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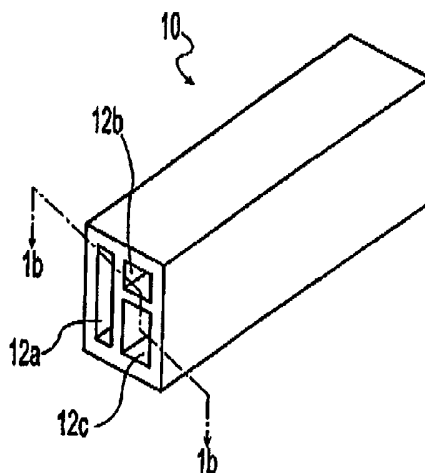
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(54) Title: MULTI-STREAM MICROCHANNEL DEVICE



(57) Abstract: The invention is a process and device for exchanging heat energy between three or more streams in a microchannel heat exchanger which can be integrated with a microchannel reactor to form an integrated microchannel processing unit. The invention enables the combining of a plurality of integrated microchannel devices to provide the benefits of large-scale operation. In particular, the microchannel heat exchanger of the present invention enables flexible heat transfer between multiple streams and total heat transfer rates of about 1 Watt or more per core unit volume expressed as W/cc.

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## MULTI-STREAM MICROCHANNEL DEVICE

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### CROSS-REFERENCE TO RELATED APPLICATIONS

The present application is related to the following commonly-assigned applications filed concurrently herewith on August 15, 2002: "Integrated Combustion Reactors and Methods of Conducting Simultaneous Endothermic and Exothermic Reactions", Attorney Docket No. 02-052 and "Process for Cooling a Product in a Heat Exchanger Employing Microchannels for the Flow of Refrigerant and Product", Attorney Docket No. 01-002 which applications are incorporated herein by reference.

### FIELD OF THE INVENTION

15 This invention relates to microchannel devices and processes for multi-stream heat exchange and particularly to multi-stream heat exchange in combination with chemical reaction and more particularly to multi-stream heat exchange in combination with endothermic chemical reactions such as reforming and more particularly to endothermic reactions coupled with exothermic reactions such as combustion.

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### BACKGROUND OF THE INVENTION

Heat exchangers are critical components in virtually all unit operations involving fluid (gas or liquid) streams. They become even more critical when it is desired to add heat or thermal energy or take away heat or thermal energy from a chemical reaction. For example, endothermic reactions often require, or benefit from, the addition of heat energy. Exothermic reactions, on the other hand, often require, or benefit from, the removal of heat energy. Owing to the economic importance of many such chemical reactions, there is a continual quest for improved performance, both in terms of conversion of reactants to products and in terms of selectivity to desired products relative to undesired products.

30 MicroChannel Technology (MCT) has been demonstrated to provide many such benefits and recent years have seen a significant increase in the application of MCT to many unit operations. See, e.g., A. A. Rostami et al., *Flow and Heat Transfer for Gas Flowing In Microchannels: A Review*, 38 Heat and Mass Transfer 359-67 (2002) (applications in

medicine biotechnology, avionics, consumer electronics, telecommunications, metrology, and many others) and R. S. Wegeng et al., *Compact Fuel Processors for Fuel Cell Powered Automobiles Based on Microchannel Technology*, Fuel Cells Bulletin No. 28 (2002) (compact hydrogen generators for fuel cells). MCT utilizes microchannel devices for carrying out processes that had previously been constrained to far larger equipment; often three to 1,000 times as large for comparable total throughput. MCT devices, which contain features of at least one internal dimension of width or height of less than about 2 mm and preferably less than about 1 mm, have the potential to change unit operations in ways analogous to the changes that miniaturization has brought to computing technology. MCT can be used to advantage in small-scale operations, such as in vehicles or personal (portable) devices. Importantly, too, MCT systems that can be economically mass-produced and connected together to accomplish large-scale operations are very desirable.

More particularly, heat exchangers have become smaller and smaller with more heat energy transferred per unit volume due to the additional area of smaller channels in heat exchangers. Earlier technology includes so-called compact heat exchangers. See, e.g., V. V. Wadekar, *a ChE's Guide to CHEs*, Chemical Engineering Progress, Dec. 2000, 30-49. Compact heat exchangers provide heat energy transfer rate densities, or heat energy transfer rate per unit volume (thermal power density) (where the volume is the total core volume as defined herein below), only up to about 0.4 W/cc for gas-phase exchangers. MCT heat exchangers, by comparison, provide heat energy transfer rate densities (thermal power density) of about 1 W/cc to 40 W/cc. Compact heat exchangers also have low interstream planar heat transfer percents, typically less than 10 percent. MCT heat exchangers, by comparison, have much higher interstream planar heat transfer percents, typically greater than 10 percent, preferably greater than 20 percent, more preferably greater than 40 percent, and even more preferably greater than 50 percent. In addition, MCT heat exchangers can rely on smaller average approach temperatures when producing the higher thermal power densities.

The above disadvantages of compact heat exchangers can be overcome by the use of MCT heat exchangers. There are problems, however, even with existing MCT heat exchangers. For example, MCT heat exchangers have not been designed which can process more than two separate streams in a single integral device. Processing three or more streams in a heat exchanger can, for example, enable unequal heat gain and loss between the three or

more streams. Thus, when it is desirable to transfer heat energy between three or more streams, a compact heat exchanger must be employed or multiple two-stream MCT heat exchangers must be employed. Even multiple two-stream MCT heat exchangers, however, allow significantly more heat transfer to the ambient and the necessary stream transfer piping can cause higher pressure drops to redistribute flows or dead zones and eddies which can cause extended residence times. These extended residence times can cause fouling, corrosion, erosion, decomposition, formation of undesirable byproducts, and, for example, coke can be deposited when processing carbon-containing streams at elevated temperatures. Furthermore, for MCT heat exchangers to realize their full potential, they must be combined in significant numbers to be scaled up to economic large-scale operations. Thus, owing to having a large number of small MCT heat exchangers in close proximity and the close proximity of one channel to another, manifolding the streams entering and exiting an MCT heat exchanger (or any MCT device) becomes a problem.

The manifold design objective is to provide for acceptably uniform flow through a device with an acceptable manifold geometry and stream mechanical energy losses. See, W.M. Kays and A.L. London, *Compact Heat Exchangers*, 3d ed., at 41 (1984). Restated, manifold design requires tradeoffs among device performance factors as affected by flow uniformity, overall pressure drop, and manifold size and complexity. For example, device performance could be heat transfer performance in the case of endothermic reactions coupled with exothermic reactions within an MCT device. As will be appreciated by those skilled in the art, the manifold design for any given stream is readily approached through application of fluid dynamics. Kays at 41-43.

When manifolding multiple streams in MCT devices, the design problem becomes even greater than designing a two-stream manifold. Having more streams present in a device means proportionally less of the external surface area of that device is available for accessing each stream. The compactness of an MCT device works against the geometric spacing requirements needed to seal manifolds to prevent stream-to-stream leakage. The manifold design must, therefore, address both the design objective stated herein above, as well as the limited external surface area.

Heat exchangers are not the only unit operation to benefit from the push toward miniaturization. Closely related, reactors, too, have begun to shrink in size substantially and with excellent results. Wegneg at 9-12 (vaporizers, reforming reactors, and steam

reforming). There remain, however, special problems involving MCT reactors and the need for heat transfer. For example, thermal stresses pose significant problems. MCT devices are manufactured and assembled to much higher tolerances than comparable conventional large-scale devices and multiple MCT devices must be closely-packed to economically match the throughput of comparable to large-scale devices. (An MCT device, while producing high output per core unit volume of the device, typically must be combined in very high numbers to provide comparable throughput.) Thus, temperature differentials that could be easily tolerated by a conventional device of greater dimensions can produce unacceptable thermal stresses in an MCT device which is smaller and thus experiences a much higher temperature gradient. Illustratively, an MCT reactor that is overly constrained geometrically either by multiple integral heat exchangers or integrally-combined multiple integral MCT heat exchanger/reactor units can be subjected to potentially destructive thermal stresses. In general, as a result of the increased efficiency of MCT heat exchangers, they exhibit high temperature gradients with corresponding high thermal stresses. To solve this problem, heat exchangers have been "de-coupled" from the reactors to allow for thermal expansion. In doing so, however, separate piping or tubing is required. As a result, as with multiple two-stream MCT heat exchangers, there can be significant heat loss between multiple units to the ambient and through associated piping or tubing. As noted herein above, such piping connections can become sites for fouling and coke-formation problems. Alternatively, more expensive metals that can tolerate the thermal stresses or inexpensive throwaway devices must be employed.

In addition, the goal of combining multiple heat exchanger/reactor devices to provide economically high total throughput has proved to be elusive. See, e.g., O. Woerz, *Microreactors as Tools in Chemical Research*, in *Microreaction Technology*, IMRET 5: Proceedings of the Fifth International Conference on Microreaction Technology at 385 (Michael Matlosz et al. eds. October 2001) ("In principle, [it is conceivable that microreactors can also be used for production]. However, serious problems would be encountered."). In the petroleum processing industry, for example, even minimally-sized specialty units, for, for example, hydrogen production, typically have a capacity of at least one million standard cubic feet per day (scfd) of hydrogen up to about 100 million scfd of hydrogen. A single-stream MCT device, in contrast, produces, at most, 1,000 to 10,000 scfd

of hydrogen. Therefore, to provide comparable throughput, a system must comprise from 100 to up to 100,000 closely-integrated arrays of microchannel units.

The present invention overcomes the drawbacks of the prior art of having to provide multiple two-stream heat exchangers with the necessary inter-unit piping, the inability of integrating an MCT heat exchanger with an MCT reactor, and combining a plurality of integrated MCT heat exchanger/reactor devices to form an MCT system to gain the benefits of large-scale operation, that is, high throughput to equal large-scale operations. In doing so, significant thermal power density with multiple streams is achieved, heat loss to the ambient is reduced, corrosion, erosion, decomposition, and coke formation are reduced or eliminated, and higher throughput per unit volume is attained. In addition, thermal stresses are reduced by operating devices with a monotonically increasing temperature profile.

#### BRIEF DESCRIPTION OF THE INVENTION

The present invention is a process and device for exchanging heat energy between three or more streams in an MCT heat exchanger, integrating the MCT heat exchanger with an MCT reactor to form an integrated MCT processing unit, combining a plurality of integrated MCT processing units into an integrated MCT processing system, and finally combining a plurality of integrated MCT systems into an MCT processing stack to provide the benefits of large-scale operation. Particularly, the MCT heat exchange process and device enables flexible heat transfer between multiple streams and total heat transfer rates of about 1 Watt (W) or more per core unit volume (cubic centimeters (cc)) (W/cc), pressure drop on the order of about 0.25 psi per in. or less, stream Reynolds Numbers in the transition or laminar zones, and interstream planar heat transfer percents of greater than about 30 percent. In some embodiments, the integrated MCT heat exchanger and MCT reactor exhibits a monotonically increasing temperature profile and, thus, thermal stresses are minimized.

#### BRIEF DESCRIPTION OF THE DRAWINGS

FIG. 1a is a perspective view of a heat exchanger according to the present invention.

FIG. 1b is a perspective section view at section 1b—1b of the perspective heat exchanger shown in FIG. 1a.

FIG. 1c is a plan view of the heat exchanger shown in FIG 1a.

FIG. 1d is a schematic perspective view of the heat exchanger shown in FIG. 1a illustrating counter-/co-flow operation.

FIG. 2a is a perspective view of a cross-flow heat exchanger according to a further embodiment of the present invention.

5 FIG. 2b is a perspective section view of the cross-flow heat exchanger shown in FIG. 2a at section 2b—2b.

FIG. 2c is a schematic perspective view of the cross-flow heat exchanger shown in FIG. 2a illustrating co-/cross-flow operation.

10 FIG. 3a is a cross-section view of an MCT device having a heat exchange portion and a reaction portion in combination according to the present invention.

FIG. 3b is a cross-section view of an MCT device having a heat exchange portion and a reaction portion in combination having a reverse orientation of the MCT device illustrated in FIG. 3a.

15 FIG. 4 is a cross-section view of an MCT device having a heat exchange portion and a reaction portion in combination according to a further embodiment of the present invention.

FIG. 5 is a cross-section view of an MCT processing system having a heat exchange portion and a reaction portion in combination according to the present invention.

FIG. 6a is an exploded perspective view of an MCT processing complex according to the present invention.

20 FIG. 6b is an exploded perspective view of an MCT processing complex reaction portion according to a further embodiment of the present invention.

FIG. 6c is an exploded perspective view of an MCT processing complex combustion portion according to a further embodiment of the present invention.

25 FIG. 7a is a modified negative cutaway perspective view of the MCT processing complex shown in FIG. 6a where channels are shown as solid regions.

FIG. 7b is a rotated modified negative cutaway perspective view of the MCT processing complex shown in FIG. 7a.

FIG. 8a is a perspective view an MCT processing stack according to a further embodiment of the present invention.

30 FIG. 8b is a rotated perspective view of the MCT processing stack shown in FIG. 8a.

FIG. 9 is a perspective view of the MCT processing stack shown in FIG. 8a illustrating stream headers and stream flows.

FIG. 10 is a plan view of the heat exchanger described in Example 1.

FIG. 11a is a perspective view of a first end of the heat exchanger described in Example 1.

FIG. 11b is a perspective view of a second end of the heat exchanger described in Example 1.

FIG. 12 shows the Volumetric Flowrates, Outlet Pressures, and Fluid Compositions for Example 1.

FIG. 13 shows the Inlet Temperatures for Example 1.

FIG. 14 shows the Outlet Temperatures for Example 1.

FIG. 15 shows the Pressure Drops for Example 1.

FIG. 16 shows a comparison of a heat exchanger according to the present invention with a computer simulation.

FIG. 17 shows the relationship of hydraulic diameter to heat transfer coefficient.

FIG. 18 shows an arrangement of channels exchanging heat wherein one fluid flows through a channel with heat enhancement fins.

FIG. 19 shows an arrangement of microchannels exchanging heat with no heat enhancement fins.

#### NUMERALS

10	MCT heat exchanger
20	11a First wall
	11b Second wall
	12a First microchannel
	12b Second microchannel
	12c Third microchannel
25	14 Length
	15a Height of microchannel 12a
	15b Width of microchannel 12a
	16a Height of microchannel 12b
	16b Width of microchannel 12b
30	17a Height of microchannel 12c
	17b Width of microchannel 12c
	18 Height of first wall 11a



	19	Width of second wall 11b
	16	Height
	18	Width
	20	First fluid stream
5	22	Second fluid stream
	24	Third fluid stream
	30	MCT heat exchanger
	32a	First microchannel
	32b	Second microchannel
10	32c	Third microchannel
	33	Rib
	34	First side
	36	Second side
	38	Third side
15	40	Fourth side
	42	First fluid stream
	44	Second fluid stream
	46	Third fluid stream
	50	MCT processing unit
20	52	Reactor microchannel
	54	First reactor heat exchange microchannel
	56	Reaction microchannel
	58	Second reactor heat exchange microchannel
	60	Reaction catalyst
25	62	Combustor microchannel
	64	First combustor heat exchange microchannel
	66	Combustion microchannel
	68	Second combustor heat exchange microchannel
	70	Combustion catalyst
30	72	Oxidizer microchannel
	74	Aperture
	75	Reactants stream

	76	Products stream
	77	Fuel stream
	78	Oxidizer stream
	79	Exhaust stream
5	80	MCT processing unit
	82	Reactor microchannel
	84	First reactor heat exchange microchannel
	86	Reaction microchannel
	88	Second reactor heat exchange microchannel
10	90	Reaction catalyst
	92	Combustor microchannel
	94	First combustor heat exchange microchannel
	96	Combustion microchannel
	98	Second combustor heat exchange microchannel
15	100	Combustion catalyst
	102	Oxidizer microchannel
	104	Aperture
	110	MCT processing system
	111	MCT processing unit
20	112	First reactor microchannel
	113	Second reactor microchannel
	114	First reactor heat exchange microchannel
	115	Second reactor heat exchange microchannel
	116	First reaction microchannel
25	117	Second reaction microchannel
	118	Third reactor heat exchange microchannel
	120	Reaction catalyst
	122	First combustor microchannel
	123	Second combustor microchannel
30	124	First combustor heat exchange microchannel
	125	Second combustor heat exchange microchannel
	126	First combustion microchannel

	127	Second combustion microchannel
	128	Third combustor heat exchange microchannel
	130	Combustion catalyst
	132	First oxidizer microchannel
5	133	Second oxidizer microchannel
	134	Aperture
	136	First termination microchannel
	138	Second termination microchannel
	140	Reactor microchannel tongue
10	142	Combustor microchannel tongue
	210	MCT processing complex
	212	First reactants manifold
	213	First reactants manifold stub
	213a	Reactants flue
15	214	Second reactants manifold
	215	Second reactants manifold stub
	216	Products manifold
	217	Products manifold stub
	217a	Products flue
20	218	First fuel manifold
	219	First fuel manifold stub
	219a	Fuel flue
	220	Second fuel manifold
	221	Second fuel manifold stub
25	222	First oxidizer manifold
	223	First oxidizer manifold stub
	223a	Oxidizer flue
	224	Second oxidizer manifold
	225	Second oxidizer manifold stub
30	310	MCT processing stack
	312	Reactants header
	314	Products header

- 316 Fuel header
- 318 Oxidizer header
- 320 Exhaust header

5                    DETAILED DESCRIPTION OF THE INVENTION AND BEST MODE

The term “millichannel” refers to a channel having at least one internal dimension of width or height of up to about 10 mm.

