

Introduction

1 Introduction 1

R. Ditz

- 1.1 Liquid Chromatography – its History 1**
- 1.2 Focus of the Book 4**
- 1.3 How to Read this Book 6**

2 Fundamentals and General Terminology 9

M. Schulte, A. Epping

- 2.1 Principles of Adsorption Chromatography 9**
- 2.1.1 Adsorption Process 10**
- 2.1.2 Chromatographic Process 12**
- 2.2 Basic Effects and Chromatographic Definitions 13**
- 2.2.1 Chromatograms and their Parameters 13**
- 2.2.2 Voidage and Porosity 15**
- 2.2.3 Influence of Adsorption Isotherms on the Chromatogram 18**
- 2.3 Fluid Dynamics 20**
- 2.3.1 Extra Column Effects 21**
- 2.3.2 Column Fluid Distribution 21**
- 2.3.3 Packing Non-idealities 22**
- 2.3.4 Sources for Non-ideal Fluid Distribution 22**
- 2.4 Mass Transfer Phenomena 23**
- 2.4.1 Principles of Mass Transfer 23**
- 2.4.2 Efficiency of Chromatographic Separations 25**
- 2.4.3 Resolution 28**
- 2.5 Equilibrium Thermodynamics 32**
- 2.5.1 Definition of Isotherms 32**
- 2.5.2 Models of Isotherms 33**
- 2.5.2.1 Single-component Isotherms 34**
- 2.5.2.2 Multi-component Isotherms 36**
- 2.5.2.3 Ideal Adsorbed Solution (IAS) Theory 37**
- 2.6 Thermodynamic Effects on Mass Separation 41**
- 2.6.1 Mass Load 41**
- 2.6.2 Linear and Nonlinear Isotherms 41**
- 2.6.3 Elution Modes 46**

2.7	Practical Aspects of Parameter Determination	47
2.7.1	Linearized Chromatography	48
2.7.2	Nonlinear Chromatography	49
3	Columns, Packings and Stationary Phases	51
	<i>K. K. Unger, C. du Fresne von Hohenesche, M. Schulte</i>	
3.1	Column Design	51
3.1.1	Column Hardware and Dimensions	51
3.1.2	Columns with Particles (Particulate Column Beds)	54
3.1.3	Columns with a Continuous Bed (Monolithic Columns)	55
3.1.4	Column Pressure Drop	56
3.1.5	Frit Design	57
3.2	Column Packings	62
3.2.1	Survey of Packings and Stationary Phases	62
3.2.2	Generic, Designed and Tailored Adsorbents	63
3.2.2.1	Generic Adsorbents	63
3.2.2.2	Tailored Adsorbents	66
3.2.2.3	Designed Adsorbents	66
3.2.3	Reversed Phase Silicas	67
3.2.3.1	Silanisation of the Silica Surface	68
3.2.3.2	Reversed Phase Packings with Polymer Coatings (Types of Polymer Coatings)	72
3.2.3.3	Physico-chemical Properties of Reversed Phase Silicas	74
3.2.3.4	Chromatographic Characterization of Reversed Phase Silicas	76
3.2.4	Cross-linked Organic Polymers	78
3.2.4.1	General Aspects	79
3.2.4.2	Hydrophobic Polymer Stationary Phases	82
3.2.5	Chiral Stationary Phases	83
3.2.6	Properties of Packings and their Relevance to Chromatographic Performance	86
3.2.6.1	Chemical and Physical Bulk Properties	87
3.3	Column Packing Technology	93
3.3.1	Characterization of the Column Bed Structure	95
3.3.2	Assessment of Column Performance	96
3.4	Column Testing	97
3.4.1	Test Systems	97
3.4.2	Hydrodynamic Properties and Column Efficiency	98
3.4.3	Mass Loadability	99
3.4.4	Comparative Rating of Columns	100
3.5	Column Maintenance and Regeneration	101
3.5.1	Cleaning in Place (CIP)	101
3.5.2	Conditioning of Silica Surfaces	103
3.5.3	Sanitization in Place (SIP)	104
3.5.4	Column and Adsorbent Storage	105

