

Contents

Preface to the Second Edition *XIII*

Preface to the First Edition *XV*

About the companion website *XVII*

Nomenclature *XIX*

Part I Basic Concepts and Principles *1*

1 Introduction *3*

1.1 Background and Scope *3*

1.2 Dimensions and Units *4*

1.3 Intensive and Extensive Properties *6*

1.4 Equilibria and Rates *6*

1.5 Batch Versus Continuous Operation *8*

1.6 Material Balance *8*

1.7 Energy Balance *9*

References *11*

Further Reading *12*

2 Elements of Physical Transfer Processes *13*

2.1 Introduction *13*

2.2 Heat Conduction and Molecular Diffusion *14*

2.3 Fluid Flow and Momentum Transfer *15*

2.4 Laminar Versus Turbulent Flow *18*

2.5 Transfer Phenomena in Turbulent Flow *21*

2.6 Film Coefficients of Heat and Mass Transfer *23*

Further Reading *26*

3 Chemical and Biochemical Kinetics *27*

3.1 Introduction *27*

3.2 Fundamental Reaction Kinetics *27*

3.2.1 Rates of Chemical Reaction *27*

3.2.1.1 Elementary Reaction and Equilibrium *28*

3.2.1.2 Temperature Dependence of Reaction Rate Constant k *29*

3.2.1.3	Rate Equations for First- and Second-Order Reactions	30
3.2.2	Rates of Enzyme Reactions	34
3.2.2.1	Kinetics of Enzyme Reaction	35
3.2.2.2	Evaluation of Kinetic Parameters in Enzyme Reactions	37
3.2.2.3	Inhibition and Regulation of Enzyme Reactions	39
	References	45
	Further Reading	45
4	Cell Kinetics	47
4.1	Introduction	47
4.2	Cell Growth	47
4.3	Growth Phases in Batch Culture	49
4.4	Factors Affecting Rates of Cell Growth	52
4.5	Cell Growth in Batch Fermentors and Continuous Stirred-Tank Fermentors (CSTF)	53
4.5.1	Batch Fermentor	53
4.5.2	Continuous Stirred-Tank Fermentor	54
	Reference	56
	Further Reading	56
	Part II Unit Operations and Apparatus for Biosystems	57
5	Heat Transfer	59
5.1	Introduction	59
5.2	Overall Coefficients U and Film Coefficients h	59
5.3	Mean Temperature Difference	62
5.4	Estimation of Film Coefficients h	64
5.4.1	Forced Flow of Fluids through Tubes (Conduits)	65
5.4.2	Forced Flow of Fluids across a Tube Bank	67
5.4.3	Liquids in Jacketed or Coiled Vessels	67
5.4.4	Condensing Vapors and Boiling Liquids	68
5.5	Estimation of Overall Coefficients U	68
	References	72
	Further Reading	72
6	Mass Transfer	73
6.1	Introduction	73
6.2	Overall Coefficients K and Film Coefficients k of Mass Transfer	73
6.3	Types of Mass Transfer Equipment	77
6.3.1	Packed Column	78
6.3.2	Plate Column	79
6.3.3	Spray Column	79
6.3.4	Bubble Column	79
6.3.5	Packed- (Fixed-) Bed Column	80
6.3.6	Other Separation Methods	80