10                    The term “microchannel” refers to a channel having at least one internal dimension of width or height of up to about 2 mm, and in one embodiment from about 0.1 mm to about 2 mm, and in one embodiment from about 0.1 mm to about 1 mm. The length may be up to about 5 meters (m) or more. Preferably, the length is about 1 m or less. More preferably the length is about 0.5 m or less. A microchannel is also a millichannel.

15                    A millichannel may be used in an apparatus in conjunction with microchannels for both heat exchanger applications and for combined heat exchange and reactor applications. The milli-channel offers the advantage of reduced pressure drop, but the disadvantage of lower heat transfer coefficients and surface area, including IPHTAP-type area. There are examples of when a process is advantaged by the inclusion of a milli-channel with microchannels for multiple fluid processing streams. As one example, if a relatively large  
20                    fraction of heat greater than 70 percent were desired to be transferred from Fluid A to Fluid B and a much smaller fraction of heat from Fluid A to Fluid C in a single apparatus, then the Fluid C channels may be made in the milli-channel range. Combined exchanger and reactor applications may be advantaged by the inclusion of one or fluid milli-channel. As an example, in the limit of a very low pressure drop constraint on one or more fluids, such as  
25                    combustion air, this channel may be designed in the milli-channel range. A very low pressure drop requirement for one fluid in a heat exchanger application may necessitate the use of a milli-channel. As one example, a process that utilized natural gas to provide home heating or power would be required to not exceed the allowable back pressure on the feed line, typically a few psi. Another advantage of a combined milli-channel and microchannel  
30                    process is the combined application of homogeneous combustion with additional heat exchangers to preheat and recover heat. Heat recovery from combustion may take the form of heating water for portable or stationary applications. Homogeneous combustion is

challenging in a microchannel for many hydrocarbon fuels, as the critical hydrocarbon quench diameter is often larger than a microchannel but well below the limits of a milli-channel. As an example, the quench diameter of methane exceeds 2 mm at room temperature and would not ignite in a microchannel. As the critical dimension increases from the microchannel range out to the broader milli-channel range, the overall size of the device may grow larger. For some applications, this is not disadvantageous if there are no space limitations. It will be appreciated by one skilled in the art, that many applications could be advantaged through the combinations of microchannels and milli-channels to tailor the performance of a process to meet desired specifications.

The term "microchannel" or "MCT" when applied to a device, process, system, or the like, means that such device, process, or system includes at least one microchannel.

The term "MCT processing unit" refers to a microchannel device having at least one reactor section and at least one heat exchanger section in combination.

The term "MCT processing system" refers to a plurality of MCT processing units in combination.

The term "MCT processing complex" refers to a plurality of MCT processing systems in combination.

The term "MCT processing stack" refers to a plurality of MCT processing complexes in combination.

The term "total core volume V" refers to the sum total volume of microchannels plus the volume of walls separating the microchannels, but specifically excluding any volume defined by any manifolds or headers. Thus, outside walls which define the outer dimensions of the device, are not included. Referring to FIGs 1a and 1b, by way of example only, the total core volume V of the device shown would be computed as follows:

$$V = [(height\ 15a) * (width\ 15b) + (height\ 16a) * (width\ 16b) + (height\ 17a) * (width\ 17b) + (height\ 18) * (width\ 17b) + (height\ 15a) * (width\ 19)] * [length\ 14]$$

As will be understood by those skilled in the art, the total core volume V will be calculated based upon generally accepted principles of solid geometry and different configurations may be approached in different manners.

The term "total thermal power density" refers to the amount of heat gained by the cold stream(s) divided by the total core volume V.

The term "interstream planar heat transfer area percent" (IPHTAP) relates to the highest effective heat transfer and refers to the surface area that separates two fluids exchanging heat in a channel device excluding ribs, fins, and surface area enhancers as a percent of the total interior surface area of a channel that also includes ribs, fins, and surface area enhancers. That is, the ratio of the area through which heat is transferred to neighboring channels with a different fluid flowing to the total surface area of the channel. Referring to FIG. 18, an arrangement of channels is shown exchanging heat; there are three fluids, Fluid A, Fluid B, and Fluid C. Fluid A exchanges heat with Fluid B and with Fluid C. Channel A comprises heat enhancement fins (N/in.) as shown in FIG. 18. IPHTAP is calculated as  $[2a/(2a+2b+2c)]*100$ . In a typical compact heat exchanger, where  $a = 2.0$  in.,  $b = 0.5$  in., and  $N = 20$  fins/in., IPHTAP equals 16 percent. A geometry with IPHTAP = 100 percent would signify that all available area is utilized for exchanging heat with neighboring different streams. This example assumes that heat exchange at both long edges of the channel. If the channel is an end channel and exchanges heat at only one edge, IPHTAP = 8 percent. In a microchannel, in contrast (FIG. 19), where  $a = 2.0$  in.,  $b = 0.025$  in.,  $d = 0.040$  in. and  $e = 0.98$  in., IPHTAP would be: Channel with Fluid A =  $[2a/(2a+2b)]*100 = 49$  percent; Channel with Fluid B =  $[8c/(8c+8b)]*100 = 95$  percent; Channel with Fluid C =  $[2e/(4e+4b)]*100 = 49$  percent.

When used in this Specification, the terms "reactor", "reaction", "combustor", "combustion", "oxidizer", and the like, when referring to microchannels and streams, are nominal only. It is to be understood that, within the scope and spirit of the present invention, no reaction or any reaction and no combustion or any similar combustion or exothermic reaction may take place within such named microchannels. By way of example only, reactions may include catalytic processes such as acetylation, addition reactions, alkylation, dealkylation, hydrodealkylation, reductive alkylation, amination, aromatization, arylation, autothermal reforming, carbonylation, decarbonylation, reductive carbonylation, carboxylation, reductive carboxylation, reductive coupling, condensation, cracking, hydrocracking, cyclization, cyclooligomerization, dehalogenation, dimerization, epoxidation, esterification, exchange, Fischer-Tropsch, halogenation, hydrohalogenation, homologation, hydration, dehydration, hydrogenation, dehydrogenation, hydrocarboxylation, hydroformylation, hydrogenolysis, hydrometallation, hydrosilation, hydrolysis, hydrotreating, hydrodesulfurization/hydrodenitrogenation (HDS/HDN), isomerization, methanation,

methanol synthesis, methylation, demethylation, metathesis, nitration, oxidation, partial oxidation, polymerization, reduction, Sabatier reaction, steam and carbon dioxide reforming, sulfonation, telomerization, transesterification, trimerization, water gas shift (WGS), and reverse water gas shift (RWGS). By further example, phase changes such as condensation and evaporation are also within the contemplation of the present invention, as are operations such as absorption and adsorption.

Referring initially to FIGs 1a-1d, the MCT heat exchanger 10 of the present invention has a total core volume  $V$  and comprises a first microchannel 12a, a second microchannel 12b, and at least a third microchannel 12c. In operation, a first stream 20, a second stream 22, and at least a third stream 24 flow through the first microchannel 12a, the second microchannel 12b, and the at least third microchannel 12c, respectively. While FIG. 1d illustrates a single-pass, parallel counter/co-current flow pattern, it will be understood by those skilled in the art that the flow pattern may be any of suitable design. Multiple pass flows as well as co-current and cross-current flow patterns (shown in FIGs 2a-2c) are possible. Importantly, the total thermal power densities of such devices can be from about one (1) W/cc to 40 W/cc or more, the total pressure drop can be 0.25 psi per in. or less, and the interstream planar heat transfer area percent greater than 10 percent. Particular attention is drawn to the shapes, sizes, and separations of the first microchannel 12a, the second microchannel 12b, and the at least third microchannel 12c. By varying the dimensions and overall design format of the microchannel layout and the walls separating the microchannels, the flow of heat energy between streams can be varied virtually infinitely. It is also possible to provide a higher heat transfer rate per unit volume, less metal between microchannels is required, and a higher heat transfer coefficient per hydraulic diameter. Thus,

$h \sim f(D_h)$ , where  $h$  is the heat transfer coefficient,  $D_h$  is the hydraulic

diameter, and

$D_h = 4A/P$ , where  $A$  is the cross-sectional area and  $P$  is the wetted perimeter.

As is shown, for example, in FIG. 16, heat transfer coefficients,  $h$ , increase as the hydraulic diameter,  $D_h$ , decreases.

Consider, first, the overall size of the device; the width, length, and height. A larger overall size leads to higher total heat capacities and less relative heat loss ( $Q_{\text{loss}}/Q_{\text{total}}$ ) but

also leads to difficulties in manifolding and flow distribution. In a counter-current flow heat exchanger, a larger heat exchanger length gives a smaller average approach temperature between the hot and cold streams. That is,  $T_{\text{hot-exit-mean}} - T_{\text{cold-inlet-mean}}$ . However, a smaller

approach temperature also indicates lower transversal heat flux between the streams.

5 Consider, next, the thermal properties of the device; including the thermal conductivity, specific heat, and density. A higher thermal conductivity gives a higher transversal heat transfer rate but also higher longitudinal heat conduction. The former will enhance the heat transfer between the streams in adjacent channels. The latter is undesirable because it degrades the heat exchange performance due to larger approach temperatures. An optimal

10 thermal conductivity for a given structure and dimensions for microchannel heat exchangers can be determined. See, e.g., T. Stief et al., *Numerical Investigations on Optimal Heat Conductivity in Micro Heat Exchangers*, AIChE 2000 Spring Meeting (March 2-9, 2000).

Larger specific heats and densities lead to higher thermal inertia and, therefore, a slow transition of operation statuses, for example start-up and shut-down. Consider, next, the total

15 flow rate, or capacity, of an individual stream. The increase in flow rate generally leads to a smaller temperature drop of a hot stream (or to a smaller increase in temperature of a cold stream) throughout the exchanger. This also means that the overall approach temperature of all the streams will increase. If the flow rates of other streams remain unchanged, the local heat flux will increase by increasing the flow rate of one stream. A decrease in the

20 microchannel dimension leads to an increase in the heat transfer coefficient and, in turn, the heat flux between the fluid in the microchannel and the microchannel wall. For a cold stream, its exit temperature becomes higher, for the same mass flux, than it was before reducing the size of the microchannel dimension. The overall thermal effectiveness is increased because the amount of heat transferred from or to the other streams also increases.

25 However, the increase in the amount of heat transferred from or to the other streams is generally smaller than that of the stream whose microchannel dimension is reduced. There is, however, a practical lower limit since the lower the microchannel dimension, the higher the pressure drop. In the present invention, a microchannel having a rectangular cross-section is preferred as this geometry gives higher heat transfer coefficients and less solid material is required than with a square or round channel. Particularly, very wide microchannels with a  
30 very small microchannels can nearly isolate a particular stream from thermal communication with other streams. A spacer or rib in, or between streams, may function as a fin to improve



the heat transfer between the stream and the solid wall and, in turn, improve the heat transfer to other streams. This effect is also found in ribs, webs, and spacers between different streams at temperatures lower than local wall temperatures. However, one of the effects of increasing the dimensions of webs, ribs, spacers, and perimeter metal is to increase the unwanted metal cross-sectional area and, in turn, the axial conduction. Another effect of increasing dimensions of webs between different streams is to increase the resistance of transverse heat conduction when heat transfer between the two streams is desired. These two effects decrease the transverse heat flux between different streams and, therefore, degrade the heat exchange performance.

As will be appreciated by those skilled in the art, the choice of microchannel cross-section is not limited to rectangular; other polygonal and even circular or elliptical cross-sections can be used within the scope of the present invention.

Referring now to FIGs 2a-2c, in another embodiment of the present invention, an MCT heat exchanger has at least four surfaces 34, 36 (indicated but not shown), 38, and 40 (indicated but not shown), and comprises a first microchannel 32a, a second microchannel 32b, and at least a third microchannel 32c. In operation, a first stream 42, a second stream 44, and at least a third stream 46 flow through the first microchannel 32a, the second microchannel 32b, and the at least third microchannel 32c, respectively. Illustratively, the third microchannel 32c may further comprise a plurality of interior walls or ribs 33. As will be appreciated by those skilled in the art, the ribs 33 introduce significant design flexibility and allow a virtually limitless combination of hydraulic diameters. In addition, the ribs 33 can, in appropriate circumstances, help provide additional structural support when dealing with pressure differentials across the walls separating one microchannel from another. While FIGs. 2a-2c illustrate a single-pass flow pattern, it will be understood by those skilled in the art that the flow pattern may be of any suitable design. In addition, one skilled in the art will appreciate that the angles between the faces need not be exact right angles as shown; many other angles will be effective depending upon the application. Importantly, however, the total thermal power density of such devices can be about 21 W/cc to 40 W/cc or more.

As will be further appreciated by those skilled in the art, the usefulness of the present invention is not limited to the specific configurations illustrated in FIGs 1a-1d and 2a-2c. By way of example only, the various microchannels may vary in number, size, and complexity. The relative positions of one microchannel to other microchannels may also be varied as may

the thickness as well as the inherent thermal conductivity of the walls separating one microchannel from the other microchannels. See discussion herein above.

#### Example 1

5 Referring now to FIGs 10-15, a heat exchanger was specifically designed to simulate a heat exchanger according to one embodiment of the present invention. The heat exchanger used five distinct fluids, denoted in FIGs 10-15 as Fluids A, B, C, D, and E. Fluids C and D were split into two streams each with each stream flowing through separate microchannels; fluids A, B, and E each flowed through separate microchannels (as Streams A, B, and E,  
10 respectively), making a total of seven microchannels in the heat exchanger. As shown in FIG. 10, Fluid C flowed through two microchannels as Stream C1 and Stream C2. Similarly, Fluid D flowed through two microchannels as Stream D1 and D2. The experimental results show the performance of the heat exchanger and the results as compared to numerical simulations from a computer program.

15 Referring again to FIG. 10, the heat exchanger consisted of seven rectangular microchannels, each ten inches (in.) long. The height of each microchannel where Streams A and B flowed was 0.020 in. The height of the microchannel where Stream E flowed was 0.040 in. The height of each microchannel where Stream D1 and Stream D2 flowed was 0.020 in., and the heights of the microchannels where Streams C1 and C2 flowed were 0.030  
20 in. and 0.020 in., respectively. The order of the seven streams in the heat exchanger was C1, D1, A, B, E, C2, and D2 (shown in FIG. 10). (For clarity and consistency, the heat exchanger microchannels are referred to by the name of the stream flowing through them. Thus, Stream C1 flows through microchannel C1.)