3.6 Guidelines for Choosing Chromatographic Columns and Stationary Phases 105

4 Selection of Chromatographic Systems 107

W. Wewers, J. Dingenen, M. Schulte, J. Kinkel

4.1 Definition of the Task 110

4.2 Properties of Chromatographic Systems 114

4.2.1 Mobile Phases for Liquid Chromatography 114

4.2.1.1 Stability 117

4.2.1.2 Safety Concerns 117

4.2.1.3 Operating Conditions 117

4.2.2 Adsorbent and Phase System 120

4.2.2.1 Normal Phase System 121

4.2.2.2 Reversed Phase Chromatography 122

4.3 Criteria for Choice of Chromatographic Systems 124

4.3.1 Choice of Phase System Dependent on Solubility 125

4.3.1.1 Improving Loadability for Poor Solubilities 127

4.3.1.2 Dependency of Solubility on Sample Purity 129

4.3.1.3 Generic Gradients for Fast Separations 130

4.3.2 Criteria for Choice of NP Systems 130

4.3.2.1 Pilot Technique Thin-layer Chromatography 131

4.3.2.2 Retention in NP Systems 131

4.3.2.3 Solvent Strength in Liquid–Solid Chromatography 133

4.3.2.4 Selectivity in NP Systems 136

4.3.2.5 Mobile Phase Optimization by TLC Following the PRISMA Model 136

4.3.2.6 Strategy for an Industrial Preparative Chromatography Laboratory 145

4.3.3 Criteria for Choosing RP Systems 150

4.3.3.1 Retention and Selectivity in RP Systems 150

4.3.3.2 Gradient Elution for Small amounts of Product on RP Materials 152

4.3.3.3 Rigorous Optimization for Isocratic Runs 154

4.3.3.4 Rigorous Optimization for Gradient Runs 156

4.3.3.5 Practical Recommendations 160

4.3.4 Criteria for Choosing CSP Systems 162

4.3.4.1 Suitability of Preparative CSP 162

4.3.4.2 Development of Enantioselectivity 163

4.3.4.3 Optimization of Separation Conditions 165

4.3.4.4 Practical Recommendations 166

4.3.5 Conflicts During Optimization of Chromatographic Systems 168

5 Process Concepts 173

M. Schulte, K. Wekenborg, W. Wewers

5.1 Design and Operation of Equipment 173

5.1.1 Solvent and Sample Delivery System 175

5.1.1.1 HPLC Pumps 175

5.1.1.2 Gradient Formation 175

5.1.1.3	Eluent Degassing	176
5.1.1.4	Eluent Reservoir	176
5.1.1.5	Sample Injection	177
5.1.2	Chromatographic Column	177
5.1.3	Detection and Separation System	177
5.1.3.1	Solvent-sensitive Detectors	181
5.1.3.2	Fraction Collection	182
5.2	Discontinuous Processes	183
5.2.1	Isocratic Operation	183
5.2.2	Flip-flop Chromatography	184
5.2.3	Closed-loop Recycling Chromatography	185
5.2.4	Steady State Recycling Chromatography	187
5.2.5	Gradient Chromatography	188
5.3	Continuous Processes	190
5.3.1	Column Switching Chromatography	190
5.3.2	Annular Chromatography	190
5.3.3	Multiport Switching Valve Chromatography (ISEP/CSEP)	191
5.3.4	Simulated Moving Bed (SMB) Chromatography	193
5.3.5	SMB Chromatography with Variable Conditions	197
5.3.5.1	VariCol	197
5.3.5.2	PowerFeed	199
5.3.5.3	Partial feed	199
5.3.5.4	ISMB	200
5.3.5.5	ModiCon	201
5.3.6	Gradient SMB Chromatography	201
5.3.6.1	Solvent-gradient SMB Chromatography	201
5.3.6.2	Supercritical Fluid SMB Chromatography	202
5.3.6.3	Temperature gradient SMB Chromatography	203
5.4	Guidelines	204
5.4.1	Scale	204
5.4.2	Range of k'	205
5.4.3	Number of Fractions	206
5.4.4	Example 1: Lab Scale; Two Fractions	206
5.4.5	Example 2: Lab Scale; Three or More Fractions	206
5.4.6	Example 3: Production Scale; Wide Range of k'	209
5.4.7	Example 4: Production Scale; Two Main Fractions	210
5.4.8	Example 5: Production Scale; Three Fractions	211
5.4.9	Example 6: Production Scale; Multi-stage Process	213
6	Modeling and Determination of Model Parameters	215
	<i>M. Michel, A. Epping, A. Jupke</i>	
6.1	Introduction	215
6.2	Models for Single Chromatographic Columns	216
6.2.1	Classes of Chromatographic Models	216
6.2.2	Derivation of the Mass Balance Equations	217

