

## Contents

**Preface** *XIII*

**Symbols** *XV*

|          |   |           |
|----------|---|-----------|
| <b>1</b> | <b>Introduction</b>   | <b>1</b>  |
| 1.1      | Overview of Membrane Science and Technology                   | 1         |
| 1.2      | History of Membrane Science and Technology                    | 4         |
| 1.3      | Advantages and Limitations of Membrane Processes              | 7         |
| 1.4      | The Membrane-Based Industry: Its Structure and Markets        | 9         |
| 1.5      | Future Developments in Membrane Science and Technology        | 12        |
| 1.5.1    | Biological Membranes  | 14        |
| 1.6      | Summary   | 16        |
|          | Recommended Reading   | 16        |
|          | References  | 17        |
| <b>2</b> | <b>Fundamentals</b>   | <b>19</b> |
| 2.1      | Introduction  | 19        |
| 2.2      | Definition of Terms   | 19        |
| 2.2.1    | The Membrane and Its Function                                 | 19        |
| 2.2.2    | Membrane Materials and Membrane Structures                    | 21        |
| 2.2.2.1  | Symmetric and Asymmetric Membranes                            | 22        |
| 2.2.2.2  | Porous Membranes  | 23        |
| 2.2.2.3  | Homogeneous Dense Membranes                                   | 23        |
| 2.2.2.4  | Ion-Exchange Membranes  | 24        |
| 2.2.2.5  | Liquid Membranes  | 24        |
| 2.2.2.6  | Fixed Carrier Membranes                                       | 24        |
| 2.2.2.7  | Other Membranes   | 25        |
| 2.2.2.8  | Membrane Geometries   | 25        |
| 2.2.3    | Mass Transport in Membranes                                   | 27        |
| 2.2.4    | Membrane Separation Properties                                | 31        |
| 2.2.5    | Definition of Various Membrane Processes                      | 33        |
| 2.2.5.1  | Pressure-Driven Membrane Processes                            | 34        |
| 2.2.5.2  | Activity and Concentration Gradient Driven Membrane Processes | 35        |

|          |  |    |
|----------|--|----|
| 2.2.5.3  | Electrical Potential and Electrochemical Potential Driven Processes                        | 36 |
| 2.3      | Fundamentals of Mass Transport in Membranes and Membrane Processes                         | 37 |
| 2.3.1    | Basic Thermodynamic Relationships with Relevance to Membrane Processes                     | 37 |
| 2.3.2    | Basic Electrochemical Relationships with Relevance to Membrane Processes                   | 42 |
| 2.3.2.1  | Electron and Ion Conductivity and Ohm's Law  | 42 |
| 2.3.2.2  | Ion Conductivity, Ion Mobility, and Drift Speed  | 43 |
| 2.3.2.3  | Coulomb's Law and the Electric Field Effect on Ions in Solution                            | 45 |
| 2.3.2.4  | The Electric Field Effect in Electrolyte Solutions and the Debye-Hückel Theory             | 46 |
| 2.3.2.5  | Electrical Dipoles and Intermolecular Forces   | 48 |
| 2.3.3    | Chemical and Electrochemical Equilibrium in Membrane Systems                               | 49 |
| 2.3.3.1  | Water Dissociation Equilibrium and the pH- and pK Values of Acids and Bases                | 49 |
| 2.3.3.2  | Osmotic Equilibrium, Osmotic Pressure, Osmosis, and Reverse Osmosis                        | 51 |
| 2.3.3.3  | The Electrochemical Equilibrium and the Donnan Potential between a Membrane and a Solution | 54 |
| 2.3.3.4  | The Donnan Exclusion of the Co-ions  | 55 |
| 2.3.4    | Fluxes and Driving Forces in Membrane Processes  | 57 |
| 2.3.4.1  | Viscous Flow through Porous Membranes  | 58 |
| 2.3.4.2  | Diffusion in Liquids and Dense Membranes   | 59 |
| 2.3.4.3  | Diffusion in Solid or Dense Materials  | 63 |
| 2.3.4.4  | Ion Flux and Electrical Current  | 65 |
| 2.3.4.5  | Diffusion of Ions in an Electrolyte Solution   | 66 |
| 2.3.4.6  | Ion Mobility and Ion Radius in Aqueous Solutions   | 67 |
| 2.3.4.7  | Migration of Ions and the Electrical Current   | 68 |
| 2.3.4.8  | The Transport Number and the Permselectivity of Ion-exchange Membranes                     | 69 |
| 2.3.4.9  | Interdependence of Fluxes and Driving Forces   | 70 |
| 2.3.4.10 | Gas Flux through Porous Membranes, the Knudsen and Surface Diffusion and Molecular Sieving | 71 |
| 2.3.4.11 | Surface Diffusion and Capillary Condensation of Gases                                      | 73 |
| 2.4      | Mathematical Description of Mass Transport in Membranes                                    | 74 |
| 2.4.1    | Mass Transport Described by the Thermodynamics of Irreversible Processes                   | 75 |
| 2.4.2    | Mass Transport Described by the Stefan–Maxwell Equations                                   | 77 |
| 2.4.3    | Membrane Mass Transport Models   | 79 |
| 2.4.3.1  | The Solution–Diffusion Model   | 79 |
| 2.4.3.2  | The Pore Flow Model and the Membrane Cut-off   | 84 |
|          | References   | 87 |