The heat exchanger was constructed of Inconel 625 and the microchannels were  
25 made by "popping" a 0.030-in. diameter hole with an electrode in the places where the rectangular microchannels were needed. After the holes were made, microchannels were made by using wire ElectroDischarge Machining (EDM). If the microchannel width was less than 0.030 in., the edge portions of the original round hole still existed around the outside of the microchannel; the portions of the original hole were purposely, alternatingly, offset to the  
30 top and bottom of the microchannels. If the microchannel width was equal to or greater than 0.030 in., no portions of the round hole remained.

Referring to FIGs. 11a and 11b, manifolding for the inlet of Microchannel C2 was accomplished by sending Stream C2 directly into the device while manifolding for the outlet of Microchannel C1 was accomplished by exiting Stream C1 directly out from the device; the other microchannels were blocked off by welding the microchannels closed on the front and back faces. The inlet to Microchannel C1 was manifolded by drilling in through the side of the heat exchanger. The outlet from Microchannel C1 came directly out of the heat exchanger similar to Microchannel C2. Microchannel D2 on the edge of the heat exchanger was also manifolded in and out of the side of the heat exchanger. The other microchannels in the center of the heat exchanger were manifolded in the top and bottom of the heat exchanger. The diameter of the inlet and outlet holes was equal to or smaller than the width of the channel, i.e., 0.020 in. to 0.040 in. Generally, three or four holes that served as the inlet or exit were drilled into each such microchannel.

The exact composition and flowrates of each of the streams for each test are shown in FIG. 12. Experiments were performed with flowrates corresponding to six conditions. The first two conditions were nearly equivalent except that the reactant and product streams entered the heat exchanger at approximately one-half the expected pressure.

Experiments were performed at the temperatures and pressures shown in FIGs 12 and 13. The directions of the streams are shown in FIGs 11a and 11b. Streams A, C1, C2 flow in the same direction and counter-current to the flow of Streams B, D1, D2, and E.

There were three sets of experimental tests performed for the heat exchanger; Tests X, Y, and Z as shown in FIGs 12-15. The pressure drops of some of the streams are shown in FIG. 15; all pressure drops were measured before and after the fluid entered and exited the microchannel, therefore contraction and expansion losses are included in the measured pressure losses. The pressure losses of the individual streams were measured with differential pressure gauges, most of which measured a maximum differential pressure of 5.4 psi and a resolution of 0.1 psi. The stream labeled D1 was measured with a meter capable of measuring 9.0 psi and a resolution of 0.2 psi.

The five-stream heat exchanger demonstrated that a multi-stream microchannel heat exchanger could successfully heat and cool multiple streams in a single device. There was reasonable agreement with a numerical simulation that was constructed. The comparison between the experimental values and the results from the numerical simulation are shown in FIG. 16. The inlet temperatures were fixed and the outlet temperatures calculated.

An approach temperature was also calculated:

$$T_m = \frac{\sum_{i=1}^n T_i \cdot m_i \cdot Cp_i}{\sum_{i=1}^n m_i \cdot Cp_i},$$

5 where  $T_m$  is the mean temperature of the hot streams at a first end of the heat exchanger and is also used to calculate the mean temperature of the cold streams at the first end, the mean temperature of the hot streams at the second end, and the mean temperature of the cold streams at the second end.  $T_i$  is the  $i$ th hot stream,  $m_i$  is the mass flow rate (kg/s) of the  $i$ th hot stream,  $Cp_i$  is the heat capacity of the  $i$ th hot stream. The mean temperature of the hot  
10 streams at the first end was 857 deg. C and at the second end 250 deg. C. The mean temperature of cold streams at the first end 730 deg. C and at the second end 161 deg. C. The mean approach temperatures are: 126 deg. C at the first end and 89 deg. C at the second end.

Referring now to FIG. 3a, in another embodiment of the present invention, an MCT  
15 processing unit 50 has a total core volume  $V$  (not shown) and comprises a reactor microchannel 52, a combustor microchannel 62, and an oxidizer microchannel 72. The reactor microchannel 52 comprises a first reactor heat exchange microchannel 54, a reaction microchannel 56, and a second reactor heat exchange microchannel 58. Alternatively, only one reactor heat exchange microchannel may be present. Also, as will be understood by  
20 those skilled in the art, the precise point where the reactor microchannel 52 is no longer primarily exchanging heat and is functioning primarily as a reactor can be difficult to determine and can be somewhat arbitrary. For example, the reactor microchannel 52 may be in thermal communication with one or more other microchannels in the same unit. The reaction microchannel 56 may further include a reaction catalyst 60. The reaction catalyst 60  
25 may contain any suitable metal or semi-metal and/or their oxides comprising one or more elements from Groups IIIA, IVA, VA, VIIA, VIIIA, IB, IIB, IIB, IVB, Ce, Pr, Sm, Tb, Th or their oxides and combinations thereof. The reaction catalyst 60 may also contain promoters which enhance the chemical or physical properties of the reaction catalyst 60, and may contain any suitable metal, semi-metal or non-metal, and/or their oxides, comprising one or  
30 more elements from the previous list and/or Group IA, IIA, VB, VIB and combinations

thereof. The reaction catalyst 60 may also be supported on any suitable support material, such as silica, alumina, zirconia, titania, magnesia, yttria, ceria, lanthana, carbon or combinations of these, which supply either sufficient surface area or chemical interaction to benefit the action of the active constituent. The reaction catalyst 60, by way of example only, may be applied to an engineered substrate such as a felt, foam, fin, mesh, gauze, or foil and the substrate inserted into a cutout (not shown) in a wall of the reaction microchannel 56 to act as a flow-by catalyst, may be inserted into the reaction microchannel 56 to act as a flow-through catalyst, or may be applied to a wall or walls of the reaction microchannel 56 as a washcoat. Thus, the reaction catalyst 60 may be present in the form of a powder or small pellet, a monolith, a wall coating or combinations of these forms. In the case of powders and monoliths, the reaction catalyst 60 may be comprised of a skeletal, or Raney type, metal. In the case of a monolith, the reaction catalyst 60 may be present as a slurry or wash coating on a foam, felt, screen, mesh, gauze or similar substrate. In the case of a wall coating, the reaction catalyst 60 may be applied as by slurry coating or direct wash coating, preferably with prior treatment of the wall in such a way as to maximize adhesion and/or surface area. In some cases, constituents of the reaction catalyst 60 may be comprised wholly or partially from native materials present in the wall or monolith alloys. The reaction catalyst 60 may also include two or more different catalyst types in different regions of the reaction microchannel 56. Alternatively, depending upon the desired reaction, the reaction microchannel 56 may include no reaction catalyst 60. Finally, there may be no reaction in reaction microchannel 56, for example, when vaporizing a liquid stream.

The combustor microchannel 62 comprises a first combustor heat exchange microchannel 62, a combustion microchannel 66, and a second combustor heat exchange microchannel 68. As with the reactor microchannel 52, alternatively, only one combustor heat exchange microchannel may be present. Also, as with the reactor microchannel 52, as will be understood by those skilled in the art, the precise point where the combustor microchannel 62 is no longer primarily exchanging heat and is functioning primarily as a combustor can be difficult to determine and somewhat arbitrary. And, in fact, combustion and significant heat exchange can, and does, occur in the same region of the combustor microchannel 62. For example, the combustor microchannel 62 may be in thermal communication with one or more other microchannels in the same device. The combustion microchannel 66 may also include a combustion catalyst 70. To provide further flexibility,

the first combustor heat exchange microchannel 64 and the second heat exchange microchannel 68 may also include a combustion catalyst 70 to provide pre- and post-oxidation reactions. The combustion catalyst may contain any suitable active metal and/or metal oxide, preferably comprising one or more elements from Groups IIIA, VIIIA or IB, Ce, Pr, Sm or their oxides and combination thereof, or more preferably comprising one or more of the elements Pt, Pd, Y, La, Ce, Pr or their oxides, and combinations thereof. The combustion catalyst 70 may also be supported on any suitable support material, such as silica, alumina, zirconia, titania, magnesia, yttria, ceria, lanthana, carbon or combinations thereof, which supply either sufficient surface area or chemical interaction to benefit the action of the active constituent. The combustion catalyst 70 may be present in the form of a powder or small pellet, a monolith, a wall coating or combinations of these forms. In the case of powders and monoliths, the combustion catalyst 70 may be comprised of a skeletal, or Raney type, metal. In the case of a monolith, the combustion catalyst 70 may be present as a slurry or wash coating on a foam, felt, screen, mesh, gauze or similar substrate. In the case of a wall coating, the combustion catalyst 70 may be applied as by slurry coating or direct wash coating, preferably with prior treatment of the wall in such a way as to maximize adhesion and/or surface area. In some cases, constituents of the combustion catalyst 70 may be comprised wholly or partially of native materials present in the wall or monolith alloys. Alternatively, depending upon the desired combustion, the combustion microchannel 66, the first combustor heat exchange microchannel 64, and the second combustor heat exchange microchannel 68 may include no combustion catalyst 70. As will be appreciated by those skilled in the art, combustion may be replaced with any number of exothermic reactions. By way of example only, acetylation, alkylation, hydrodealkylation, epoxidation, Fischer-Tropsch, hydration, dehydration, hydrogenation, oxidative dehydrogenation, hydrolysis, methanation, methanol synthesis, metathesis, oxidation, polymerization, and water-gas shift (WGS).

The oxidizer microchannel 72 comprises one or more apertures 74 through which the oxidizer microchannel 72 is in fluid communication with the combustor microchannel 62. As with the combustor microchannel 62, the oxidizer microchannel 72 may provide for the introduction of other reactants to an exothermic reaction.

In operation, by way of example only, a reactants stream 75, such as a mixture of steam and methane, is introduced into the reactor microchannel 52 at the first reactor heat

exchange microchannel 54. A fuel stream 77, such as hydrogen or methane or other hydrocarbon, is introduced into the combustor microchannel 62 at the first combustor heat exchange microchannel 64, and an oxidizer stream 78, such as air, is introduced into the oxidizer microchannel 72. As the reactants stream 75 flows through the reaction microchannel 56 it is converted, for example, in a reforming reaction, to the products stream 58, such as a mixture of steam, methane, and hydrogen. A reaction catalyst 60 is used. As the fuel stream 77 flows through the first combustor heat exchange microchannel 64 and the combustion microchannel 66, it becomes combined with oxidizer 78 introduced into the oxidizer microchannel 72 and thus into the combustor microchannel 64 via the one or more apertures 74, and combusts to form the exhaust stream 79. A combustion catalyst 70 may be [is?] used. Note that pre-oxidation may occur in the first combustor heat exchange microchannel 64 to preheat the reactants stream 75. Likewise, oxidation may continue into the second combustor heat exchange microchannel 68 to provide additional heat energy downstream of the combustion microchannel 66. By further example only, the reaction converting the reactants stream 75 into the products stream 76 is an endothermic reaction such as steam methane reforming or hydrocarbon dehydrogenation, the fuel stream 77 is hydrogen or a combination of carbonaceous fuels, and the oxidizer stream 78 is air.

As will be appreciated by those skilled in the art, the present invention, embodiments of which are represented and described herein, may be useful for unit operations where there is only a single reaction. By way of example only, reactor microchannel 52 may serve as a vaporizer. Similarly, an MCT device may comprise a first combustor microchannel in thermal communication with a second combustor microchannel, the combustor microchannels supported by one or more oxidizer microchannels. And, as discussed herein above, oxidative combustion need not be one of the reactions involved. To further illustrate the flexibility of the present invention, FIG. 3b shows a modification of the MCT processing unit 50 of FIG. 3a. All descriptions in FIG. 3a are attributable to FIG. 3b but the flow is shown in a countercurrent pattern.

FIG. 4 shows another embodiment of the present invention. An MCT processing unit 80 has a total core volume  $V$  (not shown) and comprises a reactor microchannel 82, a combustor microchannel 92, and an oxidizer microchannel 102. The reactor microchannel 82 comprises a first reactor heat exchange microchannel 84, a reaction microchannel 86, and a second reactor heat exchange microchannel 88. Alternatively, only one reactor heat

exchange microchannel may be present. Also, as will be understood by those skilled in the art, the precise point where the reactor microchannel 82 is functioning primarily as a reactor or not can be difficult to determine and can be somewhat arbitrary. For example, the reactor microchannel 82 may be in thermal communication with one or more other microchannels in the same device. The reaction microchannel 86 may further include a reaction catalyst 90. Alternatively, depending upon the desired reaction, the reaction microchannel 86 may include no reaction catalyst 90.

The combustor microchannel 92 comprises a first combustor heat exchange microchannel 92, a combustion microchannel 96, and a second combustor heat exchange microchannel 98. As with the reactor microchannel 82, alternatively, only one combustor heat exchange microchannel may be present. Also, as with the reactor microchannel 82, as will be understood by those skilled in the art, the precise point where the combustor microchannel 92 is no longer primarily exchanging heat and is functioning primarily as a combustor can be difficult to determine and somewhat arbitrary. For example, the combustor microchannel 92 may be in thermal communication with one or more other microchannels in the same device. The combustion microchannel 96 may also include a combustion catalyst 100. To provide further flexibility, the first combustor heat exchange microchannel 94 and the second heat exchange microchannel 98 may also include combustion catalyst 100. The combustion catalyst 100 may be [different types of catalysts and different methods of applying]. Alternatively, depending upon the desired combustion, the combustion microchannel 96, the first combustor heat exchange microchannel 94, and the second combustor heat exchange microchannel 98 may include no combustion catalyst 100.

The oxidizer microchannel 102 comprises one or more apertures 104 through which the oxidizer microchannel 102 is in fluid communication with the combustor microchannel 92.

Operation of the MCT processing unit 80, by way of example only, is analogous to that described herein above in reference to the MCT processing unit 50.

As will be appreciated by those skilled in the art, the apertures 74 (shown in FIGs 3a and 3b) and the apertures 104 (shown in FIG. 4) add yet another dimension to the design flexibility of the present invention. By varying the placement, cross-section, shape, and size of a plurality of apertures 74 and of a plurality of apertures 104, significant flexibility can be achieved in combining two or more streams. Likewise, the thickness of the material through



which the apertures 74 and the apertures 104 are created can add yet another dimension to the design flexibility. By changing these variables, the mixing or fluid communication between the two streams can be uniquely controlled. By way of example only, in a combustion application, the temperature profile and the heat transferred can be tailored to the particular application and reactor design. This is achieved because the oxidizer stream 78 acts as a limiting agent in a combustion reaction. Thus, the apertures 74 and apertures 104 function to introduce specific amounts of the oxidizer stream 78 to specific points so as to control the rate and extent of the combustion reaction along the entire length of the combustor microchannel 62 and combustor microchannel 92.

Referring now to FIG. 5, an MCT processing system 110 has a total core volume  $V$  (not shown) and comprises a plurality of MCT processing units 111, a first termination microchannel 136, and a second termination microchannel 138. As will be understood by those skilled in the art, the choice of termination modes may be varied according to the design requirements of the MCT processing system 110. As discussed herein above, to realize the advantages of MCT, multiple MCT processing units 111 must be combined into an integrated system to approach the total throughput of a large-scale operation. The MCT processing system 110 helps accomplish that by integrating a plurality of MCT processing units 111, the basic technology of which has been introduced herein above.

