### Verse

قال تعالى

صدق الله العظيم

سورة يوسف آية ر قم (76)

# **Dedication**

To my

Wife,

Son,

Parents,

Teachers,

Brothers and friends.

With gratitude and love .

# Acknowledgement

My faithful thanks and praise be to Allah for providing me strength to conduct this research. I would like to express my deep appreciation and sincere gratitude to my supervisor Dr.Ibrahim Hassan Elameen and my Co-supervisor Dr. Gurashi Abdalla Gasmelseed for their valuable guidance and supervision.

.Thanks are also due to my wife and son

Thanks are extended to everyone who assists me to make this study possible.

.Thanks are also due to international research center

#### **Abstract**

Experimental data for the equilibrium of the Nile blend crude was determined. The equilibrium data were correlated (using short cut methods) and an equilibrium model was constructed. This model coupled with a multicomponent material balance was used for the determination of the number of theoretical stages, stage .efficiency, and composition and temperature profiles

The work undertaken, lead to a novel design and a mathematical model of the columns that can separate multicomponent systems. Software was developed and might be used for research and development as well as at the stage of starting – up and shut down periods .A case study taking Distillation Column Units( CDU) of Khartoum Refinery was .studied and investigated

Three transfer functions around the condenser, the reboiler and the feed plate were determined. A software of MATLAB 7 was used to analys the system stability, these were . Nyquist diagram, Bode plot and Routh Hurwtz

Composition profile curves ,T-XY diagram as well as the equilibrium curves were determined using ASPEN PLUS software .for multicomponent systems

The transfer function's of the reboiler, condenser, and feed plate were obtained .From the transfer functions created Nyquist diagrams, Bode plots, were converted from Laplace domain to Z .domain, using MATLAB7 Software

X-Y profiles were determined using excel software. Also several variables were obtained for the products of multicompent .systems using ASPEN PLUS Software

Dimensions of the distillation column design were determined such as number of theoretical stages, number of actual stages, feed stage .location and efficiency

.A closed loop control strategy for the system was recommended

# ملخص الاطروحة

أعدت بيانات اتزان تجريبية لخام مزيج النيل. بيانات الاتزان تم ربطها وذلك باستخدام الطرق المبسطة وتم بناء نموزج اتزان النموزج ربط بموازنة مادة متعددة حيث استخدمت في حساب عدد الصحون النظرية وكفاءة الصينية والتراكيز ودرجات الحرارة الجانبية.

هذا العمل ي قود الى طريقة فى بناء نموزج رياضى لعمود يمكن استخدامه لفصل نظام متعدد.

قمنا باستخدام برامج فى هذا البحث من مرحلة البداية الى مرحلة السيانة ، حيث كانت دراسة الحالة لبرج التقطير المتعدد لمصفاة الخرطوم.

قمنا باعداد ثلاثة دوال انتقال حول المكثف،الغلاية وصينية التغذية و قمنا برسم مخطط نيكوست ومخطط بودى والتحويل من مجال لابلاس الى Z مجال وذلك باستخدام برنامج ماتلاب 7.

قمنا برسم مخطط للعلاقة بين تركيزالسائل والبخاروذك باستخدام برنامج اكسل وكذك قمنا بحسابات لمتغيرات عديدة لمنتجات التقطير المتعدد وذك باستخدام برنامج اسبن بلس.

ابعاد تصميم برج التقطير تم حسابها تمثلت في عدد الصواني النظرية والصواني الدخرية والصواني الدخرية والكفاءة. نوصى بنظام تحكم مغلق.

#### **Table of Contents**

Contents	Page Number
Verse	i
Dedication	ii
Acknowledgment	iii
Abstract English	iv
Abstract Arabic	vi
Table of Contents	vii
List of Tables	xii
List of Figures	xiii
(CHAPTER ONE(Introduction	1
Intoduction.1	2
1.1Crude oil distillation	2
1.2Vapor liquid equilibrium	3
1.3Dew points bubble points	4
Statement of the problem 1.4	5
5Distillation column designs .1	6
1.5.1Introduction	6
1.5.2Design calculations	6
Number of plates 1.5.3	7
Introduction to control 1.6	7
Background 1.6.1	7
Column schematic 1.6.2	9
Material balance and energy balance effects 1.6.3	9
Vapor and liquid dynamics 1.6.4	11
Entertainment 1.6.5	12
1.7Control of distillation columns	12
Introduction 1.7.1	12
Degrees of freedom analysis 1.7.2	13
Controlling pressure in distillation 1.7.3	14

