor(\langle YBP \rangle_n / \langle YTP \rangle_n)$ vs. number of cycles for several values of λ . As expected, this parameter does significantly affect the separation. For small λ , little mass transfer occurs between phases and hence little separation takes place. As λ increases, the amount of interphase mass transfer increases toward a limit imposed by equilibrium.

Mode 9: With circulation and assume that:

 $t_{II} = t_{IV} = t_{VI} = t_{VIII} = tc$ where tc = time duration of circulation.

Figure 9.3 shows the calculated separation factors vs. n for $\lambda = 1.667 \times 10^{-3}$ and 6.667 x 10^{-3} . As to increases SF will increase or decrese, depending on the value of λ , and approach a limit-equilibrium condition. When the value of λ is small(e.g. 1.667×10^{-3}), SF increases with to . However, for a larger value of λ (e.g. 6.667×10^{-3}), an opposite effect will result. Also as to increases, the mixing between the column and reservoir becomes significant; and at the end of each circulation step(i.e., steps II, IV, VI or VIII in Figure 9.1), the adsorption column should have a uniform concentration in either fluid or solid phase.





Figure 9.3 Effect of Circulation on Separation

Figure 9.4 and 9.5 show the typical experimental results respectively by Modes 8 and 9. As expected, hemoglobin does migrate downward and accumulate at the bottom end. In both top and bottom product streams, albumin concentration is essentially unaffected.

The experimental data shown in Figure 9.4 were obtained based on tc = 1440 sec. Although not shown, the results for tc > 1440 secs are essentially identical to those for tc=1440 secs. This is to say that the data shown in Figure 9.4 were obtained at equilibrium. These data were used to predict the equilibrium constants as follows: (1) assume values of K1 and K2, (2)Let λ be infinity and calculate the transients using the STOP-GO method, and (3)If the calculated results fit the data K1 and K2 are the desired values. If not, assume new equilibrium constants and repeat steps 2 and 3. The estimated values of K1 and K2 for runs 2 and 3 (Figure 8-4) are respectively,

K1 = 0.33; K2 = 5.

Figure 9.5 shows the experimental results via Mode 8 for Q = 1.667×10^{-2} and 5×10^{-2} cm/Sec. The data were used to determine the velocity dependence of λ . The values of λ were obtained by matching calculated plots of separation factor vs. n with experimental data using the following procedures: (1) Assume the value of λ , (2) Using the K values obtained above, calculate the



Figure 9.4 Experimental and Caculated Concentration Transient.

SF vs. n(by Stop and GO method), and (3) If the calculated results check with the data, the λ is the desired one. If not, assume a new λ and repeat steps 2 and 3. The estimated λ 's for Runs 4 and 8 are:

Run 4:
$$\lambda_1 = 5 \times 10^{-3}$$
 for $Q_1 = 1.667 \times 10^{-2}$
Run 8: $\lambda_2 = 2.33 \times 10^{-3}$ for $Q_2 = 5 \times 10^{-2}$

By applying the following model(Sweed and Wilhelm^[31])

$$\frac{\lambda_2}{\lambda_1} = \begin{pmatrix} Q_1 \\ -Q_2 \end{pmatrix}^a$$
(9.1)

obtains a=0.693, thus, the correlation of rate conststant with the flow velocity is:

$$\lambda = \lambda_1 \left(\frac{Q_1}{Q}\right)^a = 2.036 \times 10^{-2} Q^{-0.693}$$
 (9.2)

From the equation 9.2, one can calculate λ for any given Q. Equation (9.2) and the estimated K values are based on Runs 4 and 8, and can only be applied to a parapump for which the buffer pH levels and ionic strengths are identical to those for Run 4 and 8.

In most mass transfer operations, the film mass transfer coefficient is increased with the increase of flow velocity. It is seen in this ionic exhanger gel, that the mass transfer rate constant(λ) is decreased with the increase of flow velocity.



This observation may be explained by the smaller volume of exchanger gel in higher flow rate. Figure 9.6 plots the volume exchanger gel versus the flow rate at the buffer ionic of strength IS1 (0.1 M Tris + 0.1 N NaCl). Since λ is the product of mass transfer coeffficient and specific surface. The reduction of exchanger volume will reduce the specific surface, and affect the mass transfer coefficient in a rather complicated The overall mass transfer coeffcient consists of the wav. film coefficient, intra-particle coefficient, and the external surface coefficient. The reduction of exchanger volume will intra-particle (pores) resistance. Thus the the increase reduction of exchanger volume in a higher flow rate leads to the (1) reduce the sepcific surface, (2) increase the following. intra-particle resistance, (3) increase the surface resistance. These three effects may overwhelm the effect of external film coefficient which is increased as flow velocity is increased; hence a smaller λ results. Further quantitative treatment of the intra-particle coefficient would be an interesting research, however, such work is not included in this thesis.

9.3 : Validity of Model and Result of Theoretical Exploration

The model equations and the correlated values of λ , Kl, and K2 were further tested with additional experimental results, and were applied to explore the behavior of the semi-continuous



Figure 9.6 Effect of Flow Rate on the Height of Bed

one-column parapump. It shoud be pointed out that equation (9.2) is derived from the data of separation factor(SF) vs. number of cycles, n. It can also be applied to the prediction of concentration transients (Figure 9.7). The agreement between calculated results and the data is quite good. Figure 9.8 shows two additional experimental runs used in verifying the validity of the model. The expermintal and model parameters are summarized in Table 7. The effect of Q on separation is also shown in Figures 9.7 and 9.8. A decrease in Q results in an increase in λ , and thus separation. However, if Q becomes too small, axial diffusion may become significant, and a poor separation may result.

Figure 8 illustrates the effect of feed on separation. This figure shows the calculated results (for $F_T = F_B$) with tc=0. F_B and F_T are respectively equal to Qt_{III} (bottom feed) and Qt_{VII} (top feed). For small λ (i.e., $\lambda = 0.005$) the separation factor at steady state (SFss) decreases as F_T (or F_B) increases. For large λ (or a parapump operated near equilibrium), separation factor (SFss) increases very rapidly reaching a maximum value as F_T (or F_B) increases. Further increase in feed size results in a drop of SFss, because the intermixing between the feed and product streams.

Wilhelm et al.^[31] studied thermal recuperative parapumps and showed that for large values of λ (heat transfer rate



Experimental Data for Rumns 4 and 8.

12:



Table 7. Experimental and Model Parameters

 $k_1 = 0.33 P_1 = 8; IS_1 = 0.2M NaH_2 PO_4 + 0.2M Na_2 HPO_4 + 0.1M NaCI$ 5 P2 = 6; $IS_2 = 0.05M NaH_2P_4 + 0.05M Na_2HPO_4$ K2 =

L = 0.08 m, $y_0 = 0.02 \text{ weight \% of haemoglobin + 0.02 weight \% of Albumin$

 $Qt_{\rm I} = 1.2 \times 10^{-5} {\rm m}^3$

	n <u>Albumin</u>	1.0	1.0	1.0	1.0	1.0	1.0
y _{co} / y _c	Haemoglobi	0.9	0.9	0, 5	0.5	0.5	0.7
~	VDT=VDB, m	5 x 10 ⁻⁶	5×10^{-6}	15 x 10 ⁻⁶	15 x 10 ⁻⁶	15 x 10 ⁻⁶	15 x 10 ⁻⁶
~	FT, m	9 x 10 ⁻⁶	5.5 x 10 ⁻⁶	6.5 x 10 ⁻⁶	12 x 10 ⁻⁶	9 x 10 ⁻⁶	9 x 10 ⁻⁶
	F _B , m ³	4 x 10 ⁻⁶	2 x 10 ⁻⁶	5 x 10 ⁻⁶	10 x 10 ⁻⁶	4×10^{-6}	3×10^{-6}
	A #60	Equilibrium	Equilibrium	0.3	0.3	0.19	0.14
لد ا	р В	1,440	1,440	0	0	0	0
a	m ^{3/в}	1.667 x 10 ⁻⁸	1.667 x 10 ⁻⁸	1.667 × 10 ⁻⁸	1.667 x 10 ⁻⁸	3.333 x 10 ⁻⁸	5. x 10 ⁻⁸
	Run	7	e S	4	6	7	8
constant between the solid and fluid phases) the steady state separation factor for a batch pump is essentially a constant and does not change with λ . This is consistent with what we have shown in Figure 9.9. Note that this figure is based on the assumption that there is no lag between the fluid displacement and pH transfer flux(i.e., B=1 and C=0, in Equation (4.7)), corresponding to that of GUMA approaches infinity in Wilhelm's thermal parapump. At $F_T = F_B = 0$ (batch parapump), the SFss is 15 and is independent of λ . This occurs because for a batch pump, regardless of λ , compositional equilibrium exists between phases at steady state(when n is infinity).

Figure 9.10 shows the effect of F_T and F_B on the bottom product concentration. The volumes of top and bottom feeds(F_T and F_B) are respectively equal to those for bottom and top products (PB and PT). As F_T decreases or F_B increases, (<YBP>ss/Yo) increases. The effect becomes more profound at low values of F_T . If one desires, for example, to obtain a very high concentration of a desired protein from a mixture, one would operate a parapump at a low value of F_T and high value of F_B . Also, for a given (<YBP>ss/Yo), an increase in the bottom feed (F_B) results in an increase in the bottom product(PB).

Figure 9.11 shows the effect of the column height on the separation. Two cases are considered; h=0.08 and h=0.16m. The values of Qt_T , F_T and F_B for h=0.16 m are set to be twice



Figure 9.9 Effect of Feed Size on Separation



Figure 9.10 Effect of The Feed Size on the Bottom Concentration

of those for h=0.08m. For the equilibrium case(λ is infinity) h has essentially no effect on the separation. For the case of finite mass transfer, separation increases with h. The influence of the dead volume(VDT or VDB) in the reservoir is shown in Figure 9.12. Increasing the volume shows a slow down in the separation, but does not affect the ultimate separation.



Figure 9.11 Effect of Column Height on Separation



Chapter 10: Comparison of Separation by Cycling Zone and Parametric Pumping, with Multi-Cell Model and pH Wave Equation

10.1 : Cycling Zone and Parametric Pumping

Parametric pumping and cycling zone are two separation techniques which separate a fluid mixture by applying a periodic change of control variable to a system. The common separation principle of these two techniques is:

 periodic alternation of the control variable to induce interphase mass transfer in the column.

(2) the interphase mass transfer flux is reversible.

The difference between parametric pumping and cycling zone is:

- the fluid flow is reversible for parametric pumping and unidirectional for cycling zone.
- (2) parametric pumping has one more degree of freedom (displacement) than cycling zone.