Each MCT processing unit 111 comprises a first reactor microchannel 112, a second reactor microchannel 113, a first combustor microchannel 122, a second combustor microchannel 123, a first oxidizer microchannel 132, and a second oxidizer microchannel 133. The first reactor microchannel 112 comprises a first reactor heat exchange microchannel 114, a first reaction microchannel 116, and a third reactor heat exchange microchannel 118. The second reactor microchannel 113 comprises a second reactor heat exchange microchannel 115 and a second reaction microchannel 117 and is in fluid communication with the third reactor heat exchange microchannel 118. The first reaction microchannel 116 may also include a reaction catalyst 120. The second reaction microchannel 117 may also include a reaction catalyst 120. Preferably, as shown in FIG. 5, a reactor microchannel tongue 140 is also included.

The first combustor microchannel 122 comprises a first combustor heat exchange microchannel 124, a first combustion microchannel 126, and a third combustor heat exchange microchannel 128. The second combustor microchannel 123 comprises a second combustor

heat exchange microchannel 125 and a second combustion microchannel 127 and is in fluid communication with the third combustor heat exchange microchannel 128. The first combustion microchannel 126 may also include a combustion catalyst 130. The second combustion microchannel 127 may also include a combustion catalyst 130. Preferably, as shown in FIG. 5, a combustor microchannel tongue 142 is also included. The reactor microchannel tongue 140 and the combustor microchannel tongue 142 provide flow stabilization and, if non-rigid, flow equalization to overcome minor variations in microchannel dimensions.

The first oxidizer microchannel 132 comprises at least one aperture 134 through which the first oxidizer microchannel 132 is in fluid communication with the first combustor microchannel 126. The second oxidizer microchannel 133 comprises at least one aperture 134 through which the second oxidizer microchannel 133 is in fluid communication with the second combustor microchannel 123.

Operation of each MCT processing unit 111, by way of example only, is analogous to that described herein above in reference to the MCT processing unit 50 and the MCT processing unit 80.

Referring now to FIG. 6a, an MCT processing complex 210 has a total core volume V (not shown) and comprises a plurality of MCT processing systems 110 (best illustrated in FIG. 5), a first reactants manifold 212, a second reactants manifold 214, a products manifold 216, a first fuel manifold 218, and a second fuel manifold 220. As will be appreciated by those skilled in the art, the precise arrangement of each manifold is subject to various design considerations and it is within the scope and intent of the present invention to include other such arrangements. By way of example only, the first fuel manifold 218, the second fuel manifold 220, the first reactants manifold 212, and the second reactants manifold 214 the first reactants manifold 212, and the second reactants manifold 214 all terminate on the same face of the MCT processing complex 210 but at different positions along an external face of the MCT processing complex 210. (Also seen in FIGs 8a and 8b.) As will further be appreciated by those skilled in the art, an exhaust manifold (not shown) could also be included to collect fluids exiting the third combustor heat exchange microchannels 128. By way of further illustration, FIGs 7a and 7b show a partial cutaway negative wireframe view of the microchannel arrangement shown in FIG. 6a. In addition to a plurality of MCT processing

systems 110, it is preferable to repeat the MCT processing complex 210 to form an MCT processing stack 310 (illustrated in FIGs. 8 and 9) capable of high throughput.

FIGs 6b and 6c illustrate a further embodiment of the present invention for manifolding the various microchannels. For example, a reactants flue 213a provides fluid communication between a plurality of first reactor microchannels 116 and an outside surface of the MCT processing complex 210 via the first reactants manifold 212 and a first reactants manifold stub 213 and between a plurality of second reactants microchannels 117 and an outside surface of the MCT processing complex 210 via the second reactants manifold 214 and a second reactants manifold stub 215. Likewise, a products flue 217a provides analogous fluid communication for a plurality of third reactor heat exchange microchannels 118, a fuel flue 219a provides analogous fluid communication for a plurality of first combustor microchannels 122 and a plurality of second combustor microchannels 123, and the oxidizer flue 223a provides analogous fluid communication for a plurality of first oxidizer microchannels 132 and a plurality of second oxidizer microchannels 133. As will be appreciated by those skilled in the art, an exhaust flue may provide fluid communication between a plurality of third combustor heat exchange microchannels 128, thus further illustrating the design flexibility of the present invention. In addition, by way of example only, the orientations of the first reactants manifold stub 213, the first reactants manifold 212, and the plurality of first reactor microchannels 116 relative to one another is virtually infinitely flexible. Thus, allowing even further design flexibility depending upon the specific application.

Referring now to FIGs 8a and 8b, an MCT processing stack 310 has a total core volume V (not shown) and comprises a plurality of MCT processing complexes 210. Shown in FIG. 8a are a plurality of first fuel manifolds 218 and second fuel manifolds 220 in substantial linear alignment, a plurality of first reactants manifolds 212 and second reactants manifolds 214 in substantial linear alignment, and a plurality of third combustion heat exchanger microchannels 128 in substantial linear alignment. Shown in FIG. 8b are a plurality of first oxidizer manifolds 222 and second oxidizer manifolds 224 in substantial linear alignment, and a plurality of products manifolds 216 in substantial linear alignment. While FIGs 8a and 8b illustrate a specific relational arrangement of manifolds and the plurality of third combustor heat exchange microchannels 128, it will be understood by one skilled in the art that other arrangements are possible.

Referring now to FIG. 9, an MCT processing stack 310 comprises a plurality of MCT processing complexes 210, a reactants header 312, a products header 314, a fuel header 316, an oxidizer header 318, and an exhaust header 320. As will be appreciated by those skilled in the art, the precise arrangement of each manifold is subject to various design considerations and it is within the scope and intent of the present invention to include other such arrangements.

Fabrication of the MCT processing stack 310 is by known techniques. The MCT processing complexes 210 are made as first subassemblies. The headers 312, 314, 316, 318 are then conventionally welded onto the exterior of the subassemblies. The heating rate during welding must be closely monitored to ensure a high level of quality; hot spots may damage the subassemblies, including delamination. In addition to welding on the headers 312, 314, 316, 318, the subassemblies themselves may be welded into place on any form of infrastructure. This infrastructure, by way of example only, may serve as outer protection, fixing the device in space, safety containment, insulation, cooling jacket, and lifting points.

In operation, by way of example only, a reactants stream 75 is introduced into the reactants header 312, a products stream 76 is discharged from the products header 314, a fuel stream 77 is introduced into the fuel header 316, an oxidizer stream 78 is introduced into the oxidizer header 318, and the exhaust stream 79 is discharged from the exhaust header 320. The embodiment shown in FIGs 8a-9 shows a plurality of integral heat exchanger and reactor combinations. There are five distinct fluid streams: The reactants stream 75, the products stream 76, the oxidizer stream 78, the fuel stream 77, and the exhaust stream 79. As shown in the accompanying figures, the exhaust stream 79 exits straight out of each MCT processing complex 210 via each third combustor heat exchange microchannel 128. Alternatively, any of the other streams could be headered straight off each MCT processing complex 210. The exhaust stream 79 was selected to minimize the overall pressure drop of the oxidizer stream 78-fuel stream 77-exhaust stream 79 system. The four remaining streams are headered on the sides of each MCT processing complex 210 and, thus, on the sides of the MCT processing stack 310. Each fluid stream enters or exits at different points along the length of each MCT processing complex 210. For multi-stream devices, therefore, fluids may enter or exit at different points of the MCT processing complex 210, thus allowing much design flexibility in the thermal profile. For example, streams that enter much warmer than other streams may be selected to be headered further down the length, or toward warmer sections of the device.

Thus, advantage is taken of the monotonically increasing temperature profile feature of the device. The heights of the manifolds is selected to generally minimize overall pressure drop while still allowing for good flow distribution among the internal array of microchannels. Smaller heights may be utilized where higher pressure drops can be tolerated.

5

#### CLOSURE

While the invention has been explained in relation to various detailed embodiments, it is to be understood that various modifications thereof will become apparent to those skilled in the art upon reading the Specification. Therefore, it is to be understood that the invention  
10 disclosed herein is intended to cover such modifications as fall within the scope of the appended claims.

### **Claims**

1. A heat exchanger, the heat exchanger comprising:  
a first microchannel, having an inlet thereto and an outlet therefrom;  
a second microchannel, having an inlet thereto and an outlet therefrom; and  
at least a third microchannel, having an inlet thereto and an outlet therefrom,  
wherein each inlet and each outlet is distinct from the other inlets or outlets,  
respectively.
2. The heat exchanger of claim 1, further including a fluid flowing in the first microchannel, the fluid having a Reynolds number of less than 4000.
3. The heat exchanger of claim 2, wherein the residence time of the fluid in the first microchannel is less than 500 ms.
4. The heat exchanger of claim 3, wherein the fluid flowing in the first microchannel has a pressure drop of 15 psi or less.
5. The heat exchanger of claim 1, wherein when a first fluid is flowing through the first microchannel, a second fluid is flowing through the second microchannel, and an at least third fluid is flowing through the at least third microchannel, the total thermal power density is greater than 1 W/cc.
6. The heat exchanger of claim 1, wherein the IPHTAP of at least one microchannel is about 30 or greater.
7. The heat exchanger of claim 1, wherein the residence time of a first stream flowing in the first microchannel is less than 500 ms.

8. The heat exchanger of claim 1, wherein at least one microchannel has at least one internal dimension of width or height of about 2 mm or less.
9. The heat exchanger of claim 1, wherein at least one microchannel has at least one internal dimension of width or height of about 0.1 mm or less.
10. A heat exchanger, the heat exchanger comprising:
  - a first microchannel, having an inlet thereto and an outlet therefrom;
  - a second microchannel, having an inlet thereto and an outlet therefrom; and
  - at least a third microchannel, having an inlet thereto and an outlet therefrom,wherein each inlet and each outlet is distinct from the other inlets or outlets, respectively, and wherein when a first fluid flows through the first microchannel, the IPHTAP is about 30 or greater.
11. The heat exchanger of claim 10, wherein when a first fluid is flowing through the first microchannel, a second fluid is flowing through the second microchannel, and an at least third fluid is flowing through the at least third microchannel, the total thermal power density is greater than 1 W/cc.
12. A heat exchanger, the heat exchanger comprising:
  - a first microchannel, having an inlet thereto and an outlet therefrom;
  - a second microchannel, having an inlet thereto and an outlet therefrom; and
  - at least a third microchannel, having an inlet thereto and an outlet therefrom,wherein each inlet and each outlet is distinct from the other inlets or outlets, respectively, and the first microchannel has a hydraulic diameter different from at least the second microchannel.
13. The heat exchanger of claim 12, wherein when a first fluid flows through the first microchannel, a second fluid flows through the second microchannel, and an at

least third fluid flows through the at least third microchannel, the IPHTAP of at least one microchannel is about 10 or greater.

14. The heat exchanger of claim 12, wherein at least one microchannel has at least one internal dimension of width or height of about 2 mm or less.

15. The heat exchanger of claim 12, wherein at least one microchannel has at least one internal dimension of width or height of about 0.1 mm or less.

16. A heat exchanger, the heat exchanger comprising:  
a first surface;  
a second surface, in a substantially opposing and spaced-apart relation to the first surface;  
a third surface, in a substantially orthogonal relation to the first surface and to the second surface;  
a fourth surface, in a substantially opposing and spaced-apart relation to the third surface;  
a first microchannel, defining a passageway between the first surface and the second surface;  
a second microchannel, defining a passageway between the first surface and the second surface; and  
at least a third microchannel, defining a passageway between the third surface and the fourth surface, wherein the first microchannel has a cross-sectional area different from at least the second microchannel or the third microchannel.

17. The heat exchanger of claim 16, wherein at least one microchannel has at least one internal dimension of width or height of about 2 mm or less.



18. The heat exchanger of claim 16, wherein at least one microchannel has at least one internal dimension of width or height of about 0.1 mm or less.
19. A process for exchanging heat between three streams in a device, the method comprising:
- (a) flowing a first stream, having a first temperature, through a first microchannel formed within the device;
  - (c) flowing a second stream, having a second temperature, through a second microchannel formed within the device;
  - (d) flowing a third stream, having a third temperature, through a third microchannel formed within the device.
20. The process of claim 19, wherein the first stream is flowing at a Reynolds number of about 4000 or less.
21. The process of claim 19, wherein the residence time of the first stream is about 500 ms or less.
22. The process of claim 19, wherein the first stream is a gaseous fluid and flows through the first microchannel at a pressure drop of about 15 psi or less.
23. A process for exchanging heat between multiple streams, the method comprising:
- (a) flowing a first stream, having a first temperature, through a first microchannel;
  - (b) flowing a second stream, having a second temperature, through a second microchannel;
  - (c) flowing at least a third stream, having an at least third temperature, through an at least third microchannel; and

(d) placing the first stream in thermal communication with the second stream and the at least third stream.

24. The process of claim 23, wherein when the first stream is a gaseous fluid, and flows through the first microchannel at a pressure drop of about 15 psi or less.

25. The process of claim 24, wherein the residence time of the first gaseous fluid stream is about 500 ms or less.

26. The process of claim 23, wherein the IPHTAP of at least one microchannel is about 30 or greater.

27. A heat exchange process comprising:

- (a) flowing a first fluid through a plurality of first microchannels;
- (b) flowing a second fluid through a plurality of second microchannels; and
- (c) flowing at least a third fluid through a plurality of at least third microchannels, the set of at least third microchannels being in thermal communication with the set of first microchannels and with the set of second microchannels.

28. The heat exchange process of claim 27, wherein the total thermal power density is greater than 1 W/cc.

29. A heat exchanger, the heat exchanger comprising:

- a first end and a second end;
- a first microchannel;
- a second microchannel;
- a third microchannel;
- a fourth microchannel;

a fifth microchannel;

a sixth microchannel; and

a seventh microchannel, each microchannel defining a passageway between the first end and the second end, wherein each microchannel is in thermal communication with at least one of the other microchannels and the first microchannel has a cross-sectional area different from at least the second microchannel.

30. The heat exchanger of claim 29, wherein when a first portion of a first gaseous fluid, at a first temperature flows through the first microchannel, a first portion of a second gaseous fluid, at a second temperature flows through the second microchannel, a third gaseous fluid, at a third temperature flows through the third microchannel, a fourth gaseous fluid, at a fourth temperature flows through the fourth microchannel, a fifth gaseous fluid, at a fifth temperature flows through the fifth microchannel, a second portion of the first gaseous fluid, flows through the sixth microchannel, and a second portion of the second gaseous fluid, flows through the seventh microchannel, the total thermal power density of the heat exchanger is at least 1 W/cc.

31. The heat exchanger of claim 30, wherein the weighted average approach temperature is about 150°C.

32. A device for carrying out at least a first unit operation and at least a first chemical reaction, the device comprising:

a first microchannel;

a second microchannel, in thermal communication with the first microchannel; and

at least a third microchannel, the at least third microchannel in fluid communication with the second microchannel, wherein when a first stream is

introduced into the first microchannel, a second stream comprising at least a first reactant is introduced into the second microchannel, and an at least third stream comprising at least a second reactant is introduced into the at least third microchannel, the at least first unit operation proceeds in the first microchannel, the at least first reactant and the at least second reactant combine to form an at least first product via the at least first chemical reaction, and heat energy is transferred between the first microchannel and the second microchannel.

33. The device of claim 32, wherein at least one microchannel has at least one internal dimension of width or height of about 2 mm or less.

34. The device of claim 32, wherein at least one microchannel has at least one internal dimension of width or height of about 0.1 mm or less.

35. The device of claim 32, further comprising a catalyst disposed within the second microchannel.

36. A device for carrying out a chemical reaction, the device comprising:  
a heat exchanger and reactor in combination, the heat exchanger comprising a first, a second, a third, a fourth, and a fifth microchannel, the reactor comprising a first reaction microchannel in fluid communication with the first heat exchanger microchannel and the second heat exchanger microchannel, a second reaction microchannel in fluid communication with the third heat exchanger microchannel and the fifth heat exchanger microchannel, and a perforated microchannel in fluid communication with the fourth heat exchanger microchannel, the perforated microchannel formed to include one or more apertures, the perforated microchannel in fluid communication with the second reaction microchannel through the one or more apertures.

