

(19) **DANMARK**



Patent- og
Varemærkestyrelsen

(10) **DK/EP 2496515 T3**

(12) **Oversættelse af
europæisk patentskrift**

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- (51) Int.Cl.: **B 81 B 1/00 (2006.01)** **B 01 J 19/30 (2006.01)**
- (45) Oversættelsen bekendtgjort den: **2020-10-12**
- (80) Dato for Den Europæiske Patentmyndigheds
bekendtgørelse om meddelelse af patentet: **2020-08-12**
- (86) Europæisk ansøgning nr.: **10829199.8**
- (86) Europæisk indleveringsdag: **2010-11-05**
- (87) Den europæiske ansøgnings publiceringsdag: **2012-09-12**
- (86) International ansøgning nr.: **US2010055733**
- (87) Internationalt publikationsnr.: **WO2011057150**
- (30) Prioritet: **2009-11-06 US 258741 P**
- (84) Designerede stater: **AL AT BE BG CH CY CZ DE DK EE ES FI FR GB GR HR HU IE IS IT LI LT LU LV
MC MK MT NL NO PL PT RO RS SE SI SK SM TR**
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- (54) Benævnelse: **MIKROFIBERMATERIALE TIL OPTIMERING OG KONTROL AF STÆRKT EKSOTERME OG
STÆRKT ENDOTERME REAKTIONER/PROCESSER**
- (56) Fremdragne publikationer:
**EP-A1- 1 029 590
US-A- 5 102 745
US-A- 5 293 742
US-A1- 2002 068 026
US-A1- 2004 150 122
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DESCRIPTION

FIELD OF THE INVENTION

[0001] The invention relates to a packed vessel that is able to be used to carry out highly exothermic or highly endothermic reactions or processes that utilize fine temperature control.

BACKGROUND OF THE INVENTION

[0002] Exothermic reactions and processes such as Fischer-Tropsch, and methanol formation from syngas, ethylene oxidation, maleic anhydride, phthalic anhydride, formaldehyde, acrylonitrile, acrylic acid, 1,2-dichloroethane, vinyl chloride, air compression, concentrated acid dilution, vapor condensation and others are strongly exothermic. Endothermic reactions and processes such as steam methane reforming and evaporation and others are strongly endothermic. Efficient heat transfer from/to reaction zone is required to improve the product selectivity, catalyst life and operational safety. A well-known reactor, the multi-tube reactor in a tube-and-shell configuration, has been used for highly exothermic or highly endothermic reactions. It is similar to a tube-and-shell heat exchanger, as shown in European patent No. 0,308,034. It consists of a number of thin tubes (usually less than 2 inches) in which catalyst particles are filled. These tubes are surrounded by cooling fluids, which pass through the shell side of the heat-exchanger-like reactor. Due to the high surface to volume ratio of the thin tubes, efficient heat exchange is able to be achieved. However, this design faced severe scale-up issues. At a larger scale, more thin tubes are required. The increasing part count makes the manufacture of such types of reactors very difficult and expensive, especially at large scales.

[0003] There were reactor designs that allow heating or cooling fluids passing through the tube side, and catalyst particles filled within space between shell and tubes. These designs are able to simply solve the scale-up issue of multi-tubular reactors, however, at the cost of heat exchanging efficiency. In this design family, different types of geometries of tubes have been used to improve heat exchanging efficiency, as shown in previous patents GB 2,204,055, US 4,224,983, US 5,080,872; different flow directions were also chosen for better heat exchanging performance.

[0004] These reactor designs, no matter how different they look, share one common structural characteristic: the reaction zone and heat exchanging zone are separated by tube walls. Therefore, these reactors are able to be classified as reactors with external heat exchanging.

[0005] Several new catalyst/reactor structure designs have been developed to improve the intra-bed heat transfer. The first approach is wash-coated monolithic catalyst structure, including metal honeycomb structure (US 3,849,076; 4,101,287; 4,300,956; 6,869,578), metal monolith extrusion structure (US 6,881,703; 7,608,344) and metal microchannel reactor (US

7,084,180; 7,226,574; 7,294,734). This approach wash-coats a thin layer of catalyst on the internal wall of the monolithic structures. These structures made of thermal conductive materials (mainly metals or metal alloys) transfer heat fast from/to the reaction zone. Some of the catalyst structures have thick channel walls that allow heat exchanged on their external surfaces. For example, a catalyst structure (US 7,608,344) is made by extruding copper powders and then structure is formed by sintering or annealing in reducing environments. Copper forms a continuous phase that provides a very high thermal conductivity (e.g. 200 W/K-m), which equals to the product of bulk copper thermal conductivity and copper volumetric fraction (G. Groppi and E. Tronconi). The copper honeycomb structure transfers the heat from the wash-coated catalyst inside channel walls to the external honeycomb surface in an efficient way. Other monolithic or channel structures (US 3,849,076; 4,101,287; 4,300,956; 6,869,578, 7,084,180; 7,226,574; 7,294,734) have thin channel walls and small channel sizes (usually several millimeters or less). In these cases, some channels have hot fluid and cold fluid passing through different channels next or cross to each other using the thin walls to separate the fluids and transfer heat. This design minimizes the heat transfer distance (resistance) and provides superior heat transfer performance at the cost of reactor complexity and reliability. In a word, the wash-coated monolithic structures significantly improve the heat transfer by reducing the heat transfer resistance and increasing the heat exchanging area. However, this wash-coated monolith approach, due to the nature of wash-coating, only allows a thin film of catalyst loaded inside the reactor channel. A typical catalyst volume loading is much less than 3 vol.%; some monolithic structures with small channel size (e.g. less than 1 mm) are able to reach a catalyst loading of 3-8 vol.%. Moreover, the mass transfer only take place by molecular diffusion in radial direction, which is much slower than the mass transfer in typical packed bed where bulk gas diffusion is dominant. The limited catalyst loading and low mass transfer rate results in slow reaction kinetics.

[0006] Another approach uses metal microfibrous media with catalyst entrapped for fast heat transfer. This type of media was first developed by Tatarchuk in 1992 (US. 5,080,963, 5,096,663). The media had good electrical conductivity and was developed as electrode materials for supercapacitors and fuel cells. Due to the similarity, the thermal conductivity of the materials should be predictable. Since 1994, this media has been modified for catalytic processes (US 5,102,745, 5,304,330, 6,231,792, 7,501,012) and sorbent processes. In 2001, a novel reactor design with a folded microfibrous media sheet, which was parallel to the flow direction was proposed for fast heat transfer. This design also suffers from the slow radial molecular diffusion limit due to its parallel flow pattern. Moreover, the porous media only take negligible amount of reactor volume. Considering the low volume fraction of catalyst in this microfibrous media, the overall catalyst loading in the reactor will be extremely low. The folded structure has only several edge contacts with the reactor wall for heat transfer. This means the effective heat exchanging area is very limited. These drawbacks make the design much less competitive compared to the monolithic approach.

EP1 029 590 discloses a fabric material for use as an adsorbent at cryogenic temperatures comprising woven carbon fibres and interwoven elements of thermally conductive material such as an aluminium alloy ribbon. US2005 0169820 discloses a microfibrous matrix with embedded supporting particulates/fibers and chemically reactive materials as a filtration

system for the removal of contaminants and other harmful agents from liquids and gaseous streams.

US 5 102 745 discloses a family of composites which are characterised as a network of a first fiber and at least a second fiber, where at least the first fibers have a multiplicity of bonded junctions at their point of crossing.

SUMMARY OF THE INVENTION

[0007] Various aspects and features of the present invention are defined in the appended claims.

BRIEF DESCRIPTION OF THE DRAWINGS

[0008]

FIG. 1 illustrates a photo of a microfibrous media and microfibrous entrapped catalysts according to some embodiments.

FIG. 2 illustrates a diagram of an example of a microfibrous media assembly according to some embodiments.

FIG. 3 illustrates a graph of the effectiveness factor versus catalyst particle radius according to some embodiments.

FIG. 4 illustrates a graph of thermal conductivity measured for microfibrous media made of stainless steel at various metal fiber volume fractions according to some embodiments.

FIG. 5 illustrates a diagram of a test apparatus to verify the improvement in thermal conductivity using metal microfibrous entrapped catalyst according to some embodiments.

FIG. 6 illustrates a graph of transient performance of using microfibrous entrapped catalyst to improve thermal conductivity according to some embodiments.

FIG. 7 illustrates a graph of measured effective thermal conductivity in transient tests according to some embodiments.

FIG. 8 illustrates a graph of a measure of effective thermal conductivity in steady state tests according to some embodiments.

DETAILED DESCRIPTION OF THE PREFERRED EMBODIMENT

[0009] The present invention, which is defined in the appended claims, focuses on improving the intra-bed heat exchanging efficiency and maintaining high catalyst, sorbent or electrocatalyst loading. In some aspects, catalysts, sorbents and electrocatalysts are all referred to generically as thermal facilitators. Although catalysts are typically described herein, in some embodiments, sorbents and/or electrocatalysts are used in addition to or instead of catalysts. The invention employs microfibrinous media made of micro-sized fibers of high thermal conductivity to transfer heat. The media is inserted into the reaction zone under physical compression. Due to the compression and its flexibility, the media well touches the reactor internal wall and utilizes the entire reactor internal wall for heat exchanging. More importantly, the metal microfibrinous network made of highly conductive metals, where catalytic materials are entrapped, provides fast paths to transfer heat from catalyst particles to the reactor wall in case of exothermic reaction. The fluid perpendicularly or near-perpendicularly passes through the microfibrinous media. This flow direction enables accelerated heat and mass transfer due to bulk diffusion. As a result, this catalyst structure is able to provide enhanced mass transfer rate, high activity catalyst loading, large heat exchanging area and low heat transfer resistance.

[0010] The present invention is able to be referred to as a reactor with optimized intra-bed heat exchanging. The invention is able to be combined with the reactors with external heat exchanging for the ultimate heat exchanging performance. In the invention, the highly exothermic or highly endothermic reactions take place on the catalysts particles entrapped within the microfibrinous network, or the reactions take place on the surface of metal fibers. The microfibrinous entrapped catalysts are loaded in the reactors for highly exothermic and high endothermic reactions. The microfibrinous entrapped catalysts are flexible; they are able to match the shape of reactor and contact with the metal reactor wall very well. Moreover, the metal fibers are typically made of highly thermally conductive metals such as silver, zinc, copper, aluminium and other metals. Thus the metal fibers behave as a bridge that transfers the heat generated from the catalysts particles, where reaction takes place, to a cold reactor wall for highly exothermic reactions; and transfer the heat from the hot reactor wall to catalyst particles or metal fibers for highly endothermic reactions. The present invention is able to also be applied for a process that requires fine temperature control or uniform temperature profile. Due to the use of highly conductive metals, the microfibrinous media has a near-isothermal temperature profile, as illustrated in examples below.

