Contents

Preface to the Third Edition *xiii*
Preface to the Second Edition *xv*
Preface to the First Edition *xvii*
Nomenclature *xix*
About the Companion Website *xxiii*

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 *7*
1.6 Material Balance *8*
1.7 Energy Balance *9*
Problems *10*
References *11*
Further Reading *11*

2 Elements of Physical Transfer Processes *13*
2.1 Introduction *13*
2.2 Heat Conduction and Molecular Diffusion *13*
2.3 Fluid Flow and Momentum Transfer *15*
2.4 Laminar Versus Turbulent Flow *17*
2.5 Transfer Phenomena in Turbulent Flow *20*
2.6 Film Coefficients of Heat and Mass Transfer *22*
Problems *24*
References *25*

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 *33*
3.2.2.1 Kinetics of Enzyme Reaction *34*
3.2.2.2 Evaluation of Kinetic Parameters in Enzyme Reactions *36*
3.2.2.3 Inhibition and Regulation of Enzyme Reactions *38*
Problems *41*
References *44*
Further Readings *44*

4 Cell Kinetics *45*
4.1 Introduction *45*
4.2 Cell Growth *45*
4.3 Growth Phases in Batch Culture *47*
4.4 Factors Affecting Rates of Cell Growth *49*
4.5 Cell Growth in Batch Fermentors and Continuous Stirred-Tank Fermentors *51*
4.5.1 Batch Fermentor *51*
4.5.2 Continuous Stirred-Tank Fermentor *52*
Problems *52*
Reference *54*
Further Reading *54*

Part II Unit Operations and Apparatus for Biosystems *55*

5 Heat Transfer *57*
5.1 Introduction *57*
5.2 Overall Coefficients *U* and Film Coefficients *h* *57*
5.3 Mean Temperature Difference *60*
5.4 Estimation of Film Coefficients *h* *62*
5.4.1 Forced Flow of Fluids Through Tubes (Conduits) *62*
5.4.2 Forced Flow of Fluids Across a Tube Bank *64*
5.4.3 Liquids in Jacketed or Coiled Vessels *64*
5.4.4 Condensing Vapors and Boiling Liquids *65*
5.5 Estimation of Overall Coefficients *U* *66*
Problems *68*
References *69*
Further Readings *69*

6 Mass Transfer *71*
6.1 Introduction *71*
6.2 Overall Coefficients *K* and Film Coefficients *k* of Mass Transfer *71*
6.3 Types of Mass Transfer Equipment *75*
6.3.1 Packed Column *75*
6.3.2 Plate Column *76*
6.3.3 Spray Column *77*
6.3.4 Bubble Column *77*
6.3.5 Packed- (Fixed-) Bed Column *77*
6.3.6 Other Separation Methods *78*
6.4 Models for Mass Transfer at the Interface *78*
6.4.1 Stagnant Film Model *78*
6.4.2 Penetration Model *78*
6.4.3 Surface Renewal Model *79*
6.5 Liquid-Phase Mass Transfer with Chemical Reactions *79*
6.6 Correlations for Film Coefficients of Mass Transfer *81*
6.6.1 Single-Phase Mass Transfer Inside or Outside Tubes *81*
6.6.2 Single-Phase Mass Transfer in Packed Beds *83*
6.6.3 *J*-Factor *83*
6.7 Performance of Packed Column *84*
6.7.1 Limiting Gas and Liquid Velocities *84*
6.7.2 Definitions of Volumetric Coefficients and HTUs *85*
6.7.3 Mass Transfer Rates and Effective Interfacial Areas *87*
Problems *90*
References *91*
Further Readings *92*

7 Bioreactors *93*
7.1 Introduction *93*
7.2 Some Fundamental Concepts *94*
7.2.1 Batch and Continuous Reactors *94*
7.2.2 Effects of Mixing on Reactor Performance *95*
7.2.2.1 Uniformly Mixed Batch Reactor *95*
7.2.2.2 Continuous Stirred-Tank Reactor *95*
7.2.2.3 Plug Flow Reactor *96*
7.2.2.4 Comparison of Fractional Conversions by CSTR and PFR *97*
7.2.3 Effects of Mass Transfer Around and Within Catalyst or Enzymatic Particles on the Apparent Reaction Rates *97*
7.2.3.1 Liquid Film Resistance Controlling *98*
7.2.3.2 Effects of Diffusion Within Catalyst Particles *98*
7.2.3.3 Effects of Diffusion Within Immobilized Enzyme Particles *100*
7.3 Bubbling Gas–Liquid Reactors *102*
7.3.1 Gas Holdup *102*
7.3.2 Interfacial Area *102*
7.3.3 Mass Transfer Coefficients *103*