|          |  |           |
|----------|--|-----------|
| <b>3</b> | <b>Membrane Preparation and Characterization</b>   | <b>89</b> |
| 3.1      | Introduction   | 89        |
| 3.2      | Membrane Materials   | 89        |
| 3.2.1    | Polymeric Membrane Materials   | 90        |
| 3.2.1.1  | The Physical State of a Polymer  | 90        |
| 3.2.1.2  | Crystallinity and Glass Transition Temperature   | 92        |
| 3.2.1.3  | The Glass Transition Temperature and the Free Volume   | 93        |
| 3.2.1.4  | Molecular Weight of a Polymer Chain  | 94        |
| 3.2.1.5  | Macroscopic Structures of Polymers   | 95        |
| 3.2.1.6  | Polymer Chain Interaction and Its Effect on Physical Properties                              | 97        |
| 3.2.1.7  | The Chemical Structure of the Polymer and Its Effect on Polymer Properties                   | 98        |
| 3.2.2    | Inorganic Membrane Materials   | 100       |
| 3.2.2.1  | Metal Membranes  | 100       |
| 3.2.2.2  | Glass Membranes  | 101       |
| 3.2.2.3  | Carbon Membranes   | 101       |
| 3.2.2.4  | Metal Oxide Membranes  | 102       |
| 3.2.3    | Liquid Membrane Materials  | 103       |
| 3.3      | Preparation of Membranes   | 104       |
| 3.3.1    | Preparation of Symmetric Porous Membranes  | 104       |
| 3.3.1.1  | Isotropic Membranes Made by Sintering of Powders, Stretching of Films, and Template Leaching | 106       |
| 3.3.1.2  | Membranes Made by Pressing and Sintering of Polymer Powders                                  | 106       |
| 3.3.1.3  | Membranes Made by Stretching a Polymer Film of Partial Crystallinity                         | 107       |
| 3.3.1.4  | Membranes Made by Track-Etching  | 108       |
| 3.3.1.5  | Membranes Made by Micro-Lithography and Etching Techniques                                   | 109       |
| 3.3.1.6  | Glass Membranes Made by Template Leaching  | 112       |
| 3.3.1.7  | Porous Graphite Membranes Made by Pyrolyzing Polymer Structures                              | 112       |
| 3.3.1.8  | Symmetric Porous Polymer Membranes Made by Phase Inversion Techniques                        | 112       |
| 3.3.2    | Preparation of Asymmetric Membranes  | 114       |
| 3.3.2.1  | Preparation of Integral Asymmetric Membranes   | 115       |
| 3.3.3    | Practical Membrane Preparation by Phase Inversion  | 117       |
| 3.3.3.1  | Temperature-Induced Membrane Preparation   | 117       |
| 3.3.3.2  | Diffusion-Induced Membrane Preparation   | 118       |
| 3.3.4    | Phenomenological Description of the Phase Separation Process                                 | 124       |
| 3.3.4.1  | Temperature-Induced Phase Separation Process   | 125       |
| 3.3.4.2  | Thermodynamics of a Temperature-Induced Phase Separation of a Two-Component Mixture          | 126       |
| 3.3.4.3  | The Diffusion-Induced Phase Separation Process   | 133       |
| 3.3.4.4  | Structures of Asymmetric Membranes Obtained by Phase Inversion                               | 136       |