[0011] The present invention is able to work with the current reactors with improved external heat exchanging for the best heat exchanging performance. Microfibrinous entrapped catalysts are able to be loaded either in the tube side or the shell side. If in the tube side, the microfibrinous entrapped catalyst media is able to be loaded in the tubes in the form of disk. In other examples, not within the scope of the claims, the microfibrinous entrapped catalyst media may be loaded in the tubes in the form of a rod or another form. The tube diameter is able to be much larger than these in traditional multi-tubular reactors due to significantly improved heat exchanging rate. Thus the part counts are able to be significantly reduced, and the manufacturing reactor for large scales will be much cheaper and easier than traditional multi-tubular reactor approach. Similarly, metal microfibrinous entrapped catalyst is able to also be

loaded in shell side in the form of disks. In other examples, not within the scope of the claims, the metal microfibrous entrapped catalyst is able to be loaded in shell side in the form of pellets, rolls, and other forms.

[0012] In order to maintain the optimized contact between microfibrous media and facilitate the loading/uploading into/from the reactor, a microfibrous media assembly is invented. It includes supporting structures (e.g. plates and screens) and the microfibrous media in between. The supporting structures integrate many tiny microfibrous media pieces into a single article, which is easy to load or unload. The structures hold and compress the media, make it uniformly distributed and compressed inside the reactor and well attached to the reactor wall. In some cases, the supported structure also helps to disperse and even take the force on the entire microfibrous media bed due to pressure drop.

[0013] It is an object of the subject invention to provide a superior heat transfer from/to gaseous or liquid streams. For this object, highly conductive metal fibers are used to prepare microfibrous entrapped catalysts. These fibers are made of metal or metal alloys with high thermal conductivities, such as copper, silver, aluminium, nickel and their alloys. For particular conditions involving corrosion, micro-sized fiber of special metals or metal alloys (e.g. stainless steel) with lower thermal conductivity will be used. The fiber volume contents are able to be tailored to achieve the optimal heat transfer performance as well as catalytic activity, microfibrous structure integrity, pressure drop, and other characteristics.

[0014] The microfibrous media are formed from fibers, with such fibers generally having a diameter of at least 1 micron with the fibers having a diameter which does not exceed 30 microns. In other examples, not within the scope of the claims, smaller or larger diameters are able to be used. A typical fiber volumetric fraction is in the range of 1-10 vol.%. Higher volume fractions are able to also be achieved to enhance the heat transfer for special cases.

[0015] The active catalytic materials are able to be catalysts particles, or microfibrous network made of special metals, or coating on the microfibrous network. The catalysts particles are in the form of grains, pellets, extrudates, rings, combinations thereof or others forms. The typical particle size is in the range of 10 microns to 300 microns (0.3 millimeter), although smaller or larger particles are also able to be used. A typical particle volumetric fraction is in the range of 0~20 vol.%. However, higher particle volume fractions are also able to be used.

[0016] It is to be understood that the microfibrous entrapped catalysts are able to be comprised of one type of fiber or are able to be comprised of two or more different fibers and the metal fibers are able to have a single diameter or are able to have different diameters. Additionally, the fibers are able to be coated with a thin film of catalyst whereby the mesh support is coated with catalyst in addition to having catalyst fibers or particles retained in interstices of the mesh support.

[0017] It is an object of the invention to provide a reaction rate, if not greater than, comparable to that of a traditional packed bed made of pellets or extrudates. In this invention, small

catalysts particulates (10~300 micron) are entrapped in the metal microfibrous network. These particulates are too small to fill in a traditional packed bed. Due to the high external surface area and minimized pore diffusion achieved at small particle sizes, the microfibrous entrapped catalysts are able to reach a volumetric reaction rate that is slightly greater than a traditional packed bed, as shown in the examples below.

[0018] The present invention provides a general platform to entrap various catalysts for different reactions. It is an object of this invention to provide a microfibrous support structure for retaining and entrapping particulate or fiber materials that are chemically reactive toward a predetermined reactant. The microfibrous entrapped catalysts are able to be initially formed by producing a microfibrous media having a catalyst support retained in the interstices thereof, followed by impregnating the retained support with an appropriate catalyst. Alternatively, the microfibrous media is able to be produced with supported or unsupported catalyst particles in the microfibrous network. Moreover, the microfibrous entrapped catalysts are able to also be produced wherein the particles retained therein are catalyst precursors, which precursors are subsequently converted to an active catalyst. As another alternative example, the microfibrous entrapped catalyst is able to be initially formed and the catalyst or catalyst precursors inserted into the interstices of the microfibrous network after formation of the network.

[0019] The microfibrous entrapped catalysts with particles or fibers retained in the interstices thereof are preferably produced by a procedure of the type described in U.S. Patents 5,304,330; 5,080,963; 5,102,745; or 5,096,663, and US Patent Applications 20020068026 and 20050169820. Traditional high speed and low cost paper making equipment and techniques are able to be used to prepare the composite material. In such a process, micron-sized diameter metal, polymer, glass, ceramic or other fibers in a variety of compositions and alloys are able to be slurried in an aqueous suspension (along with optional binders, if required) and with the possible use of cellulose fibers and other selected reactant or support particulates such as, but not limited to, alumina support particles. The resulting mixture is able to then be cast into a preformed sheet using a wet-lay process and dried to create a sheet of preformed material. Where a water soluble binder is used in this preparation, drying may be sufficient to fuse the fibers at their junctures, but in the case of those pre-forms utilizing cellulose, subsequent pre-oxidation in an O₂ flow at approximately 500 °C. for generally about one hour may be employed to remove the bulk of cellulose. Subsequent sintering of the pre-form in an H₂ flow at an elevated temperature (700~900 °C, depending on the type of fiber) for generally about thirty minutes allows for removal of the remaining cellulosic binder/pore former and entraps the selected support particulates within a sinter-locked network of metal, glass or ceramic fibers.

[0020] Figure 1 shows one type of microfibrous media made of copper for highly exothermic and highly endothermic reactions. Figure 2 describes an example of an assembly of microfibrous media to facilitate packing and unpacking.

[0021] Figure 3 depicts the reactivity of using small particulates in a microfibrous network for Fischer-Tropsch synthesis. The reaction of Fischer-Tropsch synthesis (FTS) is controlled by

pore diffusion. The small particulates of 100-200 micron in size demonstrated an effectiveness factor of approximately 1. The effectiveness factor of 3/16" extrudates widely used in FTS is approximately 0.2. Considering the catalyst fraction of the microfibrinous entrapped catalyst is around 0.15, and the catalyst particle volumetric fraction is around 0.6, the catalyst loading in the packed bed is 4 times higher than that in the microfibrinous entrapped catalyst. As a result, the reaction rate in the microfibrinous entrapped catalyst will be 1.25 times higher than that in the typical packed bed. Similarly, if a reaction is controlled by external mass transfer, the microfibrinous entrapped catalyst will provide an even higher reaction rate than typical packed beds due to large external surface area and fast external mass transfer rate. These results suggest the use of microfibrinous entrapped catalyst will not hurt the reaction rate even if the active catalyst volumetric loading in microfibrinous entrapped catalyst is only 1/4 of that in a typical packed bed. This results from the use of small sized particles, which have high external surface area and a high effectiveness factor.

[0022] Figure 4 demonstrates the measured thermal conductivity of several stainless steel microfibrinous media with various microfiber volumetric fractions. The result indicates that the thermal conductivity of microfibrinous media equals the product of thermal conductivity of bulk stainless steel and the volume fraction of stainless steel fibers. The result suggests the thermal conductivity of the microfibrinous entrapped catalyst containing microfibers and catalyst particles is able to be calculated using a volumetric weighted average.

[0023] Figure 5 illustrates a test apparatus to experimentally verify the improvement in thermal conductivity of using microfibrinous entrapped catalysts. It mainly includes a stainless steel tube and a water bath. The tube had an inner diameter of 1.4 inches and the length is 8 inches. Inside the tube, a fixed bed of test material was loaded at the center of the tube. Several thin thermocouples were buried inside the fixed bed. Both ends of the tube were tightly sealed, preventing the water from contacting the test materials. Only a N₂ stream is able to enter the tube. The water bath was maintained at ~92 °C.

[0024] A packed bed made of Al₂O₃ particles (60-80 mesh) and a layer of copper microfiber entrapped Al₂O₃ (60-80 mesh) were compared for heat transfer performance at both steady state and transient state. The unit of length "inch" is equal to 0,0254 "metre" (SI unit). The packed bed was 2 inches long and with a thermal capacity of 10.8 J/K inch of bed. The microfibrinous entrapped catalyst contained 5 vol.% copper fibers, and 20% of alumina. The layer of microfibrinous entrapped catalyst was also 2 inches long and its thermal capacity is 10.9J/K inch of bed. The two fixed beds have almost the same thermal capacity, thus all the differences in temperature changes during the test will result from difference in their thermal conductivity. Other packed beds made of mixture of copper powder (60-80 mesh) and the Al₂O₃ particles, and micro fibrous media beds made of Ni fiber and Stainless Steel fibers were also evaluated.

[0025] Two sets of experiments were carried out using this test apparatus. The first set of experiments was carried out for transient state evaluation. During the tests, the test tube was

immersed into the water bath at time 0, and the temperatures read by the thermocouple at point "1" were recorded every minute. The temperature time profiles of the packed beds and micro fibrous beds are shown in Figure 6. It is clear that copper micro fibrous entrapped catalyst reached 90 °C in about 2 minutes. However, it took the packed bed more than 18 minutes to reach the same temperature. Since the two beds had almost the same thermal capacity, the significant difference suggests that the copper microfibrous entrapped catalyst has a much higher thermal conductivity than the packed bed of alumina. The estimated effective thermal conductivities of these fixed beds are shown in Figure 7. Copper microfibrous media demonstrated a thermal conductivity of ~ 10 W/K-m, which is 47 times higher than those of the packed bed made of particles, including the packed bed made of copper powders. The media made of Stainless Steel fibers, which has much lower thermal conductivity compared to copper fiber, also demonstrated a thermal conductivity 17 times higher than those of the packed beds.

