а

advanced process control (APC) base-layer control system 248 controller limits, plant constraints 260–261 distributed control system 248 dynamic process models 248 planning and scheduling activities 248 process control hierarchy 247–249 production and plant constraints 248 real-time optimization 248 air emissions 60 ancillary services 309–310 artificial intelligence (AI) 130

b

Bayer Climate Check 318 best demonstrated practice (BDP) 86 values 330 bivariate least squares (BLS) regression 133 Brundtland report 454 business clustering business parks and park management 461 - 462cross-sectorial clustering and cluster management 464-466 economic incentives 461 industrial ecology 461 total site integration and site management 462-464 business parks 461 business parks management 462

С

CasADi 281 CEN/CENELEC Sector Forum 30 Chemometrics 137–138 China's economic growth 23 circular economy 465 cleaning-in-place (CIP) subsystem 136 closed loop methods 235 CO₂-emissions Agenda 21, 21 UNFCCC 21 Communication on Progress (COP) 51 composite curves 406 continuous improvement process (CIP) 76 continuous stirred tank reactor (CSTR) 269 cost functions 425 Covestro 318 cross-sectorial symbiosis 465 cumulated energy demand (CED) 394 cyber physical systems 160

d

Danish Kalundborg eco-industrial park 450 data extraction 355 data pre-treatment "control" pyramid 182 data reconciliation maximum likelihood principle 188 mixing streams 191–194 non-Gaussian measurements errors 189

Resource Efficiency of Processing Plants: Monitoring and Improvement, First Edition. Edited by Stefan Krämer and Sebastian Engell. © 2018 Wiley-VCH Verlag GmbH & Co. KGaA. Published 2018 by Wiley-VCH Verlag GmbH & Co. KGaA.

data pre-treatment (contd.) parametric uncertainty 192 structural uncertainty 192 dynamic data reconciliation 208 - 209gross errors detection and removal Robust M-estimators 202–205 statistical methods 195–202 measurement errors and variable estimation accuracy 183 EcosimPro window 186 Gaussian distribution 182 liquid junction 183 precision 183 redundant data 184 temperature measurements 184 and steady state detection 205-208 decision support systems (DSS) aggregated tiles 220 analysis, of optima 231 Bullet chart 216-217 dashboard concept, sugar plant case-study 223-224 difference charts 218-220 exemplary application 226–228, 232 - 235flexibility 225-226 graphical guidance 225 information 213 multicriterial optimization 231-232 plant sections 215 real-time performance 231 Sankey diagrams 215–216 scenario database 226 stacked bars and stacked area plots 217 - 218variability bar 217 visual feedback 226 visualization elements 220-221 visualization techniques 213 what-if analysis 224-228 demand side response (DSR) additional conventional power plants 299 ancillary services 309-310 business-motivated goals 294

climate issue 295 dispatchable demand response 296 dynamic demand 296 electrical energy 294 electricity grid 295 energy consumption 294 energy efficiency (EE) 301-303 energy industry 294 energy portfolio optimization 305 - 306energy sector 294 energy shortage 305 energy storage capacity 299 grid capacity 300 history 296-297 load management 304 load shedding 309 load shifting 309 market drivers and market barriers 300 - 301market options 300 nondispatchable demand response 295-296 peak shaving 309 power production and consumption 299 renewable energy sources 299–300 technology-driven innovations 295 utility trigger and price changes 305 valorization 310-313 differential-algebraic ones (DAE) 208 differentiation 479-480 distributed control systems (DCS) 167,265 district clusters 465 district networks, using process waste heat 443 dynamic optimization (DO) 209, 280

е

eco-industrial parks 442 eco-management and audit scheme (EMAS) 49 economic evaluation constraints 360–361 economic incentives 461 EcosimPro 186

electricity 423-424 investment and operating costs 425 - 428life-cycle assessment 428 nomenclature 424 non-negativity of grid interactions 423 transportation 424-425 electricity laws 28 EN 16247 29-31 energy and resource company-specific environmental indicator systems 7 definition 4 energy efficiency 6-8, 11 ISO 50001 2011 and standards ISO 50002 to 50015 12 primary energy 5 real-time, concept of 8 resource efficiency 6–8, 11–15 energy and resource efficiency 404 energy and resource management continual improvement process (CIP) 34 employee participation 38 energy storage 36 EnPI development 34–36 ISO 50001 38 low usage/consumption 36 self-generation 37 energy balance constraints 358-360 Energy-Capital trade-off 407 energy clustering, at business parks 462 energy conversion units 435–437 energy efficiency CO₂-emissions 20–21 EN 16247 and ISO 50002 29-31 EnMS standards 25 EU concern 23-24 EU goals 21–22 in worldwide 22-23 IPMVP 31 ISO 17741 and ISO 50047 31 ISO 50001 28 and dissemination 26–27