6.4	Models for Mass Transfer at the Interface	80
6.4.1	Stagnant Film Model	80
6.4.2	Penetration Model	81
6.4.3	Surface Renewal Model	81
6.5	Liquid Phase Mass Transfer with Chemical Reactions	82
6.6	Correlations for Film Coefficients of Mass Transfer	84
6.6.1	Single-Phase Mass Transfer Inside or Outside Tubes	84
6.6.2	Single-Phase Mass Transfer in Packed Beds	85
6.6.3	J -Factor	86
6.7	Performance of Packed Column	87
6.7.1	Limiting Gas and Liquid Velocities	87
6.7.2	Definitions of Volumetric Coefficients and HTUs	88
6.7.3	Mass Transfer Rates and Effective Interfacial Areas	91
	References	95
	Further Reading	95
7	Bioreactors	97
7.1	Introduction	97
7.2	Some Fundamental Concepts	98
7.2.1	Batch and Continuous Reactors	98
7.2.2	Effects of Mixing on Reactor Performance	99
7.2.2.1	Uniformly Mixed Batch Reactor	99
7.2.2.2	Continuous Stirred-Tank Reactor (CSTR)	99
7.2.2.3	Plug Flow Reactor (PFR)	100
7.2.2.4	Comparison of Fractional Conversions by CSTR and PFR	101
7.2.3	Effects of Mass Transfer Around and within Catalyst or Enzymatic Particles on the Apparent Reaction Rates	102
7.2.3.1	Liquid Film Resistance Controlling	102
7.2.3.2	Effects of Diffusion within Catalyst Particles	103
7.2.3.3	Effects of Diffusion within Immobilized Enzyme Particles	105
7.3	Bubbling Gas–Liquid Reactors	106
7.3.1	Gas Holdup	106
7.3.2	Interfacial Area	107
7.3.3	Mass Transfer Coefficients	108
7.3.3.1	Definitions	108
7.3.3.2	Measurements of $k_L a$	109
7.4	Mechanically Stirred Tanks	111
7.4.1	General	111
7.4.2	Power Requirements of Stirred Tanks	113
7.4.2.1	Ungassed Liquids	113
7.4.2.2	Gas-Sparged Liquids	114
7.4.3	$k_L a$ in Gas-Sparged Stirred Tanks	116
7.4.4	Liquid Mixing in Stirred Tanks	118
7.4.5	Suspending of Solid Particles in Liquid in Stirred Tanks	119
7.5	Gas Dispersion in Stirred Tanks	120

7.6	Bubble Columns	120
7.6.1	General	120
7.6.2	Performance of Bubble Columns	121
7.6.2.1	Gas Holdup	121
7.6.2.2	$k_L a$	122
7.6.2.3	Bubble Size	122
7.6.2.4	Interfacial Area a	122
7.6.2.5	k_L	123
7.6.2.6	Other Correlations for $k_L a$	123
7.6.2.7	$k_L a$ and Gas Holdup for Suspensions and Emulsions	124
7.7	Airlift Reactors	125
7.7.1	IL Airlifts	125
7.7.2	EL Airlifts	126
7.8	Packed-Bed Reactors	127
7.9	Microreactors	127
	References	131
	Further Reading	132
8	Membrane Processes	133
8.1	Introduction	133
8.2	Dialysis	134
8.3	Ultrafiltration	136
8.4	Microfiltration	138
8.5	Reverse Osmosis	139
8.6	Membrane Modules	141
8.6.1	Flat Membrane	141
8.6.2	Spiral Membrane	142
8.6.3	Tubular Membrane	142
8.6.4	Hollow-Fiber Membrane	142
	References	143
	Further Reading	143
9	Cell-Liquid Separation and Cell Disruption	145
9.1	Introduction	145
9.2	Conventional Filtration	145
9.3	Microfiltration	147
9.4	Centrifugation	148
9.5	Cell Disruption	151
	References	153
10	Sterilization	155
10.1	Introduction	155
10.2	Kinetics of Thermal Death of Cells	155
10.3	Batch Heat Sterilization of Culture Media	156
10.4	Continuous Heat Sterilization of Culture Media	158

10.5	Sterilizing Filtration	161
	References	164
11	Adsorption and Chromatography	165
11.1	Introduction	165
11.2	Equilibria in Adsorption	165
11.2.1	Linear Equilibrium	165
11.2.2	Adsorption Isotherms of Langmuir Type and Freundlich Type	166
11.3	Rates of Adsorption into Adsorbent Particles	167
11.4	Single- and Multistage Operations for Adsorption	168
11.5	Adsorption in Fixed Beds	170
11.5.1	Fixed-Bed Operation	170
11.5.2	Estimation of the Break Point	171
11.6	Separation by Chromatography	174
11.6.1	Chromatography for Bioseparation	174
11.6.2	General Theories on Chromatography	176
11.6.2.1	Equilibrium Model	176
11.6.2.2	Stage Model	177
11.6.2.3	Rate Model	177
11.6.3	Resolution Between Two Elution Curves	178
11.6.4	Gel Chromatography	179
11.6.5	Affinity Chromatography	181
11.7	Biorecognition Assay	183
11.7.1	Antigen Recognition by an Antibody	183
11.7.2	Enzyme-Linked Immunosorbent Assay (ELISA)	183
	References	187
	Further Reading	187
	Part III Practical Aspects in Bioengineering	189
12	Fermentor Engineering	191
12.1	Introduction	191
12.2	Stirrer Power Requirements for Non-Newtonian Liquids	193
12.3	Heat Transfer in Fermentors	195
12.4	Gas–Liquid Mass Transfer in Fermentors	197
12.4.1	Special Factors Affecting $k_L a$	198
12.4.1.1	Effects of Electrolytes	198
12.4.1.2	Enhancement Factor	198
12.4.1.3	Presence of Cells	199
12.4.1.4	Effects of Antifoam Agents and Surfactants	199
12.4.1.5	$k_L a$ in Emulsions	199
12.4.1.6	$k_L a$ in Non-Newtonian Liquids	201
12.4.2	Desorption of Carbon Dioxide	202
12.5	Criteria for Scaling-Up Fermentors	204
12.6	Modes of Fermentor Operation	206