[0026] The second set of experiments evaluates the performance of the two beds at steady state. During the experiments, the tube with a fixed bed loaded was immersed into the water bath. A N_2 flow at 18 SLPM was passed through the reactor. The temperatures read by a different thermocouple reached steady state in about 30 minutes. Then the temperatures were recorded every 30 minutes for 2 hours. The temperature at the center-line of the fixed beds is shown in Figure 8. It is clear that the gas temperature increased very quickly from 40 °C at entrance to near the water bath temperature of 80 °C at the center point ($x/L=0.5$) of the microfibrous bed. The temperature increase in the case of the Al_2O_3 packed bed is only 4 °C. The temperature increase of the microfibrous entrapped catalyst is 10 fold higher than that of the packed bed. This suggests metal microfibrous entrapped catalyst has high heat transfer coefficient to transfer the heat from the reactor wall to the stream flowing through the reactor. The averaged heat transfer coefficient of the micro fibrous entrapped catalyst is approximately 10 times higher than that of the packed bed. This will significantly benefit highly endothermic reactions, in which a huge amount of heat is required to be transferred into the bed, especially the center, to sustain the reaction. Microfibrous entrapped catalysts will also benefit highly exothermic reactions, in which a huge amount of heat needs to be removed from the bed, especially the center, to keep the reactions under control.

[0027] A packed bed made of Co/Al_2O_3 catalyst and microfiber media with the same catalyst entrapped were evaluated for Fischer-Tropsch synthesis in a $\frac{3}{4}$ " stainless steel reactor (15 mm id). The experimental conditions are listed in Table 1. Both beds had a volume of 15.7 cc and contained catalyst of 2.5 g (20 vol.% catalyst loading). The packed bed was diluted by Al_2O_3 particles. The center-line temperature profile was measured by multipoint thermocouple and is shown in Table 2. The packed bed experiment was carried out at 225 °C and achieved a CO conversion of 0.54. In order to maintain the same conversion, the reactor wall temperature of the microfiber media bed had to be maintained at 235 °C. The centerline temperatures of the packed bed were 3-6 times higher than the temperatures in the microfibrous media bed. The microfibrous media bed reached a maximum temperature gradient of 2.1 °C. If the heat transfer via thermocouples is taken into consideration, actual temperature gradient inside the

packed bed is higher than the measured results. For a FTS reactor with larger diameter, i.e. 2", the temperature gradient will be higher than 30 °C in the packed bed, 10 °C in the microfibrinous media bed, according to a conservative estimation. The uniform temperature profile in a microfibrinous bed will provide an improved selectivity to desired product. If 30 °C is tolerable, then the microfibrinous bed is able to be of a larger diameter thus significantly reducing the required tube numbers to reach the same productivity. Moreover, the microfibrinous media bed only utilizes ¼ of catalyst loaded in typical packed bed, as discussed before. As a result, the reactor construction cost will be significantly reduced due to lower part count and less catalyst loading.

Table 1. Temperature profile along FTS reactors with a single pass conversion of 0.54.

	Packed Bed	Copper MFEC
flow rate/h ⁻¹	830.4	830.4
Wall T/°C	225	235
Conversion	0.543	0.538

Table 2. Temperature profiles inside the FTS reactor.

Point	Location	T/°C	T-Twall/°C	T/°C	T-Twall/°C
Gas	1	216.4	-8.6	226.5	-8.5
Heat	2	219.6	-5.4	228.5	-6.5
Up	3	222.6	-2.4	232.2	-2.8
	4	228.7	3.7	234.9	-0.1
Reaction	5	231.9	6.9	237.1	2.1
Section	6	229.5	4.5	235.8	0.8
Average 4~6		230.03	5.03	235.93	0.93

[0028] To utilize the microfibrinous media, the microfibrinous media is used in a desired implementation such as a container for a sorption process, a container for a catalytic reaction process, a component in a high efficiency heat exchanger, a thermal sink or phase change thermal modulator, part of an electrochemical reactor or a static mixture. Depending on the implementation, the microfibrinous media is used accordingly. Common to the implementations is the improved thermal conductivity and heat transfer.

[0029] In operation, the microfibrinous media enhances intra-bed heat transfer characteristics. Microfibrinous entrapped catalysts have a much higher thermal conductivity and a higher heat transfer co-efficient than a traditional packed bed due to the use of highly conductive micron-sized metal fibers and improved wall contacting. Since microfibrinous media entraps fine catalyst particles, the microfibrinous entrapped catalysts have a similar reaction rate at a much lower catalyst loading than the traditional packed bed. By changing the active entrapped catalyst, microfibrinous media is able to be applied to different highly exothermic and highly endothermic reactions/processes, and reactions/processes that utilize fine temperature control or uniform temperature profile.

[0030] Some embodiments of the invention are described herein.

[0031] In some embodiments, an internal packing that enhances external transport into or out of a vessel. The packing promotes heat transfer. The packing promotes electrical conduction. The packing is malleable to promote good internal contacting to itself and to the internal walls of the vessel. The vessel is sealed. The vessel is a flow through design, or periodically opened, closed, or the flow is variable in flow rate or direction. The vessel is tubular, rectangular or conical. In other examples, not within the scope of the claims, the vessel may be of some other cross-sectional description or form factor. The vessel serves as a container for a sorption process. The vessel serves as a container for a catalytic reaction process. The vessel serves as a component in a high efficiency heat exchanger. The vessel serves as a thermal sink or phase change thermal moderator. The vessel is part of an electrochemical reactor. The vessel serves as a static mixer. The packing includes high thermal conductivity fibers. The packing includes fibers with high electrical conductivity. The fibers are used to immobilize a sorbent. The fibers are used to immobilize a catalyst. The fibers are used to immobilize an electrocatalyst. The fibers are used to infiltrate a phase change medium. The fibers are fused at their junctures to promote heat transfer or electrical conduction. The dimensions of the fibers and immobilized phase are chosen to minimize pressure drop. The dimensions of the fibers and immobilized phase are chosen to promote high levels of volumetric reactivity. The fiber diameter and composition are selected to promote high levels of heat transfer at the inside wall of the vessel. The fiber diameter and composition are selected to promote high levels of electrical conduction and low contact resistance at the inside wall of the vessel. The orientation of the packing is selected to promote heat transfer or electrical conduction in a specific direction. The volume fractions of the conduction aid and the immobilized phase are adjustable over wide ranges. The fibers are of different diameters. The packing and entrapped phase are spatially graded. The diameter, volume loading and composition of the fibers and the immobilized phase are optimized to promote the rate of reaction and/or sorption per unit of pressure drop. The diameter, volume loading and composition of the fibers and the immobilized phase are optimized to minimize the intravessel temperature gradient within the reaction and/or sorption vessel at a specified level of volumetric reactivity. The diameter of the fibers and immobilized phase are optimized to promote the rate of electrochemical reaction per unit of electrical resistance. The diameter, volume loading and composition of the fibers and immobilized phase are optimized to minimize the intravessel electrical resistance at a specified level of volumetric reactivity. The medium in the vessel in contact with the packing is a gas. The medium in the vessel in contact with the packing is a liquid. The medium in the vessel in contact with the packing is a two phase mixture of liquid and gas. The medium in the vessel in contact with the packing undergoes a phase change. The process occurring is exothermic or endothermic. The rate of the process occurring in the vessel depends on temperature. The selectivity of the process occurring in the vessel depends on temperature. The internal packing helps remove exotherms or endotherms associated with sorption, desorption, or steady-state catalytic or electrochemical reaction. The packing helps remove heat and reduce thermal excursions associated with nonsteady-state heterogeneous reactions such as catalyst regeneration, calcinations, oxidations and autoreductions. The intrapacking Reynold's number

is low and lies in a regime of non-turbulent flow. The intrapacking Reynold's number is high and lies in a regime of turbulent flow. The volume fraction of catalyst, sorbent or electrocatalyst is higher than that which can be attained in a fixed bed reactor of a packed bed or monolithic design. The level of reaction and heat transfer are similar to a fluid bed reactor but in the absence of back mixing. The position of the immobilized solid reactive phase does not depend on gravitational orientation or fluid velocity versus particulate drag forces. The volume fraction and diameter of the fibers are selected to entrap solids of a selected particle size. The vessel permits higher levels of chemical conversion per pass or per cycle. The vessel permits higher levels of chemical conversion per pass with the lowest possible temperature gradient within the internal packing. The packing is stacked onto an assembly apparatus to facilitate packing, unpacking or maintenance of the vessel. Intermediate inert mechanical layers are used to maintain the malleable packing at a selected volume fraction and mechanical loading. Layers of the packing material are stacked in a specific order to promote process integration and process intensification. The profile and cut patterns within the layers are selected to promote fluid contacting, mixing and prescribed fluid movement within the internal packing. The structure of the apparatus is used to mount various sensors such as thermocouples, chemical sensors, flow sensors, pressure sensors and other sensors. The output of the sensors is used to control the process to promote: economics, safety, environmental compliance and process throughput per unit of: volume, mass or energy. An apparatus includes multiple vessels within a common manifold, and operated similar to a "tube" and shell heat exchanger. The vessels are not tubular but adhere to the specified form factors. The heat is transferred in a co-current fashion. The heat is transferred in a counter-current fashion. The number of individual vessels is reduced (at constant volume of the entrapped media) by making each vessel larger and still maintaining adequate thermal control due to the enhanced conductivity of the media. The individual vessels are not located within a common manifold but operate individually. The number of vessels is significantly reduced because they can be made of larger volume and still provide adequate heat transfer properties at a fixed level of chemical processing throughput. The vessels are made shorter in the axial flow direction because heat is transferred more effectively and temperature sensitive equilibrium limited reactions occur to a greater and more desirable degree. The performance attributes and compositions of the catalyst, electrocatalyst or sorbent are specifically selected in a non-obvious manner to take advantage of the enhanced transport properties and intra-media operating temperature specific to the process and assemblage network of the vessels.