precursors towards 25-26 ISO 50004 28 measurement and verification plan (M&V plan) 31 energy efficiency audits basis analysis 67-69 current energy status 66-67 detailed analysis and collection of ideas 69-72 energy performance 65 evaluation and selection of measures 72 - 76extension to resource consumption 77 realization and monitoring 76–77 Energy Efficiency Check 318 energy flow analysis (EFA) 83, 85, 86 energy influencing variables (EIVs) 321, 329, 336 energy laws 28 Energy Management and Production Planning approach 311 Energy Performance Indicators (EnPI) 332 energy portfolio optimization 305–306 energy requirement, of process unit operation 416 electricity 416 exergy analysis 417 heat transfer 416 support materials 416 energy savings portfolio 326 energy shortage 305 enterprise resource planning (ERP) 162 environmental declarations 55 ϵ -constraint scheme 428 EU Commission 24 EU-EMAS Regulation 46 Europe 2020 strategy 446 European Commission 33 **European Energy Efficiency Directive** 463 European R&D 151–152 European Strategic Energy Technology (SET) plan 460 exergy analysis 405, 417

f

fossil fuel sources 23

g

Gaussian distribution 132 German power grid 294 German Renewable Energy Act 27 GHG Protocol Corporate Standard 54 Global Reporting Initiative (GRI) 7, 51–52 Goldbeck's circus model 475 graphene-based sensors 150 greenhouse gas (GHG) emissions 11, 340 greenhouse gas (GHG) Protocol 47, 54 GreenPAT strategies 146

h

H2020's SPIRE programme 151 heat cascade 420 heat exchanger network 350 heat integration 405-416 advanced heat integration technology application 413-416 chemical production site 413-416 composite and grand composite curves 409-411 ΔT_{\min} determination 406–408 energy conversion units, optimization of 435-437 heat recovery targets, improvements of 412-413 penalising heat exchangers 411-412 heat pump (HP) 412 heat recovery improvement potentials 432-435 heat recovery system 70 heat transfer requirements 418 detailed-model analysis 419 black-box analysis 418 grey-box analysis 418 simple-model analysis 418-419 white-box analysis 418 hybrid methods 364 hydrogen pinch analysis 351 hyperspectral imaging (HSI) 138–139

İ

industrial ecology 460 industrial process, description 404 industrial symbiosis (IS) 449 business clustering, see business clustering 460 European Strategic Energy Technology (SET) plan 460 innovation potential 458 multidisciplinary nature 459 industrial symbiosis parks 450 industrial symbiosis policies 454 industrial symbiosis research 454 industrial symbiosis services 453 industrial symbiosis technologies 451 information technology context awareness 167-168 process industries control and monitoring algorithms 160 control and supervisory functions 160 cyber physical systems 160 ERP and SCM systems 162 internal sensors and embedded logic controller 160 material and energy efficiency 162 plant control strategies 162 sensors and actuators 160 resource managed units 163–164 3-tier information modelling approach meta model 164 properties 167 RMU 165-166 Type Model 164 integrated development environment (IDE) 168 Intelligent Manufacturing Systems (IMS) 130 Interior point methods 278 International Energy Agency 10 International Integrated Reporting Council (IIRC) 52 Internet-of-Things (IoT) devices 148

investment and operating costs 425-428ISO 14000 series 54 ISO 14000 standards 55 ISO 14001 46 ISO 50002 30 ISO 50006 34 ISO 50015 34 ISO labelling standards 55

k

Kalundborg collaboration 451 key performance indicators (KPIs) 59, 83, 181, 326, 332

I

LESTS survey 456 life cycle assessment methodology 405 life cycle impact assessment indicator 428 linear multivariable model predictive control (LMPC) 247 load shifting 309 low-carbon economy 447 low grade heat 70

m

Management Systems (MSs) 24-25 market barriers 300 market-corrected energy consumption (MEC) 332 market drivers 300 mass balance constraints 357-358 mass integration 420-423 material flow analysis (MFA) 83, 85, 86 maximum energy recovery (MER) 412 maximum likelihood principle 188 mechanical vapour recompression (MVR) 412, 413-416 MEMS-based sensors 147-148 MILP model 421 MISO Energy 305 mixed integer linear programming (MILP) formulation 419 model predictive control (MPC) 266 Modern consumption meters 70