37. The device of claim 36, wherein the chemical reaction is endothermic.
38. The device of claim 36, wherein the first reaction microchannel is in thermal communication with the second reaction microchannel.
39. The device of claim 36, wherein the first heat exchanger microchannel is in thermal communication with the third heat exchanger microchannel.
40. The device of claim 36, wherein the second heat exchanger microchannel is in thermal communication with the fifth heat exchanger microchannel.
41. The device of claim 36, wherein the third heat exchanger microchannel is in thermal communication with the fourth heat exchanger microchannel.
42. The device of claim 36, further comprising a catalyst disposed within the first reaction microchannel.
43. The device of claim 36, further comprising a catalyst disposed within the second reaction microchannel.
44. A device for carrying out an endothermic reaction, the device comprising:  
a reaction microchannel;  
a combustion microchannel in thermal communication with the reaction microchannel; and  
an oxidizer microchannel in fluid communication with the combustion microchannel.
45. The device of claim 44, wherein at least one microchannel has at least one internal dimension of width or height of about 2 mm or less.

46. The device of claim 44, wherein at least one microchannel has at least one internal dimension of width or height of about 0.1 mm or less.
47. The device of claim 44, further comprising a catalyst disposed within the reaction microchannel.
48. The device of claim 44, further comprising a catalyst disposed within the combustion microchannel.
49. A process for carrying out an endothermic reaction, the process comprising:
- (a) flowing at least one endothermic reactant through a first microchannel, wherein the at least one endothermic reactant is converted to at least one endothermic product;
  - (b) flowing a fuel through a second microchannel;
  - (c) flowing an oxidizer through a third microchannel;
  - (d) combining the oxidizer and the fuel, wherein the fuel and the oxidizer are converted to at least one exhaust product, whereby thermal energy is produced; and
  - (e) transferring at least a portion of the thermal energy to the first microchannel.
50. The process of claim 49, further comprising contacting the at least one endothermic reactant with a catalyst.
51. The process of claim 49, further comprising contacting the combined oxidizer and fuel with a catalyst.
52. A device for converting a reactants feed stream into a products stream via a chemical reaction, the device comprising a heat exchanger and reactor in combination, the heat exchanger having a distal end and a proximal end and

comprising a first, a second, a third, a fourth, and a fifth microchannel, each microchannel defining a passageway between the distal end and the proximal end, the reactor being integral to the heat exchanger proximal end and comprising a first microchannel reaction section, the first microchannel reaction section in fluid communication with the first heat exchanger microchannel and the second heat exchanger microchannel, a second microchannel reaction section, the second microchannel reaction section in fluid communication with the third heat exchanger microchannel and the fifth heat exchanger microchannel, and a perforated microchannel section, the perforated microchannel section in fluid communication with the fourth heat exchanger microchannel and formed to define one or more apertures, the perforated microchannel section in fluid communication with the second microchannel reaction section.

53. The device of claim 52, further comprising a catalyst disposed within the first microchannel reaction section.

54. The device of claim 52, further comprising a catalyst disposed within the second microchannel reaction section.

55. The device of claim 54, further comprising a catalyst disposed within the third heat exchanger microchannel.

56. The device of claim 52, wherein when the reactants feed stream is introduced into the second heat exchanger microchannel at the distal end, a fuel stream is introduced into the third heat exchanger microchannel at the distal end, an oxygen-containing stream is introduced into the fourth heat exchanger microchannel at the distal end, the products stream is allowed to discharge through the first heat exchanger microchannel at the distal end, and an exhaust stream is allowed to discharge through the fifth heat exchanger microchannel at the distal end, within the

heat exchanger, the products stream gives up heat to the feed stream and the exhaust stream gives up heat to the oxygen-containing stream, and within the reactor, the oxygen-containing stream and the fuel stream combine in a combustion reaction which provides heat for one or more reactions wherein the reactants feed stream is at least partially converted to the products stream.

57. A device for converting a reactants feed stream into a products stream via a chemical reaction, the device comprising a heat exchanger and reactor in combination, the heat exchanger having a distal end and a proximal end and comprising a first, a second, a third, and a fourth microchannel, each microchannel defining a passageway between the distal end and the proximal end, the reactor being integral to the heat exchanger proximal end and comprising a first microchannel reaction section, the first microchannel reaction section in fluid communication with the first heat exchanger microchannel and the second heat exchanger microchannel and a second microchannel reaction section, the second microchannel reaction section in fluid communication with the third heat exchanger microchannel and the fourth heat exchanger microchannel.

58. The device of claim 57, further comprising a catalyst disposed within the first microchannel reaction section.

59. The device of claim 57, further comprising a catalyst disposed within the second microchannel reaction section.

60. The device of claim 59, further comprising a catalyst disposed within the third heat exchanger microchannel.

61. A device for carrying out an endothermic chemical reaction, the device comprising a heat exchanger and a reactor in combination, the heat exchanger



comprising a first, a second, a third, a fourth, a fifth, a sixth, a seventh, and an eighth microchannel, the reactor being integral to the heat exchanger and comprising a first exothermic reaction microchannel, the first exothermic reaction microchannel in fluid communication with the fourth heat exchanger microchannel and the sixth heat exchanger microchannel, a second exothermic reaction microchannel in fluid communication with the eighth heat exchanger microchannel and the sixth heat exchanger microchannel, a first perforated microchannel in fluid communication with the fifth heat exchanger microchannel and formed to include one or more first perforated microchannel apertures, the first perforated microchannel in fluid communication with the first exothermic reaction microchannel through the one or more first perforated microchannel apertures, a second perforated microchannel in fluid communication with the seventh heat exchanger microchannel and formed to include one or more second perforated microchannel apertures, the second perforated microchannel in fluid communication with the second exothermic reaction microchannel through the one or more second perforated microchannel apertures, a first endothermic reaction microchannel in fluid communication with the first heat exchanger microchannel and the second heat exchanger microchannel, and a second endothermic reaction microchannel in fluid communication with the third heat exchanger microchannel and the second heat exchanger microchannel.

62. The device of claim 61, further comprising a catalyst disposed within at least one of the endothermic reaction microchannels.

63. The device of claim 61, further comprising a catalyst disposed within at least one of the exothermic reaction microchannels.

64. The device of claim 61, further comprising a tongue interposed between the first exothermic reaction microchannel and the second exothermic reaction microchannel.

65. The device of claim 61, further comprising a tongue interposed between the first endothermic reaction microchannel and the second endothermic reaction microchannel.

66. A process for reforming a hydrocarbon feed stream into a synthesis gas products stream, the process comprising:

- (a) introducing the hydrocarbon feed stream into a first heat exchanger microchannel;
- (c) introducing a fuel stream into a second heat exchanger microchannel;
- (d) introducing an oxygen-containing stream into a third heat exchanger microchannel;
- (e) at least partially reforming the feed stream into the synthesis gas products stream;
- (f) combusting the fuel stream with the oxygen-containing stream;
- (g) discharging the products stream through a fourth heat exchanger microchannel; and
- (h) discharging the exhaust stream through a sixth heat exchanger microchannel.

67. The process of claim 66, further comprising exposing the hydrocarbon feed stream to a catalyst.

68. The process of claim 66, further comprising exposing the fuel stream and the oxygen-containing stream to a catalyst.

69. A microchannel device, the microchannel device comprising:

a first microchannel and a second microchannel, the second microchannel formed to include one or more apertures, the second microchannel in fluid communication with the first microchannel.

70. The microchannel device of claim 69, further comprising a catalyst disposed within the first microchannel.

71. An apparatus for conducting a unit operation, the apparatus comprising:  
a plurality of microchannel devices, each microchannel device comprising a heat exchanger section and a unit operation section in combination, the heat exchanger section comprising at least five microchannels, the unit operation section being integral to the heat exchanger section and comprising a first unit operation microchannel in fluid communication with the first heat exchanger section microchannel and the second heat exchanger section microchannel, a second unit operation microchannel in fluid communication with the third heat exchanger section microchannel and the fourth heat exchanger section microchannel, and a perforated microchannel in fluid communication with the at least fifth heat exchanger section microchannel and further in fluid communication with the second unit operation microchannel;

a first manifold in fluid communication with the first heat exchanger section microchannel of each microchannel device;

a second manifold in fluid communication with the second heat exchanger section microchannel of each microchannel device;

a third manifold in fluid communication with the third heat exchanger section microchannel of each microchannel device; and

a fourth manifold in fluid communication with the fifth heat exchanger section microchannel of each microchannel device.

72. A process for conducting a unit operation and a chemical reaction, the process consisting of:

- (a) introducing a first stream into a first manifold;
- (b) distributing the first stream into a plurality of first microchannels;
- (c) introducing a second stream into a second manifold;
- (d) distributing the second stream into a plurality of second microchannels;
- (e) introducing a third stream into a third manifold;
- (f) distributing the third stream into a plurality of third microchannels;
- (g) contacting the second stream and the third stream, wherein a chemical reaction is effected; and
- (h) transferring heat between the first stream and the chemical reaction.

73. The process of claim 72, wherein the first stream comprises at least one hydrocarbon.

74. The process of claim 72, wherein the second stream comprises at least one combustible compound.

75. The process of claim 72, wherein the third stream comprises at least one oxidizing compound.

76. A microchannel device, the microchannel device comprising:  
a first laminate defining a plurality of first microchannels, each first microchannel in fluid communication with a first manifold and a second manifold;  
a second laminate defining a plurality of second microchannels, each second microchannel in fluid communication with a third manifold and a fourth manifold;  
and

a third laminate defining a plurality of third microchannels, each third microchannel in fluid communication with a fifth manifold and in fluid communication with at least one of the plurality of second microchannels.

77. The microchannel device of claim 76, further comprising a catalyst disposed within at least one of the plurality of first microchannels.

78. The microchannel device of claim 76, further comprising a catalyst disposed within at least one of the plurality of second microchannels.

79. A microchannel device the microchannel device comprising:

a plurality of first laminates, each first laminate defining a plurality of first microchannels, each first microchannel in fluid communication with a first manifold and a second manifold, each first manifold in fluid communication with a first header, and each second manifold in fluid communication with a second header;

a plurality of second laminates, at least one second laminate adjacent to a first laminate, each second laminate defining a plurality of second microchannels, each second microchannel in fluid communication with a third manifold and a fourth manifold, each third manifold in fluid communication with a third header, and each fourth manifold in fluid communication with a fourth header; and

a plurality of third laminates, at least one third laminate adjacent to a second laminate, each third laminate defining a plurality of third microchannels, each third microchannel in fluid communication with a fifth manifold and in fluid communication with at least one of the plurality of second microchannels and each fifth manifold in fluid communication with a fifth header.

80. A microchannel apparatus for conducting a chemical reaction, the apparatus comprising a plurality of microchannel devices, each device comprising:

a plurality of first reactants microchannels, each first reactants microchannel in fluid communication an outside surface of the device;

a plurality of first products microchannels, each first products microchannel in fluid communication with a respective first reactants microchannel and in fluid communication with an outside surface of the device;

a plurality of second reactants microchannels, each second reactants microchannel in fluid communication with a respective first products microchannel and in fluid communication with an outside surface of the device;

a plurality of third reactants microchannels, each third reactants microchannel in fluid communication with an outside surface of the device;

a plurality of fifth reactants microchannels, each fifth reactants microchannel in fluid communication with an outside surface of the apparatus and in fluid communication with a respective third reactants microchannel;

a plurality of second products microchannels, each second microchannel in fluid communication with a respective third reactants microchannel and in fluid communication with an outside surface of the apparatus;

a plurality of fourth reactants microchannels, each fourth reactants microchannel in fluid communication with a respective second products microchannel and in fluid communication with an outside surface of the apparatus;  
and

a plurality of sixth reactants microchannels, each sixth microchannel in fluid communication with a respective fourth reactants microchannel and in fluid communication with an outside surface of the apparatus.

81. The apparatus of claim 80, the apparatus further comprising:

a first header in fluid communication with the plurality of first reactants microchannels and in fluid communication with the plurality of second reactants microchannels;

a second header in fluid communication with the plurality of first products microchannels;

a third header in fluid communication with the plurality of third reactants microchannels and in fluid communication with the plurality of sixth reactants microchannels;

a fourth header in fluid communication with the plurality of fifth reactants microchannels and in fluid communication with the plurality of fourth reactants microchannels; and

a fifth header in fluid communication with the plurality of second products microchannels.

82. A microchannel apparatus for conducting a chemical reaction, the apparatus comprising:

a plurality of microchannel devices, each device comprising:

a first reactants manifold;

a plurality of first reactants microchannels, each first reactants microchannel in fluid communication with the first reactants manifold;

a first products manifold;

a plurality of first products microchannels, each first products microchannel in fluid communication with the first products manifold and in fluid communication with a respective first reactants microchannel;

a second reactants manifold;

a plurality of second reactants microchannels, each second reactants microchannel in fluid communication with the second reactants manifold and in fluid communication with a respective first products microchannel;

a third reactants manifold;

a plurality of third reactants microchannels, each third reactants microchannel in fluid communication with the third reactants manifold;

a plurality of fifth reactants microchannels, each fifth reactants

microchannel in fluid communication with an outside surface of the device and in fluid communication with a respective third reactants microchannel;

a second products manifold;

a plurality of second products microchannels, each second products microchannel in fluid communication with the second products manifold and in fluid communication with a respective third reactants microchannel;

a fourth reactants manifold;

a plurality of fourth reactants microchannels, each fourth reactants microchannel in fluid communication with the fourth reactants manifold and in fluid communication with a respective second products microchannel;

a plurality of sixth reactants microchannels, each sixth reactants microchannel in fluid communication with an outside surface of the device and in fluid communication with a respective fourth reactants microchannel;

a first header in fluid communication with the plurality of first and second reactants manifolds;

a second header in fluid communication with the plurality of first products manifolds;

a third header in fluid communication with the plurality of third and fourth reactants manifolds;

a fourth header in fluid communication with the plurality of second products manifolds; and;

a fifth header in fluid communication with the plurality of fifth and sixth reactants microchannels.

83. A microchannel apparatus for conducting a chemical reaction, the apparatus comprising:

a plurality of microchannel devices, each device comprising:

a first reactants manifold;



a plurality of first reactants microchannels, each first reactants microchannel in fluid communication with the first reactants manifold;  
a first products manifold;  
a plurality of first products microchannels, each first products microchannel in fluid communication with the first products manifold and in fluid communication with a respective first reactants microchannel;  
a second reactants manifold;  
a plurality of second reactants microchannels, each second reactants microchannel in fluid communication with the second reactants manifold;  
a plurality of third reactants microchannels, each third reactants microchannel in fluid communication with an outside surface of the device and in fluid communication with a respective second reactants microchannel;  
a second products manifold;  
a plurality of second products microchannels, each second products microchannel in fluid communication with the second products manifold and in fluid communication with a respective second reactants microchannel;  
a first header in fluid communication with the plurality of first reactants manifolds;  
a second header in fluid communication with the plurality of first products manifolds;  
a third header in fluid communication with the plurality of second reactants manifolds;  
a fourth header in fluid communication with the plurality of second products manifolds; and  
a fifth header is fluid communication with the plurality of second products microchannels.

84. A device for combining two streams into a single stream, the device comprising:

a first channel;

a second channel;

a third channel; and

a tongue interposed between the first channel and the second channel, wherein a first stream flowing in the first channel in a direction toward the tongue and a second stream flowing in the second channel in a direction toward the tongue in a direction substantially opposite from the first stream impinge upon opposite sides of the tongue and are directed into the third channel whereby the first stream and the second stream become combined.