[0032] In some embodiments, a microfibrinous reactor for highly exothermic and highly endothermic reactions/processes comprises a reactor tube packed with microfibrinous media made of highly thermal conductive micron-sized fibers or assemblies made of the microfibrinous media. A fluid perpendicularly or near-perpendicularly passes through the microfibrinous media inside the reactor. The thermal conductive microfibrinous media transfers the heat from the fluid to the reactor wall for exothermic reaction/processes, and from the reactor wall to the fluid for endothermic reaction/processes. The reactor tube is made of metal and other thermal conductive materials, which may be, but are not limited to, metals, metal alloys, C, Si, SiC. The microfibrinous media comprises approximately 1~25 vol.% of micron-sized fibers and 0~60vol.% of catalyst or sorbent/adsorbent materials. The micron-sized fibers are fibers made from metal

with high thermal conductivities. These metals may be, but are not limited to, silver, copper, aluminium, nickel, iron, titanium, chromium, and metal alloys of these metals. The micron-sized fibers are fibers made from non-metal materials with high thermal conductivities. These materials may be, but are not limited to, C, Si and SiC. The micron-sized fibers have an average diameter of 1-30 microns. In other examples, not within the scope of the claims, fibers with larger diameters may also be used. The catalytic materials are entrapped catalyst particles, active coating layers on the micron sized fibers, and/or the active surface areas of the metal fibers themselves. The sorbent/adsorbent materials are entrapped sorbent/adsorbent particles, active coating layers on the micron sized fibers, and/or the metal fibers themselves. The catalyst particles and sorbent/adsorbent particles have an average diameter of 10-300 microns, though smaller or larger particles may also be used. The catalyst particles and sorbent/adsorbent particles are in the form of powder, grains, pellets, extrudates, rings, or combinations thereof. The microfibrinous media is in the form of a stack (or stacks) of disks in reactors of axial flow direction so that the flow direction is perpendicular or near-perpendicular to layers of microfibrinous entrapped catalyst. In other examples, not within the scope of the claims, the microfibrinous media may be in the form of rolls in the reactors of radial flow direction so that the flow direction is perpendicular or near-perpendicular to layers of microfibrinous entrapped catalyst. In other examples, not within the scope of the claims, the microfibrinous media may be in the form of other shapes such as spheres, fussy pellets, and other complex three dimensional structures, or various combinations thereof may also be used. The assembly of microfibrinous media includes microfibrinous media in various shapes and supporting structures. The supporting structures hold and compress the microfibrinous media to attach the reactor wall, and facilitate loading the microfibrinous media into the reactor and unloading the media out from the reactor, especially when the reactor is long. The reactors packed with microfibrinous entrapped catalysts provide improved heat transfer means for highly exothermic and highly endothermic reactions/processes, and reactions/processes that need fine temperature control and uniform temperature profile. The microfibrinous entrapped catalysts transfer heat (generated/ or consumed) from the reaction/catalyst zone to the outer wall (in an e.g., tubular reactor), where

other heat transfer fluids or measures are employed to remove/add required heat in order to maintain an optimal reactor temperature and temperature profile for highly selective and/or high volume reactivity applications. The microfibrinous entrapped catalysts transfer heat to/from the reaction zone, where endothermic/exothermic reactions take place. The exothermic reactions/processes include, but are not limited to, Fischer-Tropsch synthesis for hydrocarbons, methanation, methanol formation and other alcohol synthesis using carbon monoxide and hydrogen, gas-to-liquid (GTL), coal-to-liquid (CTL) processes, biomass-to-liquid (BTL) processes, hydrocarbon partial oxidation reactions, ammonia synthesis, adsorption, air compression, and others. The endothermic reactions/processes include, but are not limited to, steam reforming, and ammonia decomposition, reactor cooling and others. The reactions/processes include both homogeneous and heterogeneous reactions/processes. The fluid is able to be gaseous and/or liquid. The structured catalyst material where the volumetric loading of either catalyst or metal fiber, or both, is spatially graded across the cross-section or other defining coordinate system so as to optimally adjust heat transport through the fibers versus heat generation/removal at the catalyst surface. The structured catalyst wherein the

fiber hardness, media compressibility, fiber diameter, or other physical means are chosen to increase the number of fiber contacts at the interior wall of the reactor thereby increasing the critical interior wall heat transfer coefficient. A heterogeneous reactive structure wherein the catalyst is replaced by a chemical adsorbent or absorbent which is also used for either an endothermic or exothermic chemical separation process. A metal fiber entrapped chemical reactant which is either consumed or produced during the course of the reaction, is accommodated within a conductive metal fiber matrix so as to achieve appropriate and desired temperatures during the course of the chemical reaction. A general reactor design process and reactor wherein the ratio of heat generating/removing materials and reactions are balanced against the inclusion and distribution of conductive metal fibers so as to better optimize and improve the general performance of the process. The reactor design process wherein the goal of the optimization may include one or more of the following: lowest annualized operating cost, highest single pass conversion, greatest selectivity to a desired product, lowest selectivity to an undesired product, smallest and/or lightest reactor, smallest and lightest balance-of-plant (including the summation of other process units and unit operations) for a more complex process flow sheet that is driven by both the reactor performance itself as well as other required separations, recycle streams, product specifications and others. A structured reactive material wherein the number of individual reactor tubes can be significantly reduced because they can be made larger in diameter (and still maintain appropriate temperature control) due to the presence of the conductive fibers. The structured material wherein the metal fibers are replaced by other high thermal conductivity

fibers including: polycrystalline diamond, graphites, diamond coated fibers, silicon carbides, sapphire, and other polymers, inorganics or composites and coatings thereof. A generalized methodology of improved chemical reaction process control that is accomplished by one or more temperature sensors, or chemical reactant/product composition sensors that are embedded in a reactive structure and which can utilize optimized feedback process control in order to achieve and realize various process optimization goals.

[0033] In some embodiments, an internal packing that enhances external transport out of (or into) a vessel comprises micro fibrous media made of highly thermal conductive micron-sized fibers or assemblies made of the microfibrinous media for exothermic (or endothermic) reactions/processes. A fluid perpendicularly or near-perpendicularly passes through the internal packing inside the vessel. The packing promotes heat transfer. The packing promotes electrical conduction. The packing is malleable to promote good internal contacting to itself and to the internal walls of the vessel. The vessel is sealed. The vessel is a flow through design, or periodically opened, closed, or the flow is variable in flow rate or direction. The vessel is tubular, rectangular or conical. In other examples, not within the scope of the claims, the vessel is of some other cross-sectional description or form factor. The vessel serves as a container for a sorption process. The vessel serves as a container for a catalytic reaction process. The vessel serves as a component in a high efficiency heat exchanger. The vessel serves as a thermal sink or phase change thermal moderator. The vessel is part of an electrochemical reactor. The vessel serves as a static mixer. The vessel is made of metal and other thermal conductive materials, which may be, but are not limited to, metals, metal alloys, C, Si, SiC and other ceramics. The microfibrinous media comprises approximately 1-25 vol.% of micron-sized

fibers and 0~60 vol.% of catalyst or sorbent/adsorbent materials as immobilized phase. The packing and entrapped phase are spatially graded. The micron-sized fibers are fibers made from metal with high thermal conductivities. These metals may be, but are not limited to, silver, copper, aluminum, nickel, iron, titanium, chromium, and metal alloys of these metals.

[0034] The fibers made from non-metal materials with high thermal conductivities. These materials may be, but are not limited to C, Si, SiC, aluminum nitride and boron nitride. The micron-sized fiber are fibers with high electrical conductivity. The micron-sized fibers have an average diameter of 1-30 microns. In other examples, not within the scope of the claims, fibers with larger diameters may also be used. The micron-sized fibers have different diameters. The fibers are fused at their junctures to promote heat transfer or electrical conduction. The catalytic materials include entrapped catalyst particles, active coating layers on the micron sized fibers, and/or the active surface areas of the metal fibers themselves. The sorbent/adsorbent materials include entrapped sorbent/adsorbent particles, active coating layers on the micron sized fibers, and/or the metal fibers themselves. The catalyst particles and sorbent/adsorbent particles have an average diameter of 10-300 microns, though smaller or larger particles may also be used. The catalyst particles and sorbent/adsorbent particles are in the form of powder, grains, pellets, extrudates, rings, or combinations thereof. The fibers are used to immobilize a sorbent. The fibers are used to immobilize a catalyst. The fibers are used to immobilize an electrocatalyst. The fibers are used to infiltrate a phase change medium. The fibers and microfibrinous media are used to transfer heat between the fluid and vessel wall by conduction. The fibers and microfibrinous media are used to promote the heat transfer between the fluid and vessel wall. The dimensions of the fibers and immobilized phase are chosen to minimize pressure drop. The dimensions of the fibers and immobilized phase are chosen to promote high levels of volumetric reactivity. The fiber diameter and composition are selected to promote high levels of heat transfer at the inside wall of the vessel. The fiber diameter and composition are selected to promote high levels of electrical conduction and low contact resistance at the inside wall of the vessel. The orientation of the packing is selected to promote heat transfer or electrical conduction in a specific direction. The volume fractions of the conduction aid and the immobilized phase are adjustable over wide ranges. The diameter, volume fraction and composition of the fibers and the immobilized phase are optimized to promote the rate of reaction and/or sorption per unit of pressure drop. The diameter, volume loading and composition of the fibers and the immobilized phase are optimized to minimize the intravessel temperature gradient within the reaction and/or sorption vessel at a specified level of volumetric reactivity. The diameter of the fibers and immobilized phase are optimized to promote the rate of electrochemical reaction per unit of electrical resistance. The diameter, volume loading and composition of the fibers and immobilized phase are optimized to minimize the intravessel electrical resistance at a specified level of volumetric reactivity. The microfibrinous media is in the form of a stack (or stacks) of disks in reactors of axial flow direction so that the fluid flow direction is perpendicular or near perpendicular to layers of microfibrinous entrapped catalyst. In other examples, not within the scope of the claims, the microfibrinous media may be in the form of rolls in the reactors of radial flow direction so that the fluid flow direction is perpendicular or near-perpendicular to layers of microfibrinous entrapped catalyst. In other examples, not within the scope of the claims, other shapes such as spheres, fuzzy pellets, and