Controlling tops composition in distillation 1.7.4	15
1.8Computer control loops	15
1.9Physical properties of feedstocks	15
Objectives 1.10	16
(CHAPTER TWO (Literature Review	17
Literature review.2	18
2.1Distillation	18
The basic distillation process 2.2	19
Types of distillation 2.3	20
Simple distillations 2.3.1	20
Fractional distillation 2.3.2	21
Steam distillation 2.3.3	24
Multicomponent distillation 2.3.4	25
Vacuum distillation 2.3.5	26
Azeoetrope distillation 2.3.6	26
Pressure - swing distillation 2.3.7	27
Short path distillation 2.3.8	28
Other types 4 .2	29
Modern distillation 5 .2	30
Fractional distillation of crude oil 6 .2	31
Boiling point principle 7 .2	32
Focus on fossil fuels 8 .2	33
Continuous distillation 2.9	35
The destructive distillation process 2.10	38
Distillation by retort 2.11	38
2.12Applications of distillation	39
2.13The idealized distillation model	40
The case of batch distillation 2.14	42
The case of continuous distillation 2.15	43
Distillation principles 2.16	43
2.17Basic definitions	43
2.17.1Mixture	43
2.17.2Vapor pressure	44
2.17.3The boiling point diagram	44
2.18Methods for boiling curve	45
2.18.1Equlibruim K-values	46
2.18.2Raoult's &Henry's law	47
2.18.3Relative volatility	48
2.19Vapor liquid equilibria	49

2.19.1Vapor liquid equilibrium curves	50
2.19.2Equlibrium data for multicomponent system	52
2.20Distillation column design	53
2.20.1McCabe Thiele method for number of stages	54
2.20.2Operating line for rectifying section	55
2.20.3Operating line for stripping section	56
2.20.4q - line or feed line	58
2.20.5Charactersitic of q- line or feed line	59
2.20.6Equlibrium & operating lines	60
2.20.7Construction of McCabe Thiele number of stages	61
2.21Extreme cases	62
2.21.1Total reflux	62
(2.21.2Minmum reflux ratio(Rmin	63
2.21.3What is optimum reflux	63
2.21.4Open steam or direct steam	64
2.21.5Side streams	65
Types of distillation column 2.22	66
2.22.1Batch column	67
2.22.2Continuous columns	67
Types of continuous columns 2.23	67
2.24Basic distillation equipment & operation	69
2.24.1Main components of distillation columns	69
2.24.2Basic operation & terminology	70
2.25Column internals	71
2.25.1Tray & plates	71
Liquid and vapor flows in a tray column 2.26	73
2.27Tray designs	75
Column reboilers 2.28	75
Overall column design 2.29	76
The tower height &plate spacing 2.29.1	77
2.29.2Column diameter design	77
2.29.3Plate efficiency	78
2.29.4Condenser & re boiler duty	79
2.30Factore affecting distillation column operation	81
2.30.1Feed conditions	82
2.30.2Reflux conditions	82
2.30.3Vapor flow conditions	83
2.30.4Cloumn diameter	84
2.30.5State of trays & packings	84

2.30.6Weather conditions	85
2.31Control theory	85
Overview 2.32	86
An example 2.33	86
Closed loop transfer function 2.34	87
PID Controller 2.35	89
2.36Modern control theory	90
Stability 2.37	91
2.38System classifications	94
2.39Main control strategies	95
2.40Digital controller implementation	96
2.41Control systems intro-components of digt.con.loop	97
2.42Desgin of digital controller in s – domain	98
Real - time control 2.43	99
2.44Z – transform	100
Transfer function 2.45	100
Zeros and poles 2.46	101
Output response 2.47	102
Continuous signal 2.48	102
Discreet signal 2.49	104
acquisition 2.50	104
Digital signal 2.51	105
Introduction to aspen plus 2.52	105
Simulation 2.53	107
(CHAPTER THREE(Models formulation and solution	109
3.1Apparatus	110
Sensors 3.1.1	110
Temperature 3.1.2	110
Pressure 3.1.3	110
3.2Distillation control strategies	111
3.2.1Cascade control in distillation	112
3.3Development of transfer function	112
3.3.1Transfer function	112
3.3.1.1Reboiler transfer function	113
3.3.1.2Condenser transfer function	114
3.3.1.3Feed plate transfer function	115
3.4Vapor liquid equilibrium	116
3.5VLE data introduction	117
.Thermodynamic description of vapor liquid equilibrium 3.6	118

Pure systems 3.7	119
3.8Multicomponent systems	120
3.9Boling point diagrams	120
K values and relative volatility values 3.10	123
Vapor liquid equilibrium diagrams 3.11	124
(CHAPTER FOUR(Results and Discussion	126
Distillation column designs 4.1	127
Introduction 4.1.1	127
Design calculations 4.1.2	127
Number of plates 4.1.3	127
Plate design by 4.1.4	128
4.2Dew point &bubble point	142
Basis for distillation control strategies 4.3	146
Control of $x_D$ or $x_B$ for upsets in F 4.3.1	146
Control of $x_D$ or $x_B$ for upsets in $x_F$ 4.3.2	147
3.3Control of $x_D$ or $x_B$ for upsets in F4.	147
Control of $x_D$ or $x_B$ for upsets in $x_F$ 4.3.4	147
4.4Transfer function results	148
4.4.1Reboiler transfer function	148
Result convert to discrete or digital scheme 4.4.1.1	148
Result Z – Plane 4.4.1.2	149
Result Nyquist Diagrams 4.4.1.3	150
Result Bode Plots 4.4.1.4	151
4.4.2Condenser transfer function	151
Result convert to discrete or digital scheme 4.4.2.1	151
Result Z – plane 4.4.2.2	152
Result Nyquist Diagrams 4.4.2.3	153
Result Bode Plots 4.4.2.4	154
4.4.3Feed plate transfer function	154
Result convert to discrete or digital scheme 4.4.3.11	154
Result Z – plane 4.4.3.2	155
Result Nyquist Diagrams 4.4.3.3	156
Result Bode Plots 4.4.3.4	157
4.5Nyquist plot using Mat lab	158
4.6Multicomponent distillation in aspen plus	159-163
(CHAPTER FIVE(Conclusion & Recommendations	164
Conclusion 5.1	165
Recommendations5.2	165
REFERENCES	166