MORE RACER evaluation framework contribution factor 101-102 interdependent influencing factors 102 performance contribution 100 performance indicators 101 utility integration and energy provider 105 - 106moving horizon estimation (MHE) 209 multi-level energy requirement definition 418-419 multivariable predictive control (MPC) technology base-layer controllers 258-259 constraint control additive constraints 245-246 closed-loop optimization 246 - 247depropanizer column 240–244 graphical representation 244 - 245large-scale continuous chemical processes 240 skilled and experienced operators 240 control solution 260 features 249-254 financial benefits 254-256 justification and benefit estimation 256 - 258limitations 259 ongoing maintenance and training 261-262 product quality measurement and inferentials 259-260 utility and product values 260

n

NAMUR survey 73 NAMUR Worksheet NA140 70 necessary conditions of optimality (NOC) 281 non-linear programming interior point methods 278–279 KKT optimality conditions 276–277 Lagrange multipliers 275 non-linear programming (*contd.*) sequential quadratic programming (SQP) 277–278 non-renewable energy resources 22

0

OCAP project 452 offline realtime optimization 247 oil crisis 22 online approach 136 Organisation Environmental Footprint (OEF) 59 oxygen depolarized cathode (ODC) technology 320

р

Pareto curve 429 Pareto principle 476 People-Planet-Profit triangle 446 pinch analysis principles 406 pinch technology 350-351 piping and instrumentation diagrams (PandID) 66 Plant Information Management Systems 162 plus-minus principle 412 power consumption 72 principal component analysis (PCA) 195 Principles and Guidance on **Communication of Footprint** Information 55 process analytical technologies (PAT) 130 data mining of historians 143 definition 142 GreenPAT strategies 146 integration tasks 145 maintenance and after-sales support policies 145 metrological constraints 144 online/inline analytical probes 143 output data format 145 parameters 144 QbD procedure 143 ranges 144 sample nature and features 144

sampling frequency 144 - 145scope 144 sources of problems 145 timeframe 145 validation 144 wider business context 145 process flow diagram 404 process industry chemical industry 9 definition 8 EU chemical industry 9 primary and secondary energy 5 raw materials 5, 9–10 resource-efficient production 4 separation processes 4 Product Environmental Footprint (PEF) 59 ProPAT 151 Pyomo 281

q

Quality Management Systems (QMS) 26 quality-by-design (QbD) 143, 151

r

real-time energy indicators 311 real-time optimization (RTO) systems continuous stirred tank reactor (CSTR) 269 data reconciliation (DR) 272 DCS 265 dynamic optimization (DO) 280-281 economic optimizer 269 global process efficiency and economy 271 gross errors 272 implementation, of solutions 274 MPC 266, 268 multiple-effect evaporation process data reconciliation 286-289 optimal operation 289-290 resource efficiency indicators 290 steady-state modelling 283-285 non-linear programming

interior point methods 278-279 KKT optimality conditions 276 - 277Lagrange multipliers 275 sequential quadratic programming (SOP) 277-278 non-linear programming (NLP) problem 271 process-model gap problem 274 software and practice 279–280 real-time resource efficiency indicators baseline indicators 91 baseline, definition 88.91 batch resource efficiency indicators 113 - 114energy efficiency 114-115 energy performance indicator (EnPI) 88 environmental impact 86 evaluation method 93 external economic factors 87 gate-to-gate approach 85 generic indicators 88 generic resource efficiency indicators 87 key production phases 116–117 life-cycle analysis (LCA) 87–88 long-term storage effects 86 material and energy flow analysis 85 material efficiency 115-116 MORE RACER evaluation framework aggregation 98-105 application 95-98 definition 93-95 non-influenceable factors 91 plant-wide contributions 118–119 pre-selected indicators 92-93 process analytical technology 84 process industries 84 product-oriented REI 106-107 propagation and aggregation 119 purification efficiency 117-118 questionnaire method 92 reaction efficiency 117 transition from batch to continuous operation 122-124

transition from batch to continuous production 124 water and waste efficiency 116 reporting mechanisms, resource efficiency eco-management and audit scheme (EMAS) 49 environmental challenges 46 environmental labels and declarations 55 - 59environmental management systems 46 EU-directive on industrial emissions (IED) 47-48 EU-directive on non-financial reporting 48-49 European Union 46 Global reporting Initiative (GRI) 51 - 52greenhouse gas (GHG) Protocol 47, 54 International Integrated Reporting Council (IIRC) 52, 54 KPI 59-60 OECD Guidelines for multinational enterprises 49-50 PEF and OEF guidelines 59 sustainability reporting 46 United Nation's Global Compact Initiative 50–51 resource and energy integration formulation 419 resource efficiency 82 normative approach 32–33 resource efficiency indicators (REI) 36, 181 application design process 168–171 industrial installations batch-continuous-process 171 - 175integrated chemical production complex 175-178 supplementary model-based approaches 224 what-if analysis 224 resource integration, constraints for 421

