National Examinations December 2019

16-CHEM-A2, UNIT OPERATIONS and SEPARATION PROCESSES

3 hours duration

NOTES

1. If doubt exists as to the interpretation of any question, the candidate is urged to submit with the answer paper, a clear statement of any assumptions made.
2. The examination is an **open book exam.** One textbook of your choice with notations listed on the margins etc., but no loose notes are permitted into the exam.
3. Candidates may use any **non-communicating** scientific calculator.
4. All problems are worth 25 points. At least **two problems** from **each** of parts **A** and **B** must be attempted.
5. **Only the first two** questions as they appear in the answer book from each section will be marked.
6. State all assumptions clearly.

<u>PART A:</u> UNIT OPERATIONS

A1. A liquid (density = 997.1 kg/m^3, viscosity = 2.1 x 10^{-3} Pa.s) is pumped at 27 °C from an open tank through a 1-inch nominal diameter smooth sanitary pipe (inside diameter = 2.291 cm) to a second tank at a higher level. The mass flow rate is 1 kg/s through 30 m of straight pipe with two 90° standard elbows and one angle valve (fully open). The supply tank maintains a liquid level of 3 m, and the liquid leaves the system at elevation of 12 m above the floor. Compute the power requirements of the pump assuming an efficiency of 60%.

A2. Spherical glass particles (12 mm diameter and 2500 kg/m^3 density) and spherical metal particles (1.5 mm diameter and 7500 kg/m^3) are falling in water (density = 1000 kg/m^3).

(a) **[12.5 points]** Calculate the terminal falling velocities of glass and metal particles in water for a constant friction factor of 0.22.

(b) **[12.5 points]** At what water velocity will fluidized beds of glass particles and metal particles have the same bed densities? The relation between fluidization velocity (u_c), terminal velocity (u_0) and bed voidage (e) for a spherical particle is given by the equation (u_c/u_0) = $e^{2.3}$

A3. A single-frame laboratory plate and frame filter press is used to filter water containing 1.39% mole fraction of calcium carbonate ($CaCO_3$). The density of solid calcium carbonate is 2830 kg/m³. Tests at a temperature of 19 °C and $\Delta P = 2.72$ atm gave the following results:

Filtrate Volume (in liters)	Time (in seconds)
0.2	1.8
0.4	4.2
0.6	7.5
0.8	11.2
1.0	15.4
1.2	20.5
1.4	26.7
1.6	33.4
1.8	41.0
2.0	48.8
2.2	57.7
2.4	67.2
2.6	77.3
2.8	88.7

The unit was 30 mm thick and had a filtering area of 263 cm². Density of the dried cake was 1603 kg/m³. Determine the following:

a) **[12 points]** Filtrate volume equivalent in resistance to the filter medium and piping

b) **[9 points]** Specific cake resistance and cake porosity

c) **[4 points]** Specific surface area of the cake

PART B: SEPARATION PROCESSES

B1. A countercurrent rotary drier at 22 °C is fed granular material containing 40% moisture and the material is withdrawn at 32 °C containing 5% moisture. The air supplied, which contains 0.006 kg water vapor per kg of dry air, enters the drier at 112 °C and leaves at 37 °C. The drier handles 0.125 kg/sec wet stock of granular material. Assuming that radiation losses amount to 20,000 J/kg of dry air used, determine the following:

(a) **[18 points]** Mass flow of dry air supplied to the drier

(b) **[7 points]** Humidity of air leaving the drier.

DATA:
Specific heat capacity of dried granular material = 880 J/kg K
Specific heat capacity of dry air = 1000 J/kg K
Specific heat capacity of water vapor = 2010 J/kg K
Latent heat of water vapor at 22 °C = 2.449 MJ/kg

B2. A salt ($Na_2SO_4.10H_2O$) is to be produced in a Swenson-Walker crystallizer by cooling to 17 °C a solution of anhydrous Na_2SO_4 that saturates between 17 °C and 27 °C. The solubilities of anhydrous Na_2SO_4 in water are 40 kg/100 kg of water at 27 °C and 14 kg/100 kg water at 17 °C. The mean heat capacity of the liquor is 3.8 kJ/kg K and the heat of crystallization is 230 kJ/kg. For the crystallizer running in countercurrent flow mode, the available heat transfer area is 3 m^2/m length, the overall heat transfer coefficient is 0.15 kW/m^2 K. If the cooling water enters the crystallizer at 7 °C and leaves at 17 °C with negligible evaporation, how many sections of the crystallizer will be required to process 0.25 kg/s of the product? Assume each section to be 3 m long.