12.6.1	Batch Operation	207
12.6.2	Fed-Batch Operation	207
12.6.3	Continuous Operation	209
12.6.4	Operation of Enzyme Reactors	211
12.7	Fermentors for Animal Cell Culture	213
	References	214
	Further Reading	215
13	Instrumentation and Control of Bioprocesses	217
13.1	Introduction	217
13.2	Instrumentation of Bioprocesses	218
13.2.1	Process Variables and Sensors in Bioprocess Operations	218
13.2.1.1	Physical Variables	220
13.2.1.2	Chemical Variables	221
13.2.1.3	Biochemical Variables	222
13.3	Control of Bioprocesses	223
13.3.1	Schematic View of Instrumentation and Control of Bioprocesses	223
13.3.2	Principles of Control Systems Used for Bioprocesses	224
13.3.2.1	Closed-Loop System with Feedback	224
13.3.2.2	Algorithms for Manipulation of Control Variables	225
13.3.3	Examples of Bioprocess Control	229
13.3.3.1	pH and Temperature Control	229
13.3.3.2	DO Control	230
13.3.3.3	Respiratory Quotient	230
13.3.3.4	pH Stat	231
13.3.3.5	DO Stat	231
13.4	Advanced Control of Bioprocesses	231
13.4.1	Optimization and Control of Bioprocesses	232
13.4.2	Application of Artificial Intelligence (AI) Technology to Bioprocess Control	232
13.4.2.1	Fuzzy Control	232
13.4.2.2	Artificial Neural Network	233
13.4.2.3	Expert System	233
	References	234
	Further Reading	234
14	Downstream Operations in Bioprocesses	235
14.1	Introduction	235
14.2	Separation of Microorganisms by Filtration and Microfiltration	238
14.2.1	Dead-End Filtration	238
14.2.2	Cross Flow Filtration	240
14.3	Separation by Chromatography	242
14.3.1	Factors Affecting the Performance of Chromatography Columns	242

14.3.1.1	Velocity of Mobile Phase and Diffusivities of Solutes	242
14.3.1.2	Radius of Packed Particles	243
14.3.1.3	Sample Volume Injected	243
14.3.1.4	Column Diameter	244
14.3.2	Scale-Up of Chromatography Columns	245
14.4	Separation in Fixed-Beds	246
14.5	Sanitation in Downstream Processes	247
	References	248
	Further Reading	249
15	Medical Devices	251
15.1	Introduction	251
15.2	Blood and Its Circulation	251
15.2.1	Blood and Its Components	251
15.2.2	Blood Circulation	253
15.3	Oxygenation of Blood	254
15.3.1	Use of Blood Oxygenators	254
15.3.2	Oxygen in Blood	255
15.3.3	Carbon Dioxide in Blood	256
15.3.4	Types of Blood Oxygenators	258
15.3.5	Oxygen Transfer Rates in Blood Oxygenators	259
15.3.5.1	Laminar Blood Flow	259
15.3.5.2	Turbulent Blood Flow	260
15.3.6	Carbon Dioxide Transfer Rates in Blood Oxygenators	265
15.4	Artificial Kidney	266
15.4.1	Human Kidney Functions	266
15.4.2	Artificial Kidneys	268
15.4.2.1	Hemodialyzer	268
15.4.2.2	Hemofiltration	270
15.4.2.3	Peritoneal Dialysis	270
15.4.3	Mass Transfer in Hemodialyzers (cf. 8.2)	271
15.5	Bioartificial Liver	275
15.5.1	Human Liver	275
15.5.2	Bioartificial Liver Devices	276
	References	278
	Appendix A: Conversion Factors for Units	279
	Appendix B: Solutions to the Problems	281
	Index	295