10.2 : Model Equations

In the previous chapter, we assume that the velocity of the pH wave is equal to the velocity of fluid flow. Such assumption is not held in this chapter, and equation (4.7) is applied to correlate the pH wave velocity. Again, the STOP and GO method is applied to solve pH, X, and Y from equations (4.7), (4.3), and

3.2 (local equilibrium theory is applied) along with the equilibrium relations. Since the equilibrium relation is pH dependent, and the pH is a continuous function in (z,t) domain when B is not equal to unity and C not equal to zero, an expression for equilibrium relation to pH is required to compute the control variables of systems. In this chapter, we apply the linear iso-pH equilibrium relationship, X=K(pH) Y, and the iso-pH equilibrium constant, K(pH) , is assumed to have a linear relation to pH in the range from Pl to P2, as stated in equation (10.1).

$$K(pH) = K(P1) + {K(P2)-K(P2)} (pH-P1)/(P2-P1)$$
 (10.1)

10.3 : Analytical solution of pH Breakthrough Curve

We first examine the pH breakthrough curve with pH wave equation (4.7) in the multi-cell model. For a column consisting of N cells in series, as shown in Figure 10.1(a), fluid is introduced to the 1st cell and exits at the Nth cell. In the multi-cell model, the fluid flow is considered as being transfered down discretely and sequentially from the top cell to the bottom cell, and each transfer displaces the void volume of a cell. For example, the fluid at the i-th cell and at time=(j-1) dt, is transfered to the (i+1)-th cell at time=j, and the i-th cell receives the fluid transfered from the (i-1)-th cell. The





Figure 10.1

(a) N Cells Column

2///

1+13 V i-1

:

equations for the pH model and the boundary conditions for a breakthrough operation is stated in equations (4.7), (10.2), and (10.3) .

$$pH(i,j) = pH(i-1,j-1) \cdot B + pH(i,j-1) \cdot C$$
 (4.7)

IC:
$$pH(i,0)=pH0$$
 for $i=1,2,...$ N (10.2)

BC:
$$pH(0,j)=pHN$$
 for $j=1,2,...$ (10.3)

When B and C are constants, the equation 5 has a solution

$$pH(i,j) = pHN B \sum_{k=1}^{i} \frac{j-i+1}{k-1} + pHO C \sum_{k=1}^{j-i+1} \frac{j}{k-1} + \frac{j}{k-1}$$

In the special case where C=1-B, the solution becomes:

$$pH(i,j) = pHN B \sum_{k=1}^{i} {j-i+1 \atop k=1} {k+i-2 \atop k=2} {k-1 \atop k=2} {k-1 \atop k=2} {k-1 \atop k=1} {k-1 \atop k$$

pH(i,j) can be calculated for given i,j with the process constants pHN, pHO, B, and C. This analytical solution is derived from a column which is initially uniform, as stated in the initial condition (10.2). The calculated numerical results by the above analytical solution are shown in Figure 10.2, 10.3. Figure 10.2 shows the pH wave versus dimensionless volume flow It is also shown that pH transition with through volume, j/N. respect to dimensionless elution volume (j/N) is affected by the For example, in order to shift the pH from pH0 to value of N. 7.5 it takes j/N = 1.2 for N=2, and takes j/N = 1.53 for N=4. If we have two columns, say Column 1 and Column 2, we may denote the height of the columns as L1 and L2, respectively, and L2=2 * L1. In order to achieve the same change of pH in the last cell, Column 2 needs an elution volume which is more than double of the elution volumn required for Column 1.

It is shown that the steepness of the pH curve is increased as N increased. pH changes abruptly at j/N = 1/B when N is very large. Figure 10.3 shows the pH versus j/N with B=0.4, 0.5, 0.8 respectively and N=1000. In real world the experimental pH elution curve is shown in Figure 10.4(a) and 10.4(b) for a column packed with CM-Sepharose ionic exchanger. The experimental data of pH breakthrough curve are matched with the theoretical results shown in Figures 10.2 and 10.3, and give an estimated value of (1/B) roughly equal to 1.68 from Figure 10.4(a) and 2.4 from



Figure 10.2 Calculated pH Breakthrough Curve



Figure 10.3 Calculated pH Breakthrough Curve for N=1000

Figure 10.4(b). Thus the corresponding estimated value of B ranges from 0.6 to o.4. Since the pH data in Figures 10.4(a) and 10.4(b) is not steep enough, the B value obtained here is rather a rough estimation. In the following section, the B value is obtained from the data fitting of pH in cycling operation, which gives a B value ranging from 0.5 to 0.55, and confirms the previous estimation.

10.4 : Separation of Cycling Zone for Single Solute System

A cycling zone device is schematically shown in Figure The apparatus includes an adsorptive column and two 10.1(b). reservoirs in top of the column. The reservoirs contain feed fluid mixture, and the pH of the two reservoirs are kept at Pl and P2 respectively. The cycling zone is operated in such a way that the fluid mixture is introduced into the top of column alternatively from two reservoirs. Thus the the pH level of a particular location in this column is periodically changing and with the same frequency as the periodic alternation of the pH of fluid entered the column. The periodic change of control variable in the column, synchronizes the change of adsorptive (pH) equilibrium, and is coupled with the interphase transfer in the column. The fluid phase concentration is depleted in adsorption favor zones(with large equilibrium constant), and enriched in the adsorption unfavor zones(with small equilibrium constant).



Figure 10.4 Experimental pH Breakthrough Curve

Figure 10.5 shows the experimental cycling waves of pH and concentration of albumin in anion exchanger column. It is seen that the peak of solute concentration occured when the pH changed from adsorptive favor pH to adsorptive unfavor pH. This is simply explained as follows. The solute moves to solid phase when adsorptive favor pH dominates the cell, and solute moves back to the fluid phase when adsorptive unfavor pH dominates the cell. Thus the peak of solute concentration is enriched at the adsorptive unfavor pH front as seen in Figure 10.6 and 10.8.

The model equation of pH and concentration for cycling zone fluid flows down from top in multi-cells in series can be written in the following equations.

Equations (10.6)-(10.9) are applied to calculate the pH value, with the calculated pH and equations (10.10) - (10.12), and (10.1) are applied to calculate the solute concentration in each



Figure 10.5 pH and Concentration Wave for Albumin in R⁺ Column



Figure 10.6 pH and Concentration Wave for Hemoglobin in R⁻ Column P1=8.5, P2=5.7

cell after a transfer step. Figure 10.6 and 10.8 show the correlation of pH wave and concentration wave for hemoglobin in cation exchanger column, and albumin in anion exchanger column. of solute occured, and the model gave a fair Separation correlation in pH and concentration wave in these two cases. Figure 10.7 and 10.9 show no essential separation though the state variable, pH, is periodically changed in the column. This is because the rather insensitive adsorptive equilibrium for both level is far higher (or lower than) the isoelectric point of ЪЦ this protein. The value of K_{P1}, K_{P2}, N, and B, as shown in the figures, are obtained from best fitting of experimental data.

10.5 : Separation of Parametric Pumping for a Single Solute System

A parametric pumping device is again schematically shown in Figure 10.1(c) as a comparison to the cycling zone device. The apparatus of parametric pumping is described in Chapter 6. As stated before, the fluid in the two resevoirs is alternatively pumped up and down into the column, and the fluid originally existing in the column is collected in the reservoir at the other end of the column. Thus the flow direction and the pH level at a particular location in this column is periodically changed with the same frequency as the the flow direction and pH alternation. Notice that parametric pumping involves reverse fluid flow and



Figure 10.7 pH and Concentration Wave for Albumin in R-Column P1=8.5; P2=5.7



Figure 10.8 pH and Concentration Wave for Albumin in R^+ Column; P2=5.7; P3=4.0



Fig 10.9 pH and Concentration Wave for Hemoglobin in R+ Column P2 = 5.7, P3 = 4.0

cycling zone only involves unidirectional fluid flow.

Equation (10.1) to (10.2) and local equilibrium are applied in parametric pumping separation. The displacement of parametric another parameter which affects separation. is The pumping optimal displacement for parapump operation versus the amount of feed with fixed B value is shown in Figure 10.10. It is seen that when B=1.0, the optimal displacement is always equal to the void volume of column. The optimal displacement increases as the B value decreases. Also, the optimal displacement decreases when increases. The control variable (pH) is closer to being feed completely changed when the feed or displacement is increased, and thus enhances separation.

10.6 : Comparison of Parametric Pumping and Cycling Zone in Single Solute System

The comparison of cycic zone and single column parametric pumping in terms of separation factor and production rate is shown in Figure 10.11 and 10.12. It is clear that parametric pumping is favored for higher separation factor and the advantage is significant for small feed and small B value. The cycling zone is favored for production rate at any feed amount and B value. In Figure 10.13, the separation factor is ploted against the production throughput for cycling zone and parametric pumping. It is seen that the domain of parametric pumping





One-Column Parapump and Cycling Zone



occupies the area in up and left, and the domain of cycling zone is nearly a curve on the right of the figure. Figure 10.13 again shows that parametric pumping favors separation factor and the cycling zone favors throughput. Two experimental points are indicated on this figure as a reference to a real situation. The above comparison is based on the same size column in parapump and cycling zone with semi-continuous operation. It is possible to operate cycling zone continuously by using two parallel units, and parapump continuously by using 4 parallel units. The continuous parapump and cycling zone, as shown schematically in Figure 10.14, are studied in computer simulation. The results of these 2 continuous process are shown in Figures 10.15 and 10.16. It is seen that the domain of continuous parapump (4 parallel units) is shifted toward the right, and its right margin overlaps domain curve of continuous cycling zone (2 parallel units). the Thus the parapump can obtain the same throughput as the cycling zone does, and it is still possible to obtain a higher separation factor under certain operation conditions. The result for B=0.7 is shown more clearly in Figure 10.16. The parapump can obtain a higher separation factor under some operating conditions and can also operate for a large throughput.

10.7 : 3 pH Level Cycling Zone

Hemoglobin can be separated by cycling zone operation with

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Figure 10.13 Comparison of Cycling Zone and Parapump in Separation for B ranges from 0.0 to 1.0







Figure 10.15 Comparison of Continuous Parapump and Cycling Zone for B ranges from 0.0 to 1.0



Figure 10.16 Comparison of **C**ontinuous Parapump with Cycling Zone at B=0.7

periodic alternation of pH from 6 to 8, and albumin can be separated by cycling zone operation with periodic alternation of pH from 4 to 6. A three pH level cycling zone operation is theoretically investigated by computer simulation. It is assumed adsorptive equilibrium of individual species is that the uninterfered by the other in the multiple solutes mixture. 3 Α pH cycling zone device is schematically shown in Figure 10.17. apparatus of the 3 pH level cycling zone includes an The adsorptive column and three reservoirs in top of the column. Reservoirs contains feed fluid mixture, and the pH of the three reservoirs are kept at Pl, P2, and P3 respectively. The cycling zone is operated in such a way that the fluid mixture is introduced into the top of column alternatively from three reservoirs. Thus the pH level of a particular location in this column is periodically changing from Pl to P3 and with certain time duration in which pH close to P2 synchronizes the alternation of the pH of the fluid mixture entered the column. Figure 10.18 shows the output pH wave and concentration wave of 2 components. It is shown that there are 3 pH plateaus, say high, middle, and low, in the output pH wave. It is also shown that there are two distinct peaks of output concentration wave for the two components, A and B. The separation factor for two solutes mixture is defined by equation (10.13).



Figure 10.17 Schematic Digram of 3-pH Cycling Zone







Figure 10.19 pH and Concentration Wave in 3 pH Cycling Zone (Enlargement of Figure 10.18)

- where Yi : concentration of component i ; (i=1,2)
 - PDi : volume of throughput in which the concentration the i-th component is higher.
 - F = PD1 + PD2 : total volume of feed

system contains protein A and B, PDl is the product For a which favors A concentration fraction, while PD2 is the product which favors B concentration fraction. As shown in Figure 10.19, PD2 consists of the elution volume from 90 - 99 and 110 - 126, and PD1 consists of the rest of the elution volume in this Figure 10.22 shows the effect of B value on particular cycle. the separation of 2 solutes by cycling zone opration. As it is seen, an optimal B value exists for a particular height of It is understood that, for small B value, the change of column. control variable is flat so that mass transfer is slower in the column. Mass transfer increased as B value increased, which gives sharper control variable change in the columns, and hence increases the separation factor. Separation drops when B reaches unity, which can be explained by the fact that the relative travelling speed of 2 concentration wave is decreased. It is also seen from Figure 10.24 that a higher separation is given by B=0.5, and a lower separation is given by B=1.0 in the long column region. This is because the difference in equilibrium constant for these two components is largest at pH near P2. When B=1 , the pH shifts sharply to one of the 3 pH levels (Pl, P2 and P3); when B= 0.5, the pH range is narrowed down and the pH stays


Figure 10.20 Effect of pH on Relative Equilibrium Constant (KB/KA)



Figure 10.21 System of 3 pH open Parapump

around P2 more ofent. As shown in Figure 10.20, the relative equilibrium constant, K(A,pH)/K(B,pH), is largest at the region of pH=P2, and the smallest at the region of pH=P1 and P3. Although the increase of B value enhances the mass transfer of both components, the relative mass transfer at the area near P1 and P3 is small, thus the average of relative mass transfer is smaller for the case of B=1.0. Thus separation given by B=0.5 will be better than that for B=1 as long as the column is long enough. Figure 10.24 also shows that there is an optimal height of column at a given B value and feed size. Poor separation occurs when the column is too long for the same reasons as stated above.

