Contents

List of Contributors XIX

v

- 1 Introduction 1
- Toshiomi Yoshida
- 1.1 Introduction 1
- 1.2 Enzyme Technology 2
- 1.3 Microbial Process Engineering 2
- 1.3.1 Bioreactor Development 2
- 1.3.2 Measurement and Monitoring *3*
- 1.3.3 Modeling and Control 4
- 1.3.4 Solid-State Fermentation 4
- 1.4 Plant Cell Culture 5
- 1.5 Animal Cell Culture 5
- 1.6 Environmental Bioengineering 6
- 1.7 Composition of the Volume 7
 - References 7

Part I Enzyme Technology 11

2 Enzyme Technology: History and Current Trends 13

Klaus Buchholz and Uwe T. Bornscheuer

- 2.1 The Early Period up to 1890 *13*
- 2.1.1 Observations and Empirical Results 13
- 2.1.2 Theoretical Approaches 14
- 2.2 The Period from 1890 to 1940 16
- 2.2.1 Scientific Progress 16
- 2.2.2 Theoretical Developments 17
- 2.2.3 Technological Developments 18
- 2.3 A New Biocatalyst Concept Immobilized Enzymes 19
- 2.3.1 Fundamental Research 19
- 2.3.2 Examples of Industrial Development: The Case of Penicillin Amidase
 - (PA) Penicillin Hydrolysis and Derivatives 20

VI Contents

2.3.3	Examples of Industrial Development: The Case of Sugar Isomerization 23	
2.4	Expanding Enzyme Application after the 1950s 24	
2.4 2.5		
2.5	Recombinant Technology – A New Era in Biocatalysis and Enzyme Technology 27	
2.5.1	New Enzymes – A Key to Genetic Engineering 27	
2.5.2	Analytical and Diagnostic Enzymes 29	
2.5.3	Expanding Market of Industrial Enzymes 31	
2.6	Current Strategies for Biocatalyst Search and Tailor Design 32	
2.6.1	Enzyme Discovery from the Metagenome or Protein Databases 32	
2.6.2	Protein Engineering of Enzymes 34	
2.6.3	Enzyme Cascade Reactions 35	
2.6.4	Metabolic Engineering 37	
2.7	Summary and Conclusions 39	
	Acknowledgment 40	
	Abbreviations 40	
	References 40	
3	Molecular Engineering of Enzymes 47	
	Maria Elena Ortiz-Soto and Jürgen Seibel	
3.1	Introduction 47	
3.2	Protein Engineering: An Expanding Toolbox 48	
3.2.1	From Sequence to Fold and Function 49	
3.2.2	Improving Enzyme Properties by Rational Design and Directed	
	Evolution 49	
3.2.3	Designing Smart Libraries 51	
3.2.4	<i>In Vivo</i> Continuous Directed Evolution 54	
3.2.5	Diversification of Enzyme Functionalities by Recombination 55	
3.3	High-Throughput Screening Systems 56	
3.4 Engineered Enzymes for Improved Stability and Asymmetric		
	Catalysis 58	
3.4.1	Stability 58	
3.4.1.1	Cellulases 59	
3.4.1.2	Lipases 60	
3.4.2	Asymmetric Biocatalysis 62	
3.5	De Novo Design of Catalysts: Novel Activities within Common	
	Scaffolds 65	
3.6	Conclusions 69	
	References 69	
4	Biocatalytic Process Development 81	
	John M. Woodley	
4.1	A Structured Approach to Biocatalytic Process Development 83	
4.2	Process Metrics 83	
4.2.1	Reaction Yield 84	