|         |  |     |
|---------|--|-----|
| 3.3.4.5 | Identification of Various Process Parameters in the Preparation of Phase Inversion Membranes | 136 |
| 3.3.4.6 | General Observation Concerning the Structure of Phase Inversion Membranes                    | 137 |
| 3.3.4.7 | The Selection of a Polymer/Solvent/Precipitant System for the Preparation of Membranes       | 144 |
| 3.3.4.8 | Membrane Pre- and Post-Precipitation Treatment   | 148 |
| 3.3.5   | Preparation of Composite Membranes   | 149 |
| 3.3.5.1 | Techniques Used for the Preparation of Polymeric Composite Membranes                         | 151 |
| 3.3.6   | Preparation of Inorganic Membranes   | 155 |
| 3.3.6.1 | Suspension Coating and the Sol–Gel Process   | 157 |
| 3.3.6.2 | Perovskite Membranes   | 158 |
| 3.3.6.3 | Zeolite Membranes  | 159 |
| 3.3.6.4 | Porous Carbon Membranes  | 160 |
| 3.3.6.5 | Porous Glass Membranes   | 161 |
| 3.3.7   | Preparation of Homogeneous Solid Membranes   | 161 |
| 3.3.7.1 | Preparation of Liquid Membranes  | 162 |
| 3.3.7.2 | Preparation of Ion-Exchange Membranes  | 164 |
| 3.4     | Membrane Characterization  | 170 |
| 3.4.1   | Characterization of Porous Membranes   | 171 |
| 3.4.1.1 | Techniques using Microscopy  | 172 |
| 3.4.1.2 | Determination of Micro- and Ultrafiltration Membrane Fluxes                                  | 173 |
| 3.4.1.3 | Membrane Retention and Molecular Weight Cut-Off  | 175 |
| 3.4.1.4 | The Bacterial Challenge Test   | 178 |
| 3.4.2   | Membrane Pore Size Determination   | 178 |
| 3.4.2.1 | Air/Liquid and Liquid/Liquid Displacement  | 179 |
| 3.4.2.2 | The Bubble Point Method and Gas Liquid Porosimetry   | 180 |
| 3.4.2.3 | Liquid/Liquid Displacement   | 182 |
| 3.4.2.4 | Permporometry  | 185 |
| 3.4.2.5 | Thermoporometry  | 188 |
| 3.4.3   | Characterization of Dense Membranes  | 189 |
| 3.4.3.1 | Determination of Diffusivity in Dense Membranes  | 190 |
| 3.4.3.2 | Long-Term Stability of Membranes   | 193 |
| 3.4.4   | Determination of Electrochemical Properties of Membranes                                     | 193 |
| 3.4.4.1 | Hydraulic Permeability of Ion-Exchange Membranes   | 194 |
| 3.4.4.2 | The Fixed Charge Density of Ion-Exchange Membranes   | 194 |
| 3.4.4.3 | Determination of the Electrical Resistance of Ion-Exchange Membranes                         | 195 |
| 3.4.4.4 | Membrane Resistance Measurements by Impedance Spectroscopy                                   | 198 |
| 3.4.4.5 | Permselectivity of Ion-Exchange Membranes  | 203 |
| 3.4.4.6 | Membrane Permeation Selectivity for Different Counter-ions                                   | 206 |
| 3.4.4.7 | Water Transport in Ion-Exchange Membranes  | 207 |
| 3.4.4.8 | Characterization of Special Property Ion-Exchange Membranes                                  | 209 |