6.2.2.1	Mass Balance Equations	218
6.2.2.2	Convective Transport	221
6.2.2.3	Axial Dispersion	222
6.2.2.4	Intraparticle Diffusion	222
6.2.2.5	Mass Transfer	222
6.2.2.6	Adsorption Kinetics	224
6.2.2.7	Adsorption Equilibrium	224
6.2.3	Ideal Equilibrium Model	226
6.2.4	Models with One Band-broadening Effect	229
6.2.4.1	Equilibrium Dispersive Model	230
6.2.4.2	Transport Model	232
6.2.4.3	Reaction Model	233
6.2.5	Lumped Rate Models	233
6.2.5.1	Transport Dispersive Model	234
6.2.5.2	Reaction Dispersive Model	235
6.2.6	General Rate Models	235
6.2.7	Initial and Boundary Conditions of the Column	238
6.2.8	Stage Models	239
6.2.9	Assessment of Different Model Approaches	240
6.2.10	Dimensionless Model Equations	242
6.3	Modeling HPLC Plants	244
6.3.1	Experimental Set-up and Simulation Flowsheet	244
6.3.2	Modeling Extra Column Equipment	246
6.3.2.1	Injection System	246
6.3.2.2	Piping	246
6.3.2.3	Detector	246
6.4	Numerical methods	247
6.4.1	General Solution Procedure	247
6.4.2	Discretization	248
6.5	Parameter Determination	251
6.5.1	Parameter Classes for Chromatographic Separations	251
6.5.1.1	Design Parameters	251
6.5.1.2	Operating Parameters	252
6.5.1.3	Model Parameters	252
6.5.2	Determination of Model Parameters	253
6.5.3	Evaluation of Chromatograms	255
6.5.3.1	Moment Analysis and HETP Plot	257
6.5.3.2	Parameter Estimation	263
6.5.3.3	Peak Fitting Functions	265
6.5.4	Detector Calibration	268
6.5.5	Plant Parameters	269
6.5.6	Determination of Packing Parameters	271
6.5.6.1	Void Fraction and Porosity of the Packing	271
6.5.6.2	Axial Dispersion	271
6.5.6.3	Pressure Drop	273

6.5.7 Isotherms	273
6.5.7.1 Determination of Adsorption Isotherms	273
6.5.7.2 Determination of the Henry Coefficient	276
6.5.7.3 Static Methods	277
6.5.7.4 Dynamic Methods	278
6.5.7.5 Frontal Analysis	278
6.5.7.6 Analysis of Disperse Fronts (ECP/FACP)	283
6.5.7.7 Peak-maximum Method	285
6.5.7.8 Minor Disturbance/Perturbation Method	285
6.5.7.9 Curve Fitting of the Chromatogram	288
6.5.7.10 Calculation of Mixture Behavior from Single Component Data	288
6.5.7.11 Data Analysis and Accuracy	289
6.5.8 Mass Transfer	291
6.6 Validation of Column Models	292
6.7 Modeling of SMB Processes	297
6.7.1 Process Principle	297
6.7.2 SMB Process Models	299
6.7.3 TMB Model	301
6.7.4 Comparison between TMB and SMB model	302
6.7.5 Process and Operating Parameters	304
6.7.6 Experimental validation	304
6.7.6.1 Introduction	304
6.7.6.2 Results	307