4.2.2	Productivity 85		
4.2.3	Biocatalyst Yield 85		
4.2.4	Product Concentration 86		
4.3	Technologies for Implementation of Biocatalytic Processes 87		
4.3.1	Biocatalyst Engineering 87		
4.3.1.1	Protein and Genetic Engineering 87		
4.3.1.2	Biocatalyst Immobilization 87		
4.3.2	Reaction Engineering 88		
4.3.2.1	Reactant Supply 89		
4.3.2.2	Product Removal 89		
4.3.2.3	Two-Phase Systems 90		
4.4	Industrial Development Examples 91		
4.4.1	Development of a Biocatalytic Route to Atorvastatin (Developed by		
	Codexis Inc., USA) 91		
4.4.2	Development of a Biocatalytic Route to Sitagliptin (Developed by		
	Codexis Inc., USA and Merck and Co., USA) 92		
4.5	Future Outlook 95		
4.6	Concluding Remarks 96		
	References 96		
5	Development of Enzymatic Reactions in Miniaturized		
	Reactors 99		
	Takeshi Honda, Hiroshi Yamaguchi, and Masaya Miyazaki		
5.1	Introduction 99		
5.2	Fundamental Techniques for Enzyme Immobilization 100		
5.2.1	Enzyme Immobilization by Adsorption 101		
5.2.1.1	Monoliths and Particles 109		
5.2.1.2	Synthetic Polymer Membranes and Papers 109		
5.2.1.3	Adsorption to Channel Walls 109		
5.2.2	Enzyme Immobilization by Entrapment 110		
5.2.2.1	Silica-Based Matrices 111		
5.2.2.2	Non-Silica-based Matrices 117		
5.2.3	Enzyme Immobilization by Affinity Labeling 119		
5.2.3.1	His-Tag/Ni-NTA System 119		
5.2.3.2	GST-Tag/Glutathione System 125		
5.2.3.3	Avidin/Biotin System 125		
5.2.3.4	DNA Hybridization System 126		
5.2.3.5	Other Techniques Using Nucleotides for Enzyme		
	Immobilization 126		
5.2.4	Enzyme Immobilization by Covalent Linking 127		
5.2.4.1	Immobilization to Solid Supports 127		
5.2.4.2	Direct Immobilization to a Channel Wall 142		
5.2.4.3	Enzyme Polymerization 146		
5.2.5	Enzyme Immobilization by Other Techniques Using		
	Organisms 149		

VIII Contents

5.2.6	Application of Immobilized Enzymes in Microfluidics 149	
5.3	Novel Techniques for Enzyme Immobilization 150	
5.3.1	Polyketone Polymer: Enzyme Immobilization by Hydrogen	
	Bonds 151	
5.3.2	Thermoresponsive Hydrogels 151	
5.3.3	Immobilization Methods Using Azide Chemistry 152	
5.3.3.1	Staudinger Ligation 152	
5.3.3.2	Click Chemistry 152	
5.3.4	Graphene-Based Nanomaterial as an Immobilization	
	Support 153	
5.3.5	Immobilization Methods Using Proteins Modified with	
01010	Solid-Support-Binding Modules 154	
5.4	Conclusions and Future Perspectives 155	
011	Abbreviations 156	
	References 157	
	Part II Microbial Process Engineering 167	
6	Bioreactor Development and Process Analytical Technology 169	
	Toshiomi Yoshida	
6.1	Introduction 169	
6.2	Bioreactor Development 170	
6.2.1	Parallel Bioreactor Systems for High-Throughput Processing 171	
6.2.1.1	Microtiter Plate Systems 172	
6.2.1.2	Stirred-Tank Reactor Systems 178 Microfluidic Microbioreactor Systems 184	
6.2.1.3		
6.2.1.4	Bubble Column Systems 188	
6.2.1.5	Comparison of Various Parallel-Use Micro-/Mini-Bioreactor	
	System 189	
6.2.2	Single-Use Disposable Bioreactor Systems 193	
6.2.2.1	Features of Single-Use Bioreactors 194	
6.2.2.2	Sensors and Monitoring 194	
6.2.2.3	Single-Use Bioreactors in Practical Use 195	
6.3	Monitoring and Process Analytical Technology 196	
6.3.1	Monitoring and State Recognition 196	
6.3.1.1	Sensors for Monitoring Bioprocesses 196	
6.3.1.2	Spectrometry 199	
6.3.2	Process Analytical Technology (PAT) 200	
6.3.2.1	PAT Tools 201	
6.3.2.2	PAT Implementations 202	
	rAi implementations 202	
6.4	Conclusion 203	
6.4	·	

