

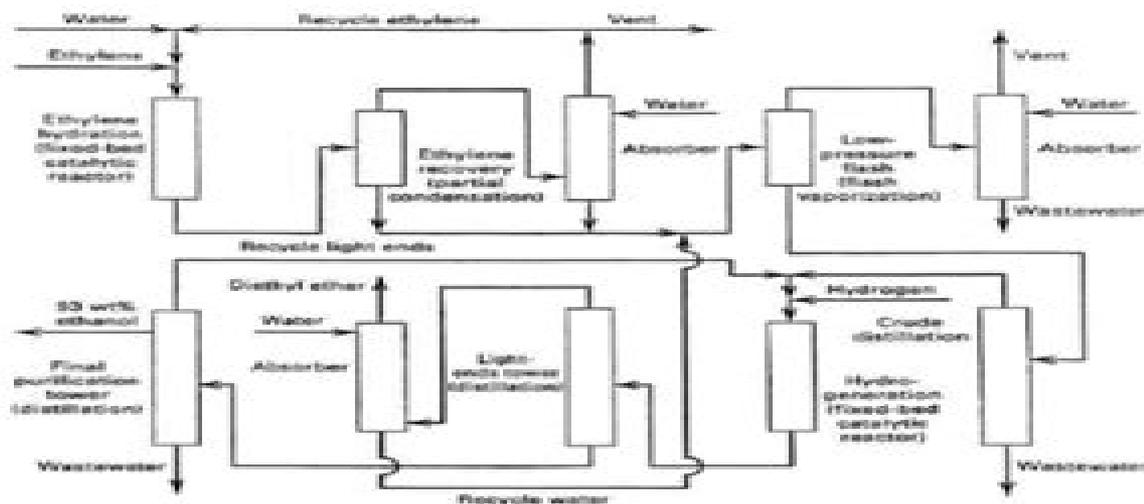
## Exercise 1.1

**Subject:** Separation operations in an ethanol process.

**Given:** Flow sheet for the process.

**Find:** Operation in each block of the process

**Analysis:** The flow sheet is as follows:



Starting from the left side of the top row, number the equipment blocks 1-5. On the next row, number them from right to left as 6-10.

1. The feed to the reactor contains ethylene, propylene, and water. The very incomplete reaction effluent of gas contains, in addition: ethyl alcohol, diethyl ether, acetaldehyde, and isopropyl alcohol.
2. Most of the chemicals, except most of the ethylene, are condensed and sent to item 4. The remaining gas is sent to 3.
3. The ethylene is recovered from the small quantity of other chemicals in the absorber. Most of the ethylene is recycled to 1. The water and other chemicals are sent to 4.
4. Remaining ethylene is flashed off and sent to 5. The liquid contains most of the hydrocarbons and is sent to 6.

# Separation Process Principles 3rd Edition Solution Manual

**Cary Judson King**



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### **Table of Contents Separation Process Principles 3rd Edition Solution Manual**

1. Understanding the eBook Separation Process Principles 3rd Edition Solution Manual
  - The Rise of Digital Reading Separation Process Principles 3rd Edition Solution Manual
  - Advantages of eBooks Over Traditional Books
2. Identifying Separation Process Principles 3rd Edition Solution Manual
  - Exploring Different Genres
  - Considering Fiction vs. Non-Fiction
  - Determining Your Reading Goals
3. Choosing the Right eBook Platform
  - Popular eBook Platforms
  - Features to Look for in an Separation Process Principles 3rd Edition Solution Manual
  - User-Friendly Interface

4. Exploring eBook Recommendations from Separation Process Principles 3rd Edition Solution Manual
  - Personalized Recommendations
  - Separation Process Principles 3rd Edition Solution Manual User Reviews and Ratings
  - Separation Process Principles 3rd Edition Solution Manual and Bestseller Lists
5. Accessing Separation Process Principles 3rd Edition Solution Manual Free and Paid eBooks
  - Separation Process Principles 3rd Edition Solution Manual Public Domain eBooks
  - Separation Process Principles 3rd Edition Solution Manual eBook Subscription Services
  - Separation Process Principles 3rd Edition Solution Manual Budget-Friendly Options
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  - ePub, PDF, MOBI, and More
  - Separation Process Principles 3rd Edition Solution Manual Compatibility with Devices
  - Separation Process Principles 3rd Edition Solution Manual Enhanced eBook Features
7. Enhancing Your Reading Experience
  - Adjustable Fonts and Text Sizes of Separation Process Principles 3rd Edition Solution Manual
  - Highlighting and Note-Taking Separation Process Principles 3rd Edition Solution Manual
  - Interactive Elements Separation Process Principles 3rd Edition Solution Manual
8. Staying Engaged with Separation Process Principles 3rd Edition Solution Manual
  - Joining Online Reading Communities
  - Participating in Virtual Book Clubs
  - Following Authors and Publishers Separation Process Principles 3rd Edition Solution Manual
9. Balancing eBooks and Physical Books Separation Process Principles 3rd Edition Solution Manual
  - Benefits of a Digital Library
  - Creating a Diverse Reading Collection Separation Process Principles 3rd Edition Solution Manual
10. Overcoming Reading Challenges
  - Dealing with Digital Eye Strain
  - Minimizing Distractions
  - Managing Screen Time
11. Cultivating a Reading Routine Separation Process Principles 3rd Edition Solution Manual
  - Setting Reading Goals Separation Process Principles 3rd Edition Solution Manual
  - Carving Out Dedicated Reading Time

12. Sourcing Reliable Information of Separation Process Principles 3rd Edition Solution Manual
  - Fact-Checking eBook Content of Separation Process Principles 3rd Edition Solution Manual
  - Distinguishing Credible Sources
13. Promoting Lifelong Learning
  - Utilizing eBooks for Skill Development
  - Exploring Educational eBooks
14. Embracing eBook Trends
  - Integration of Multimedia Elements
  - Interactive and Gamified eBooks

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