10.8 : Comparison of 2-Column Parapump and Cycling Zone in Splitting 2-Solutes System

The idea of 3 pH levels cycling zone can be applied to parametric pumping. In chapter 8, we have discussed the 3 pH parapump under the single cell model; here the parapump is studied in multi-cell model. Figure 10.21 shows a 3-pH 2-column parapump which is essentially the same as the parapump described in chapter 8. The apparatus includes two adsorptive columns and four reservoirs. One of the columns is packed with cation exchanger and the other with anion exchanger. As shown in Figure 10.21, one operation cycle includes 7 steps, fluid from one



Figure 10.22 Effect of B on Separation in 3-pH Parapump



Fogure 10.23 Effect of Displacement on SFss for -pH parapump

reservoir is pumped into the column ; the fluid emerged from the other end of the column is received by another reservoir. In Figure 10.21, the displacement flow (as shown in step I, III, and V,) is followed by circulation flow (as shown in the step II, IV, and VI). In Step VII, products are withdrawn and then feeds are introduced to reservoirs. The fluid is pumped into the column in the sequential order of P1, P2, and P3 for the anion exchanger column, and in the order of P3, P2, and P1 for cation exchanger column.

The model equations, used in single column, are again applied to examine the separation of this process. As shown in Figure 10.23 and Figure 10.25 , there exists an optimal displacement and optimal secondary displacement for a particular value of B. The optimal primary displacement and secondary displacement are used in operating the 2 column parametric The calculated separation is shown in Figures 10.26. pumping. The figure also shows the comparison of separation by cycling zone(solid curve) and parametric pumping(broken curve). It is seen that parametric pumping gives a higher separation factor in saller size of feed, while cycling zone does better for large size of feed. It is also an advantage of cycling zone that it is However, cycling zone operated without reverse flow. is physically difficult to operate with a small size feed.



Figure 10.24 Effect of Column Height on SFss in 3-pH Parapump



Figure 10.25 Effect of Circulation on SFss for 3 pH Parapump



Figure 10.26 Effect of Feed on SFss for Parapump and Cycling Zone at B=0.5

Chapter 11 : Conclusions

In concluding this thesis, the most significant results are listed as follows:

- (1) pH parametric pumping is very functional for separating liquid mixture. The separation principle is based on the periodic alternation of the control variable(i.e., pH in this case), and on the coupling of the transport actions (i.e., the interfacial mass transfer and bulk fluid flow).
- (2) The separation capability of multi-column parapump is superior to that of one-column parapump. An increase in the number of columns gives a corresponding increase in the capability (quality and quantity) of separation.
- (3) At steady state, the state variables are periodic functions of time, thus the parapump operation has the following two major advantages over the conventional separation processes. i: As shown in chapter 9, a better separation can be obtained by open parapump than that by batch parapump. ii: the operation parameters, such as the products withdrawn time, can be optimized according to the objective function of the operation.
- (4) The 2-pH parapump is capable of enriching the product stream with proteins; 3-pH parapump is capable of splitting proteins into two product streams.

- (5) To split two components is a rather complicated process, and the separation is dependent on the relative mass transfer rate of the two components in the columns.
- (6) Parametric pumping gives a higher separation factor(purer products) as compared to cycling zone operation,but cycling zone operation gives a larger throughput.
- (7) The experimental model system, hemoglobin and albumin, has demonstrated the separation capability of multi-column pH parametric pumping. The theoretical model has been verified by the experimental results. The Single Cell Model and the Multi-Cell Model with Stop and Go method give a good prediction and correlation for pH parametric pumping operation.

NOMENCLATURE

Ac	=	column cross sectional area cm ²
В	=	buffer capacity of fluid phase
С	=	buffer capacity of solid phase
е	=	voidage of packed bed, dimentionless
FB	=	PDT = bottom feed, cc/cycle
F _T	=	PDB = top feed, cc/cycle
h	=	column height, cm
I _i	=	isoelectric point of i
I.E.	:	= Isoelectric point
IS	=	ionic strength of solution
К	=	equilibrium constant, dimentionless
n	=	number of cycles of parapump operation
М	=	number of columns
Pi	=	i-th pH level
PDi	=	Product Stream cc/cycle ; i=1, 2, T,or B.
Q	=	fluid flow rate in the column, cc/sec
SF	=	separation factor, dimentionless
^t i	=	time duration of i-th step, sec
tc	=	circulation time sec
VP	=	displacement volume, cc/step of cycle
VDi	=	dead volume of reservoir i (i = T, M, B)
Ve	=	volume of fluid phase per stages, cc
VE	=	total void volume of column, cc
VR	=	total volume of reservoir(dead volume + Displacement),cc

Vs	=	volume of solid phase per cell, cc
u	=	linear velocity, cm/sec
х	=	Concentration of solute in solid phase,g moles/cc
Y	=	concentration of solute in fluid phase, gmoles/cc
Yco	=	initial concentration of solute in the column, g moles/cc
Υо	=	Y_{f} = concentration of solute in the feed, g moles/cc
z	=	vertical dimension , cm
入	=	Mass transfer rate constant , l/sec

Superscripts

* =	equilibrium	condition
-----	-------------	-----------

- + = anion exchanger
- = cation exchanger

Subscripts

- B = bottom reservoir
- T = top reservoir
- MR = middle reservoir
- SR = side reservoir
- op = optimal value
- ss = steady state
- n = n-th cycle
- 1,2,3 = index for pH levels or ionic strength





YUP : MAIN & SUB-PROGRAM INTERACTION

Appendix-A Fortran Program YUP

YUP: OVER ALL P-P; FEED TO COLUMN & TO RESERVOIR; PHWAVE С С STP=1 С IFP=11 DOWN FLOW; L2=F;L3=F С DOWN CIRC; L2=F;L3=TIFP=12С IFP=13FEED UP ; L2=T;L3=FС UP CIRC; L2=T;L3=TIFP=14С STP=2С FLOW; L2=T;L3=FUP IFP=21C L3=TIFP=22UP CIRC: L2=T: С FEED DOWN; L2=F;L3=FIFP=23С L2=F;L3=T IFP=24DOWN CIRC; С STP=3С DOWN FLOW; L2=F;L3=FIFP=31С L2=F;L3=T IFP=32DOWN CIRC; С IFP=33 FEEG UP ; L2=T;L3=FС IFP=34UP CIRC; L2=T;L3=T COMMON B,MA,NPHL,JD,JCIR,I,IFP,J,K,L,NCP,NRS,NRL,NSTP,NTS, /NCYCL,NCYCLP,NITV,M,TCEL,E,R,RANDA,VP,AK,PHL,PHC0,PHOLD, /PH,PHR,YOLD,XOLD,Y,X,YF,YR,YC0,YRP,YCP,YCPX,JDSP,JFC,JDXA,VDP,VFR, /VRS,VPRZ,VDXTRA,VFC,NZ,IEX,L2,L3,L4,L7,L9,LWR1,LWR2 DIMENSION AK(3,2,2),PHL(3),PHCO(5),PHOLD(5,30),PH(5,30),PHR(8), /YOLD(4,16,2),XOLD(4,16,2),Y(4,16,2),X(4,16,2),YF(8,2),YR(8,2), /YCO(5,2),YRP(4,2,177),YCP(4,2,177),YCPX(4,2,177),JFC(8),JDXA(8), /JDSP(8), VDP(8), VFR(8), VRS(8), VPRZ(8), VDXTRA(8), VFC(8), NZ(8), IEX(8) DIMENSION KXS(4), KXN(4), KFD(4), KPD(4), YRP1(4,2,177), YRP2(4,2,177), &YRP3(4,2,177),NSFR(8) LOGICAL L2, L3, L4, L7, L9, LWR1, LWR2 NEVE(I) = I - (I/2) * 2NODP(I) = I - I / 2 * 450 CONTINUE READ(5, 36)L4, L7, L9, LWR1, LWR2, KS, KN, NFCYCL IF(KS.EQ. 0)GO TO 1000 KNX=KN+1 NRS=KS+(KS-1)/2NRL=KNX+KNX/2 36 FORMAT (5L10, 5110) READ(5,61) NITV, NCP, NPHL, NTS 61 FORMAT(8110) READ(5,60) HTS, AC, E, UVOLM, RANDA, B READ(5,60) (VDP(I), I=1, NTS), VCIR READ(5,60) (VDXTRA(II), II=1, NTS) READ(5,61)(KXS(I),KXN(I),I=1,NTS)READ(5,60)(VFC(II),II=1,NTS)READ(5,61)(KFD(I),KPD(I),I=1,NTS)READ(5,60)(VPRZ(I),I=NRS,NRL)READ(5,60)(VFR(I),I=NRS,NRL)READ(5,61) (NSFR(I), I=NRS, NRL) READ(5,60) (VRS(I), I=NRS, NRL) READ(5,59)(((AK(I,K,L),I=1,NPHL),K=1,2),L=1,NCP)

```
READ(5,59)((YF(I,L),I=NRS,NRL),(YC0(J,L),J=KS,KN),(YR(K,L),
     /K=NRS,NRL),L=1,NCP)
      READ(5,59) (PHR(I), I=NRS, NRL), (PHCO(J), J=KS, KN), (PHL(K), K=1, NPHL)
59
      FORMAT(14F5.2)
60
      FORMAT(8F10.4)
      WRITE(6, 30)
      FORMAT ('1')
30
                   L4, L7, L9, LWR1, LWR2, KS, KN, NFCYCL
      WRITE(6, 36)
      WRITE(6,61) NITV, NCP, NPHL, NTS
      WRITE(6,60) HTS, AC, E, UVOLM, RANDA, B
      WRITE(6,60)(VDP(I),I=1,NTS),VCIR
      WRITE(6,60)(VDXTRA(II),II=1,NTS)
      WRITE(6,61)(KXS(I),KXN(I),I=1,NTS)
      WRITE(6,60)(VFC(II),II=1,NTS)
      WRITE (6, 61) (KFD(I), KPD(I), I=1, NTS)
      WRITE(6,60)(VPRZ(I), I=NRS, NRL)
      WRITE(6,60)(VFR(I),I=NRS,NRL)
      WRITE(6,61)(NSFR(I),I=NRS,NRL)
      WRITE(6,60)(VRS(I),I=NRS,NRL)
      WRITE(6,59)(((AK(I,K,L),I=1,NPHL),K=1,2),L=1,NCP)
      WRITE(6,59)((YF(I,L),I=NRS,NRL),(YC0(J,L),J=KS,KN),(YR(K,L),
     /K=NRS,NRL),L=1,NCP)
      WRITE(6,59)(PHR(I),I=NRS,NRL),(PHCO(J),J=KS,KN),(PHL(K),K=1,NPHL)
      VBED=HTS*AC
      WRITE(6,6601)
      FORMAT(/,2X,'IPH',4X,'K',4X,'L','
6601
                                            AK(I,K,L)
      WRITE(6,6600)((((I,K,L,AK(I,K,L),I=1,NPHL),K=1,2),L=1,NCP)
6600
      FORMAT(315, F10.3)
      IF(L9) WRITE(6,52)
      IF(.NOT.L9) WRITE(6,53)
52
      FORMAT ('0
                      THEORY : FINITE MASS TRANSFER, NON-EQUILIBRIUM,
     / INTEGRAL METHODE ')
53
                      THEORY : EQUILIBRIUM')
      FORMAT ('0
      ULIN = UVOLM/(AC*E)
      HTCEL=HTS/NITV
      TCEL=HTCEL/ULIN
      VP=VBED*E/NITV
      R = (1 - E) / E
      M=NITV+2
      MA=M-1
      MB=M-2
      KN1=KN+1
      DO 70 I=1,NTS
      JDSP(I) = VDP(I) / VP
70
      JDXA(I) = VDXTRA(I) / VP
      JCIR=VCIR/VP
      DO 72 I=1,NTS
72
      JFC(I) = VFC(I) / VP
      JCIR=VCIR/VP
      WRITE(6, 82)
      FORMAT ('0',5X,'VP',8X,'R',9X,'HTCEL',5X,'TCEL',6X,'VBED')
82
      WRITE(6,60) VP,R,HTCEL,TCEL,VBED
```

```
WRITE(6,84)(I,I=1,NTS)
      FORMAT(3X,'M',4X,'MA',10X,8('
                                           NSTP=', I2))
84
      WRITE(6,80) M,MA,(JDSP(I),I=1,NTS)
      WRITE(6,81)(JDXA(I),I=1,NTS)
      WRITE(6,85)(JFC(I),I=1,NTS)
      WRITE(6,83)JCIR
      FORMAT (215,5X,'JDSP=',10110)
80
      FORMAT(15X, 'JDXA=',10110)
FORMAT(15X, 'JFC=',10110)
81
85
      FORMAT(15X, 'JCIR=', 10110)
83
 99
      CONTINUE
С
С
С
    INITIALIZATION OF SYSTEM
С
С
      NCYCL=-1
      NSTP=-1
      IFP = -1
      DO 101 I=NRS,NRL
      DO 101 L=1,NCP
      YRP1(I,L,1)=1.
      YRP2(I,L,1)=1.
      YRP3(I,L,1)=1.
      YRP(I, L, 1) = 1.
      YCP(I, L, 1) = 1.
101
      CONTINUE
      DO 112 K=1,KN
      IF(L7.AND.(NEVE(K).EQ.0))IEX(K)=2
      IF(L7.AND.(NEVE(K).NE.0))IEX(K)=1
      IF(.NOT.L7.AND.(NEVE(K).EQ.0))IEX(K)=1
      IF(.NOT.L7.AND.(NEVE(K).NE.0))IEX(K)=2
      DO 103 J=1,NPHL
103
      IF(PHCO(K) \cdot EQ \cdot PHL(J))IPH=J
      DO 111 I=2,MA
      DO 105 L=1,NCP
      YOLD(K, I, L) = YCO(K, L)
      XOLD(K,I,L) = YCO(K,L) * AK(IPH,IEX(K),L)
      Y(K,I,L) = YCO(K,L)
      X(K,I,L) = YCO(K,L) * AK(IPH,IEX(K),L)
105
      PHOLD(K, I) = PHCO(K)
111
      PH(K,I) = PHCO(K)
112
      CONTINUE
      IF(LWR2)CALL WRIT2(KS,KN)
С
      IF(.NOT.L7)VRS(3) = VRS(3) - JDSP(1) * VP
      IF(.NOT.L7)VRS(5) = VRS(5) - JDSP(1) * VP
      IF(.NOT.L7)GO TO 116
      DO 114 I=2,NRL,3
114
      VRS(I) = VRS(I) - JDSP(1) * VP
      DO 115 I=3,NRL,3
115
      VRS(I) = VRS(I) - JDSP(1) * VP
```

```
116
      NCYCL=0
      NSTP=0
      IFP=0
      IF(LWR2)CALL WRIT2(KS,KN)
С
      IF(.NOT.LWR2)WRITE(6,602) ((IR,L,IR=NRS,NRL),L=1,NCP)
      FORMAT(//' CYCLE', 3X, 14('R(', I1, ', ', I1, ')', 2X))
602
C****
   START OF CYCLE
С
С
С
120
      CONTINUE
      NCYCL=NCYCL+1
      DO 151 IR=NRS,NRL
      DO 151 L=1,NCP
      YRP(IR, L, NCYCL) = 0.000
      YCPX(IR,L,NCYCL) = 0.000
151
      YCP(IR,L,NCYCL) = 0.000
С
С
      NSTP=1
      IFP=11
      CALL FLOW(KS,KN,NZ,NSTP,IFP)
      L2=.FALSE.
      L3=.TRUE.
      JD=JDSP(NSTP)
      IF(JD.EQ.0)GO TO 200
      CALL UPNDON (KS, KN)
      IF(LWR2)CALL WRIT2(KS,KN)
С
200
      IFP=12
      L2=.FALSE.
      L3=.TRUE.
      JD=JCIR
      IF(JD.EQ.0)GO TO 210
      CALL UPNDON (KS, KN)
      IF(LWR2)CALL WRIT2(KS,KN)
С
С
210
      IFP=13
      L2=.TRUE.
      L3=.FALSE.
      JD=JFC(NSTP)
       IF(JD.EQ.0)GO TO 268
      IF(KFD(NSTP).NE.99)GO TO 230
      DO 220 KFP=KS,KN
220
      CALL FEDCOL(KFP,KFP)
230
      IF(KFD(NSTP).NE.99)CALL FEDCOL(KFD(NSTP),KPD(NSTP))
      IF(LWR2)CALL WRIT2(KS,KN)
С
С
260
      IF((JCIR.EQ.0).OR..NOT.L4) GO TO 268
```

```
IFP=14
      CALL FLOW(KS,KN,NZ,NSTP,IFP)
      L2=.TRUE.
      L3=.TRUE.
      JD=JCIR
      CALL UPNDON (KS, KN)
      IF(LWR2)CALL WRIT2(KS,KN)
С
268
      DO 270 L=1,NCP
      DO 270 IR=NRS, NRL
270
      YRPl(IR,L,NCYCL) = YR(IR,L)
      DO 280 I=NRS,NRL
280
      IF(NSFR(I).EQ.NSTP) CALL FDRSV(I)
С
С
300
      NSTP=2
      IFP=21
      L2=.TRUE.
      L3=.FALSE.
      JD=JDSP(NSTP)
      IF(JD.EQ.0)GO TO 360
      DO 350 KK=KS,KN
      CALL FLOW(KK,KK,NZ,NSTP,IFP)
350
      CALL UPNDON (KK, KK)
      IF(LWR2)CALL WRIT2(KS,KN)
360
      JD=JDXA (NSTP)
      IF(JD.EQ.0)GO TO 400
      DO 370 KK=KS,KN
      CALL FLOW(KK,KK,NZ,NSTP,IFP)
370
      CALL UPNDON (KK, KK)
      IF(LWR2)CALL WRIT2(KS,KN)
С
С
400
      IFP=22
      L2=.TRUE.
      L3=.TRUE.
      JD=JCIR
      IF(JD.EQ.0)GO TO 410
      DO 450 KK=KS,KN
      CALL FLOW(KK,KK,NZ,NSTP,IFP)
450
      CALL UPNDON (KK,KK)
      IF(LWR2)CALL WRIT2(KS,KN)
С
С
410
      IFP=23
      L2=.FALSE.
      L3=.FALSE.
      JD=JFC(NSTP)
       IF(JD.EQ.0)GO TO 468
      IF(KFD(NSTP).NE.99)GO TO 430
      DO 420 KFP=KS,KN
420
      CALL FEDCOL(KFP,KFP)
```

```
183
```