Contents IX

7	Omics-Integrated Approach for Metabolic State Analysis of Microbial		
/	Processes 213		
	Hiroshi Shimizu, Chikara Furusawa, Takashi Hirasawa, Katsunori Yoshikawa,		
	Yoshihiro Toya, Tomokazu Shirai, and Fumio Matsuda		
7.1	General Introduction 213		
7.1	Transcriptome Analysis of Microbial Status in Bioprocesses 214		
7.2.1	Introduction 214		
7.2.2	Microbial Response to Stress Environments and Identification of		
1.2.2	Genes Conferring Stress Tolerance in Bioprocesses 215		
7.2.3	Transcriptome Analysis of the Ethanol-Stress-Tolerant Strain		
7.2.0	Obtained by Evolution Engineering 217		
7.3	Analysis of Metabolic State Based on Simulation in a Genome-Scale		
	Model 219		
7.3.1	Introduction 219		
7.3.2	Reconstruction of GSMs and Simulation by FBA 219		
7.3.3	Using Prediction of Metabolic State for Design of Metabolic		
	Modification 221		
7.4	¹³ C-Based Metabolic Flux Analysis of Microbial Processes 223		
7.4.1	Introduction 223		
7.4.2	Principles of ¹³ C-MFA 223		
7.4.3	Examples of ¹³ C-MFA in Microbial Processes 225		
7.5	Comprehensive Phenotypic Analysis of Genes Associated with Stress		
	Tolerance 227		
7.5.1	Introduction 227		
7.5.2	Development of a High-Throughput Culture System 228		
7.5.3	Calculation of Specific Growth Rate 228		
7.5.4	Results of Comprehensive Analysis of Yeast Cells Under Conditions		
	of High Osmotic Pressure and High Ethanol Concentration 228		
7.5.5	Identification of Genes Conferring Desirable Phenotypes Based on		
	Integration with the Microarray Analysis Method 230		
7.6	Multi-Omics Analysis and Data Integration 230		
7.7	Future Aspects for Developing the Field 231		
	Acknowledgments 233		
	References 233		
8	Control of Microbial Processes 237		
U	Kazuyuki Shimizu, Hiroshi Shimizu, and Toshiomi Yoshida		
8.1	Introduction 237		
8.2	Monitoring 238		
8.2.1	Online Measurements 238		
8.2.2	Filtering, Online Estimation, and Software Sensors 239		
8.2.3	Algorithm of Extended Kalman Filter and Its Application to Online		
	Estimation of Specific Rates 239		
8.3	Bioprocess Control 242		
8.3.1	Control of Fed-Batch Culture 242		

X Contents

8.3.2 8.3.3 8.3.4 8.4 8.4.1 8.4.2 8.5	Online Optimization of Continuous Cultures 244 Cascade Control for Mixed Cultures 246 Supervision and Fault Detection 249 Recent Trends in Monitoring and Control Technologies 250 Sensor Technologies and Analytical Methods 251 Control Technologies 252 Concluding Remarks 253 Abbreviations 254 References 254		
	Part III Plant Cell Culture and Engineering 259		
9	Contained Molecular Farming Using Plant Cell and Tissue		
	Cultures 261 Stefan Schillberg, Nicole Raven, Rainer Fischer, Richard M. Twyman, and		
	Andreas Schiermeyer		
9.1	Molecular Farming – Whole Plants and Cell/Tissue Cultures 261		
9.2	Plant Cell and Tissue Culture Platforms 263		
9.2.1	Cell Suspension Cultures 263		
9.2.2	Tissue Cultures 264		
9.2.3	Light-Dependent Expression Platforms 264		
9.3	Comparison of Whole Plants and <i>In Vitro</i> Culture Platforms 265		
9.4	Technical Advances on the Road to Commercialization 267		
9.4.1	Improving the Quantity of Recombinant Proteins Produced in Cell Suspension Cultures 267		
9.4.2	Improving the Quality and Consistency of Recombinant Proteins Produced in Cell Suspension Cultures 269		
9.5	Regulatory and Industry Barriers on the Road to		
	Commercialization 271		
9.6	Outlook 273		
	Acknowledgments 275		
	References 275		
10	Bioprocess Engineering of Plant Cell Suspension Cultures 283 Gregory R. Andrews and Susan C. Roberts		
10.1	Introduction 283		
10.2	Culture Development and Maintenance 286		
10.3	Choice of Culture System 288		
10.4	Engineering Considerations 291		
10.4.1	Cell Growth and Morphology 291		
10.4.2	Gas Requirements 292		
10.4.3	Aggregation 292		
10.4.4	Medium Rheology 293		
10.4.5	Shear Sensitivity 293		
10.5	Bioprocess Parameters 294		