85. The device of claim 84, wherein the tongue extends into the third channel.

86. A multi-channel device, the multi-channel device comprising:

(a) a first plate;

(b) a second plate, adjacent to the first plate, the second plate comprising at least one slot, the at least one slot in communication with an edge of the second plate;

(c) a third plate, adjacent to the second plate, the third plate comprising at least one aperture, the at least one aperture in communication with a second plate at least one slot, the third plate cooperating with the first plate and the second plate to form a channel defined by the second plate at least one slot;

(d) a fourth plate, adjacent to the third plate, the fourth plate comprising at least one slot, the at least one slot in communication with a third plate at least one aperture;

(e) a fifth plate, adjacent to the fourth plate, the fifth plate comprising at least one slot, the at least one slot in communication with an edge of the fifth plate;

(f) a sixth plate, adjacent to the fifth plate, the sixth plate comprising at least one slot, the at least one slot in communication with a fifth plate at least one slot;

(g) a seventh plate, adjacent to the sixth plate, the seventh plate comprising at least one aperture, the at least one aperture in communication with a sixth plate at

least one slot, the seventh plate cooperating with the third plate, the fourth plate, the fifth plate, and the sixth plate to form at least one channel defined by the fourth plate at least one slot, the fifth plate at least one slot, and the sixth plate at least one slot;

(h) an eighth plate, adjacent to the seventh plate, the eighth plate comprising an at least one slot, the at least one slot in communication with an edge of the second plate;

and

(i) a ninth plate, adjacent to the eighth plate, the ninth plate cooperating with the eighth plate and the seventh plate to form a channel defined by the eighth plate at least one slot.

87. The multi-channel device of claim 86, wherein the fifth plate at least one slot further comprises a tongue.

88. The multi-channel device of claim 86, wherein the channel defined by the second plate at least one slot further comprises a catalyst.

89. The multi-channel device of claim 86, wherein the channel defined by the eighth plate at least one slot further comprises a catalyst.

90. The multi-channel device of claim 86, further comprising:

(a) a tenth plate, adjacent to the ninth plate, the tenth plate comprising at least one slot, the at least one slot in communication with an edge of the tenth plate;

(b) an eleventh plate, adjacent to the tenth plate, the eleventh plate comprising:

(i) at least one first aperture, the at least one first aperture in communication with a tenth plate at least one slot; and

(ii) at least one second aperture, the at least one second aperture in communication with a tenth plate at least one slot;

the eleventh plate cooperating with the ninth plate and the tenth plate to form a channel defined by the tenth plate at least one slot ;

(c) a twelfth plate, adjacent to the eleventh plate, the twelfth plate comprising:

(i) at least one slot, the at least one slot in communication with an edge of the twelfth plate and in communication with the eleventh plate at least one aperture; and

(ii) at least one aperture, the at least one aperture in communication with the eleventh plate at least one second aperture;

(d) a thirteenth plate, adjacent to the twelfth plate, the thirteenth plate comprising at least one aperture, the at least one aperture in communication with a twelfth plate at least one aperture, the thirteenth plate cooperating with the eleventh plate and the twelfth plate to form at least one first channel defined by the twelfth plate at least one slot;

(e) a fourteenth plate, adjacent to the thirteenth plate, the fourteenth plate comprising at least one slot, the at least one slot in communication with an edge of the fourteenth plate and in communication with the thirteenth plate at least one aperture;

(f) a fifteenth plate, adjacent to the fourteenth plate, the fifteenth plate comprising at least one slot, the at least one slot in communication with an edge of the fifteenth plate and in communication with a fourteenth plate at least one slot;

(g) a sixteenth plate, adjacent to the fifteenth plate, the sixteenth plate comprising at least one slot, the at least one slot in communication with an edge of the sixteenth plate and in communication with a fifteenth plate at least one slot;

(h) a seventeenth plate, adjacent to the sixteenth plate, the seventeenth plate comprising at least one aperture, the at least one aperture in communication with a sixteenth plate at least one slot, the seventeenth plate cooperating with the thirteenth plate, the fourteenth plate, the fifteenth plate and the sixteenth plate to form at least one channel defined by the fourteenth plate at least one slot, the fifteenth plate at

least one slot, and the sixteenth plate at least one slot;

(i) an eighteenth plate, adjacent to the seventeenth plate, the eighteenth plate comprising:

(i) at least one slot, the at least one slot in communication with an edge of the eighteenth plate; and

(ii) at least one aperture, the at least one aperture in communication with the seventeenth plate at least one aperture;

(j) a nineteenth plate, adjacent to the eighteenth plate, the nineteenth plate comprising:

(i) at least one first aperture, the at least one first aperture in communication with an eighteenth plate at least one slot; and

(ii) at least one second aperture, the at least one second aperture in communication with an eighteenth plate at least one aperture;

the nineteenth plate cooperating with the seventeenth plate and the eighteenth plate to form a channel defined by the eighteenth plate at least one slot;

(k) a twentieth plate, adjacent to the eighteenth plate, the twentieth plate comprising at least one slot, the at least one slot in communication with an edge of the twentieth plate; and

(l) a twenty-first plate, adjacent to the twentieth plate, the twenty-first plate cooperating with the nineteenth plate and the twentieth plate to form a channel defined by the twentieth plate at least one slot.

91. The multi-channel device of claim 90, wherein the fifteenth plate at least one slot further comprises a tongue.

92. The multi-channel device of claim 90, wherein the channel defined by the twelfth plate at least one slot comprises a catalyst.

93. The multi-channel device of claim 90, wherein the channel defined by the twentieth plate at least one slot comprises a catalyst.

94. A multi-channel device, the multi-channel device comprising:

- (a) a first plate, the first plate comprising a second and a fourth aperture;
- (b) a second plate, adjacent to the first plate, the second plate comprising:
  - (i) a first slot, the first slot further comprising a notch, the notch in communication with the first plate second aperture;
  - (ii) at least one second slot, the at least one second slot in communication with the first slot; and
  - (iii) a fourth aperture, the fourth aperture in communication with the first plate fourth aperture;
- (c) a third plate, adjacent to the second plate, the third plate comprising:
  - (i) a second aperture, the second aperture in communication with the second plate notch;
  - (ii) a fourth aperture, the fourth aperture in communication with the second plate fourth aperture; and
  - (iii) at least one fifth aperture, the fifth aperture in communication with the second plate at least one second slot;the third plate cooperating with the first plate and the second plate to form a plurality of channels defined by the second plate first slot and the second plate at least one second slot;
- (d) a fourth plate, adjacent to the third plate, the fourth plate comprising:
  - (i) at least one slot, the at least one slot in communication with the third plate at least one fifth aperture;
  - (ii) a second aperture, the second aperture in communication with the third plate second aperture; and
  - (iii) a fourth aperture, the fourth aperture in communication with the third plate fourth aperture;

(e) a fifth plate, adjacent to the fourth plate, the fifth plate comprising:

(i) a first slot, the first slot comprising a notch, the notch in communication with the fourth plate fourth aperture;

(ii) at least one second slot, the at least one second slot in communication with the fourth plate at least one slot; and

(iii) a second aperture, the second aperture in communication with the fourth plate second aperture;

(f) a sixth plate, adjacent to the fifth plate, the sixth plate comprising

(i) at least one slot, the at least one slot in communication with a fifth plate at least one second slot;

(ii) a second aperture, the second aperture in communication with the fifth plate second aperture; and

(iii) a fourth aperture, the fourth aperture in communication with the fifth plate notch;

the sixth plate cooperating with the fourth plate and the fifth plate to form a channel defined by the fifth plate first slot;

(g) a seventh plate, adjacent to the sixth plate, the seventh plate comprising:

(i) a second aperture, the first aperture in communication with the sixth plate second aperture;

(ii) a fourth aperture, the fourth aperture in communication with the sixth plate fourth aperture; and

(iii) at least one fifth aperture, the at least one fifth aperture in communication with the sixth plate at least one slot;

the seventh plate cooperating with the third plate, the fourth plate, the fifth plate, and the sixth plate to form a plurality of channels defined by the fourth plate at least one slot, the fifth plate at least one second slot, and the sixth plate at least one slot;

(h) an eighth plate, adjacent to the seventh plate, the eighth plate comprising:

(i) a first slot, the first slot further comprising a notch, the notch in communication with the seventh plate second aperture;

(ii) at least one second slot, the at least one second slot in communication with the first slot; and

(iii) a fourth aperture, the fourth aperture in communication with the seventh plate fourth aperture; and

(i) a ninth plate, adjacent to the eighth plate, the ninth plate comprising a second and a fourth aperture, the ninth plate cooperating with the seventh plate and the eighth plate to form a first channel defined by the eighth plate first slot and at least one second channel defined by the eighth plate at least one second slot.

95. The multi-channel device of claim 94, wherein the at least one second channel defined by the second plate at least one second slot further comprises a catalyst.

96. The multi-channel device of claim 94, wherein the at least one second channel defined by the eighth plate at least one second slot further comprises a catalyst.

97. The multi-channel device of claim 94, wherein the at least one fifth plate second slot further comprises a tongue.

98. The multi-channel device of claim 94, the first plate through and including the ninth plate each further comprising a first aperture and a third aperture, the device further comprising:

(a) a tenth plate, adjacent to the ninth plate, the tenth plate comprising:

(i) a first slot, the first slot further comprising a notch, the notch in communication with the ninth plate first aperture;

(ii) at least one second slot, the at least one second slot in communication with the first slot;

(iii) a second aperture, the second aperture in communication with the



ninth plate second aperture;

(iv) a third aperture, the third aperture in communication with the ninth plate third aperture; and

(v) a fourth aperture, the fourth aperture in communication with the ninth plate fourth aperture;

(b) an eleventh plate, adjacent to the tenth plate, the eleventh plate comprising:

(i) at least one first aperture, the at least one second aperture in communication with the tenth plate notch;

(ii) at least one second aperture, the at least one second aperture in communication with the tenth plate notch;

(iii) at least one third aperture, the at least one third aperture in communication with the tenth plate third aperture;

(iv) a fourth aperture, the fourth aperture in communication with the tenth plate fourth aperture;

(v) at least one fifth aperture, the at least one fifth aperture in communication with the tenth plate at least one second slot; and

(vi) at least one sixth aperture, the at least one sixth aperture in communication with the tenth plate at least one second slot;

(c) a twelfth plate, adjacent to the eleventh plate, the twelfth plate comprising:

(i) a first slot, the first slot further comprising a notch, the notch in communication with the eleventh plate third aperture;

(ii) at least one second slot, the at least one second slot in communication with the first slot and in communication with the eleventh plate at least one sixth aperture;

(iii) at least one fifth aperture, the at least one fifth aperture in communication with the eleventh plate at least one fifth aperture;

(iv) a first aperture, the first aperture in communication with the eleventh plate first aperture;

(v) a second aperture, the second aperture in communication with the eleventh plate second aperture; and

(vi) a fourth aperture, the fourth aperture in communication with the eleventh plate fourth aperture;

(d) a thirteenth plate, adjacent to the twelfth plate, the thirteenth plate comprising:

(i) a first aperture, the first aperture in communication with the twelfth plate first aperture;

(ii) a second aperture, the second aperture in communication with the twelfth plate second aperture;

(iii) a third aperture, the third aperture in communication with the twelfth plate notch;

(iv) a fourth aperture, the fourth aperture in communication with the twelfth plate seventh aperture; and

(v) a fifth aperture, the fifth aperture in communication with the twelfth plate fifth aperture;

the thirteenth plate cooperating with the eleventh plate and the twelfth plate to form a plurality of channels defined by the twelfth plate first slot and the twelfth plate at least one second slot;

(e) a fourteenth plate, adjacent to the thirteenth plate, the fourteenth plate comprising:

(i) a first, second, third and fourth aperture, each in communication with the thirteenth first, second, third and fourth apertures, respectively; and

(ii) at least one slot, the at least one slot in communication with an edge of the fourteenth plate and in communication with the thirteenth plate at least one fifth aperture;

(f) a fifteenth plate, adjacent to the fourteenth plate, the fifteenth plate comprising:

(i) a first aperture, the first aperture in communication with the fourteenth plate first aperture;

(ii) a second aperture, the second aperture in communication with the fourteenth plate second aperture;

(iii) a third aperture, the third aperture in communication with the fourteenth plate third aperture;

(iv) a fourth aperture, the fourth aperture in communication with the fourteenth plate fourth aperture; and

(v) at least one slot, the at least one slot in communication with the fourteenth plate at least one slot;

(g) a sixteenth plate, adjacent to the fifteenth plate, the sixteenth plate comprising:

(i) a first aperture, the first aperture in communication with the fifteenth plate first aperture;

(ii) a second aperture, the second aperture in communication with the fifteenth plate second aperture;

(iii) a third aperture, the third aperture in communication with the fifteenth plate third aperture;

(iv) a fourth aperture, the fourth aperture in communication with the fifteenth plate fourth aperture; and

(v) at least one slot, the at least one slot in communication with the fifteenth plate at least one slot;

(g) a seventeenth plate, adjacent to the sixteenth plate, the seventeenth plate comprising:

(i) a first aperture, the first aperture in communication with the sixteenth plate first aperture;

(ii) a second aperture, the second aperture in communication with the sixteenth plate second aperture;

(iii) a third aperture, the third aperture in communication with the sixteenth plate third aperture;

(iv) a fourth aperture, the fourth aperture in communication with the sixteenth plate fourth aperture; and

(v) at least one fifth aperture, the at least one fifth aperture in communication with the sixteenth plate at least one slot;

the seventeenth plate cooperating with the thirteenth plate, the fourteenth plate, the fifteenth plate, and the sixteenth plate to form at least one channel defined by the fourteenth plate at least one slot, the fifteenth plate at least one slot, and the sixteenth plate at least one slot;

(h) an eighteenth plate, adjacent to the seventeenth plate, the eighteenth plate comprising:

(i) a first aperture, the first aperture in communication with the seventeenth plate first aperture;

(ii) a second aperture, the second aperture in communication with the seventeenth plate second aperture;

(iii) a first slot, the first slot comprising a notch, the notch in communication with the seventeenth plate third aperture;

(iv) a fourth aperture, the fourth aperture in communication with the seventeenth plate fourth aperture;

(v) at least one second slot, the at least one second slot in communication with the first slot; and

(vi) at least one fifth aperture, the at least one fifth aperture in communication with the seventeenth plate fifth aperture

(i) a nineteenth plate, adjacent to the eighteenth plate, the nineteenth plate comprising:

(i) a first aperture, the first aperture in communication with the eighteenth plate first aperture;

(ii) a second aperture, the second aperture in communication with the eighteenth plate second aperture;

(iii) a third aperture, the third aperture in communication with the eighteenth plate notch;

(iv) a fourth aperture, the fourth aperture in communication with the eighteenth plate fourth aperture;

(v) at least one fifth aperture, the at least one fifth aperture in communication with the eighteenth plate at least one fifth aperture; and

(vi) at least one sixth aperture, the at least one sixth aperture in communication with the eighteenth plate at least one second slot;

the nineteenth plate cooperating with the seventeenth plate and the eighteenth plate to form a first channel defined by the eighteenth plate first slot and an at least second channel defined by the eighteenth plate at least one second slot;

(j) a twentieth plate, adjacent to the nineteenth plate, the twentieth plate comprising:

(i) a first slot, the first slot comprising a notch, the notch in communication with the nineteenth plate first aperture;

(ii) a second aperture, the second aperture in communication with the nineteenth plate second aperture;

(iii) a third aperture, the third aperture in communication with the nineteenth plate third aperture;

(iv) a fourth aperture, the fourth aperture in communication with the nineteenth plate fourth aperture; and

(v) at least one second slot, the at least one second slot in communication with the first slot and in communication with the nineteenth plate at least one fifth aperture and in communication with the nineteenth plate at least one sixth aperture; and

(k) a twenty-first plate, adjacent to the twentieth plate, the twenty-first plate comprising:

- (i) a first aperture, the first aperture in communication with the twentieth plate notch;
- (ii) a second aperture, the second aperture in communication with the twentieth plate second aperture;
- (iii) a third aperture, the third aperture in communication with the twentieth plate third aperture; and
- (iv) a fourth aperture, the fourth aperture in communication with the twentieth plate fourth aperture;

the twenty-first plate cooperating with the nineteenth plate and the twentieth plate to form a first channel defined by the twentieth plate first slot and at least one second channel defined by the twentieth plate at least one second slot.