430 IF(KFD(NSTP).NE.99)CALL FEDCOL(KFD(NSTP),KPD(NSTF)) IF(LWR2)CALL WRIT2(KS,KN) С С 460 IF((JCIR.EQ.0).OR..NOT.L4) GO TO 468 IFP=24L2=.FALSE. L3=.TRUE. JD=JCIR DO 466 KK=KS,KN CALL FLOW(KK,KK,NZ,NSTP,IFP) 466 CALL UPNDON (KK,KK) IF (LWR2) CALL WRIT2 (KS, KN) С 468 DO 470 L=1,NCP DO 470 IR=NRS,NRL 470 YRP2(IR,L,NCYCL)=YR(IR,L) DO 480 I=NRS,NRL 480 IF(NSFR(I).EQ.NSTP) CALL FDRSV(I) С С 500 NSTP=3 IFP=31L2=.FALSE. L3=.FALSE. JD=JDSP(NSTP) IF(JD.EQ.0)GO TO 600 DO 540 KK=KS,KN CALL FLOW(KK,KK,NZ,NSTP,IFP) CALL UPNDON (KK, KK) 540 IF(LWR2)CALL WRIT2(KS,KN) С С 600 IFP=32L2=.FALSE. L3=.TRUE. JD=JCIR IF(JD.EQ.0)GO TO 610 DO 605 KK=KS,KN CALL FLOW(KK,KK,NZ,NSTP,IFP) 605 CALL UPNDON (KK,KK) IF(LWR2)CALL WRIT2(KS,KN) С С 610 IFP=33 L2=.TRUE. L3=.FALSE. JD=JFC(NSTP) IF(JD.EQ.0)GO TO 668 IF(KFD(NSTP).NE.99)GO TO 630 DO 620 KFP=KS,KN 620 CALL FEDCOL(KFP,KFP)

```
630
      IF(KFD(NSTP).NE.99)CALL FEDCOL(KFD(NSTP),KPD(NSTP))
      IF(LWR2)CALL WRIT2(KS,KN)
С
С
660
      IF((JCIR.EQ.0).OR..NOT.L4) GO TO 668
      IFP=34
      L2=.TRUE.
      L3=.TRUE.
      JD=JCIR
      DO 665 KK=KS,KN
      CALL FLOW(KK,KK,NZ,NSTP,IFP)
665
      CALL UPNDON (KK,KK)
      IF(LWR2)CALL WRIT2(KS,KN)
С
668
      DO 670 L=1,NCP
      DO 670 IR=NRS,NRL
670
      YRP3(IR,L,NCYCL) = YR(IR,L)
      DO 680 I=NRS,NRL
680
      IF(NSFR(I).EQ.NSTP) CALL FDRSV(I)
С
С
      IF(LWR2)GO TO 915
      WRITE(6,601)NCYCL,((YRP1(IR,L,NCYCL),IR=NRS,NRL),L=1,NCP)
      WRITE(6,601)NCYCL,((YRP2(IR,L,NCYCL),IR=NRS,NRL),L=1,NCP)
      WRITE(6,601)NCYCL,((YRP3(IR,L,NCYCL),IR=NRS,NRL),L=1,NCP)
915
      CONTINUE
С
C ***
       COMPLETION OF A CYCLE
С
      IF (NCYCL.LT.11)GO TO 120
      DYRP3=YRP3 (NRS, 1, NCYCL) -YRP3 (NRS, 1, NCYCL-1)
      IF (ABS (DYRP3).LT.0.00010)GO TO 918
      IF (NCYCL.LT.NFCYCL)GO TO 120
С
С
 ***
       COMPLETION OF A RUN
С
С
918
      DO 921
               I=1,NTS
      IF(JFC(I).NE.0)GO TO 926
921
      WRITE(6,672) ((IR,L,IR=NRS,NRL),L=1,NCP)
672
      FORMAT(//' CYCLE', 3X, 14('PR(', I1, ', ', I1, ')', 1X))
      DO 922 N=1,NCYCL
922
      WRITE(6,601)N,((YRP(IR,L,N),IR=NRS,NRL),L=1,NCP)
      GO TO 940
926
      WRITE(6,604) ((IR,L,IR=NRS,NRL),L=1,NCP)
604
      FORMAT(//' CYCLE', 3X, 14('YP(', 11, ', ', 11, 2X))
      DO 930 N=1,NCYCL
      WRITE (6, 601) N, ((YCPX(IR, L, N), IR=NRS, NRL), L=1, NCP)
930
      WRITE(6,601)N,((YCP(IR,L,N),IR=NRS,NRL),L=1,NCP)
С
940
      WRITE(6,603)
603
      FORMAT (//)
```

```
WRITE(6, 36)
                    L4, L7, L9, LWR1, LWR2, KS, KN, NFCYCL
      WRITE(6,61) NITV, NCP, NPHL, NTS
      WRITE(6,60) HTS, AC, E, UVOLM, RANDA, B
      WRITE(6,60)(VDP(I),I=1,NTS),VCIR
      WRITE(6,60)(VDXTRA(II),II=1,NTS)
      WRITE(6,61)(KXS(I),KXN(I),I=1,NTS)
      WRITE(6,60)(VFC(II),II=1,NTS)
      WRITE(6,61)(KFD(I),KPD(I),I=1,NTS)
      WRITE(6,60)(VPRZ(I),I=NRS,NRL)
      WRITE(6,60)(VFR(I),I=NRS,NRL)
      WRITE(6,61)(NSFR(1),I=NRS,NRL)
      WRITE(6,60)(VRS(I),I=NRS,NRL)
      WRITE(6,59)(((AK(I,K,L),I=1,NPHL),K=1,2),L=1,NCP)
      WRITE(6,59)((YF(I,L),I=NRS,NRL),(YCO(J,L),J=KS,KN),(YR(K,L),
     /K=NRS,NRL),L=1,NCP)
      WRITE (6,59) (PHR(I), I=NRS, NRL), (PHCO(J), J=KS, KN), (PHL(K), K=1, NPHI
      IF(L9) WRITE(6,52)
      IF(.NOT.L9) WRITE(6,53)
601
      FORMAT(14, 4X, 14(F8.4))
      GO TO 50
1000
       STOP
      END
С
С
С
      SUBROUTINE FLOW(KF1, KF2, NZ, NSTP, IFP)
      DIMENSION NZ(8)
      KF3=KF2+1
      IF(NSTP.NE.1)GO TO 100
      IF(IFP.EQ.14)GO TO 50
      NZ(1) = 2
      NZ(2) = 3
       NZ(3) = 4
      RETURN
50
      DO 60 K=KF1,KF3
60
      NZ(K) = K + (K-2)/2
      RETURN
100
      IF(KF1.NE.KF2)GO TO 888
      IF (NSTP.NE.2)GO TO 300
      IF(IFP.EQ.24)GO TO 200
      KEVE = (KF1/2) * 2
      IF (KF1.EQ.KEVE) GO TO 110
      NZ(KF1) = KF1+1
      NZ(KF1+1)=KF1
      RETURN
110
      NZ(KF1) = KF1+1
      NZ(KF1+1) = KF1+2
      RETURN
200
      IF (KF1.NE.1)GO TO 230
      NZ(1) = 1
      NZ(2) = 4
      RETURN
```