Contents XI

- 10.5.1 Medium Composition and Optimization 294
- Temperature and pH 294 10.5.2
- 10.5.3 Agitation 295
- Aeration 295 10.5.4
- Operational Modes 296 10.6
- Bioreactors for Plant Cell Suspensions 10.7 297
- Conventional Bioreactors 297 10.7.1
- 10.7.1.1 Stirred-Tank Reactors 297
- Pneumatic Bioreactors 300 10.7.1.2
- 10.7.2 Disposable Bioreactors 301
- 10.8 Downstream Processing 303
- Specialized Metabolite Extraction and Purification 303 10.8.1
- 10.8.2 Recombinant Protein Extraction and Purification 304
- 10.9 Yield Improvement Strategies 306
- Specialized Metabolites and Recombinant Proteins 306 10.9.1
- 10.9.1.1 Cell Immobilization 306
- 10.9.1.2 In Situ Product Removal 306
- 10.9.2 Specialized Metabolite Specific Strategies 307
- 10.9.2.1 Elicitation 307
- 10.9.2.2 Metabolic Engineering 308
- 10.9.3 Recombinant-Protein-Specific Strategies 309
- Expression Systems 309 10.9.3.1
- Minimizing Post-Translational Loss of Recombinant Proteins 309 10.9.3.2
- 10.10 Case Studies 310
- Protalix and the ProCellExTM Platform 310 10.10.1
- 10.10.1.1 Background 311
- The ProCellEx[®] Platform 311 10.10.1.2
- Future Outlook 312 10.10.1.3
- 10.10.2 Phyton Biotech, Paclitaxel, and Plant Cell Fermentation (PCFTM) 314
- 10.10.2.1 Background 314
- 10.10.2.2 Why Plant Cell Culture? 314
- Plant Cell Fermentation (PCF[™]) 315 10.10.2.3
- 10.10.2.4 PCF[™] Compared to Other Production Platforms 315
- 10.11 Conclusion 315 References 316
- 11 The Role of Bacteria in Phytoremediation 327
 - Zhaoyu Kong and Bernard R. Glick
- 11.1 The Problem 327
- Metals and Organics in the Environment 328 11.1.1
- Traditional Clean-up Procedures 328 11.1.2
- 11.2 Defining Phytoremediation and Its Components 329
- 11.3 Role of Bacteria in Phytoremediation 330
- 11.3.1 Biodegradative Bacteria 330

XII Contents

11.3.2	Plant-Growth-Promoting Bacteria 333
11.3.2.1	Role of IAA 333
11.3.2.2	Role of Ethylene 335
11.3.2.3	Role of Nitrogen Fixation 336
11.3.2.4	Role of Siderophores 339
11.3.3	Interaction with Mycorrhizae 340
11.4	Examples of Phytoremediation in Action 342
11.5	Summary and Perspectives 343
	References 344