B3. A double-effect forward-feed evaporator is required to give a product, which contains 50% by mass of solids. Each effect has 10 m^2 of heating surface, and the heat transfer coefficient in the first effect is 2.8 kW/m^2 K and 1.7 kW/m^2 K in the second effect. Dry and saturated steam is available at a pressure of 375 kPa and the condenser operates at a pressure of 13.5 kPa. The concentrated solution exhibits a boiling-point rise of 3 K. What is the maximum permissible feed rate if feed contains 10% solids at 310 K? The latent heat is 2330 kJ/kg and the specific heat capacity is 4.1868 kJ/kg under all the above conditions.

The Periodic Table of the Elements

- Alkali metals
- Alkaline earth metals
- Transition metals
- Other metals
- Metalloids (semi-metal)
- Nonmetals
- Halogens
- Noble gases

Element name → Mercury
Atomic # → 80
Symbol → Hg
Avg. Mass → 200.59

1	2		3	4	5	6	7	8	9	10	11	12	13	14	15	16	17	18
Hydrogen 1 H 1.01																		Helium 2 He 4.00
Lithium 3 Li 6.94	Beryllium 4 Be 9.01												Boron 5 B 10.81	Carbon 6 C 12.01	Nitrogen 7 N 14.01	Oxygen 8 O 16.00	Fluorine 9 F 19.00	Neon 10 Ne 20.18
Sodium 11 Na 22.99	Magnesium 12 Mg 24.31												Aluminum 13 Al 26.98	Silicon 14 Si 28.09	Phosphorus 15 P 30.97	Sulfur 16 S 32.07	Chlorine 17 Cl 35.45	Argon 18 Ar 39.95
Potassium 19 K 39.10	Calcium 20 Ca 40.08		Scandium 21 Sc 44.96	Titanium 22 Ti 47.88	Vanadium 23 V 50.94	Chromium 24 Cr 52.00	Manganese 25 Mn 54.94	Iron 26 Fe 55.85	Cobalt 27 Co 58.93	Nickel 28 Ni 58.69	Copper 29 Cu 63.55	Zinc 30 Zn 65.39	Gallium 31 Ga 69.72	Germanium 32 Ge 72.61	Arsenic 33 As 74.92	Selenium 34 Se 78.96	Bromine 35 Br 79.90	Krypton 36 Kr 83.80
Rubidium 37 Rb 85.47	Strontium 38 Sr 87.62		Yttrium 39 Y 88.91	Zirconium 40 Zr 91.22	Niobium 41 Nb 92.91	Molybdenum 42 Mo 95.94	Technetium 43 Tc (98)	Ruthenium 44 Ru 101.07	Rhodium 45 Rh 102.91	Palladium 46 Pd 106.42	Silver 47 Ag 107.87	Cadmium 48 Cd 112.41	Indium 49 In 114.82	Tin 50 Sn 118.71	Antimony 51 Sb 121.76	Tellurium 52 Te 127.60	Iodine 53 I 126.90	Xenon 54 Xe 131.29
Cesium 55 Cs 132.91	Barium 56 Ba 137.33	57-70 *	Lutetium 71 Lu 174.97	Hafnium 72 Hf 178.49	Tantalum 73 Ta 180.95	Tungsten 74 W 183.84	Rhenium 75 Re 186.21	Osmium 76 Os 190.23	Iridium 77 Ir 192.22	Platinum 78 Pt 195.08	Gold 79 Au 196.97	Mercury 80 Hg 200.59	Thallium 81 Tl 204.38	Lead 82 Pb 207.20	Bismuth 83 Bi 208.98	Polonium 84 Po (209)	Astatine 85 At (210)	Radon 86 Rn (222)
Francium 87 Fr (223)	Radium 88 Ra (226)	89-102 **	Lawrencium 103 Lr (262)	Rutherfordium 104 Rf (267)	Dubnium 105 Db (268)	Seaborgium 106 Sg (271)	Bohrium 107 Bh (272)	Hassium 108 Hs (270)	Meitnerium 109 Mt (276)	Darmstadtium 110 Ds (281)	Roentgenium 111 Rg (280)	Copernicium 112 Cn (285)	Ununtrium 113 Uut (284)	Ununquadium 114 Uuq (289)	Ununpentium 115 Uup (288)	Ununhexium 116 Uuh (293)	Ununseptium 117 Uus (294?)	Ununoctium 118 Uuo (294)