resource optimal chemical processes applications, of synthesis 363–364 biological and thermochemical biomass conversion processes 348 crude oil and natural gas reserves 347 data extraction 355-356 decomposition procedure 352 environmental factors 365-366 global consumptions, of fossil fuels 348 hybrid methods 364-365 liquid transportation fuel 349 mathematical model economic evaluation constraints 360 - 361energy balance constraints 358-360 mass balance constraints 356 - 358objective function 361-362 optimal kind 349 optimal quantity 349-350 Pinch technology 350-351 resource crisis 347 social factors 366 solution methods 362-363 superstructure generation 353-355 uncertainty issue 366 responsibility diffusion 488 Rio Earth Summit 1992, 20 Russian Federation 22–23

S

sensing technology accuracy 132–134 electricity consumption 136 European R&D 151–152 graphene-based sensors 150 industrial energy metering 137 "Industry-4.0-grade" sensing 132 milling process 131 PAT technologies 131 precision 132 production process 130

quantum cascade lasers (QCL) 149 - 150sampling 135-136 spectroscopy technology, process-monitoring-based efficiency chemometrics 137 hyperspectral imaging (HSI) 138-139 MEMS-based sensors 147-148 process analytical technologies (PAT) 142-146 soft-sensors 146-147 time-gated Raman 139-142 standard IR thermometer 134-135 sequential approach 281 sequential quadratic programming (SQP) 277 single process integration (SPI) 430-432 site scale integration heat recovery improvement potentials 432 - 435single process integration 430-432 total site integration 430, 432 small and medium-sized enterprises (SME) 74 smart grids 295 soft-sensors 146-147 SPIRE 445 standard 486 steady state detection 205-208 steam loss cascades 335 steel and petrochemical symbiosis 458 steel production 312-213 strokes 478 STRUCTeseTM system best demonstrated practice (BDP) values 330 current energy consumption of the plant (CEC) 328 energy consumption 323 Energy Efficiency Check (EE Check) 321, 323-327 energy loss cascade 327-336 energy loss cascade and online monitor 334

energy management cycle 322 energy scope 322 implementation results 338-341 improvement plan 325 integrated energy efficiency management tool 333 ISO 50001 certification 320, 321 online monitor (OM) and daily energy protocol (DEP) 322, 336–338 open issues and research topics 341-342 operational energy optimum (OEO) 328 PDCA-cycle for Energy Management Systems 321 PDCA-cycle of energy 320 real-time energy efficiency 319 simple data analysis 320 theoretical energy optimum (TEO) 328 superstructure configuration constraints 356-357 supply chain management (SCM) systems 162 sustainability management 444 sustainability reporting 46 Swedish Standards Institute (SIS) 25 symbiosis and synergy 441

t

tax cap Efficiency System Regulation (SpaEfV) 28 thermal imaging camera 70 time-gated Raman 139–142 Total Polyphenol Index (TPI) 136 Total Site Analysis 463 total site integration (TSI) 430, 432 Type Model 164

u

ultrasound-measuring instrument 70 United Nations Framework Convention on Climate Change (UNFCCC) 21 utility systems computational effort 376 conventional optimization models 390 cost savings 373 decision support 387–390 definition 375 design and operation strategy 373 energyPRO 390 industrial case study multi-objective optimization 394 - 395near-optimal solutions 395-396 optimal solution 393 plant layout 392 TOP-Energy[®] 390 MINLP problems 376 model complexity decomposition 380-381 part-load performance 379-380 time representation 378-379 multi-objective optimization 388 near-optimal solutions 388–390 optimal synthesis 376 superstructure-based synthesis 383-385 superstructure-free synthesis 385-387 synthesis of 376 time-series aggregation 381–382

V

VDI 4800, 33 visualization method 220 visualization techniques 213

W

working/company culture appreciation 479 common sense 477 criticism 479 desired result 481–485 differentiation 479–480 fairness 476 feedback loops 491 incentives 489–490 integration 485–486 justice 476 leadership principles 481

working/company culture (*contd.*) measures 486, 487 motivation 475 orientation 479 performance 488 personal comfort zone 475 praise 478 resistance 488–489 rules 487 standard 486 strokes 478 trust 474, 476, 477 World Business Council for Sustainable Development (WBCSD) 83