

CONTENTS

	Page
Preface	v
1 INTRODUCTION	1
1.1 Overall Refinery Flow	2
2. REFINERY PRODUCTS	5
2.1 Low-Boiling Products	6
2.2 Gasoline	8
2.3 Gasoline Specifications	10
2.4 Distillate Fuels	11
2.5 Jet Fuel	12
2.6 Automotive Diesel Fuels	13
2.7 Railroad Diesel Fuels	13
2.8 Heating Oils	13
2.9 Residual Fuel Oils	14
Notes	14
3. REFINERY FEEDSTOCKS	16
3.1 Crude Oil Properties	17
3.2 Composition of Petroleum	19
3.3 Crudes Suitable for Asphalt Manufacture	22
3.4 Crude Distillation curves	23
Problems	29
Notes	30
4. CRUDE DISTILLATION	31
4.1 Atmospheric topping Unit	31
4.2 Vacuum Distillation	42
4.3 Auxiliary Equipment	44
4.4 Crude Distillation Unit Products	45
4.5 Case-Study Problems : crude Units	46
4.6 Statement of the Problem	47
4.7 General Procedure	47
Problems	50
Notes	51
5. DELAYED COKING	52
5.1 Process Description	53
5.2 Coke Removal	54
5.3 Properties and Uses of Petroleum Coke	55
5.4 Operation	56
5.5 Yields from Delayed Coking	57
5.6 Case-Study Problem : Delayed Coker	61
Problems	63
Notes	64
6. CATALYTIC REFORMING AND ISOMERIZATION	65
6.1 Feed Preparation	70
6.2 Catalytic Reforming Processes	70
6.3 Reforming Catalyst	74
6.4 Reactor Design	74

6.5	Yields and Costs	75
6.6	Isomerization	75
6.7	Capital and Operating Costs	79
6.8	Isomerization Yields and Costs	79
6.9	Case – Study Problem : Naphtha Hydrotreater and Catalytic Reforming	81
	Problems	84
	Notes	85
7.	CATALYTIC CRACKING	86
7.1	Fluidized-Bed Catalytic Cracking	87
7.2	Moving-Bed Catalytic Cracking	90
7.3	Cracking Reactions	95
7.4	Cracking of Paraffins	96
7.5	Olefin Cracking	97
7.6	Cracking of naphthenic Hydrocarbons	97
7.7	Aromatic hydrocarbon Cracking	97
7.8	Cracking Catalysts	97
7.9	Process Variables	98
7.10	Heat Recovery	100
7.11	Yield Estimation	100
7.12	Capital and Operating Costs	108
7.13	Case-Study Problem : Catalytic Cracker	108
	Problems	112
	Notes	112
8.	HYDROTREATING	114
8.1	Hydrotreating Catalysts	114
8.2	Reactions	116
8.3	Process Variables	117
8.4	Construction and Operating Costs	117
	Problems	118
	Notes	120
9.	CATALYTIC HYDROCRACKING	121
9.1	Hydrocracking Reactions	122
9.2	Feed Preparation	124
9.3	The Hydrocracking Process	125
9.4	Hydrocracking Catalyst	126
9.5	Moving-Bed Hydrocracking Processes	128
9.6	Process Variables	130
9.7	Hydrocracking Yields	131
9.8	Investment and Operating Costs	137
9.9	Case-Study Problem : Hydrocracker	139
	Problems	140
	Notes	140
10.	ALKYLATION	142
10.1	Alkylation Reactions	142
10.2	Process Variables	144
10.3	Alkylation Feedstocks	146
10.4	Alkylation Products	146
10.5	Catalysts	147
10.6	Hydrofluoric Acid Processes	148
10.7	Sulfuric Acid Alkylation Processes	151
10.8	Comparison of Processes	154
10.9	Alkylation Yields and Costs	156
10.10	Case-Study Problem : Alkylation	159
	Problems	160
	Notes	161

11.	PRODUCT BLENDING	162
11.1	Reid Vapor Pressure (RVP)	163
11.2	Octane Blending	167
11.3	Blending for Other Properties	169
11.4	Case-Study Problem : Gasoline Blending	170
	Problems	177
	Notes	178
12.	SUPPORTING PROCESSES	179
12.1	Hydrogen Manufacture	179
12.2	Gas Processing Unit	182
12.3	Acid Gas Removal	185
12.4	Sulfur Recovery Processes	190
12.5	Ecological Considerations in Petroleum Refining	198
12.6	Control of Atmospheric Pollution from Refineries	199
12.7	Control of Noise Level in Refineries	200
12.8	Case-Study Problems: Gas Recovery Unit, Amine Unit, and Sulfur Recovery unit	200
12.9	Cast-Study Problem: Hydrogen Unit	202
12.10	efinery Gas Processing unit	202
12.11	Amine Gas Treating Unit	203
12.12	Sulfur Recovery Plant	204
	Problems	205
	Notes	206
13.	COST ESTIMATION	207
13.1	Rule-of-Thumb Estimates	207
13.2	Cost-Curve Estimates	208
13.3	Major Equipment Factor Estimates	208
13.4	Definitive Estimates	209
13.5	Summary form for Cost Estimates	209
13.6	Storage Facilities	209
13.7	Land and Storage Requirements	210
13.8	Steam Systems	211
13.9	Cooling Water Systems	211
13.10	Other Utility Systems	211
13.11	Application of Estimation Techniques	214
13.12	Statement of Problem	214
	Notes	226
14.	ECONOMIC EVALUATION	228
14.1	Definitions	228
14.2	Return on Original Investment	229
14.3	Payout Time	230
14.4	Discounted Cash Flow Rate of Return	230
14.5	Case-Study Problem: Economic Evaluation	233
14.6	Case-Study Problem : Economic Solution	238
	Problems	240
	Notes	240
APPENDIXES		
A	Definitions of Refining Terms	243
B	Physical Properties	255
C	Catalyst Costs	267
D	U.S. Bureau of Mines Routine Analyses of Selected Crude Oils	271
E	Economic Evaluation Example Problem	287
F	Photographs	293
G	Yield and Cost Data Figures	307
	Index	361