Part IV Animal Cell Cultures 355

12	Cell Line Development for Biomanufacturing Processes 357	
	Mugdha Gadgil and Wei-Shou Hu	
12.1	Introduction 357	
12.2	Host Cell 359	
12.2.1	Host Cell Engineering 359	
12.3	Vector Components 360	
12.3.1	Promoter/Enhancer 360	
12.3.2	Intron 362	
12.3.3	Poly-Adenylation Signal 362	
12.3.4	Selection Marker 363	
12.3.5	Secretion Leader Sequence 364	
12.3.6	Components for Plasmid Cloning in E. coli 364	
12.4	Transfection 365	
12.4.1	Method of Transfection 365	
12.4.2	Plasmid Conformation 366	
12.5	Integration of Foreign DNA into Host Chromosome 366	
12.5.1	Site-Specific Integration 367	
12.5.2	Use of cis-Acting DNA Elements 367	
12.6	Amplification 369	
12.7	Single-Cell Cloning 370	
12.7.1	Culture Medium for Single-Cell Cloning 371	
12.7.2	Automated High-Throughput Screening for High-Producer	
	Clones 372	
12.8	Selecting the Production Clone 373	
12.8.1	Screening Platform 373	
12.8.2	Adaptation 374	
12.8.3	Process and Product Attributes 374	
12.8.4	Scale-Down Model 375	
12.9	Clone Stability 376	
12.10	Conclusion 376	
	Acknowledgments 377	
	References 377	

388

10	Medium Design, Culture Management, and the PAT
13	Initiative 383
	Ziomara P. Gerdtzen
13.1	Historical Perspective on Culture Medium 383
13.1	Cell Growth Environment 384
13.2.1	Natural Cellular Environment 384
13.2.1.1	The Role of Medium 384
13.2.1.2	Medium Design 384
13.3	Media Types 386
13.4	Medium Components 387
13.4.1	Growth-Associated, Unconsumed, and Catalytic Components
13.4.1.1	Growth-Associated Components 388
13.4.1.2	Unconsumed Components 388
13.4.1.3	Catalytic Macromolecular Components 388
13.4.2	Water in Media Preparation 388
13.4.3	Sugars and Amino Acids 390
13.4.3.1	Sugars as the Main Carbon Source 390
13.4.3.2	Amino Acids 390
13.4.4	Vitamins, Nucleosides, Fatty Acids, and Lipids 392
13.4.4.1	Vitamins' Role 392
13.4.4.2	Fatty Acids and Lipids 393
13.4.5	Bulk Ions and Trace Elements 395
13.4.6	Non-Nutritional Medium Components 396
13.4.6.1	Phenol Red 396
13.4.6.2	Sodium Bicarbonate Buffer 396
13.4.6.3	Alternative Buffers 397
13.4.6.4	Antioxidants 398
13.4.6.5	Mechanical-Damage-Protective Agents 398
13.4.6.6	Antibiotics 399
13.5	High Molecular Weight and Complex Supplements 400
13.5.1	Serum 400
13.5.1.1	Functions of Serum in Cell Culture Medium 400
13.5.1.2	Disadvantages of Serum in Cell Culture Medium 401
13.5.2	Insulin and Insulin-Like Growth Factors 402
13.5.3	Transferrin 402
13.5.4	Serum Albumin and Other Carrier Proteins 403
13.5.5	Cell Adhesion Molecules 404
13.5.6	Protein Hydrolysates 405
13.5.7	Lipid Supplements 406
13.6	Medium for Industrial Production 407
13.6.1	Medium Design and the PAT Initiative 409
13.7	Conclusions 411
	References 412