99. The multi-channel device of claim 98, wherein the fifteenth plate at least one slot further comprises a tongue.

100. The multi-channel device of claim 98, wherein the channel defined by the twelfth plate at least one second slot further comprises a catalyst.

101. The multi-channel device of claim 98, wherein the channel defined by the eighteenth plate at least one second slot comprises a catalyst.

102. A laminar device, the laminar device comprising:

- (a) a first plate, the first plate comprising at least one aperture;
- (b) a second plate, the second plate comprising a slot, the slot comprising a notch, wherein the first notch extends beyond the nominal boundaries of the slot, the notch in communication with the first plate at least one aperture; and

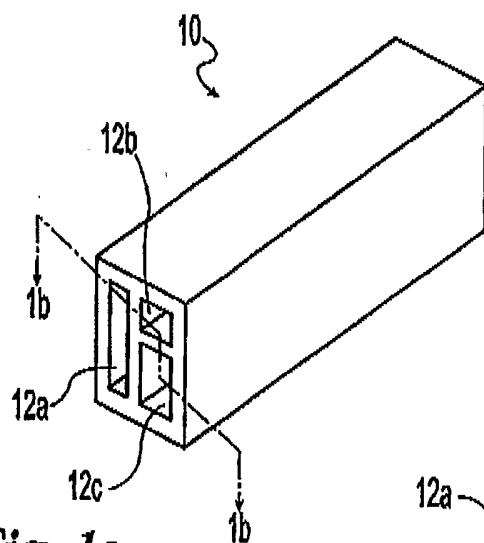
(c) a third plate, the third plate cooperating with the first plate and the second plate to form a channel defined by the second plate slot.

103. In a laminar device comprising at least one internal channel, a method of providing communication between an outer surface of the device and the at least one internal channel, the method comprising the steps of:

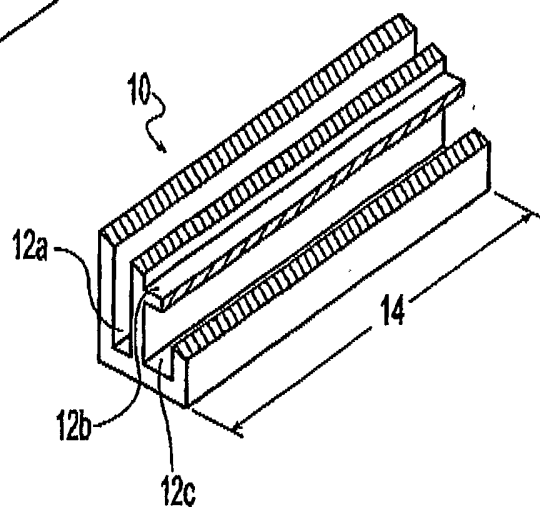
(a) forming an aperture in an outer surface first laminate; and

(b) forming a notch in an inner laminate defining the at least one internal channel, wherein the notch extends beyond the nominal boundaries of the at least one internal channel and wherein the at least one internal channel is in communication with the outer surface of the device through the first laminate aperture.

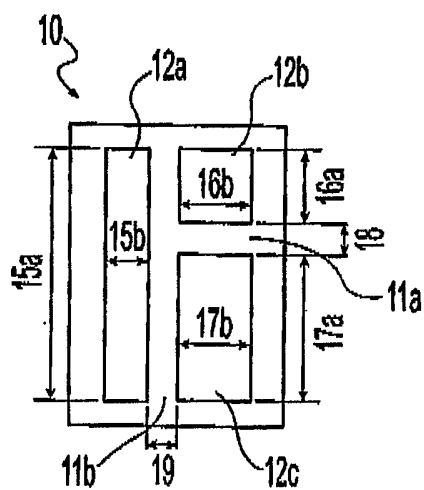
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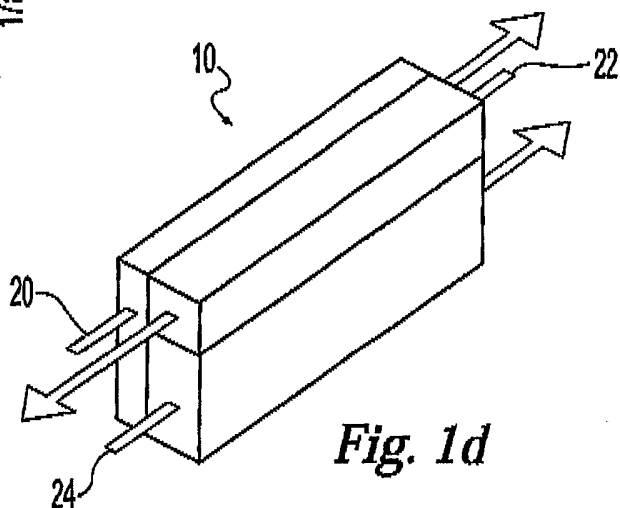
**Fig. 1a**



**Fig. 1b**

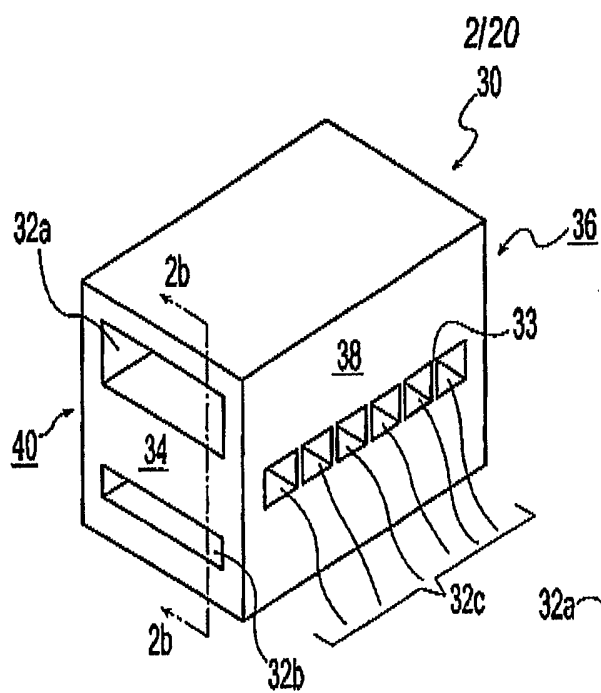


**Fig. 1c**

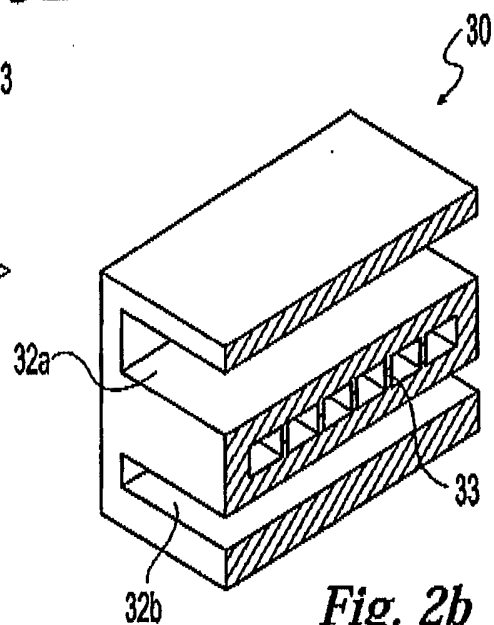


**Fig. 1d**

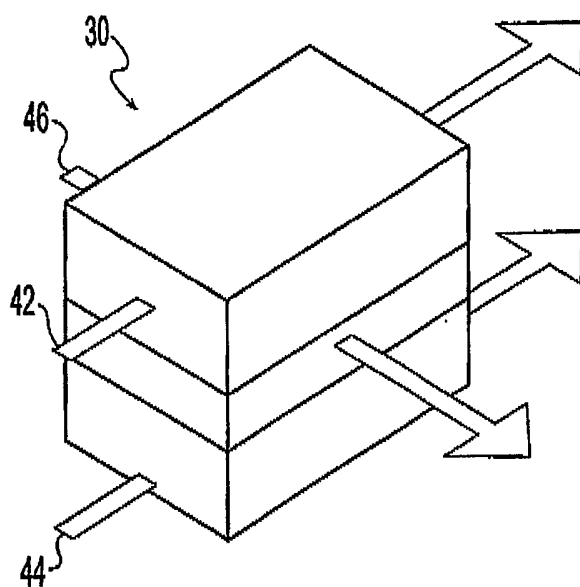




*Fig. 2a*



*Fig. 2b*



*Fig. 2c*

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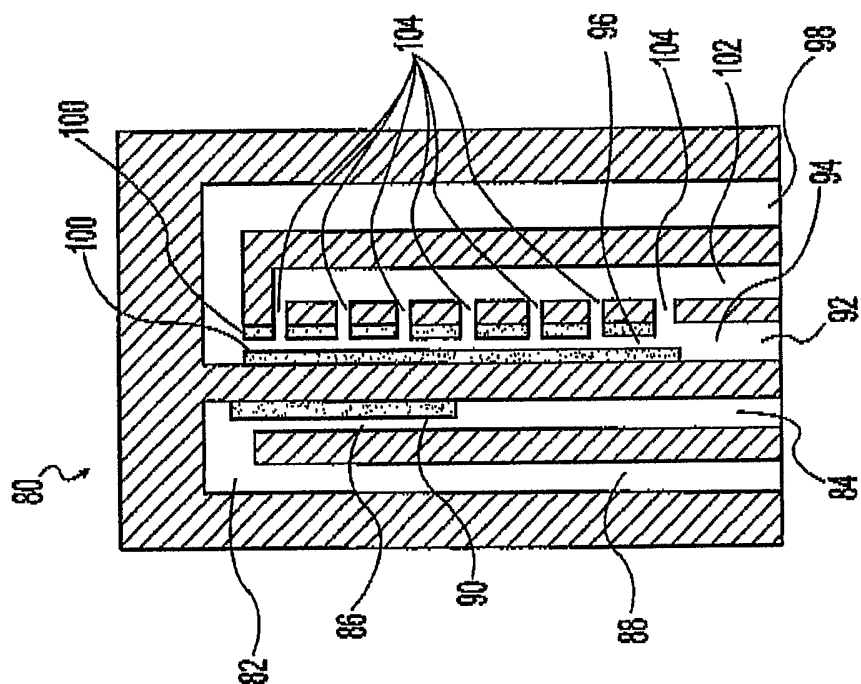


Fig. 4

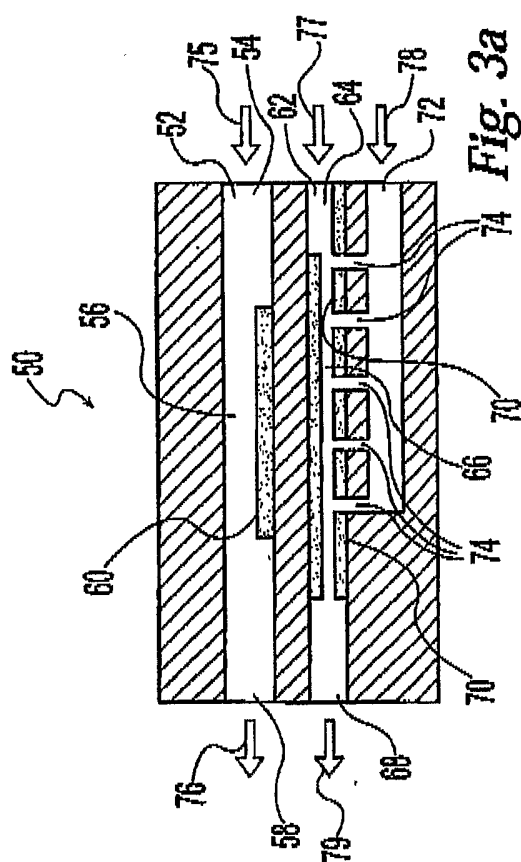
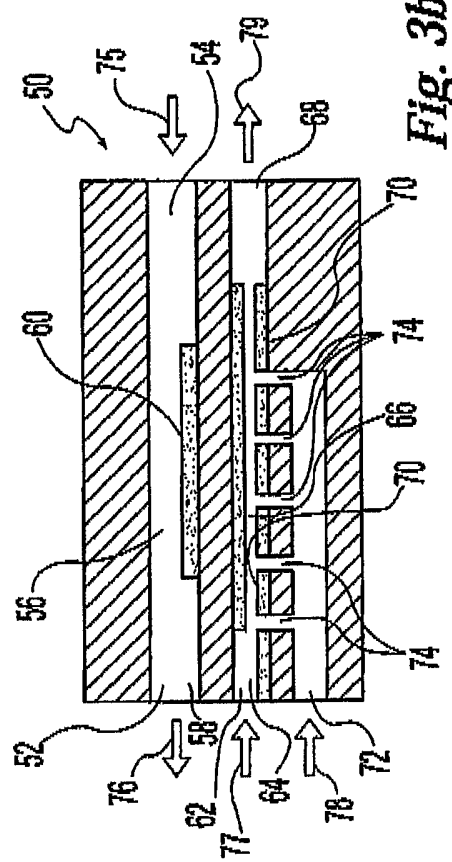
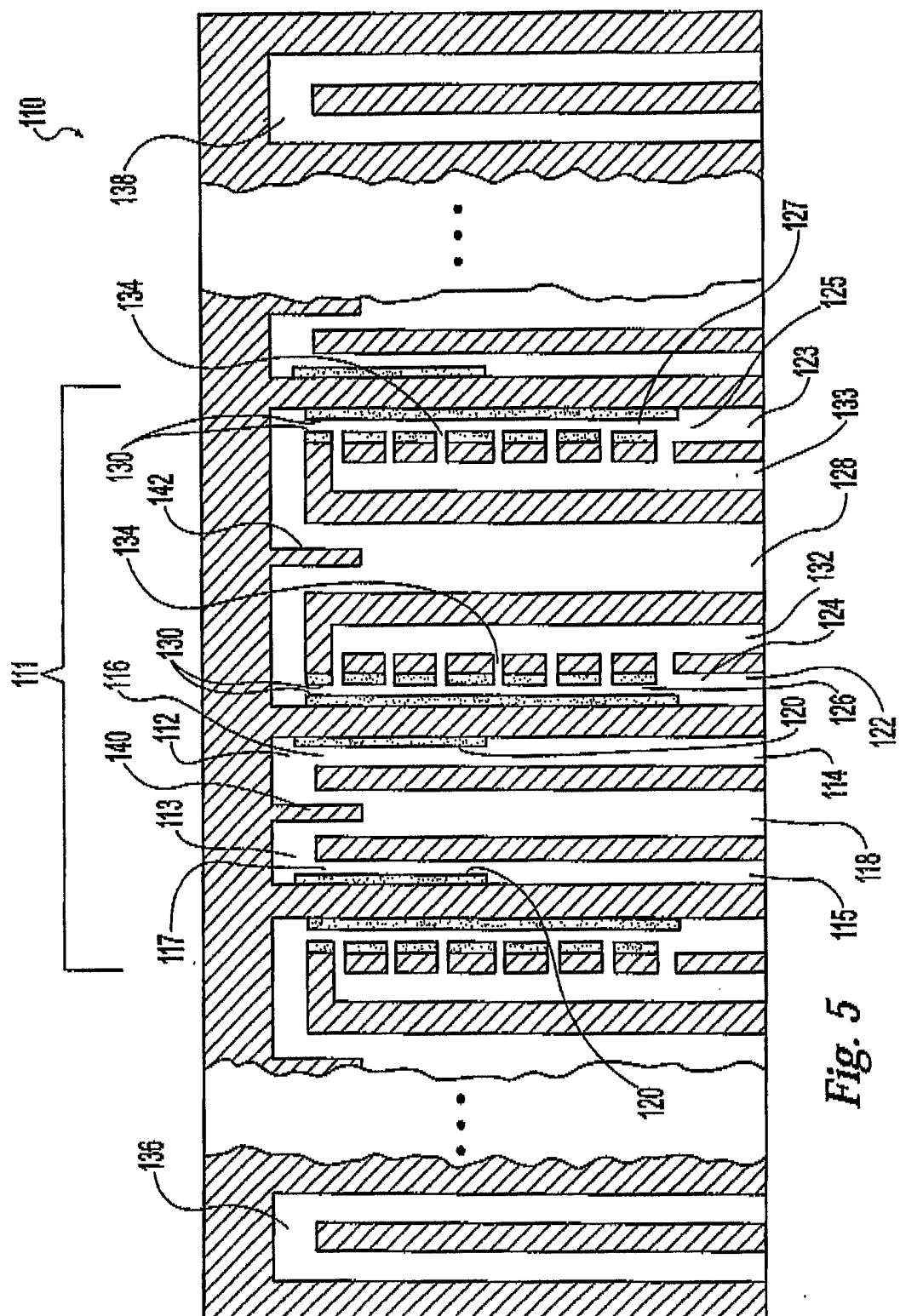