230	IF(KF1.NE.2)GO TO 888 NZ(2)=4 NZ(3)=4
300	RETORN IF (NSTP.NE.3) GO TO 888 IF (IFP.EQ.34)GO TO 400 KEVEN= (KF1/2)*2 IF (KF1.EQ.KEVE)GO TO 320 NZ (KF1)=KF1+2 NZ (KF1+1)=KF1 BETUBN
320	NZ (KF1)=KF1 NZ (KF1+1)=KF1+2 RETURN
400	IF (KF1.NE.1) GO TO 430 NZ(1)=1 NZ(2)=3 RETURN
430	IF(KF1.NE.2)GO TO 888 NZ(2)=4 NZ(3)=2 RETURN
888 6	WRITE(6,6)KF1,KF2,NSTP FORMAT('/ ERROR : KF1=',I3,' KF2=',I3,' NSTP=',I3) STOP END
C C	
	<pre>SUBROUTINE UPNDON(K1ST,KLST) COMMON B,MA,NPHL,JD,JCIR,I,IFP,J,K,L,NCP,NRS,NRL,NSTP,NTS, /NCYCL,NCYCLP,NITV,M,TCEL,E,R,RANDA,VP,AK,PHL,PHC0,PHOLD, /PH,PHR,YOLD,XOLD,Y,X,YF,YR,YC0,YRP,YCP,YCPX,JDSP,JFC,JDXA,VDP,VFR, /VRS,VPRZ,VDXTRA,VFC,NZ,IEX,L2,L3,L4,L7,L9,LWR1,LWR2 DIMENSION AK(3,2,2),PHL(3),PHC0(5),PHOLD(5,30),PH(5,30),PHR(8), /YOLD(4,16,2),XOLD(4,16,2),Y(4,16,2),X(4,16,2),YF(8,2),YR(8,2), /YC0(5,2),YRP(4,2,177),YCP(4,2,177),YCPX(4,2,177),JFC(8),JDXA(8), /JDSP(8),VDP(8),VFR(8),VRS(8),VPRZ(8),VDXTRA(8),VFC(8),NZ(8),IEX(8) LOGICAL L2,L3,L4,L7,L9,LWR1,LWR2 DIMENSION VRZSB(8) KLSTP1=KLST+1 DO 50 K=K1ST,KLST PHOLD(K,1)=PHR(NZ(K)) IF(K.NE.K1ST)PHOLD(K-1,M)=PHOLD(K,1) VRZSB(K)=VRS(NZ(K)) DO 50 L=1,NCP</pre>
50	YOLD(K,1,L)=YR(NZ(K),L) IF(K.NE.K1ST)YOLD(K-1,M,L)=YOLD(K,1,L) PHOLD(KLST,M)=PHR(NZ(KLSTP1))
55	DO 55 L=1,NCP YOLD(KLST,M,L)=YR(NZ(KLSTP1),L) VRZSB(KLSTP1)=VRS(NZ(KLSTP1))

```
CALL COLUMN (K1ST, KLST, VRZSB)
      DO 850 K=K1ST,KLSTP1
      VRS(NZ(K)) = VRZSB(K)
      IF(LWR1)WRITE(6,1)K, NZ(K), VRZSB(K), VRS(NZ(K))
                  K=',I3,'
                                 NZ(K) = ', 13, 5X, ' VOLRZ = ', 5F10.3
1
      FORMAT (
      DO 850 L=1,NCP
      IF(K.EO.KLSTPI)YR(NZ(KLSTPI),L)=Y(KLST,M,L)
850
      IF(K.NE.KLSTP1)YR(NZ(K),L)=Y(K,1,L)
      RETURN
      END
С
С
С
      SUBROUTINE COLUMN (K1ST, KLST, VRZSB)
      COMMON B,MA,NPHL,JD,JCIR,I,IFP,J,K,L,NCP,NRS,NRL,NSTP,NTS,
     /NCYCL,NCYCLP,NITV,M,TCEL,E,R,RANDA,VP,AK,PHL,PHC0,PHOLD,
     /PH,PHR,YOLD,XOLD,Y,X,YF,YR,YC0,YRP,YCP,YCPX,JDSP,JFC,JDXA,VDP,VFR,
     /VRS, VPRZ, VDXTRA, VFC, NZ, IEX, L2, L3, L4, L7, L9, LWR1, LWR2
      DIMENSION AK(3,2,2), PHL(3), PHCO(5), PHOLD(5,30), PH(5,30), PHR(8),
     /YOLD(4,16,2),XOLD(4,16,2),Y(4,16,2),X(4,16,2),YF(8,2),YR(8,2),
     /YCO(5,2),YRP(4,2,177),YCP(4,2,177),YCPX(4,2,177),JFC(8),JDXA(8)
     /JDSP(8), VDP(8), VFR(8), VRS(8), VPRZ(8), VDXTRA(8), VFC(8), NZ(8), IEX(8)
      LOGICAL L2,L3,L4,L7,L9,LWR1,LWR2
      DIMENSION VRZSB(8)
      YRCLT(VRES, VPUSH, YR, YEND) = (VRES *YR+VPUSH*YEND) / (VRES+VPUSH)
      YRTNC (VRES, VPUSH, YR, YC) = (1.-VPUSH/VRES) *YR+ (VPUSH/VRES) *YC
      YPCLT (JFP, VPUSH, YOLD, YOUT) = ( (JFP-2) *VPUSH*YOLD+
     9VPUSH*YOUT) / ((JFP-1) *VPUSH)
      PHWAVE (PHF, PHS, BB) = B*PHF+(1-B)*PHS
      KLSTP1=KLST+1
      DO 800 J=1, JD
      DO 500 K=K1ST,KLST
      DO 400 I=1,M
      IF(I.NE.1)GO TO 135
      DO 100 L=1,NCP
      IF(L2) GO TO 95
      IF(IFP.NE.11)GO TO 80
      IF (K.EQ.KIST) Y (KIST, 1, L) = YRTNC (VRZSB (KIST), VP, YOLD (KIST, 1, L),
     &YOLD(KLST,MA,L))
      IF (K.NE.K1ST)Y(K, 1, L) = YRTNC(VRZSB(K), VP, YOLD(K, 1, L),
     \&YOLD(K-1,MA,L))
      GO TO 100
80
      IF(L3)Y(K,1,L) = YRTNC(VRZSB(K), VP, YOLD(K,1,L),
     \&YOLD(K,MA,L))
      IF(.NOT.L3.AND.(K.EQ.KIST))Y(K,I,L)=YOLD(K,I,L)
      IF((.NOT.L3).AND.(K.NE.K1ST))Y(K,1,L)=YRTNC(VRZSB(K),VP,
     \&YOLD(K,1,L),YOLD(K-1,MA,L))
      GO TO 100
95
      IF(L3.AND.(K.NE.KIST))Y(K,1,L) = YRTNC(VRZSB(K),VP,YOLD(K,1,L),
     \&YOLD(K-1,2,L))
      IF (L3.AND.(K.EQ.KIST))Y(K,1,L)=YOLD(K,1,L)
      IF(.NOT.L3.AND.(K.EQ.KIST))Y(K,1,L)=YRCLT(VRZSB(K),VP,
```

```
/YOLD(K, 1, L), YOLD(K, 2, L))
      IF(.NOT.L3.AND.(K.NE.K1ST))Y(K,1,L)=YRTNC(VRZSB(K),VP,
     \&YOLD(K,1,L),YOLD(K,2,L))
100
      CONTINUE
      PH(K,1) = PHOLD(K,1)
      GO TO 400
135
      IF(I.EQ.M)GO TO 220
      IF(.NOT.L2)PH(K,I)=PHWAVE(PHOLD(K,I-1),PHOLD(K,I),B)
      IF(L2)PH(K,I)=PHWAVE(PHOLD(K,I+1),PHOLD(K,I),B)
      DO 200 L=1,NCP
      IF(.NOT.L9)CALL EQCALC
200
      IF(L9) CALL SOVOD1
      GO TO 400
220
      CONTINUE
      IF(K.EQ.KIST) GO TO 400
      DO 300 L=1,NCP
300
      Y(K-1, M, L) = Y(K, 1, L)
      PH(K-1,M) = PH(K,1)
400
      CONTINUE
500
      CONTINUE
      DO 550 L=1,NCP
      IF(.NOT.L2.AND.(.NOT.L3))Y(KLST,M,L)=YRCLT(VRZSB(KLSTP1),VP,
     &YOLD(KLST,M,L),YOLD(KLST,MA,L))
      IF(.NOT.L2.AND.L3)Y(KLST,M,L)=YOLD(KLST,M,L)
      IF(L2.AND..NOT.L3)Y(KLST,M,L)=YOLD(KLST,M,L)
550
      IF(L2.AND.L3)Y(KLST,M,L)=YRTNC(VRZSB(KLSTP1),VP,YOLD(KLST,M,L),
     &YOLD(KLST,2,L))
      PH(KLST, M) = PHOLD(KLST, M)
      DO 700 K=K1ST,KLST
      DO 700 I=1,M
      DO 600 L=1,NCP
      YOLD(K,I,L) = Y(K,I,L)
      IF((I.NE.1).AND.(I.NE.M))XOLD(K,I,L)=X(K,I,L)
600
      PHOLD(K,I) = PH(K,I)
700
      CONTINUE
      IF((.NOT.L3).AND.(.NOT.L2))VRZSB(K1ST)=VRZSB(K1ST)-VP
      IF((.NOT.L3).AND.(.NOT.L2))VRZSB(KLSTP1)=VRZSB(KLSTP1)+VP
      IF((.NOT.L3).AND.L2)VRZSB(K1ST)=VRZSB(K1ST)+VP
      IF((.NOT.L3).AND.L2)VRZSB(KLSTP1)=VRZSB(KLSTP1)-VP
      IF(LWR1)WRITE(6,6615)(I,I=1,M)
      DO 730 K=K1ST,KLST
730
      IF(LWR1)WRITE(6,6620)J,K,(PH(K,I),I=1,M)
      DO 760 L=1,NCP
      DO 760 K=K1ST,KLST
      IF(LWR1)WRITE(6,6621)J,K,L,(Y(K,I,L),I=1,M)
760
      IF(LWR1)WRITE(6,6622)J,K,L,(X(K,I,L),I=1,M)
800
      CONTINUE
      FORMAT(/,' J K L ',14(4X,'I=
FORMAT('',2I2,' PH',14F8.4)
FORMAT('',3I2,' Y',14F8.4)
                  J K L ', 14(4X, 'I=', I2))
6615
6620
6621
      FORMAT(' ',312,' X',14F8.4)
6622
      RETURN
```