Further Reading/Resources 416

XIV Contents

Processes 417 Sarika Mehra, Vikas Chandrawanshi, and Kamal Prashad14.1Primary Modes of Bioreactor Operation14.2Fed-Batch Mode of Operation14.2Fed-Batch Mode of Operation14.2Feeding Strategies for Fed-Batch Culture14.2.1Design of Feed Composition14.2Feeding Strategies for Fed-Batch Culture14.2.2Feeding Strategies for Fed-Batch Culture14.2.2.1Culture Working Volume as Control14.2.2.2Concentration of Indicator Metabolite as Control14.2.2.3Nutrient Consumption Rate as Control14.2.4Predicted Growth Rate as Control14.2.5Culture pH as Control14.2.4Predicted Growth Rate as Control14.2.5Culture pH as Control14.2.4Challenges in Fed-Batch Culture and FutureDirections43014.3Perfusion Mode of Bioreactor Operation14.3Perfusion Mode of Bioreactor Operation14.3.1Types of Perfusion Devices14.3.1Gravity Settlers14.3.1.2Filtration14.3.13Centrifuges14.3.14Hydrocyclones14.3.15Acoustic Settlers14.3.2Feeding Strategies for Perfusion Cultures14.3.2Feeding Strategies for Perfusion Culture and Future Directions14.3.2Feeding Strategies for Perfusion Cultures14.3.3Challenges in Perfusion Culture and Future Directions14.3.4Hydrocyclones14.3.2Keeding14.3.3Challenges in Perfusi
 14.1 Primary Modes of Bioreactor Operation 417 14.2 Fed-Batch Mode of Operation 419 14.2.1 Design of Feed Composition 419 14.2.2 Feeding Strategies for Fed-Batch Culture 422 14.2.2.1 Culture Working Volume as Control 423 14.2.2.2 Concentration of Indicator Metabolite as Control 423 14.2.2.3 Nutrient Consumption Rate as Control 426 14.2.4 Predicted Growth Rate as Control 427 14.2.5 Culture pH as Control 427 14.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2 Fed-Batch Mode of Operation 419 14.2.1 Design of Feed Composition 419 14.2.2 Feeding Strategies for Fed-Batch Culture 422 14.2.2.1 Culture Working Volume as Control 423 14.2.2.2 Concentration of Indicator Metabolite as Control 423 14.2.2.3 Nutrient Consumption Rate as Control 426 14.2.4 Predicted Growth Rate as Control 427 14.2.5 Culture pH as Control 427 14.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.1 Design of Feed Composition 419 14.2.2 Feeding Strategies for Fed-Batch Culture 422 14.2.2.1 Culture Working Volume as Control 423 14.2.2.2 Concentration of Indicator Metabolite as Control 423 14.2.2.3 Nutrient Consumption Rate as Control 426 14.2.4 Predicted Growth Rate as Control 427 14.2.5 Culture pH as Control 427 14.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.2 Feeding Strategies for Fed-Batch Culture 422 14.2.2.1 Culture Working Volume as Control 423 14.2.2.2 Concentration of Indicator Metabolite as Control 423 14.2.2.3 Nutrient Consumption Rate as Control 426 14.2.2.4 Predicted Growth Rate as Control 427 14.2.2.5 Culture pH as Control 427 14.2.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.2.1 Culture Working Volume as Control 423 14.2.2.2 Concentration of Indicator Metabolite as Control 423 14.2.2.3 Nutrient Consumption Rate as Control 426 14.2.2.4 Predicted Growth Rate as Control 427 14.2.2.5 Culture pH as Control 427 14.2.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.2.2 Concentration of Indicator Metabolite as Control 423 14.2.2.3 Nutrient Consumption Rate as Control 426 14.2.4 Predicted Growth Rate as Control 427 14.2.5 Culture pH as Control 427 14.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.2.3 Nutrient Consumption Rate as Control 426 14.2.2.4 Predicted Growth Rate as Control 427 14.2.2.5 Culture pH as Control 427 14.2.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.2.4 Predicted Growth Rate as Control 427 14.2.2.5 Culture pH as Control 427 14.2.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.2.5 Culture pH as Control 427 14.2.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.2.6 Oxygen Uptake Rate as Control 428 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.3 Mode and Frequency of Feeding 429 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.2.4 Challenges in Fed-Batch Culture and Future Directions 430 14.3 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
Directions43014.3Perfusion Mode of Bioreactor Operation43514.3.1Types of Perfusion Devices43514.3.1.1Gravity Settlers43514.3.1.2Filtration43814.3.1.3Centrifuges44114.3.1.4Hydrocyclones44314.3.1.5Acoustic Settlers44414.3.2Feeding Strategies for Perfusion Cultures44514.3.2.1Cell-Density-Based Feeding44514.3.2.2Metabolite-Based Feeding44514.3.3Challenges in Perfusion Culture and Future Directions44614.4Use of Disposables in Cell Culture Bioprocesses447
 Perfusion Mode of Bioreactor Operation 435 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.1 Types of Perfusion Devices 435 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.1.1 Gravity Settlers 435 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.1.2 Filtration 438 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.1.3 Centrifuges 441 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.1.4 Hydrocyclones 443 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.1.5 Acoustic Settlers 444 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.2 Feeding Strategies for Perfusion Cultures 445 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.2.1 Cell-Density-Based Feeding 445 14.3.2.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
 14.3.2.2 Metabolite-Based Feeding 445 14.3.3 Challenges in Perfusion Culture and Future Directions 446 14.4 Use of Disposables in Cell Culture Bioprocesses 447
14.3.3 Challenges in Perfusion Culture and Future Directions 44614.4 Use of Disposables in Cell Culture Bioprocesses 447
14.4 Use of Disposables in Cell Culture Bioprocesses 447
Parameters 450
14.5.1 Enzymatic Assays 450
14.5.2 Spectroscopy-Based Methods 452
14.5.3 Chromatography-Based Methods 452
14.5.4 Microscopy-Based Methods 452
14.5.5 Electrochemical Methods 453
14.6 Concluding Remarks 453
Nomenclature 455
References 456
Further Reading/Resources 468