*lanthanides	Lanthanum 57 La 138.91	Cerium 58 Ce 140.12	Praseodymium 59 Pr 140.91	Neodymium 60 Nd 144.24	Promethium 61 Pm (145)	Samarium 62 Sm 150.36	Europium 63 Eu 151.97	Gadolinium 64 Gd 157.25	Terbium 65 Tb 158.93	Dysprosium 66 Dy 162.50	Holmium 67 Ho 164.93	Erbium 68 Er 167.26	Thulium 69 Tm 168.93	Ytterbium 70 Yb 173.04
**actinides	Actinium 89 Ac (227)	Thorium 90 Th 232.04	Protactinium 91 Pa 231.04	Uranium 92 U 238.03	Neptunium 93 Np (237)	Plutonium 94 Pu (244)	Americium 95 Am (243)	Curium 96 Cm (247)	Berkelium 97 Bk (247)	Californium 98 Cf (251)	Einsteinium 99 Es (252)	Fermium 100 Fm (257)	Mendelevium 101 Md (258)	Nobelium 102 No (259)

TABLE B.2 Saturated Water: Pressure Table

P kPa, MPa	T °C	$\hat{v}_l$ m³/kg	$\hat{v}_v$ m³/kg	$\hat{u}_l$ kJ/kg	$\Delta\hat{u}_{lv}$ kJ/kg	$\hat{u}_v$ kJ/kg	$\hat{h}_l$ kJ/kg	$\Delta\hat{h}_{lv}$ kJ/kg	$\hat{h}_v$ kJ/kg	$\hat{s}_l$ kJ/kg K	$\Delta\hat{s}_{lv}$ kJ/kg K	$\hat{s}_v$ kJ/kg K
0.6113	0.01	0.001000	206.132	0	2375.3	2375.3	0.00	2501.3	2501.3	0	9.1562	9.1562
1.0	6.98	0.001000	129.208	29.29	2355.7	2385.0	29.29	2484.9	2514.2	0.1059	8.8697	8.9756
1.5	13.03	0.001001	87.980	54.70	2338.6	2393.3	54.70	2470.6	2525.3	0.1956	8.6322	8.8278
2.0	17.50	0.001001	67.004	73.47	2326.0	2399.5	73.47	2460.0	2533.5	0.2607	8.4629	8.7236
2.5	21.08	0.001002	54.254	88.47	2315.9	2404.4	88.47	2451.6	2540.0	0.3120	8.3311	8.6431
3.0	24.08	0.001003	45.665	101.03	2307.5	2408.5	101.03	2444.5	2545.5	0.3545	8.2231	8.5775
4.0	28.96	0.001004	34.800	121.44	2293.7	2415.2	121.44	2432.9	2554.4	0.4226	8.0520	8.4746
5.0	32.88	0.001005	28.193	137.79	2282.7	2420.5	137.79	2423.7	2561.4	0.4763	7.9187	8.3950
7.5	40.29	0.001008	19.238	168.76	2261.7	2430.5	168.77	2406.0	2574.8	0.5763	7.6751	8.2514
10.0	45.81	0.001010	14.674	191.79	2246.1	2437.9	191.81	2392.8	2584.6	0.6492	7.5010	8.1501
15.0	53.97	0.001014	10.022	225.90	2222.8	2448.7	225.91	2373.1	2599.1	0.7548	7.2536	8.0084
20.0	60.06	0.001017	7.649	251.35	2205.4	2456.7	251.38	2358.3	2609.7	0.8319	7.0766	7.9085
25.0	64.97	0.001020	6.204	271.88	2191.2	2463.1	271.90	2346.3	2618.2	0.8930	6.9383	7.8313