END

C C

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SUBROUTINE FEDCOL(KF,KP)
      COMMON B,MA,NPHL,JD,JCIR,I,IFP,J,K,L,NCP,NRS,NRL,NSTP,NTS,
     /NCYCL,NCYCLP,NITV,M,TCEL,E,R,RANDA,VP,AK,PHL,PHC0,PHOLD,
     /PH,PHR,YOLD,XOLD,Y,X,YF,YR,YCO,YRP,YCP,YCPX,JDSP,JFC,JDXA,VDP,VFR,
     /VRS,VPRZ,VDXTRA,VFC,NZ,IEX,L2,L3,L4,L7,L9,LWR1,LWR2
      DIMENSION AK(3,2,2),PHL(3),PHC0(5),PHOLD(5,30),PH(5,30),PHR(8),
     /YOLD(4,16,2),XOLD(4,16,2),Y(4,16,2),X(4,16,2),YF(8,2),YR(8,2),
     /YCO(5,2), YRP(4,2,177), YCP(4,2,177), YCPX(4,2,177), JFC(8), JDXA(8),
     /JDSP(8), VDP(8), VFR(8), VRS(8), VPRZ(8), VDXTRA(8), VFC(8), NZ(8), IEX(8)
      LOGICAL L2, L3, L4, L7, L9, LWR1, LWR2
      DIMENSION VRZSB(8)
      KFP1=KF+1
      KPP1=KP+1
      IF(.NOT.L2)GO TO 600
      DO 60 L=1,NCP
      YOLD (KP, 1, L) = 0.
60
      YOLD(KF,M,L) = YF(NZ(KP),L)
      VRZSB(KP) = 0.
      VRZSB(KFP1)=999
      PHOLD(KP, 1) = PHR(NZ(KP))
      PHOLD(KF, M) = PHR(NZ(KF))
      IF(KPP1.GT.KF)GO TO 205
      DO 200 K=KPP1,KF
      PHOLD(K, 1) = PHR(NZ(K))
      PHOLD(K-1,M) = PHOLD(K,1)
      VRZSB(K) = VRS(NZ(K))
      DO 200 L=1,NCP
      YOLD(K, 1, L) = YR(NZ(K), L)
200
      YOLD(K-1, M, L) = YR(NZ(K), L)
205
      CONTINUE
      CALL COLUMN (KP, KF, VRZSB)
      DO 240 L=1,NCP
      IF (NSTP.LE.2) YCPX (NZ (KP), L, NCYCL) = Y (KP, 1, L)
240
      IF (NSTP.GE.3) YCP (NZ (KP), L, NCYCL) = Y (KP, 1, L)
      IF (KPP1.GT.KF)GO TO 465
      DO 460 K=KPP1,KF
      VRS(NZ(K)) = VRZSB(K)
      DO 460 L=1,NCP
460
      YR(NZ(K),L) = Y(K,l,L)
465
      CONTINUE
      RETURN
600
      DO 660 L=1,NCP
      YOLD(KP,M,L)=0.
660
      YOLD(KF, 1, L) = YF(NZ(KP), L)
      VRZSB(KPP1)=0.
      VRZSB(KF) = 999
      PHOLD(KP,M) = PHR(NZ(KP+1))
      PHOLD(KF, 1) = PHR(NZ(KFP1))
```

```
IF(KFP1.GT.KP)GO TO 705
      DO 700 K=KFP1.KP
      PHOLD(K, 1) = PHR(NZ(K))
      PHOLD(K-1, M) = PHOLD(K, 1)
      VRZSB(K) = VRS(NZ(K))
      DO 700 L=1,NCP
      YOLD(K, 1, L) = YR(NZ(K), L)
700
      YOLD(K-1, M, L) = YR(NZ(K), L)
705
      CONTINUE
      CALL COLUMN (KF, KP, VRZSB)
      DO 740
               L=1,NCP
      IF (NSTP.LE.2) YCPX (NZ (KPP1), L, NCYCL) = Y (KP, M, L)
740
      IF (NSTP.GE.3) YCP (NZ (KPP1), L, NCYCL) = Y (KP, M, L)
      IF (KFP1.GT.KP)GO TO 800
      DO 760 K=KFP1,KP
      VRS(NZ(K)) = VRZSB(K)
      DO 760 L=1,NCP
760
      YR(NZ(K),L) = Y(K,l,L)
800
      CONTINUE
      RETURN
      END
С
CC
С
С
С
       SUBROUTINE
                    SOVOD1
      COMMON B,MA,NPHL,JD,JCIR,I,IFP,J,K,L,NCP,NRS,NRL,NSTP,NTS,
     /NCYCL,NCYCLP,NITV,M,TCEL,E,R,RANDA,VP,AK,PHL,PHC0,PHOLD,
     /PH,PHR,YOLD,XOLD,Y,X,YF,YR,YC0,YRP,YCP,YCPX,JDSP,JFC,JDXA,VDP,VFR,
     /VRS, VPRZ, VDXTRA, VFC, NZ, IEX, L2, L3, L4, L7, L9, LWR1, LWR2
      DIMENSION AK(3,2,2), PHL(3), PHCO(5), PHOLD(5,30), PH(5,30), PHR(8),
     /YOLD(4,16,2),XOLD(4,16,2),Y(4,16,2),X(4,16,2),YF(8,2),YR(8,2),
     /YCO(5,2),YRP(4,2,177),YCP(4,2,177),YCPX(4,2,177),JFC(8),JDXA(8),
     /JDSP(8), VDP(8), VFR(8), VRS(8), VPRZ(8), VDXTRA(8), VFC(8), NZ(8), IEX(8)
      LOGICAL L2,L3,L4,L7,L9,LWR1,LWR2
      FMSBS(YPF, XPF, XF, EF) = YPF-((1.-EF)/EF) * (XF-XPF)
      IF(PH(K,I)-PHL(2))30,40,40
30
      AAK=AK(3,IEX(K),L)+(AK(2,IEX(K),L)-AK(3,IEX(K),L))*
     \& (PH(K,I) - PHL(3)) / (PHL(2) - PHL(3))
      GO TO 45
40
      AAK=AK(2,IEX(K),L)+(AK(1,IEX(K),L)-AK(2,IEX(K),L))*
     \& (PH(K, I) - PHL(2)) / (PHL(1) - PHL(2))
45
      IF(.NOT.L2)YPSV=YOLD(K,I-1,L)
      IF(L2)
                  YPSV=YOLD(K,I+1,L)
      XPSV=XOLD(K,I,L)
      AA=RANDA* ( YPSV + ( (1-E)/E) * XPSV )
      BB=RANDA*((1-E)/E + 1/AAK)
      BTNEG = (-1) * BB * TCEL
      X(K,I,L) = (AA/BB) - (AA/BB - XPSV) * EXP(BTNEG)
      Y(K,I,L) = FMSBS(YPSV,XPSV,X(K,I,L),E)
      RETURN
```

END

- C C C

```
С
      SUBROUTINE EQCALC
      COMMON B, MA, NPHL, JD, JCIR, I, IFP, J, K, L, NCP, NRS, NRL, NSTP, NTS,
     /NCYCL,NCYCLP,NITV,M,TCEL,E,R,RANDA,VP,AK,PHL,PHC0,PHOLD,
     /PH,PHR,YOLD,XOLD,Y,X,YF,YR,YCO,YRP,YCP,YCPX,JDSP,JFC,JDXA,VDP,VFR,
     /VRS, VPRZ, VDXTRA, VFC, NZ, IEX, L2, L3, L4, L7, L9, LWR1, LWR2
      DIMENSION AK(3,2,2), PHL(3), PHCO(5), PHOLD(5,30), PH(5,30), PHR(8),
     /YOLD(4,16,2),XOLD(4,16,2),Y(4,16,2),X(4,16,2),YF(8,2),YR(8,2),
     /YC0(5,2), YRP(4,2,177), YCP(4,2,177), YCPX(4,2,177), JFC(8), JDXA(8),
     /JDSP(8), VDP(8), VFR(8), VRS(8), VPRZ(8), VDXTRA(8), VFC(8), NZ(8), IEX(8)
      LOGICAL L2, L3, L4, L7, L9, LWR1, LWR2
      IF(PH(K,I)-PHL(2))30,40,40
      AKD=AK(3,IEX(K),L)+(AK(2,IEX(K),L)-AK(3,IEX(K),L))*
30
     \& (PH(K, I) - PHL(3)) / (PHL(2) - PHL(3))
      GO TO 45
      AKD=AK(2,IEX(K),L)+(AK(1,IEX(K),L)-AK(2,IEX(K),L))*
40
     \& (PH(K,I) - PHL(2)) / (PHL(1) - PHL(2))
45
      IF(PHOLD(K, I) - PHL(2)) 50, 60, 60
      AKN=AK(3,IEX(K),L)+(AK(2,IEX(K),L)-AK(3,IEX(K),L))*
50
     \& (PHOLD(K, I)-PHL(3))/(PHL(2)-PHL(3))
      GO TO 65
60
      AKN=AK(2,IEX(K),L)+(AK(1,IEX(K),L)-AK(2,IEX(K),L))*
     \& (PHOLD(K,I)-PHL(2))/(PHL(1)-PHL(2))
65
      IF(L2) YIJO=YOLD(K,I+1,L)
      IF(.NOT.L2)YIJO=YOLD(K, I-1, L)
      Y(K,I,L) = (YIJO+R*AKN*YOLD(K,I,L)) / (1+R*AKD)
      X(K,I,L) = Y(K,I,L) * AKD
      RETURN
      END
С
С
С
      SUBROUTINE WRIT2(KS,KN)
      COMMON B,MA,NPHL,JD,JCIR,I,IFP,J,K,L,NCP,NRS,NRL,NSTP,NTS,
     /NCYCL,NCYCLP,NITV,M,TCEL,E,R,RANDA,VP,AK,PHL,PHC0,PHOLD,
     /PH,PHR,YOLD,XOLD,Y,X,YF,YR,YC0,YRP,YCP,YCPX,JDSP,JFC,JDXA,VDP,VFR,
     /VRS,VPRZ,VDXTRA,VFC,NZ,IEX,L2,L3,L4,L7,L9,LWR1,LWR2
      DIMENSION AK(3,2,2),PHL(3),PHCO(5),PHOLD(5,30),PH(5,30),PHR(8),
     /YOLD(4,16,2),XOLD(4,16,2),Y(4,16,2),X(4,16,2),YF(8,2),YR(8,2),
     /YCO(5,2), YRP(4,2,177), YCP(4,2,177), YCPX(4,2,177), JFC(8), JDXA(8),
     /JDSP(8), VDP(8), VFR(8), VRS(8), VPRZ(8), VDXTRA(8), VFC(8), NZ(8), IEX(8)
      LOGICAL L2, L3, L4, L7, L9, LWR1, LWR2
      KNP1=KN+1
      WRITE(6,610)NCYCL,NSTP,IFP,(KW,NZ(KW),KW=KS,KNP1)
      WRITE(6,620)(I,I=NRS,NRL)
      WRITE(6,630)(VRS(I), I=NRS, NRL)
      DO 11 L=1,NCP
11
      WRITE(6,640)L,(YR(K,L),K=NRS,NRL)
      WRITE (6, 630) (PHR (I), I=NRS, NRL)
```

```
WRITE(6,650)(I,I=1,M)
      DO 730 K=KS.KN
730
      WRITE(6,660)J,K,(PH(K,I), I=1,M)
      DO 760 L=1,NCP
      DO 760 K=KS,KN
      WRITE(6,670)J,K,L,(Y(K,I,L),I=1,M)
760
      WRITE (6, 680) J, K, L, (X(K, I, L), I=1, M)
      FORMAT (/, '
                   J K L ', 14(4X, 'I=', I2))
650
      FORMAT('',212,' PH',14F8.4)
FORMAT('',312,' Y',14F8.4)
FORMAT('',312,' X',14F8.4)
660
670
680
С
      FORMAT(/10X,' NCYCL=', I3, 5X, 'NSTP=', I3, 5X, 'IFP=', I3, 5X, 'NZ(',
610
     \&5(I1,')=', I2, 5X, 'NZ('))
                            RSV(',I1,')'))
620
      FORMAT(10X,10('
630
      FORMAT(10X, 11F10.4)
640
      FORMAT(' COMP=', I2, 2X, 10F10.4)
С
С
      RETURN
      END
      SUBROUTINE FDRSV(IR)
      COMMON B, MA, NPHL, JD, JCIR, I, IFP, J, K, L, NCP, NRS, NRL, NSTP, NTS,
     /NCYCL,NCYCLP,NITV,M,TCEL,E,R,RANDA,VP,AK,PHL,PHC0,PHOLD,
     /PH,PHR,YOLD,XOLD,Y,X,YF,YR,YC0,YRP,YCP,YCPX,JDSP,JFC,JDXA,VDP,VFR,
     /VRS,VPRZ,VDXTRA,VFC,NZ,IEX,L2,L3,L4,L7,L9,LWR1,LWR2
      DIMENSION AK(3,2,2),PHL(3),PHC0(5),PHOLD(5,30),PH(5,30),PHR(8),
     /YOLD(4,16,2),XOLD(4,16,2),Y(4,16,2),X(4,16,2),YF(8,2),YR(8,2),
     /YCO(5,2), YRP(4,2,177), YCP(4,2,177), YCPX(4,2,177), JFC(8), JDXA(8),
     /JDSP(8), VDP(8), VFR(8), VRS(8), VPRZ(8), VDXTRA(8), VFC(8), NZ(8), IEX(8)
С
      DO 20 L=1,NCP
20
      YRP(IR,L,NCYCL)=YR(IR,L)
      VRS(IR)=VRS(IR)-VPRZ(IR)
      IF(VFR(IR).EQ.0.)GO TO 50
      DO 30 L=1,NCP
      YR(IR,L)=(YR(IR,L)*VRS(IR)+VFR(IR)*YF(IR,L))/(VRS(IR)+VFR(IR))
30
      VRS(IR)=VRS(IR)+VFR(IR)
50
      CONTINUE
      RETURN
      END
```



APPENDIX-B FORTRAN PROGRAM Z2C