	Contents		
	Part V Environmental Bioengineering 469		
15	Treatment of Industrial and Municipal Wastewater: An Overview about Basic and Advanced Concepts 471 Jyoti K. Kumar, Parag R. Gogate, and Aniruddha B. Pandit		
15.1	Types of Wastewater 471		
15.2	Biological Treatment 471		
15.3	Wastewater Regulations 473		
15.4	Biological Treatment Processes 473		
15.5	Aerobic Techniques 475		
15.5.1	Mathematical Modeling 475		
15.5.2	Types of Aerobic Treatment 476		
15.5.2.1	Activated Sludge Process (ASP) 476		
15.5.2.2	Trickling Filters 481		
15.5.2.3	Rotating Biological Contactors (RBCs) 483		
15.5.2.4	Submerged Biological Contactors (SBCs) 484		
15.5.2.5	Powdered Activated Carbon Treatment (PACT) Systems 484		
15.5.2.6	Membrane Bioreactors 484		
15.5.2.7	Biological Aerated Filters (BAFs) 485		
15.5.2.8 Hybrid Processes-Integrated Fixed Film Activated Sludge			
	System 486		
15.5.2.9	Use of Ultrasound to Improve the Sludge Characteristics 487		
15.6	Anaerobic Techniques 488		
15.6.1	Types of Anaerobic Treatment Systems 489		
15.6.1.1	Upflow Anaerobic Sludge Blanket (UASB) 489		

- 15.6.1.1 Upflow Anaerobic Sludge Blanket (UASB) 489
- 15.6.1.2 Anaerobic Baffled Reactors (ABR) 490
- 15.6.1.3 Anaerobic Fluidized Bed Reactors 491
- 15.6.1.4 Expanded Granule Sludge Blanket (EGSB) Reactor 492
- Anaerobic Membrane Reactors 492 15.6.1.5
- 15.6.2 Improvements for Sludge Management 494
- 15.7 Aerobic – Anaerobic Processes 495
- 15.8 Modified Biological Processes 496
- 15.8.1 Cavitation 496
- Fenton Chemistry 500 15.8.2
- 15.8.3 Ozonation 501
- 15.8.4 Photocatalysis 503
- 15.8.5 Overview of Literature Dealing with Combined Processes 505
- 15.8.6 A Typical Case Study of Biodegradability Enhancement of Distillery Wastewater Using Hydrodynamic Cavitation 507