other complex three dimensional structures, or various combinations thereof may also be used. The internal packing assembly includes microfibrinous media in various shapes stacked on supporting structures. The supporting structures hold and compress the microfibrinous media to attach the reactor wall, and facilitate packing, unpacking or maintenance of the vessel, especially when the vessel is long. The internal packing assembly where intermediate inert mechanical layers are used to maintain the malleable packing at a selected volume fraction and mechanical loading. The internal packing assembly where layers of the packing material are stacked in a specific order to promote process integration and process intensification. The internal mechanical packaging layers where the profile and cut patterns within the layers are selected to promote fluid contacting, mixing and prescribed fluid movement within the internal packing. The structure of the apparatus is used to mount various sensors such as thermocouples, chemical sensors, flow sensors, pressure sensors and other sensors. The output of the sensors are used to control the process to promote: economics, safety, environmental compliance and process throughput per unit of volume, mass or energy input. The reactors packed with microfibrinous entrapped catalysts provide improved heat transfer means for highly exothermic and highly endothermic reactions/processes, and reactions/processes that need fine temperature control and uniform temperature profile. The microfibrinous entrapped catalysts transfer heat (generated/ or consumed) from the reaction/catalyst zone to the outer wall (in an e.g., tubular reactor), where other heat transfer fluids or measures are employed to remove/add required heat in order to maintain an optimal reactor temperature and temperature profile for highly selective and/or high volume reactivity applications. The microfibrinous entrapped catalysts transfer heat to/from the reaction zone, where endothermic/exothermic reactions take place. The rate of the process occurring in the vessel depends on temperature. The selectivity of the process occurring in the vessel depends on temperature. The internal packing helps remove exotherms or endotherms associated with sorption, desorption, or steady-state catalytic or electrochemical reaction. The packing helps remove heat and reduce thermal excursions associated with nonsteady-state heterogeneous reactions such as catalyst regeneration, calcinations, oxidations and autoreductions. The exothermic reactions/processes include, but are not limited to, Fischer-Tropsch synthesis for hydrocarbons, methanation, methanol formation and other alcohol synthesis using carbon monoxide and hydrogen, gas-to-liquid (GTL), coal-to-liquid (CTL) processes, biomass-to-liquid (BTL) processes, hydrocarbon partial oxidation reactions, ammonia synthesis, adsorption, air compression and others. The endothermic reactions/processes include, but are not limited to, steam reforming, and ammonia decomposition, reactor cooling and others. The reactions/processes include both homogeneous and heterogeneous reactions/processes. The fluid can be gas, vapor, liquid, plasma, a phase undergoing phase change and a multiple-phase mixture of above mentioned phases. The structured catalyst material where the volumetric loading of either catalyst or metal fiber, or both, is spatially graded across the cross-section or other defining coordinate system so as to optimally adjust heat transport through the fibers versus heat generation/removal at the catalyst surface. The structured catalyst wherein the fiber hardness, media compressibility, fiber diameter, or other physical means are chosen to increase the number of fiber contacts at the interior wall of the reactor thereby increasing the critical interior wall heat transfer coefficient. A heterogeneous reactive structure wherein the catalyst is replaced by a chemical adsorbent or absorbent which is also used for either an

endothermic or exothermic chemical separation process. A metal fiber entrapped chemical reactant which is either consumed or produced during the course of the reaction, is accommodated within a conductive metal fiber matrix so as to achieve appropriate and desired temperatures during the course of the chemical reaction. A general reactor design process and reactor wherein the ratio of heat generating/removing materials and reactions are balanced against the inclusion and distribution of conductive metal fibers so as to better optimize and improve the general performance of the process. The reactor design process wherein the goal of the optimization may include one or more of the following: lowest annualized operating cost, highest single pass conversion, greatest selectivity to a desired product, lowest selectivity to an undesired product, smallest and/or lightest reactor, smallest and lightest balance-of-plant (including the summation of other process units and unit operations) for a more complex process flow sheet that is driven by both the reactor performance itself as well as other required separations, recycle streams, product specifications, and others. A structured reactive material wherein the number of individual reactor tubes can be significantly reduced because they can be made larger in diameter (and still maintain appropriate temperature control) due to the presence of the conductive fibers. The structured material wherein the metal fibers are replaced by other high thermal conductivity fibers including: polycrystalline diamond, graphites, diamond coated fibers, silicon carbides, sapphire, and other polymers, inorganics or composites and coatings thereof. A generalized methodology of improved chemical reaction process control that is accomplished by one or more temperature sensors, or chemical reactant/product composition sensors that are embedded in a reactive structure and which can utilize optimized feedback process control in order to achieve and realize various process optimization goals. The intrapacking Reynold's number is low (less than 20) and lies in a regime of non-turbulent flow. The intrapacking Reynold's number is high (greater than 1500) and lies in a regime of turbulent flow. The volume fraction of catalyst, sorbent or electrocatalyst is higher than that which can be attained in a fixed bed reactor of a packed bed or monolithic design. The level of reaction and heat transfer are similar to a fluid bed reactor but in the absence of back mixing. The position of the immobilized solid reactive phase does not depend on gravitational orientation or fluid velocity versus particulate drag forces. The volume fraction and diameter of the fibers are selected to entrap solids of a selected particle size. The vessel permits higher levels of chemical conversion per pass or per cycle. The vessel permits higher levels of chemical conversion per pass with the lowest possible temperature gradient within the internal packing. The packing is stacked onto an assembly apparatus to facilitate packing, unpacking or maintenance of the vessel. Intermediate inert mechanical layers are used to maintain the malleable packing at a selected volume fraction and mechanical loading. Layers of the packing material are stacked in a specific order to promote process integration and process intensification. The profile and cut patterns within the layers are selected to promote fluid contacting, mixing and prescribed fluid movement within the internal packing. The structure of the apparatus is used to mount various sensors such as thermocouples, chemical sensors, flow sensors, pressure sensors, and other sensors. The output of the sensors are used to control the process to promote: economics, safety, environmental compliance and process throughput per unit of: volume, mass or energy.

[0035] In some embodiments, an apparatus comprised of multiple vessels within a common

manifold, and operated similar to a "tube" and shell heat exchanger. The vessels are not tubular but adhere to specified form factors. The heat is transferred in a co-current fashion. The heat is transferred in a counter-current fashion. The number of individual vessels is reduced (at constant volume of the entrapped media) by making each vessel larger and still maintaining adequate thermal control due to the enhanced conductivity of the media. The individual vessels are not located within a common manifold but operate individually. The number of vessels is significantly reduced because they can be made of larger volume and still provide adequate heat transfer properties at a fixed level of chemical processing throughput. The vessels are made shorter in the axial flow direction because heat is transferred more effectively and temperature sensitive equilibrium limited reactions occur to a greater and more desirable degree. The performance attributes and compositions of the catalyst, electrocatalyst or sorbent are specifically selected in a non-obvious manner to take advantage of the enhanced transport properties and intra-media operating temperature specific to the process and assemblage network of the vessels.

[0036] Although a catalyst has been described throughout, a sorbent, an electrocatalyst and/or other chemically reactive materials are also able to be used in addition to or instead of a catalyst.

[0037] Additional objects and advantages of the invention are set forth in, or will be apparent to those of ordinary skill in the art from, the detailed description as follows. Also, it should be further appreciated that modifications and variations to the specifically illustrated and discussed features and materials hereof may be practiced in various embodiments and uses of this invention without departing from the scope as defined by the claims. Such variations may include, but are not limited to, substitutions of the equivalent means, features, and materials for those shown or discussed, and the functional or positional reversal of various parts, features, or the like.

[0038] Still further, it is to be understood that different embodiments, as well as different presently preferred embodiments, of this invention, may include various combinations or configurations of presently disclosed features, elements, or their equivalents (including combinations of features or configurations thereof not expressly shown in the figures or stated in the detailed description).

[0039] These and other features, aspects and advantages of the present invention will become better understood with reference to the following descriptions and appended claims. The accompanying drawings, which are incorporated in and constitute a part of this specification, illustrate an embodiment of the invention and, together with the descriptions, serve to explain the principles of the invention.

[0040] The present invention has been described in terms of specific embodiments incorporating details to facilitate the understanding of principles of construction and operation of the invention. Such reference herein to specific embodiments and details thereof is not intended to limit the scope of the claims appended hereto. It will be readily apparent to one

skilled in the art that other various modifications may be made in the embodiment chosen for illustration without departing from the scope of the invention as defined by the claims.

REFERENCES CITED IN THE DESCRIPTION

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Patentkrav

1. System, som omfatter:

- 5 a. en rørformet, rektangulær eller konisk beholder, hvilken beholder er fremstillet af et varmeledende materiale; og
- b. en indvendig pakning, der er indeholdt i beholderen, til forbedring af varmetransport ind i eller ud af beholderen, hvilken indvendige pakning omfatter et mikrofibermateriale, hvilket mikrofibermateriale er fremstillet af varmeledende
- 10 fibre, hvor de varmeledende fibre er af mikrometerstørrelse og har en gennemsnitsdiameter på 1-30 μm , hvor orienteringen af den indvendige pakning er konfigureret, så den fremmer varmeoverførsel mellem en væske og indvendige vægge i beholderen ved anvendelse af skiver af mikrofibermateriale,
- 15 der er stablet i en aksial retning af beholderen, hvor den indvendige pakning berører de indvendige vægge af beholderen, hvor en væskestrømningsretning er i den aksiale retning af beholderen og vinkelret eller tæt på vinkelret på skiverne af mikrofibermateriale, hvor mikrofibermaterialet indeholder en
- 20 mikrofibrøs immobiliseret proces- og kemisk reaktionsfremmer, hvilken mikrofibrøse immobiliserede proces- og kemisk reaktionsfremmer forøger varmetransport og elektrisk ledning; og
- c. understøtningsstrukturer til at holde og komprimere den
- 25 mikrofibrøse immobiliserede proces- og kemisk reaktionsfremmer, hvor mikrofibermaterialet er mellem understøtningsstrukturerne.

30 2. System ifølge krav 1, hvor beholderen er forseglet.

3. System ifølge krav 1, hvor beholderen er et gennemstrømningsdesign, der periodisk er åbent eller lukket, eller strømmen er variabel i strømningshastighed eller -

35 retning.

4. System ifølge krav 1, hvor beholderen omfatter en katalysator, et adsorberingsmiddel eller en elektrokatalysator, der er indesluttet i eller immobiliseret i

beholderen ved hjælp af den indvendige pakning.