Nomenclature	170
APPENDIX	172

### **List of Tables**

Title	Page Number
Table(2.1) Boiling Points Of Alkenes	33
Table (4.1)percentage of the products	128
Table(4.2)products flow rates	129
Table(4.3) The result of estimation	130
Table(4.4)pressure &temperature estimation	131
Table(4.5)component vapor pressures	131
Table(4.6)Volatilities percentage	131
Table (4.7) Theta values	133
Table(4.8)Summary of design parameters	141
Table(4.9)Summary of actual design parameters	142
Table(4.10) Antoine coefficient	143
Table (4.11) Pi,ki,fi,xi and yi at constant pressure	143
Table(4.12) Antoine coefficient	144
Table (4.13) Pi,ki,fi,xi and yi at constant pressure	144

## **List of Figures**

Title	Page Number
Fig. (1.1) Temperature composition diagrams	4
Figure 1 - Degrees of Freedom Analysis of Distillation Column	13
Fig. (2.1) Laboratory set-up for steam distillation	24
Fig. (2.2) short path vacuum distillation apparatus	28
Fig. (2.3)fractional distillation set up	35
Fig. (2.4) Diagram of a typical industrial distillation tower	36
Fig. (2.5) Section of an industrial distillation tower showing	37
detail of trays with bubble caps	
Fig.(2.6)Boiling point diagram	44
Fig. (2.7) K-Factor	46
	48
Fig. (2.8) Equilibrium curve	
Fig. (2.9)Vapor liquid equilibria	49
Fig.(2.10)Vapor liquid equilibrium curves	50
Fig. (2.11)A zoetrope distillation & extractive distillation	51
Fig. (2.12)Maximum & minimum boiling point	52
Fig. (2.13) Flash model	52
Fig. (2.14)Rectification section	54
Fig. (2.15)Operating line for rectification section	55
Fig.(2.16)Stripping section	56
Fig. (2.17)Operating line for stripping section	57
Fig. (2.18)q-line	58
Fig. (2.19)Characteristics of q- line	59
Fig. (2.20)Operating lines , q- line intersect at single point	60
Figure: (2.21)Number of steps	60
Fig. (2.22) Construction of McCabe-Thiele number of stages	62
Fig. (2.23) Total Reflux	53
Figure: (2.24) Optimum Reflux	64
Fig.(2.25) Open steam or direct steam	64
Fig.(2.26) Side streams	65

Fig. (2.27) Side streams66Fig. (2.28) Batch distillation67Fig. (2.29) Continuous distillation67Fig. (2.30) Flash distillation68	
Fig. (2.29) Continuous distillation 67	
Fig. (2.30) Flash distillation	
Fig. (2.31) Basic Operation and Terminology 70	
Fig. (2.32) Bubble cab 71	
Fig. (2.33)valve trays 72	
Fig.(2.34)sieve trays 72	
(Fig.(2.35) Distillation column(bubble cab 73	
74	
Fig.(2.36) Down comer	
Fig. (2.37) Column Re boilers 75	
Fig. (2.38) Column Re boilers 76	
Fig. (2.39) Re boiler 79	
Fig. (2.40)Accumulator 80	
Fig. (2.41) Feed Conditions 82	
Fig.(2.42) Control theory 85	
Fig.(2.43) Closed-loop transfer function 88	
Fig.(2.44) Components of a Digital Control Loop 97	
Fig.(2.45)Discrete sampled signal	
Fig.(2.46)Digital signal	
Fig.(3.1) Schematic Diagram of distillation control	
Fig.( 3.2)cascade control systems	
Fig.(3.3)Boiling Point Diagram	
Fig.(3.4)Vapor-Liquid Equilibrium Diagram 124	
Fig.(4.1)Schematic diagram of conditions on slotted valve tray 136	
Fig.(4.2) Cross Sectional view in slotted valve tray tower 138	
Fig. (4.3) Zone of satisfactory operation for plate columns 140	
Fig.(4.4) x,y profiles	
Fig.(4.5)temperature vs. tray	
Fig.(4.6) Z – Plane 149	
Fig.(4.7) Nyquist Diagrams 150	
Fig.(4.8) Bode Plots	
Fig.(4.9) Z – plane 152	
Fig.(4.10) Nyquist Diagrams 153	
Fig.(4.11) Bode Plots	
Fig.(4.12) Z – plane 155	
0·( ··) =   F	

Fig.(4.14)Body plots	157
Multicomponent distillation results	159-163