XVI Contents

15.8.7	Short Case Study of Intensification of Biological Oxidation Using Acoustic Cavitation/Fenton Chemistry 509		
15.8.8	Summary of Pretreatment Approaches 511		
15.9	Overall Conclusions 511		
	List of Acronyms/Abbreviations 512		
	List of Variables and Coefficients 513		
	References 514		
16	Treatment of Solid Waste 521		
	Michael Nelles, Gert Morscheck, Astrid Lemke, and Ayman El Naas		
16.1	Biological Treatment of Source Segregated Bio-Waste 522		
16.1.1	Composting 522		
16.1.1.1	Composting Process 522		
16.1.1.2	Composting Technologies 525		
16.1.1.3	Compost Use and Quality 531		
16.1.1.4	Status of Composting in Europe and Germany 532		
16.1.2	Anaerobic Digestion 532		
16.1.2.1	Process of Anaerobic Digestion 532		
16.1.2.2	AD Technologies 534		
16.1.2.3	Digestate Use and Quality 538		
16.1.2.4	Status of Anaerobic Digestion in Europe and Germany 538		
16.2	Mechanical–Biological Treatment of Mixed Municipal Solid		
	Waste 538		
16.2.1	MBT Technologies 539		
16.2.1.1	MBT – Mechanical–Biological Treatment 539		
16.2.1.2	MBS – Mechanical–Biological Stabilization 540		
16.2.1.3	MPS – Mechanical–Physical Stabilization 541		
16.2.1.4	Status for Germany and Europe 541		
16.3	Biological Treatment of Agricultural Waste 542		
16.4	Conclusion 542		
	References 542		
17	Energy Recovery from Organic Waste 545		
	Yutaka Nakashimada and Naomichi Nishio		
17.1	Advantage of Methane Fermentation for Energy Recovery from		
	Organic Matter 545		
17.2	Basic Knowledge of Methane Fermentation of Organic Wastes 546		
17.3	Conventional Methane Fermentation Process 549		
17.4	Advanced Methane Fermentation Processes 551		
17.4.1	Methane Fermentation of Organic Wastes with High Salinity 551		
17.4.2	Methane Fermentation of Nitrogen-Rich Organic Wastes with High		
	Ammonia 552		
17.5	Hydrogen Production from Organic Wastes 555		
17.5.1	Hydrogen Production Combining Methane Fermentation 555		
17.5.2	Hydrogen Production by Various Anaerobic Bacteria 556		

Contents XVII

- 17.5.3 Feasible Substrates for Hydrogen Production 558
- 17.5.4 Bioreactor for High-Rate Hydrogen Production 559
- 17.6 Upgrading of Biogas from Organic Wastes Based on Biological Syngas Platform 561
- 17.6.1 Bioduel Production from Syngas by Acetogens 562
- 17.6.2 Development of Genetic Engineering Tools of Acetogens 563
- 17.7 Conclusions 564 References 565
- 18 Microbial Removal and Recovery of Metals from Wastewater 573 Michihiko Ike. Mitsuo Yamashita. and Masashi Kuroda
- 18.1 Microbial Reactions Available for Metal Removal/Recovery 574
- 18.1.1 Bioprecipitation/Biomineralization 575
- 18.1.2 Biovolatilization 577
- 18.1.3 Biosorption 578
- 18.1.4 Bioleaching 581
- 18.2 Selenium Recovery by *Pseudomonas stutzeri* NT-I 583
- 18.2.1 *Pseudomonas stutzeri* NT-I as a Versatile Tool for Selenium Recovery 583
- 18.2.2 Selenium Recovery by Bioprecipitation 585
- 18.2.3 Selenium Recovery by Biovolatilization 586
- 18.3 Future Prospects 587
- 18.3.1 Toward Environmental Conservation and Solutions to Resource Depletion 587
- 18.3.2 Development of Removal and Recovery Strategies for Other Elements 589
- 18.3.3 Potential for Practical Application 589
- 18.4 Conclusions 590 References 590
- 19Sustainable Use of Phosphorus Through Bio-Based
Recycling 597
- Hisao Ohtake
- 19.1 Introduction 597
- 19.2 Microbiological Basis 598
- 19.2.1 P_i Acquisition in Bacteria 598
- 19.2.2 Bacterial polyP Accumulation 599
- 19.3 Bio-Based P Recycling 600
- 19.3.1 Biological P Removal 600
- 19.3.2 P_i Release from polyP-Rich Sludge 601
- 19.3.3 P_i Recovery from Aqueous Solution 602
- 19.4 Other Options for P Recycling 604
- 19.4.1 Land Application of Biosolids 604
- 19.4.2 Animal Manure Management 605
- 19.4.3 Biosolubilization of Immobilized P_i 606

XVIII Contents

19.4.4	Industrial P Recycling	606
19.5	Conclusions 607	
	References 609	

Index 613