DRAWINGS

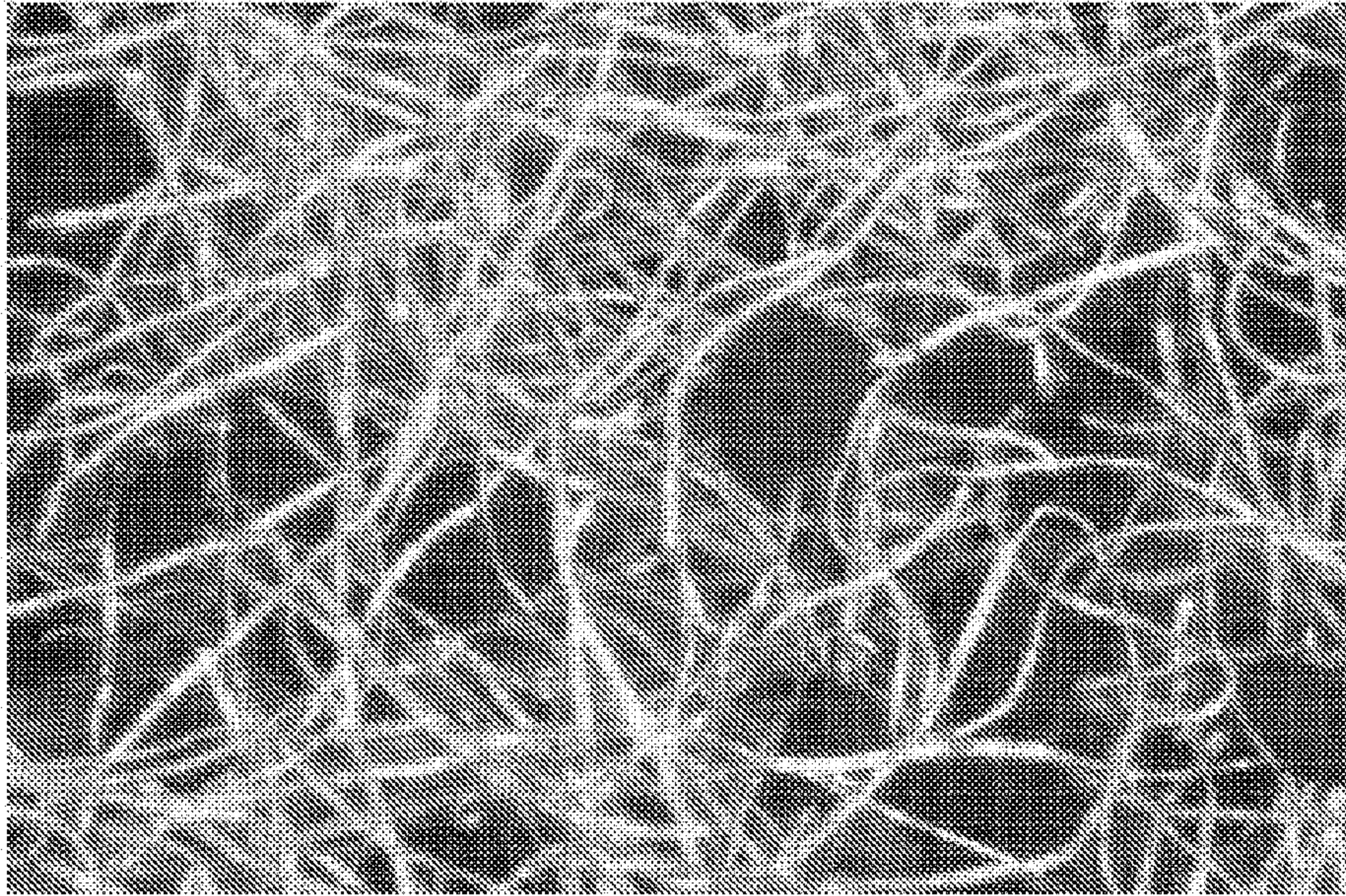


Fig. 1

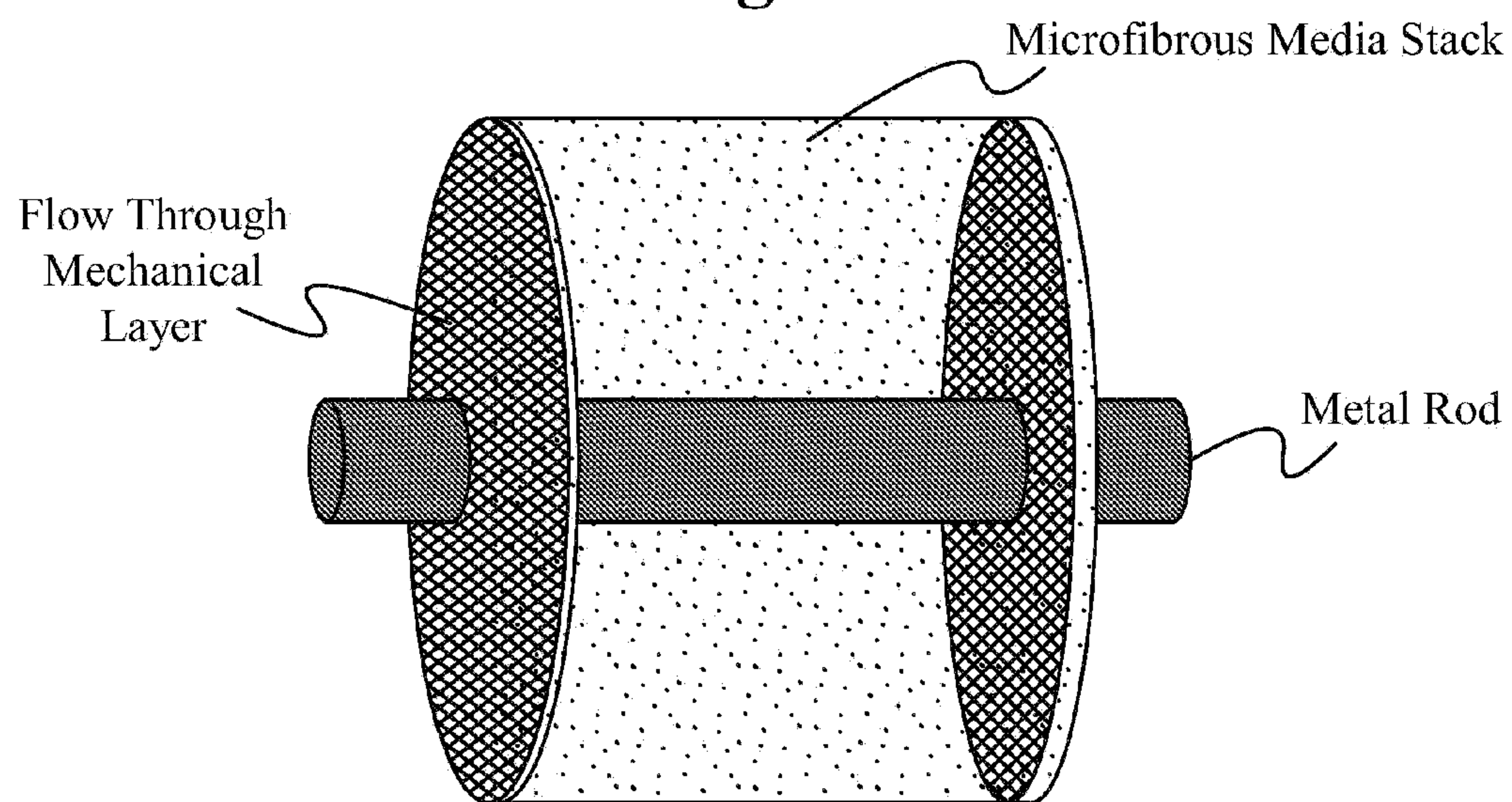


Fig. 2

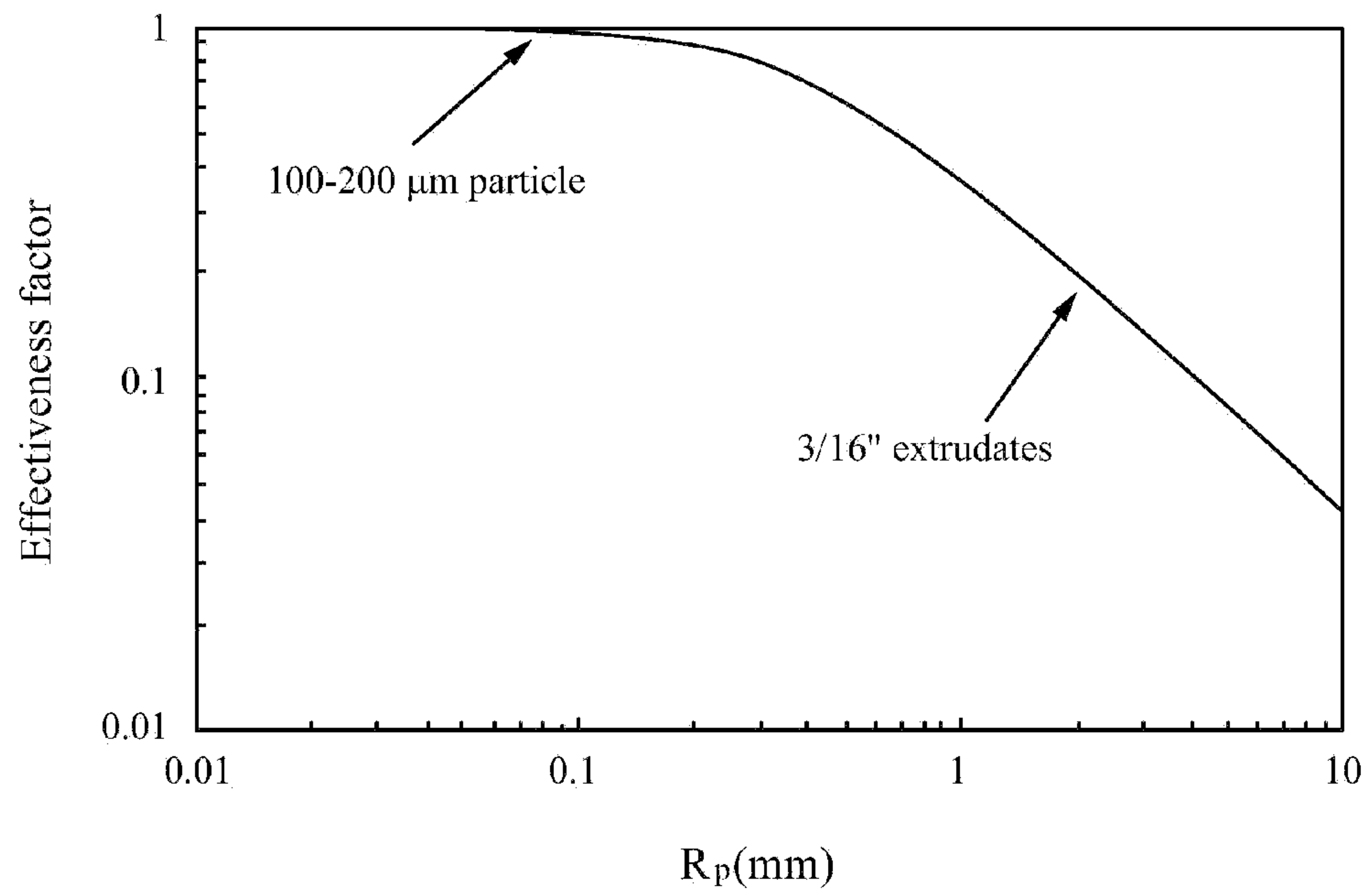