```
Z2C : CYCLIC ZON USE PHWAVE MODEL
С
С
   LAST REVISION : OCT.7/80
C
C
             FIRST HALF CYCLE
      Ll=F:
C
             SECOND HALF CYCLE
      L2=T:
С
      COMMON B, MA, AK, PHL, PH, Y, VP, YT, YB, NITV, L,
     /FIT,FIB,JF1,JF2, NTF,NBF,I,J ,RANDA,NCYCL,NCYCLP,HTS,AC,
     /JD,M,TCEL,YF1,YF2,X, E ,L1, L2, L3 ,L7,L9
      DIMENSION Y(2,37,66), PH(37,66), AK(2,3), PHL(3),
     /X(2,37,66),YEXT(2,588),YPD(2,133),YP(2),VPD(133),
     /PHEXT(588),SPNO(277),YSMP(2,277),XODPT(588),PHEPT(588),
     &YE1PT(588),YE2PT(588),VEXT(588)
      LOGICAL L1, L2, L3, L5 ,L7,L9 ,L10
      EQUIVALENCE (YE1PT(1), YE2PT(1), PHEPT(1)), (XODPT(1), VEXT(1))
      PHWAVE (PHF, PHS, B, C, D) = PHF*B* (1.-ABS(PHF-D)*C)+
     \& PHS*(1 - B*(1 - ABS(PHF - D)*C))
      READ (5,36) L7,L9,NITV,NFINAL,NCPLOT,NCOMP,IH0
22
      IF ( NITV .EQ. 0) GO TO 997
      READ(5,60)VF1,VF2,VF3,VSMP,YF1,YF2,YF3,YCLMO
      READ(5,60)((AK(L,IH),IH=1,3),L=1,NCOMP)
      READ(5,60)(PHL(IH),IH=1,3)
50
      CONTINUE
      READ(5,60)E, HTS, AC, UVOLM, RANDA, B, CBF, DPH
               .EQ.0.) GO TO 22
      IF(
          E
      VBED=HTS*AC
      WRITE(6,30)
      FORMAT ('1')
30
      FORMAT( 2L10,6I10 )
36
      FORMAT (8F10.4)
60
      IF(L9) WRITE(6,52)
      IF(.NOT.L9) WRITE(6,53)
52
                      THEORY : FINITE MASS TRANSFER, NON-EQUILIBRIUM,
      FORMAT ('0
     / INTEGRAL METHODE ')
      FORMAT ('0
                      THEORY : EQUILIBRIUM')
53
      WRITE(6,59)
      FORMAT('0',7X,'L7',8X,'L9',6X,'NITV',4X,'NFINAL',4X,'NCPLOT',5X,
59
     &'NCOMP',5X,'IHO')
      WRITE(6,36) L7,L9,NITV,NFINAL,NCPLOT,NCOMP,IH0
      WRITE(6, 62)
62
      FORMAT('0',5X,'VF1',7X,'VF2',7X,'VF3',6X,'VSMP',7X,'YF1',7X,
     &'YF2',7X,'YF3',6X,'YCLMO')
      WRITE(6,60)VF1,VF2,VF3,VSMP,YF1,YF2,YF3,YCLMO
      WRITE(6, 66)
      FORMAT('0',5X,'PH1',7X,'PH2',7X,'PH3')
65
      FORMAT('0',5X,'KHM1',6X,'KHM2',6X,'KHM3',6X,'KAB1',6X,'KAB2',
66
     &6X, 'KAB3')
      WRITE(6,60)((AK(L,IH),IH=1,3),L=1,NCOMP)
      WRITE(6, 65)
```

```
WRITE(6,60)(PHL(IH),IH=1,3)
      WRITE(6, 64)
64
      FORMAT('0',7X,'E',7X,'HTS',7X,'AC',8X,'UVOLM',5X,'RANDA',5X,
     &'B',9X,'CBF',7X,'DPH')
      WRITE(6,60)E,HTS,AC,UVOLM,RANDA,B,CBF,DPH
      ULIN = UVOLM/(AC*E)
      HTCEL=HTS/NITV
      TCEL=HTCEL/ULIN
      VP=VBED*E/NITV
      R = (1 - E) / E
      M=NITV+2
      MA=M-1
      MB=M-2
      JF2 = VF2/VP + 1
            =VF1/VP + 1
      JF1
      JF3=VF3/VP +1
      IF(L7)WRITE(6,82)
82
      FORMAT ('0', 5X, 'VP', 8X, 'R', 9X, 'HTCEL', 5X, 'TCEL', 6X, 'VBED')
      IF(L7)WRITE(6,60) VP,R,HTCEL,TCEL,VBED
      IF(L7)WRITE(6,84)
      FORMAT('0',8X,'M',9X,'MA',8X,'JF1',7X,'JF2',7X,'JF3')
84
      IF(L7)WRITE(6,80) M,MA,JF1,JF2,JF3
      IF(L7) WRITE (6,88)
      FORMAT ('0',5X, 'DETAIL PRINT : YES ')
88
      IF ( .NOT. L7 ) WRITE( 6,89 )
      FORMAT ('0',5X, 'DETAIL PRINT : NO ')
89
 33
      CONTINUE
      DO 111 I=2, M
      PH(I,1) = PHL(IH0)
      DO 106 L=1,NCOMP
      Y(L,I,1) = YCLMO
106
      X(L,I,1) = YCLMO*AK(L,IHO)
111
      CONTINUE
      JMAX=JF3
      IF(JF2.GT.JMAX)JMAX=JF2
      IF (JF3.GT.JMAX) JMAX=JF3
      DO 115 L=1,NCOMP
      DO 115 J=1,JMAX
      X(L,1, J) = 0.
      X(L,M, J) = 0.
115
      CONTINUE
      IF(L7)WRITE(6,686)
      IF((NITV.GT.12).AND.L7) WRITE(6,187)
      IF(L7)WRITE(6,661)(PH(I,1),I=1,M)
      DO 116 L=1,NCOMP
      IF(L7)WRITE(6,663)L,(Y(L,I,1),I=1,M)
116
      IF(L9.AND.L7)WRITE(6,189)(X(L,I,1),I=1,M)
      JD=JF1
      NSTP=1
      NPD=0
      NSAMPL=0
      DO 118 L=1,NCOMP
```

```
YP(L)≈1.
118
      YEXT(L,1)=1.
      PHEXT(1) = PHL(3)
      VEXT(1) = 0.
      NCYCL≈0
120
      NCYCL=NCYCL+1
      IF (NCYCL.GT.NFINAL) GO TO 300
      IF(L7)WRITE(6,645)NCYCL
      IF(L7)WRITE(6,686)
      IF((NITV.GT.12).AND.L7) WRITE(6,187)
125
      CONTINUE
      DO 183 J=1, JD
      IF(NSTP.EQ.1)PH(1,J)=PHL(1)
      IF(NSTP.EQ.2)PH(1,J)=PHL(2)
       IF(NSTP.EQ.3)PH(1,J)=PHL(3)
      DO 128 L=1,NCOMP
      IF(NSTP.EQ.1)Y(L,1,J)=YF1
      IF(NSTP.EQ.2)Y(L,1,J)=YF2
128
       IF(NSTP.EQ.3)Y(L,1,J)=YF3
      IF(J.EQ.1) GO TO 183
      DO 131 I=2,MA
      PHO=PH(I,J-1)
      PH(I,J) = PHWAVE(PH(I-1,J-1),PH(I,J-1),B,CBF,DPH)
      DO 130 L=1,NCOMP
      IF(.NOT.L9)Y(L,I,J) = CALAA(R,AK(L,1),AK(L,2),AK(L,3),Y(L,I-1,J-1),
     &Y(L,I,J-1),PHO,PH(I,J),PHL(1),PHL(2),PHL(3))
      IF(L9) CALL SOVOD1
130
      CONTINUE
131
      CONTINUE
      PH(M,J) = PH(MA,J-1)
      DO 133 L=1,NCOMP
133
      Y(L,M,J) = Y(L,MA,J-1)
      L10 = ((Y(1,M,J-1),GE,Y(2,M,J-1),AND,Y(1,M,J),LT,Y(2,M,J)),OR.
     & (Y(1,M,J-1).LT.Y(2,M,J-1).AND.Y(1,M,J).GE.Y(2,M,J)))
      IF(.NOT.L10) GO TO 150
      NPD=NPD+1
      VPD (NPD) =NSAMPL*VP
      DO 140 L=1,NCOMP
      YPD(L,NPD) = YP(L)
140
      YP(L)=0.
      NSAMPL=0
      NSAMPL=NSAMPL+1
150
      DO 152 L=1,NCOMP
152
      YP(L) = (Y(L,M,J) + (NSAMPL-1) * YP(L)) / NSAMPL
      IF(NSTP.EQ.1)NTE=(NCYCL-1)*(JF1+JF2+JF3-3)+J
      IF (NSTP.EQ.2) NTE= (NCYCL-1) * (JF1+JF2+JF3-3)+JF1-1+J
      IF(NSTP.EQ.3)NTE=(NCYCL-1)*(JF1+JF2+JF3-3)+JF2+JF1-2+J
      DO 160 L=1,NCOMP
160
      YEXT(L,NTE) = Y(L,M,J)
      PHEXT(NTE) = PH(M,J)
      VEXT(NTE) = (NTE-1) * VP
      IF(L7)WRITE(6,661)(PH(I,J),I=1,M)
```

	DO 167 L=1,NCOMP
	IF(L7)WRITE(6,663)L,(Y(L,I,J),I=1,M)
167	IF(L9.AND.L7)WRITE(6,189)(X(L,I,J),I=1,M)
183	CONTINUE
	DO 186 I=2,M
	DO 184 L=1, $NCOMP$
	IF(L9) X(L,I,1) = X(L,I,JD)
184	Y(L,I,1) = Y(L,I,JD)
186	PH(I,1) = PH(I,JD)
200	NSTP=NSTP+1
	IF (NSTP.GE.4) NSTP=NSTP-3
	TF(NSTP, EO, 2) $JD=JF2$
	TF(NSTP, EO, 3) JD=JF3
	$TF(NSTP_NE_1)GO TO 125$
	TD=.TF]
	GO TO 120
300	I I N F = N T F / 3
500	TE(NTECT (3*TNEL)) [INF]=(TNE]+]
	$\frac{11}{MDT} = \frac{1}{MDT} = 1$
255	
300	= PORMAI(/// PIA, 5) (VOL. ELI (5A) PHEAT (5A) IEA(1) (4A) IEA(2) (7) $= DO 260 I = 1 IINE1$
260	DO 200 I-IPLINET DO 200 I-IPLINET
300	WRITE(0,470) (VEAT(II), PREAT(II), (IEAT(E,II), E-I, NCOMP),
470	$\alpha_{11}=1$ (NTE, LINET) EODMAR(1 1 2 (E10 2 2E10 4))
470	$FORMAT(-, JO(TU, Z_J))$
475	WKITE(0,4/2) $= EODMAR(/// 2/0W I CW WDD1 CW WDD2 7W WDD)$
4/5	FURMAT(///,3(8X,'1',0X,'1PD1',0X,'1PD2',/X, VPD'))
	$IF(NPD_GT_{(3^{L}LNE2)})$ LINE2=LINE2+1
	1F(LINE2.LT.1) GO TO 492
	DU 480 $1=1$, LINE2 WEITHER (C. 400) (III (WED (IIII) III) NO(WE) WED (III) IIII NED (IIIII)
480	WRITE(6,490) (11, (YPD(L,11), L=1, NCOMP), $VPD(11)$, 11=1, NPD , LINE2)
490	FORMAT('', 3(18, 2X, 3F10.4))
492	JSMP=VSMP/VP
	NSMP=NTE/JSMP
	DO 550 I=JSMP,NTE,JSMP
	K=I/JSMP
	SPNO(K) = I*VP
	DO 550 L=1,NCOMP
	SUMYS=0.
	DO 540 II=1,JSMP
540	SUMYS=SUMYS+YEXT(L,I-II+1)
550	YSMP(L,K) = SUMYS/JSMP
	WRITE(6,555)
555	FORMAT(///,1X,4(' NO. SAMPL',3X,'YSMP 1',4X,'YSMP 2'))
	LINE3=NSMP/4
	IF(NSMP.GT.(LINE3*4))LINE3=LINE3+1
	DO 560 I=1,LINE3
560	WRITE(6,570) (SPNO(II),(YSMP(L,II),L=1,NCOMP),II=I,NSMP,LINE3)
570	FORMAT(' ',12(F10.4))
	IF(L9) WRITE(6,52)
	IF(.NOT.L9) WRITE(6,53)
	WRITE(6,59)