|          |  |            |
|----------|--|------------|
| 3.4.4.9  | The Mechanical Properties of Membranes                                       | 209        |
|          | References   | 210        |
| <b>4</b> | <b>Principles of Membrane Separation Processes</b>                           | <b>213</b> |
| 4.1      | Introduction   | 213        |
| 4.2      | The Principle of Membrane Filtration Processes                               | 214        |
| 4.2.1    | The Principle of Microfiltration   | 216        |
| 4.2.2    | The Principle of Ultrafiltration   | 219        |
| 4.2.3    | The Principle of Nanofiltration  | 223        |
| 4.2.4    | The Principle of Reverse Osmosis   | 229        |
| 4.2.4.1  | The Reverse Osmosis Mass Transport Described by the Solution–Diffusion Model | 230        |
| 4.2.4.2  | Reverse Osmosis Transport Described by the Phenomenological Equations        | 234        |
| 4.2.4.3  | The Water and Salt Distribution in a Polymer Matrix and the Cluster Function | 239        |
| 4.3      | The Principle of Gas and Vapor Separation                                    | 239        |
| 4.3.1    | Gas Separation by Knudsen Diffusion  | 240        |
| 4.3.2    | Gas Separation by Surface Diffusion and Molecular Sieving                    | 241        |
| 4.3.3    | Gas Transport in a Dense Polymer Matrix                                      | 243        |
| 4.3.4    | The Principle of Pervaporation   | 254        |
| 4.3.4.1  | Material Selection for the Preparation of Pervaporation Membranes            | 259        |
| 4.4      | The Principle of Dialysis  | 261        |
| 4.4.1    | Mass Transport of Components Carrying No Electrical Charges in Dialysis      | 262        |
| 4.4.2    | Dialysis Mass Transport of Electrolytes in a Membrane without Fixed Ions     | 264        |
| 4.4.3    | Dialysis of Electrolytes with Ion-Exchange Membranes                         | 266        |
| 4.5      | The Principle of Electromembrane Processes                                   | 268        |
| 4.5.1    | Electrodialysis and Related Processes  | 269        |
| 4.5.1.1  | Mass Transport in Electrodialysis  | 270        |
| 4.5.1.2  | Electrical Current and Ion Fluxes in Electrodialysis                         | 272        |
| 4.5.1.3  | The Transport Number and Membrane Permselectivity                            | 274        |
| 4.5.1.4  | Membrane Counter-Ion Permselectivity   | 275        |
| 4.5.1.5  | Water Transport in Electrodialysis   | 276        |
| 4.5.1.6  | Current Efficiency in Electrodialysis  | 276        |
| 4.5.1.7  | Electrodialysis with Bipolar Membranes                                       | 278        |
| 4.5.1.8  | Continuous Electrodeionization   | 280        |
| 4.5.1.9  | Capacitive Deionization  | 281        |
| 4.5.1.10 | Energy Generation by Reverse Electrodialysis                                 | 282        |
| 4.5.2    | Electrochemical Synthesis with Ion-Exchange Membranes                        | 283        |
| 4.5.3    | Ion-Exchange Membranes in Energy Storage and Conversion                      | 287        |
| 4.6      | The Principle of Membrane Contactors   | 292        |

- 4.6.1 Membrane Contactors Separating a Hydrophobic from a Hydrophilic Phase 294
- 4.6.2 Membrane Contactors Used to Separate Two Immiscible Liquid Phases 295
- 4.6.3 Membrane Contactors Separating a Liquid from a Gas Phase 298
- 4.6.4 Membrane Distillation 300
- 4.6.5 Osmotic Distillation 305
- 4.6.6 Supported Liquid Membranes and Facilitated Transport 306
- 4.6.7 Counter-Current Coupled Facilitated Transport 308
- 4.7 Membrane Reactors 311
- 4.7.1 Membrane Emulsifier 314
- 4.8 Membrane-Based Controlled Release of Active Agents 314
- References 320
  