Fig. 3

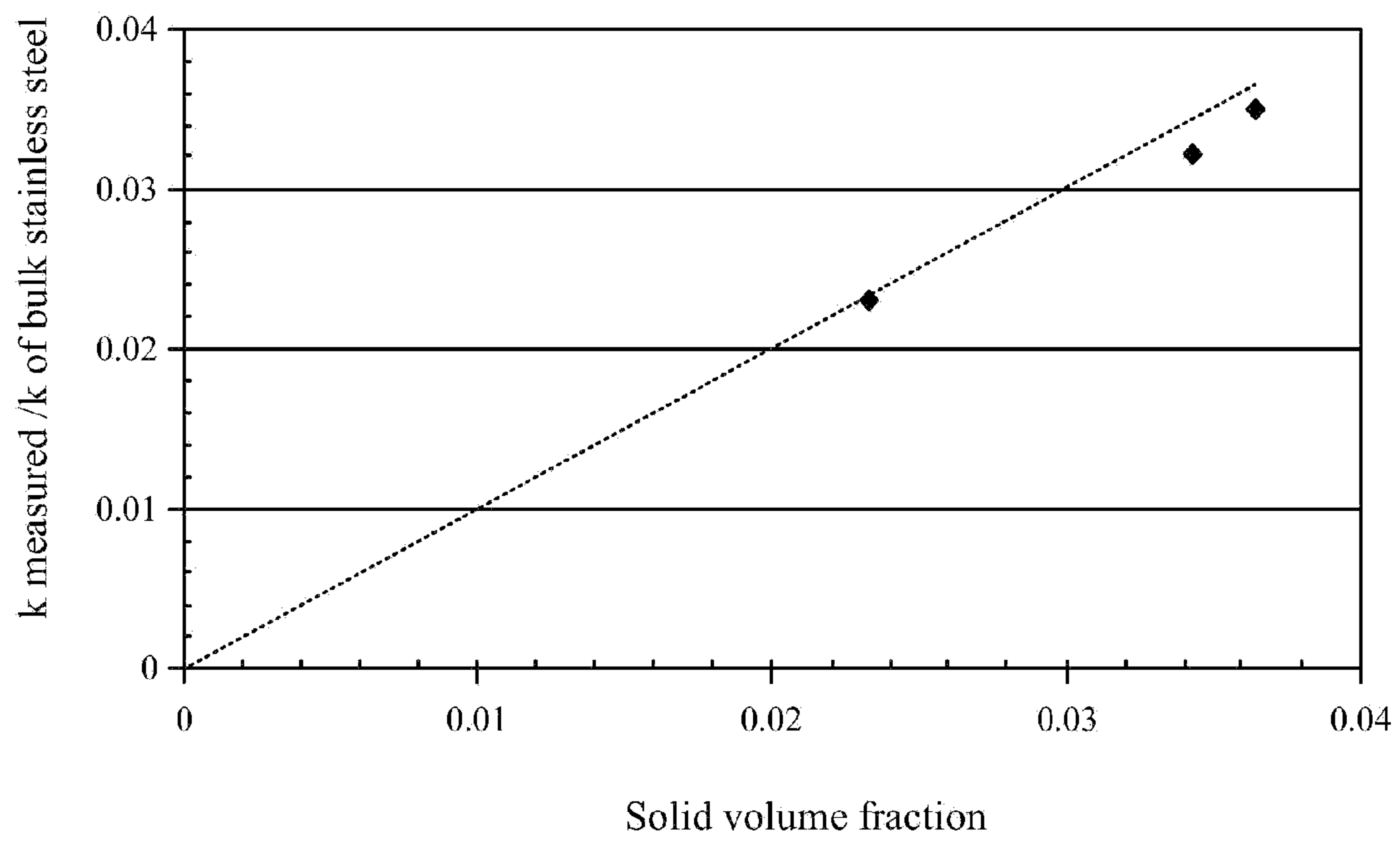
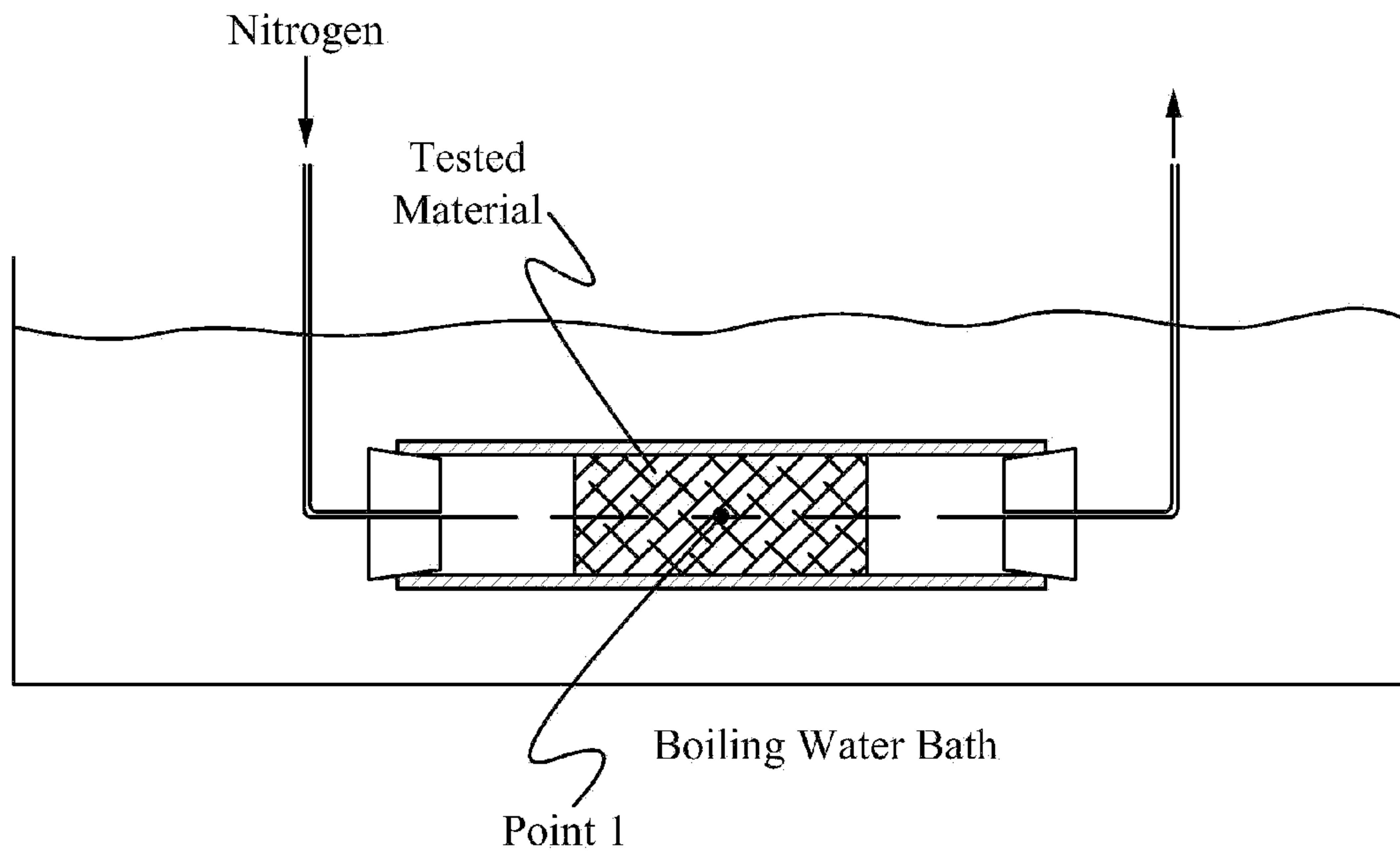
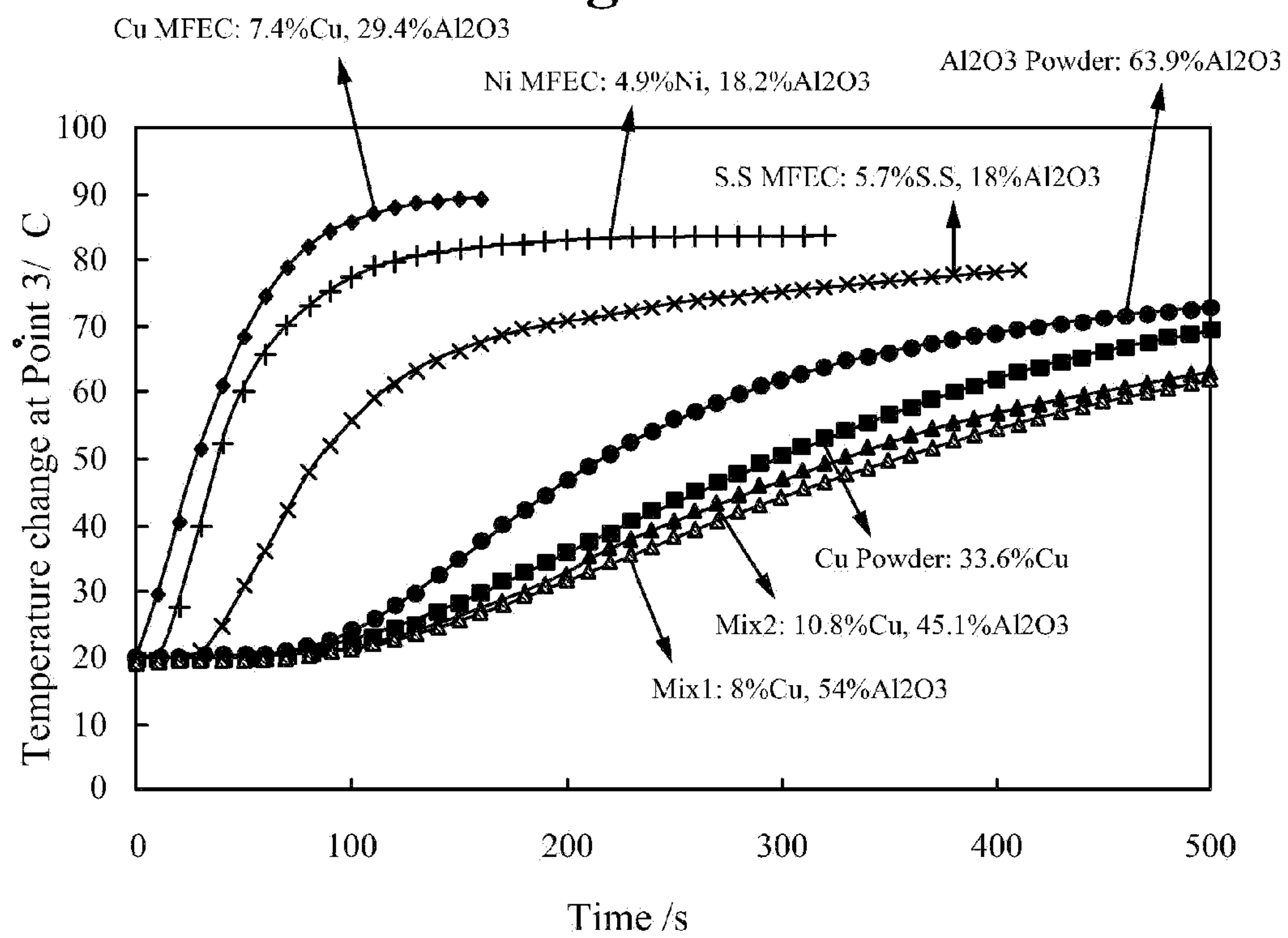