```
WRITE(6,36) L7, L9, NITV, NFINAL, NCPLOT, NCOMP, IH0
WRITE(6, 62)
WRITE(6,60)VF1,VF2,VF3,VSMP,YF1,YF2,YF3,YCLMO
WRITE (6,66)
WRITE(6,60)((AK(L,IH),IH=1,3),L=1,NCOMP)
WRITE(6, 65)
WRITE(6,60)(PHL(IH),IH=1,3)
WRITE(6, 64)
WRITE(6,60)E, HTS, AC, UVOLM, RANDA, B, CBF, DPH
CONTINUE
FORMAT('0',12110)
FORMAT(' I= ','1',7X, '2',7X,'3', 7X,'4',7X,'5',7X,'6',7X,'7',7X,
/'8',7X,'9', 6X,'10', 6X,'11',6X,'12',6X,'13',6X,'14'
                                                          )
          I= ','15',6X,'16',6X,'17',6X,'18',6X,'19',6X,'20', 6X,
FORMAT ( '
/'21', 6X,'22',6X,'23',6X,'24',6X,'25',6X,'26',6X,'27',6X,'28')
FORMAT (' Y', I1, '=', 14F8.3)
FORMAT (/, ' PH=', 14F8.3)
FORMAT (' X = ', 14F8.4)
IF (NCPLOT.LE.0)GO TO 50
NCOMT=NFINAL-NCPLOT
NPTOMT=NCOMT*(JF1+JF2-2)
NPTACT=NTE-NPTOMT
DO 710 I=1,NPTACT
XODPT(I)=VEXT(I+NPTOMT)
PHEPT(I)=PHEXT(I+NPTOMT)
WRITE(6,632)
CALL XYPLOT (NPTACT, XODPT, PHEPT)
WRITE(6,631)
DO 720 I=1,NPTACT
YE1PT(I)=YEXT(1,I+NPTOMT)
CALL XYPLOT (NPTACT, XODPT, YE1PT)
WRITE(6, 634)
DO 730 I=1,NPTACT
YE2PT(I) = YEXT(2, I + NPTOMT)
CALL XYPLOT (NPTACT, XODPT, YE2PT)
WRITE(6,633)
CALL XYPLOT (NSMP, SPNO, YSMP)
GO TO 50
             ***
                    COMP 1 CONCENTRATION WAVE')
FORMAT ('1
             ***
FORMAT('1
                          2 CONCENTRATION WAVE')
                    COMP
FORMAT('1
             ***
                    PH WAVE')
FORMAT('1
             ***
                   WAVE OF SAMPLE CONC. ')
FORMAT('0
               NCYCL=',I3)
STOP
END
```

C C

600

686

187

663

661 189

710

720

730

631

634

632

633

645 997

```
FUNCTION CALAA(R,AK1,AK2,AK3,YIJ0,YJ0,PH0,PH,PH1,PH2,PH3)
IF(PH1.LT.PH2)G0 T0 50
IF(PH.GT.PH2)AKD=AK1+(PH-PH1)*(AK2-AK1)/(PH2-PH1)
IF(PH0.GT.PH2)AKN=AK1+(PH0-PH1)*(AK2-AK1)/(PH2-PH1)
IF(PH.LE.PH2)AKD=AK3+(PH-PH3)*(AK2-AK3)/(PH2-PH3)
```
```
IF(PHO_LE_PH2)AKN=AK3+(PHO-PH3)*(AK2-AK3)/(PH2-PH3)
      CALAA = (YIJO + R * AKN * YJO) / (1 + R * AKD)
      RETURN
 50
      IF(PH_LT_PH2)AKD=AK1+(PH-PH1)*(AK2-AK1)/(PH2-PH1)
      IF(PHO_LT_PH2)AKN=AK1+(PHO-PH1)*(AK2-AK1)/(PH2-PH1)
      IF (PH.GE.PH2) AKD=AK3+ (PH-PH3) * (AK2-AK3) / (PH2-PH3)
      IF(PHO_GE_PH2)AKN=AK3+(PHO-PH3)*(AK2-AK3)/(PH2-PH3)
      CALAA = (YIJO+R*AKN*YJO) / (1+R*AKD)
      RETURN
      END
С
С
       SUBROUTINE SOVOD1
      COMMON B, MA, AK, PHL, PH, Y, VP, YT, YB, NITV, L,
     /FIT,FIB,JF1,JF2, NTF,NBF,I,J ,RANDA,NCYCL,NCYCLP,HTS,AC,
     /JD,M,TCEL,YF1,YF2,X, E ,L1, L2, L3 ,L7,L9
      LOGICAL L1, L2, L3,
                               L7
      DIMENSION Y(2,37,66), PH(37,66), AK(2,3), PHL(3),
     /X(2,37,66)
      FMSBS(YPF, XPF, XF, EF) = YPF-((1.-EF)/EF) * (XF-XPF)
      PHSV=PH(I,J)
      IF(PHSV.GE.PHL(2))AAK=AK(L,2)+(PHSV-PHL(2))*(AK(L,1)-AK(L,2))/
     \& (PHL(1)-PHL(2))
      IF(PHSV.LT.PHL(2))AAK=AK(L,2)+(PHSV-PHL(2))*(AK(L,3)-AK(L,2))/
     \& (PHL(3) – PHL(2))
      YPSV=Y(L, I-1, J-1)
      XPSV=X(L,I,J-1)
      AA=RANDA* ( YPSV + ((1-E)/E) * XPSV )
      BB=RANDA*((1-E)/E + 1/AAK)
      BTNEG = (-1) * BB * TCEL
      X(L,I,J) = (AA/BB) - (AA/BB - XPSV) * EXP(BTNEG)
      Y(L,I,J) = FMSBS(YPSV,XPSV,X(L,I,J),E)
      RETURN
       END
С
С
С
     SUBROUTINE XYPLOT
                                               07/13/79
C:0664
             TEMP.PUNCH
                                   CC05348
                                                             CCDP010
      SUBROUTINE XYPLOT(N,X,Y)
      INTEGER*4 PA, PB
      LOGICAL*1 STAR, BLANK, PLUS, BAR, HYPHEN, GRAPH (111, 51), L(5)
      REAL*4 X(N), Y(N), XSCALE(12), YSCALE(6)
      EQUIVALENCE (STAR,L(1)), (BLANK,L(2)), (PLUS,L(3))
      EQUIVALENCE (BAR, L(4)), (HYPHEN, L(5)), (PA, L(1)), (PB, L(5))
      DATA PA/'* + '/, PB/'-???'/
      IF(N.LT.2) RETURN
С
С
      INITIALIZE GRID TO BLANKS
С
      DO 1010 J=1,51
         DO 1000 I=1,111
            GRAPH(I,J)=BLANK
```

```
1000
         CONTINUE
 1010 CONTINUE
С
С
      SETUP HORIZ GRID
С
      DO 1030 J=1,51,10
         DO 1020 I=1,111
            GRAPH(I,J)=HYPHEN
 1020
         CONTINUE
 1030 CONTINUE
С
С
      SETUP VERT GRID
С
      DO 1050 I=1,111,10
         DO 1040 J=1,51
            GRAPH(I,J) = BAR
 1040
         CONTINUE
 1050 CONTINUE
С
      SETUP GRID CROSSINGS
С
С
      DO 1070 I=1,111,10
         DO 1060 J=1,51,10
            GRAPH(I,J)=PLUS
 1060
         CONTINUE
 1070 CONTINUE
С
С
      CALC SCALE FACTORS
С
      XMAX=X(1)
      XMIN=X(1)
      YMAX=Y(1)
      YMIN=Y(1)
      DO 1080 I=2,N
         XMAX=AMAX1(XMAX,X(I))
         XMIN=AMIN1(XMIN,X(I))
         YMAX=AMAX1(YMAX,Y(I))
         YMIN=AMIN1 (YMIN, Y(I))
 1080 CONTINUE
      DELX=(XMAX-XMIN)/11.
      DELY=(YMAX-YMIN)/5.
      IF(DELX.LT.0.1E-55) DELX=0.1E-55
      IF(DELY.LT.0.1E-55) DELY=0.1E-55
      DO 1090 I=1,6
         YSCALE(I) = YMAX-DELY*(I-1)
 1090 CONTINUE
      DO 1100 I=1,12
         XSCALE(I) = XMIN+DELX*(I-1)
 1100 CONTINUE
С
С
      SET AXIS (IF NEEDED)
С
```

```
IF((ABS(YMAX)+ABS(YMIN)-ABS(YMAX+YMIN)).EQ.0.0) GOTO 1120
         J=51-INT((-YMIN)/(YMAX-YMIN)*50.)
         DO 1110 I=1,111
            GRAPH(I,J)=PLUS
 1110
         CONTINUE
 1120 CONTINUE
      IF((ABS(XMAX)+ABS(XMIN)-ABS(XMAX+XMIN)).EQ.0.0) GOTO 1140
         I=INT((-XMIN)/(XMAX-XMIN)*110.)+1
         DO 1130 J=1,51
            GRAPH(I,J) = PLUS
         CONTINUE
 1130
 1140 CONTINUE
С
      PLOT CURVE IN GRID
С
С
      DELX=(XMAX-XMIN)/110.
      DELY=(YMAX-YMIN)/50.
      IF(DELX.LT.0.1E-55) DELX=0.1E-55
      IF(DELY.LT.0.1E-55) DELY=0.1E-55
      DO 1150 K=1,N
         I=INT((X(K)-XMIN)/DELX)+1
         J=51-INT((Y(K)-YMIN)/DELY)
         GRAPH(I,J) = STAR
 1150 CONTINUE
С
С
      PRINT GRAPH AND SCALE LABELS
С
      DO 1170 K=1,5
         J = (K-1) * 10 + 1
         WRITE(6,1180) YSCALE(K), (GRAPH(I,J), I=1,111)
         JJJ=J+1
         NN=J+9
         DO 1160 JJ=JJJ,NN
            WRITE(6,1190) (GRAPH(I,JJ),I=1,111)
 1160
         CONTINUE
 1170 CONTINUE
      WRITE(6,1200) YSCALE(6),(GRAPH(1,51),I=1,111),
     8
         (XSCALE(I), I=1, 11, 2), (XSCALE(I), I=2, 12, 2)
      RETURN
 1180 FORMAT (4X,G11.4,1X,'-',111A1)
 1190 FORMAT(17X,111A1)
 1200 FORMAT(4X,G11.4,1X,'-',111A1,/,11X,6(G11.4,9X),
         /,12X,6(9X,G11.4))
     8
      END
```

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