30.0	69.10	0.001022	5.229	289.18	2179.2	2468.4	289.21	2336.1	2625.3	0.9439	6.8247	7.7686
40.0	75.87	0.001026	3.993	317.51	2159.5	2477.0	317.55	2319.2	2636.7	1.0258	6.6441	7.6700
50.0	81.33	0.001030	3.240	340.42	2143.4	2483.8	340.47	2305.4	2645.9	1.0910	6.5029	7.5939
75.0	91.77	0.001037	2.217	384.29	2112.4	2496.7	384.36	2278.6	2663.0	1.2129	6.2434	7.4563
0.100	99.62	0.001043	1.6940	417.33	2088.7	2506.1	417.44	2258.0	2675.5	1.3025	6.0568	7.3593
0.125	105.99	0.001048	1.3749	444.16	2069.3	2513.5	444.30	2241.1	2685.3	1.3739	5.9104	7.2843
0.150	111.37	0.001053	1.1593	466.92	2052.7	2519.6	467.08	2226.5	2693.5	1.4335	5.7897	7.2232
0.175	116.06	0.001057	1.0036	486.78	2038.1	2524.9	486.97	2213.6	2700.5	1.4848	5.6868	7.1717
0.200	120.23	0.001061	0.8857	504.47	2025.0	2529.5	504.68	2202.0	2706.6	1.5300	5.5970	7.1271
0.225	124.00	0.001064	0.7933	520.45	2013.1	2533.6	520.69	2191.3	2712.0	1.5705	5.5173	7.0878
0.250	127.43	0.001067	0.7187	535.08	2002.1	2537.2	535.34	2181.5	2716.9	1.6072	5.4455	7.0526
0.275	130.60	0.001070	0.6573	548.57	1992.0	2540.5	548.87	2172.4	2721.3	1.6407	5.3801	7.0208
0.300	133.55	0.001073	0.6058	561.13	1982.4	2543.6	561.45	2163.9	2725.3	1.6717	5.3201	6.9918
0.325	136.30	0.001076	0.5620	572.88	1973.5	2546.3	573.23	2155.8	2729.0	1.7005	5.2646	6.9651
0.350	138.88	0.001079	0.5243	583.93	1965.0	2548.9	584.31	2148.1	2732.4	1.7274	5.2130	6.9404
0.375	141.32	0.001081	0.4914	594.38	1956.9	2551.3	594.79	2140.8	2735.6	1.7527	5.1647	6.9174
0.40	143.63	0.001084	0.4625	604.29	1949.3	2553.6	604.73	2133.8	2738.5	1.7766	5.1193	6.8958
0.45	147.93	0.001088	0.4140	622.75	1934.9	2557.6	623.24	2120.7	2743.9	1.8206	5.0359	6.8565
0.50	151.86	0.001093	0.3749	639.66	1921.6	2561.2	640.21	2108.5	2748.7	1.8606	4.9606	6.8212
0.55	155.48	0.001097	0.3427	655.30	1909.2	2564.5	655.91	2097.0	2752.9	1.8972	4.8920	6.7892
0.60	158.85	0.001101	0.3157	669.88	1897.5	2567.4	670.54	2086.3	2756.8	1.9311	4.8289	6.7600
0.65	162.01	0.001104	0.2927	683.55	1886.5	2570.1	684.26	2076.0	2760.3	1.9627	4.7704	6.7330
0.70	164.97	0.001108	0.2729	696.43	1876.1	2572.5	697.20	2066.3	2763.5	1.9922	4.7158	6.7080