7 Model Based Design and Optimization	313
<i>A. Susanto, K. Wekenborg, A. Epping, A. Jupke</i>	
7.1 Basic Principles	314
7.1.1 Objective Functions	314
7.1.1.1 Characterization of Process Performance	314
7.1.1.2 Total Separation Cost	316
7.1.2 Degrees of Freedom	317
7.1.2.1 Classification of Optimization Parameters	317
7.1.2.2 Dimensionless Representation of Operating and Design Parameters	318
7.1.3 Scaling Up and Down	322
7.1.3.1 Influence of Different HETP Coefficients for Every Component	323
7.1.3.2 Influence of Feed Concentration	324
7.1.3.3 Examples for a Single Batch Chromatographic Column	325
7.1.3.4 Examples for SMB Processes	329
7.2 Batch chromatography	330
7.2.1 Fractionation Mode (Cut Strategy)	330
7.2.2 Design and Optimization Strategy for Batch Chromatographic Column	331
7.2.3 Process Performance Depending on Number of Stages and Loading Factor	335
7.2.4 Design and Optimization Strategies from Other Authors	341

7.3	SMB Chromatography	344
7.3.1	Optimization of Operating Parameters	345
7.3.1.1	Process Design Based on TMB Models (Short-cut Methods)	346
7.3.1.2	Process Design Based on SMB Models	354
7.3.2	Optimization of Design Parameters	360
7.4	Comparison of Batch and SMB Chromatography	366
8	Chromatographic Reactors	371
	<i>T. Borren, J. Fricke</i>	
8.1	Introduction	371
8.2	Types of Chromatographic Reactors	372
8.2.1	Chromatographic Batch Reactor	372
8.2.2	Continuous Annular Reactors	373
8.2.3	Counter-current Chromatographic Reactors	374
8.2.3.1	True Moving Bed Reactor	374
8.2.3.2	Simulated Moving Bed Reactor	375
8.2.3.3	Hashimoto Process	377
8.3	Modeling of Chromatographic Reactors	378
8.3.1	Models of Chromatographic Batch Reactors	378
8.3.2	Models of Continuous Annular Chromatographic Reactors	380
8.3.3	Models of Counter-Current Chromatographic Reactors	380
8.3.3.1	SMBR Model	382
8.3.3.2	Ideal TMBR Model	382
8.3.3.3	Comparison of Modeling Approaches	384
8.3.4	Determination of the Model Parameters	384
8.4	Operation and Design of Chromatographic Reactors	385
8.4.1	Choice of the Process Conditions for Chromatographic Reactors	385
8.4.2	Operating Conditions of Batch Reactors	385
8.4.3	Operating Conditions of SMB Reactors	387
8.4.3.1	Deduction of the Design Criteria	387
8.4.3.2	Application of Design Criteria	391
8.5	Design Examples	392
8.5.1	Esterification of β -Phenethyl Alcohol with Acetic Acid	393
8.5.2	Isomerization of Glucose	395
9	Advanced Control of Simulated Moving Bed Processes	401
	<i>A. Toumi, S. Engell</i>	
9.1	Introduction	401
9.2	Model Predictive Control	402
9.3	State-of-the-art in Control of SMB Processes	404
9.4	Online Optimizing Control of a Reactive Simulated Moving Bed Process	406
9.4.1	Process Description	406
9.4.2	Formulation of the Online Optimizing Controller	407
9.4.3	Simulation Study	409

9.4.4 Experimental Study 411

9.5 Conclusions 416

Outlook 417

References 421

Appendix A 435

A1 Scale-up Factors Between Different Columns 435

A1.1 Example Determination of the Scale-up Factor 435

A.2 Standard Operating Procedures for Column Packing 435

Appendix B: Data of Test Systems 443

B.1 EMD53986 443

B.2 Tröger's Base 445

B.3 Glucose and Fructose 447

B.4 β -Phenethyl Acetate 449

Index 435