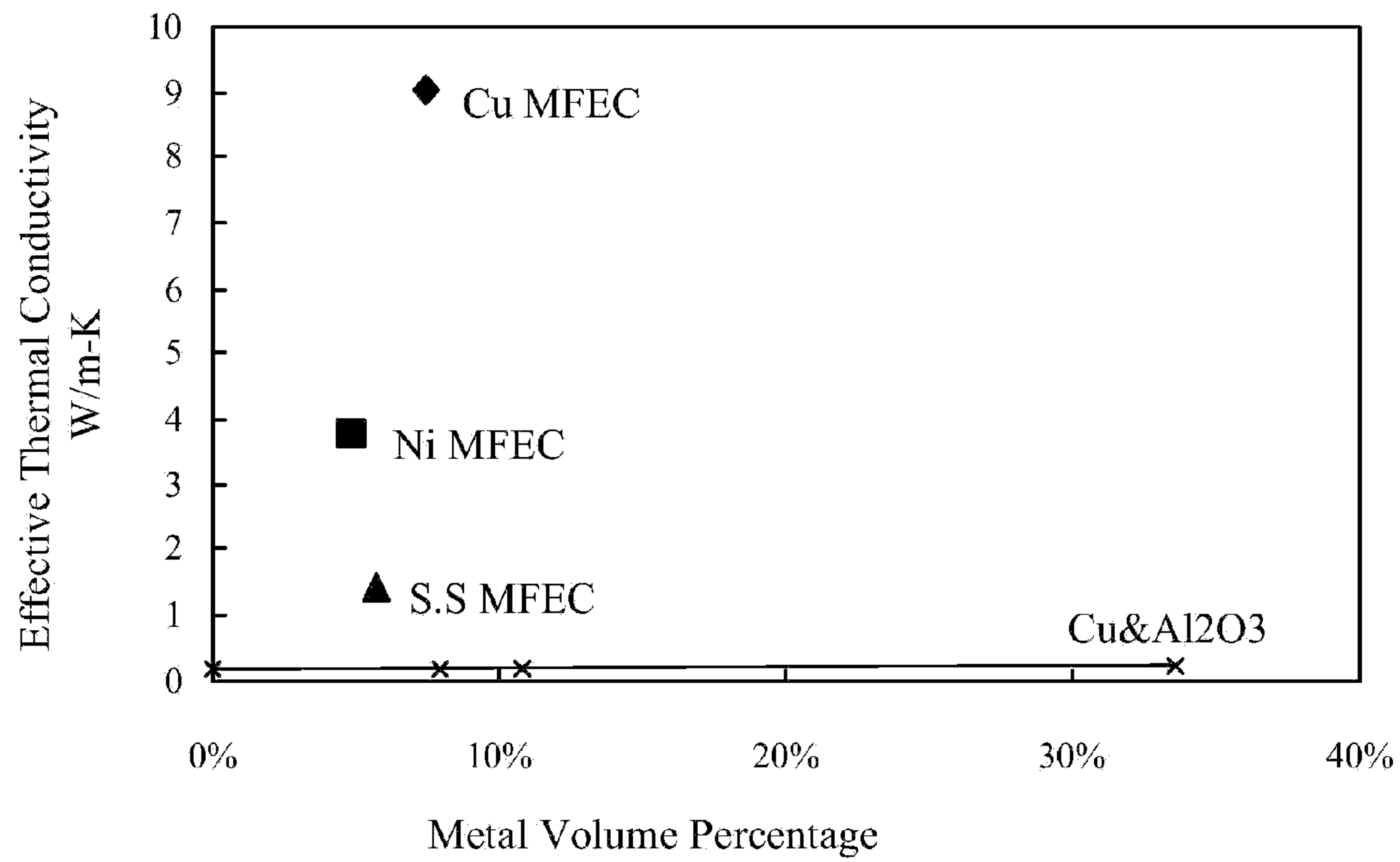
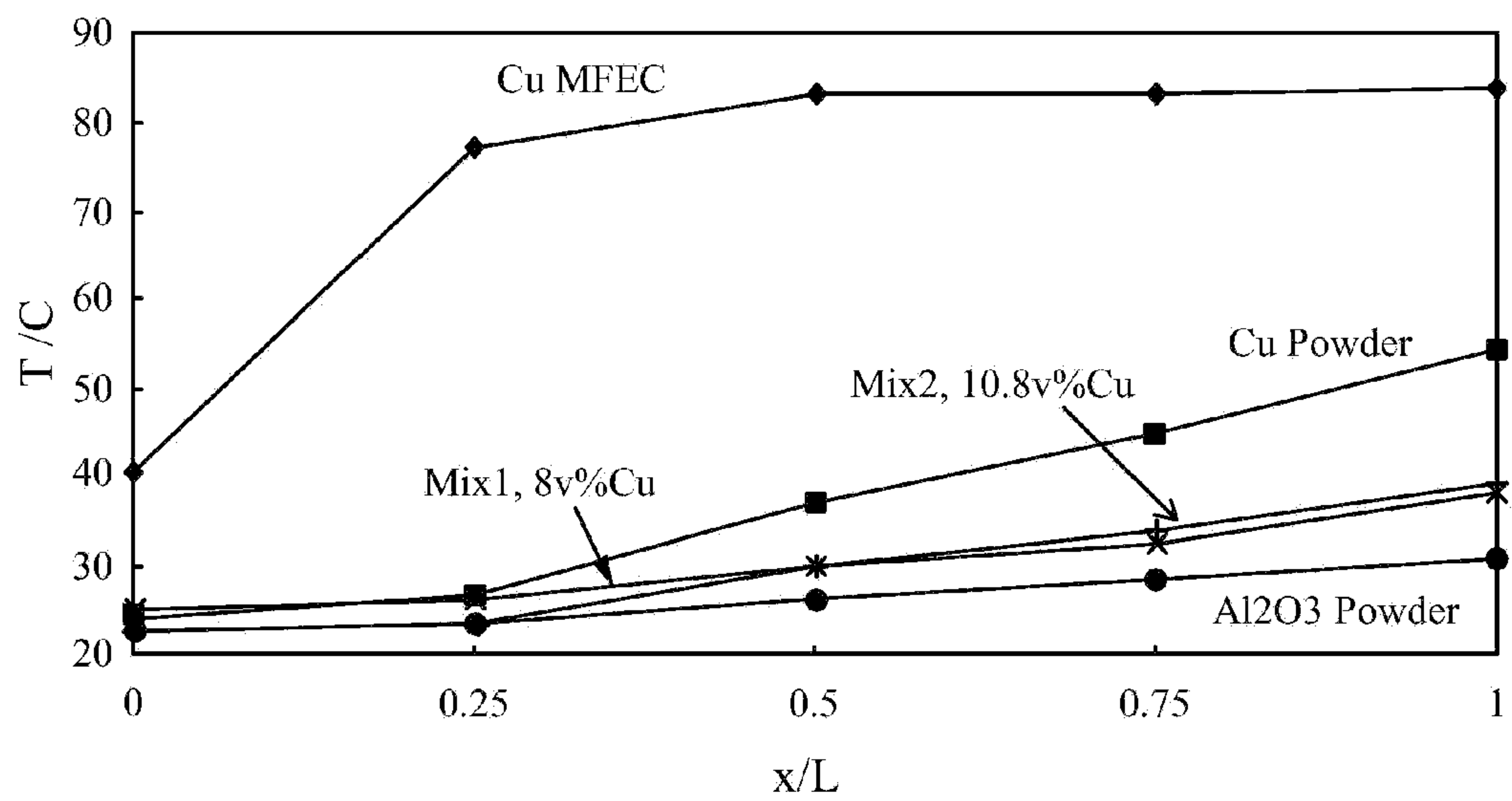


Fig. 4

**Fig. 5****Fig. 6**

**Fig. 7****Fig. 8**