- 5 Membrane Modules and Concentration Polarization 323**
- 5.1 Introduction 323
- 5.2 Membrane Modules 324
- 5.2.1 Membrane Holding Devices in Laboratory and Small-Scale Applications 324
- 5.2.1.1 The Stirred Batch Cell 325
- 5.2.1.2 The Sealed Membrane Point-of-Use Filter 326
- 5.2.1.3 The Plate-and-Frame Membrane Module 326
- 5.2.2 Industrial-Type Membrane Modules for Large Capacity Applications 328
- 5.2.2.1 The Pleated Filter Membrane Cartridge 328
- 5.2.2.2 The Spiral-Wound Module 329
- 5.2.2.3 The Tubular Membrane Module 331
- 5.2.2.4 The Capillary Membrane Module 333
- 5.2.2.5 The Hollow Fiber Membrane Module 335
- 5.2.3 Other Membrane Modules 336
- 5.2.3.1 Membrane Modules Used in Electrodialysis and in Dialysis 336
- 5.3 Concentration Polarization and Membrane Fouling 340
- 5.3.1 Concentration Polarization in Filtration Processes 342
- 5.3.1.1 Concentration Polarization without Solute Precipitation 343
- 5.3.1.2 Concentration Polarization in Turbulent Flow Described by the Film Model 343
- 5.3.1.3 Concentration Polarization in Laminar Flow Membrane Devices 348
- 5.3.1.4 Rigorous Analysis of Concentration Polarization 352
- 5.3.1.5 Membrane Flux Decline due to Concentration Polarization without Solute Precipitation 353
- 5.3.1.6 Concentration Polarization with Solute Precipitation at the Membrane Surface 354
- 5.3.2 Concentration Polarization in Other Membrane Separation Processes 362

|          |   |            |
|----------|---|------------|
| 5.3.2.1  | Concentration Polarization in Dialysis and Electrodialysis                | 363        |
| 5.3.2.2  | Concentration Polarization in Electrodialysis                             | 366        |
| 5.3.2.3  | Concentration Polarization in Gas Separation                              | 371        |
| 5.3.2.4  | Concentration Polarization in Pervaporation                               | 373        |
| 5.3.3    | Membrane Fouling and Its Causes and Consequences                          | 373        |
| 5.3.3.1  | Prevention of Membrane Fouling  | 375        |
|          | References  | 378        |
| <b>6</b> | <b>Membrane Process Design and Operation</b>                              | <b>381</b> |
| 6.1      | Introduction  | 381        |
| 6.2      | Membrane Filtration Processes   | 381        |
| 6.2.1    | Recovery Rate, Membrane Rejection, Retentate, and Filtrate Concentrations | 382        |
| 6.2.1.1  | Solute Losses in Membrane Filtration Processes                            | 386        |
| 6.2.1.2  | Operation Modes in Filtration Processes                                   | 387        |
| 6.2.1.3  | Reverse Osmosis Process Design  | 388        |
| 6.2.1.4  | Stages and Cascades in Membrane Filtration                                | 392        |
| 6.2.1.5  | Ultra- and Microfiltration Process Design                                 | 395        |
| 6.2.1.6  | Ultrafiltration Process Design  | 401        |
| 6.2.1.7  | Diafiltration   | 403        |
| 6.2.2    | Costs of Membrane Filtration Processes                                    | 406        |
| 6.2.2.1  | Energy Requirements in Filtration Processes                               | 406        |
| 6.2.2.2  | Investment- and Maintenance-Related Costs in Filtration Processes         | 411        |
| 6.3      | Gas Separation  | 412        |
| 6.3.1    | Gas Separation Process Design and Operation                               | 413        |
| 6.3.1.1  | Staging in Gas Separation and the Reflux Cascade                          | 419        |
| 6.3.2    | Energy Consumption and Cost of Gas Separation                             | 421        |
| 6.4      | Pervaporation   | 422        |
| 6.4.1    | Pervaporation Modes of Operation  | 424        |
| 6.4.1.1  | Staging and Cascades in Pervaporation                                     | 425        |
| 6.4.2    | Pervaporation Energy Consumption and Process Costs                        | 428        |
| 6.5      | Dialysis  | 428        |
| 6.5.1    | Dialysis Process and System Design  | 430        |
| 6.5.1.1  | Dialyzer Membrane Module Constructions                                    | 431        |
| 6.5.2    | Process Costs in Dialysis   | 435        |
| 6.6      | Electrodialysis and Related Processes                                     | 436        |
| 6.6.1    | Process Design in Conventional Electrodialysis                            | 436        |
| 6.6.1.1  | Operation of the Electrodialysis Stacks in a Desalination Plant           | 441        |
| 6.6.2    | Process Costs in Electrodialysis  | 442        |
|          | References  | 444        |
|          | <b>Appendix A</b>   | <b>447</b> |
|          | <b>Questions and Exercises</b>  | <b>447</b> |

**Appendix B** 457

**Index** 465