7.3.3.1 Definitions *103*
7.3.3.2 Measurements of $k_L a$ *104*
7.4 Mechanically Stirred Tanks *106*
7.4.1 General *106*
7.4.2 Power Requirements of Stirred Tanks *108*
7.4.2.1 Ungassed Liquids *108*
7.4.2.2 Gas-Sparged Liquids *110*
7.4.3 $k_L a$ in Gas-Sparged Stirred Tanks *111*
7.4.4 Liquid Mixing in Stirred Tanks *113*
7.4.5 Suspending of Solid Particles in Liquid in Stirred Tanks *114*
7.5 Gas Dispersion in Stirred Tanks *114*
7.6 Bubble Columns *115*
7.6.1 General *115*
7.6.2 Performance of Bubble Columns *116*
7.6.2.1 Gas Holdup *116*
7.6.2.2 $k_L a$ *116*
7.6.2.3 Bubble Size *117*
7.6.2.4 Interfacial Area a *117*
7.6.2.5 k_L *117*
7.6.2.6 Other Correlations for $k_L a$ *117*
7.6.2.7 $k_L a$ and Gas Holdup for Suspensions and Emulsions *118*
7.7 Airlift Reactors *119*
7.7.1 IL Airlifts *119*
7.7.2 EL Airlifts *120*
7.8 Packed-Bed Reactors *121*
7.9 Microreactors *122*
Problems *123*
References *125*
Further Reading *126*

8 Membrane Processes *127*
8.1 Introduction *127*
8.2 Dialysis *128*
8.3 Ultrafiltration *129*
8.4 Microfiltration *132*
8.5 Reverse Osmosis *133*
8.6 Membrane Modules *135*
8.6.1 Flat Membrane *135*
8.6.2 Spiral Membrane *135*
8.6.3 Tubular Membrane *135*
8.6.4 Hollow-Fiber Membrane *135*
Problems *136*
References *136*
Further Reading *137*

9 Cell–Liquid Separation and Cell Disruption *139*
9.1 Introduction *139*
9.2 Conventional Filtration *139*
9.3 Microfiltration *141*
9.4 Centrifugation *142*
9.5 Cell Disruption *144*
Problems *146*
References *147*

10 Sterilization *149*
10.1 Introduction *149*
10.2 Kinetics of Thermal Death of Cells *149*
10.3 Batch Heat Sterilization of Culture Media *150*
10.4 Continuous Heat Sterilization of Culture Media *151*
10.5 Sterilizing Filtration *154*
Problems *157*
References *157*

11 Adsorption and Chromatography *159*
11.1 Introduction *159*
11.2 Equilibria in Adsorption *159*
11.2.1 Linear Equilibrium *159*
11.2.2 Adsorption Isotherms of Langmuir Type and Freundlich Type *160*
11.3 Rates of Adsorption into Adsorbent Particles *161*
11.4 Single- and Multistage Operations for Adsorption *162*
11.5 Adsorption in Fixed Beds *163*
11.5.1 Fixed-Bed Operation *163*
11.5.2 Estimation of the Break Point *165*
11.6 Separation by Chromatography *167*
11.6.1 Chromatography for Bioseparation *167*
11.6.2 General Theories on Chromatography *168*
11.6.2.1 Equilibrium Model *168*
11.6.2.2 Stage Model *170*
11.6.2.3 Rate Model *171*
11.6.3 Resolution Between Two Elution Curves *171*
11.6.4 Gel Chromatography *172*
11.6.5 Affinity Chromatography *174*
11.7 Biorecognition Assay *175*
11.7.1 Antigen Recognition by an Antibody *175*
11.7.2 Enzyme-Linked Immunosorbent Assay (ELISA) *176*
Problems *179*
References *180*
Further Readings *180*

Part III Practical Aspects in Bioengineering *181*

12 Fermentor Engineering *183*
12.1 Introduction *183*
12.2 Stirrer Power Requirements for Non-Newtonian Liquids *185*
12.3 Heat Transfer in Fermentors *186*
12.4 Gas–Liquid Mass Transfer in Fermentors *189*
12.4.1 Special Factors Affecting $k_L a$ *189*
12.4.1.1 Effects of Electrolytes *189*
12.4.1.2 Enhancement Factor *190*
12.4.1.3 Presence of Cells *190*
12.4.1.4 Effects of Antifoam Agents and Surfactants *190*
12.4.1.5 $k_L a$ in Emulsions *191*
12.4.1.6 $k_L a$ in Non-Newtonian Liquids *192*
12.4.2 Desorption of Carbon Dioxide *193*
12.5 Criteria for Scaling-Up Fermentors *195*
12.6 Modes of Fermentor Operation *197*
12.6.1 Batch Operation *197*
12.6.2 Fed-Batch Operation *198*
12.6.3 Continuous Operation *201*
12.6.4 Operation of Enzyme Reactors *202*
12.7 Fermentors for Animal Cell Culture *203*
Problems *203*
References *204*
Further Readings *205*

13 Instrumentation and Control of Bioprocesses *207*
13.1 Introduction *207*
13.2 Instrumentation of Bioprocesses *208*
13.2.1 Process Variables and Sensors in Bioprocess Operations *208*
13.2.1.1 Physical Variables *209*
13.2.1.2 Chemical Variables *211*
13.2.1.3 Biochemical Variables *212*
13.3 Control of Bioprocesses *213*
13.3.1 Schematic View of Instrumentation and Control of Bioprocesses *213*
13.3.2 Principles of Control Systems Used for Bioprocesses *214*
13.3.2.1 Closed-Loop System with Feedback *214*
13.3.2.2 Algorithms for Manipulation of Control Variables *214*
13.3.3 Examples of Bioprocess Control *218*
13.3.3.1 pH and Temperature Control *218*
13.3.3.2 DO Control *219*
13.3.3.3 Respiratory Quotient *220*
13.3.3.4 pH Stat *220*
13.3.3.5 DO Stat *221*
13.4 Advanced Control of Bioprocesses *221*

13.4.1 Optimization and Control of Bioprocesses *221*
13.4.2 Application of Artificial Intelligence Technology to Bioprocess Control *221*
13.4.2.1 Fuzzy Control *222*
13.4.2.2 Artificial Neural Network *222*
13.4.2.3 Expert System *222*
Problems *222*
References *223*
Further Readings *223*

14 Downstream Operations in Bioprocesses *225*
14.1 Introduction *225*
14.2 Separation of Microorganisms by Filtration and Microfiltration *228*
14.2.1 Dead-End Filtration *228*
14.2.2 Cross-Flow Filtration *230*
14.3 Separation by Chromatography *231*
14.3.1 Factors Affecting the Performance of Chromatography Columns *231*
14.3.1.1 Velocity of Mobile Phase and Diffusivities of Solutes *232*
14.3.1.2 Radius of Packed Particles *232*
14.3.1.3 Sample Volume Injected *233*
14.3.1.4 Column Diameter *233*
14.3.2 Scale-Up of Chromatography Columns *234*
14.4 Separation in Fixed-Beds *235*
14.5 Sanitation in Downstream Processes *236*
Problems *237*
References *237*
Further Readings *238*

15 Medical Devices *239*
15.1 Introduction *239*
15.2 Blood and Its Circulation *239*
15.2.1 Blood and Its Components *239*
15.2.2 Blood Circulation *240*
15.3 Oxygenation of Blood *242*
15.3.1 Use of Blood Oxygenators *242*
15.3.2 Oxygen in Blood *242*
15.3.3 Carbon Dioxide in Blood *244*
15.3.4 Types of Blood Oxygenators *245*
15.3.5 Oxygen Transfer Rates in Blood Oxygenators *247*
15.3.5.1 Laminar Blood Flow *247*
15.3.5.2 Turbulent Blood Flow *248*
15.3.6 Carbon Dioxide Transfer Rates in Blood Oxygenators *253*
15.4 Artificial Kidney *253*
15.4.1 Human Kidney Functions *253*
15.4.2 Artificial Kidneys *255*

15.4.2.1 Hemodialyzer *255*
15.4.2.2 Hemofiltration *257*
15.4.2.3 Peritoneal Dialysis *257*
15.4.3 Mass Transfer in Hemodialyzers *257*
15.5 Bioartificial Liver *261*
15.5.1 Human Liver *261*
15.5.2 Bioartificial Liver Devices *262*
Problems *264*
References *264*

16 Biopharmaceutical Production Process – Focus on Antibody Drugs *267*
16.1 Introduction *267*
16.2 Upstream Processing: CHO-Based Monoclonal Antibody Production *267*
16.2.1 Cell Line Development and Genetic Engineering *268*
16.2.2 Bioreactor Cultivation and Continuous Processing *268*
16.3 Downstream Processing *270*
16.3.1 Protein A Chromatography as the Gold Standard for mAb Capture *271*
16.3.2 Polishing Process and Final Purification *272*
16.4 Virus Clearance in Biopharmaceutical Manufacturing *273*
16.4.1 Viral Inactivation and Clearance *273*
16.4.1.1 Viral Safety Assurance in Biopharmaceuticals *274*
16.4.1.2 Membrane-Based Nanofiltration for Virus Clearance *274*
16.4.1.3 Operational Considerations *274*
16.4.2 Regulatory and Validation Requirements *275*
16.5 Quality Control in Biopharmaceutical Manufacturing *275*
16.5.1 Ensuring Product Consistency and Safety Through Stringent QC Protocols *276*
16.5.2 Key Quality Control Tests in Biopharmaceuticals *276*
16.6 Conclusion: Future Innovations in Biopharmaceutical Manufacturing *277*
Problems *278*
References *279*

Appendix A Conversion Factors for Units *281*

Appendix B Solutions to the Problems *283*

Index *299*