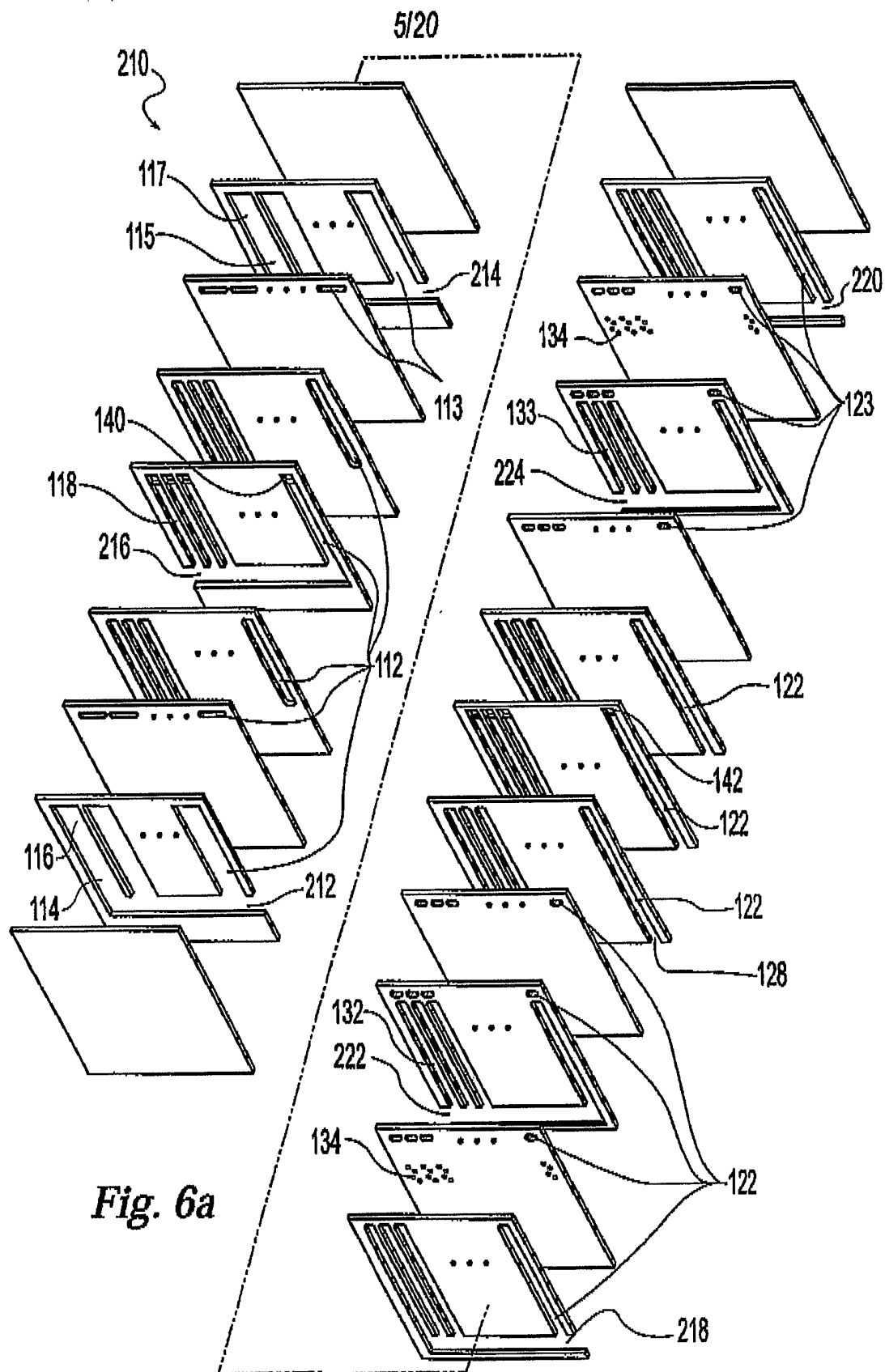
Fig. 3a

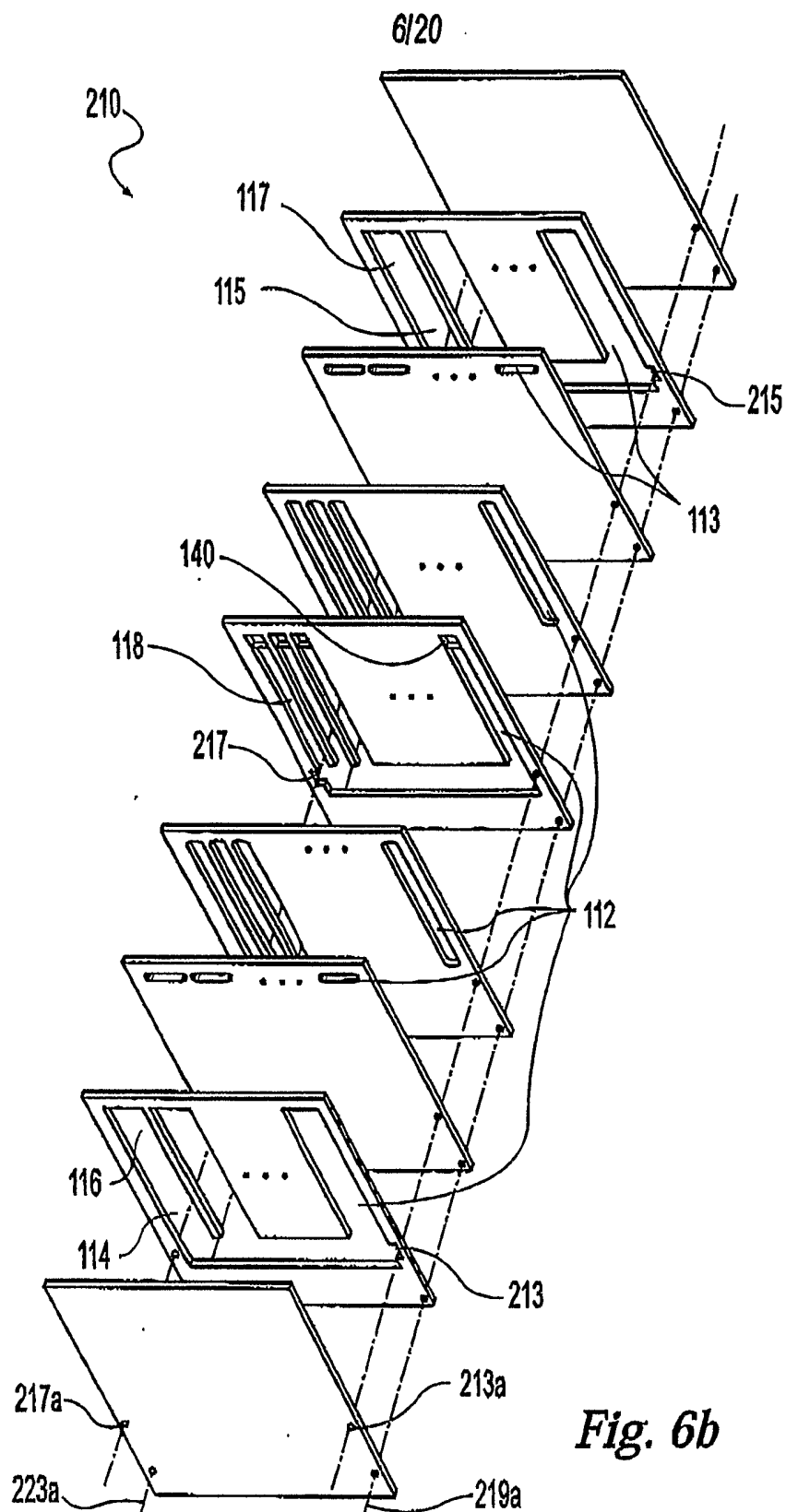


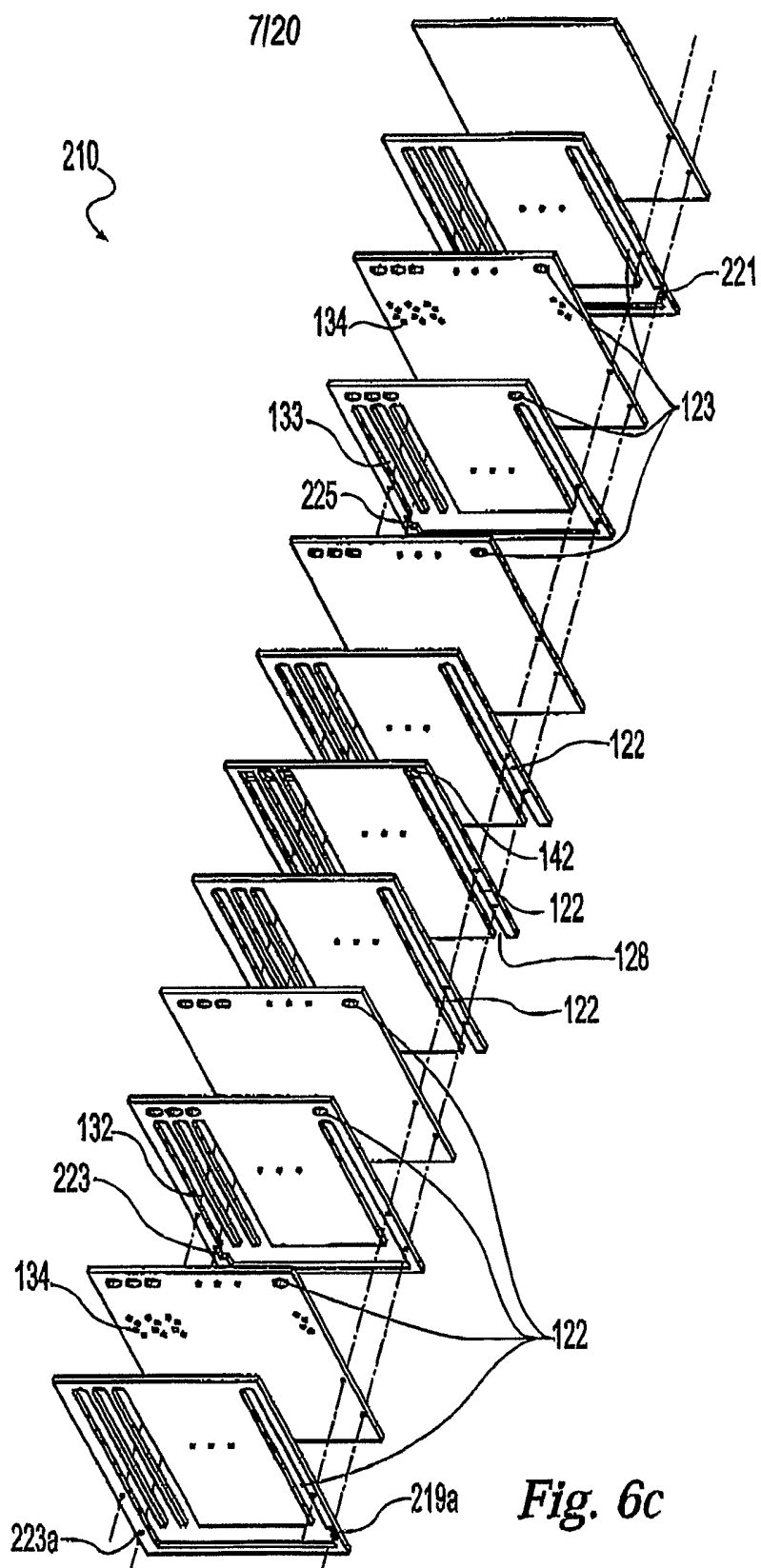
**Fig. 3b**

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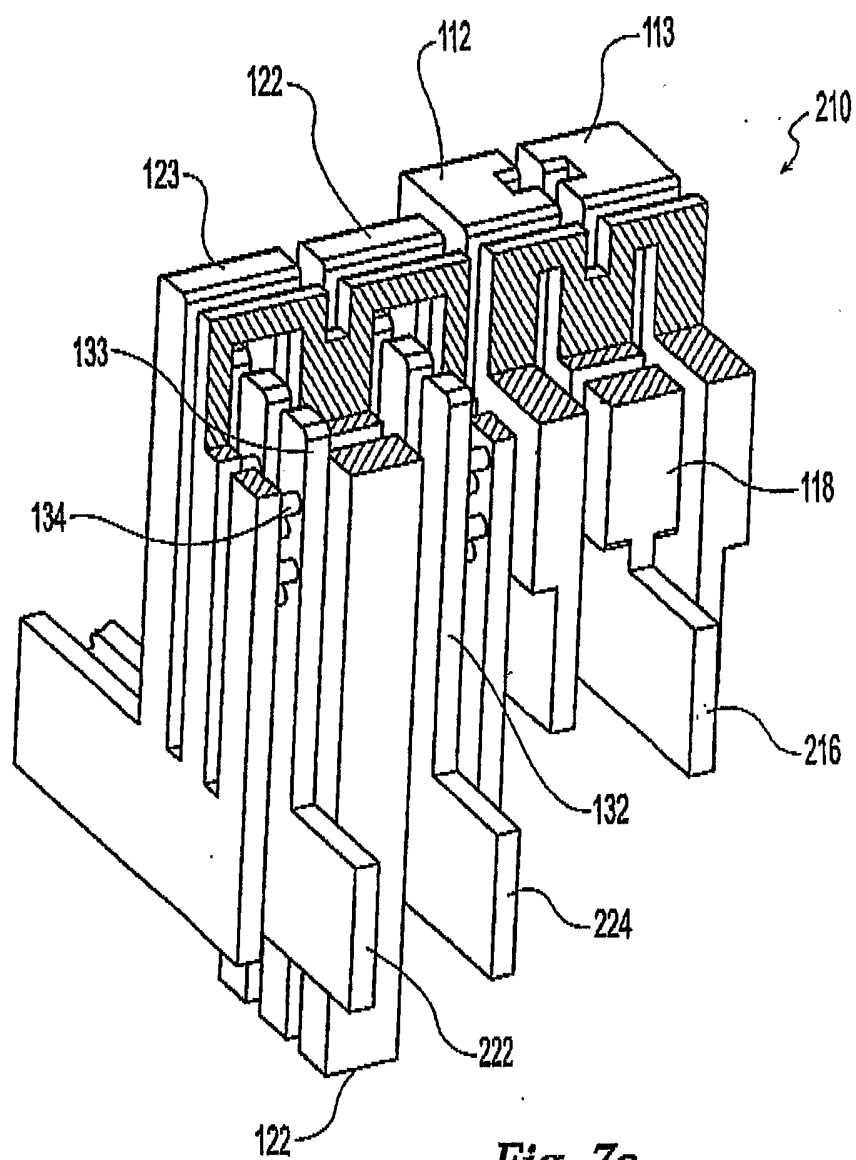




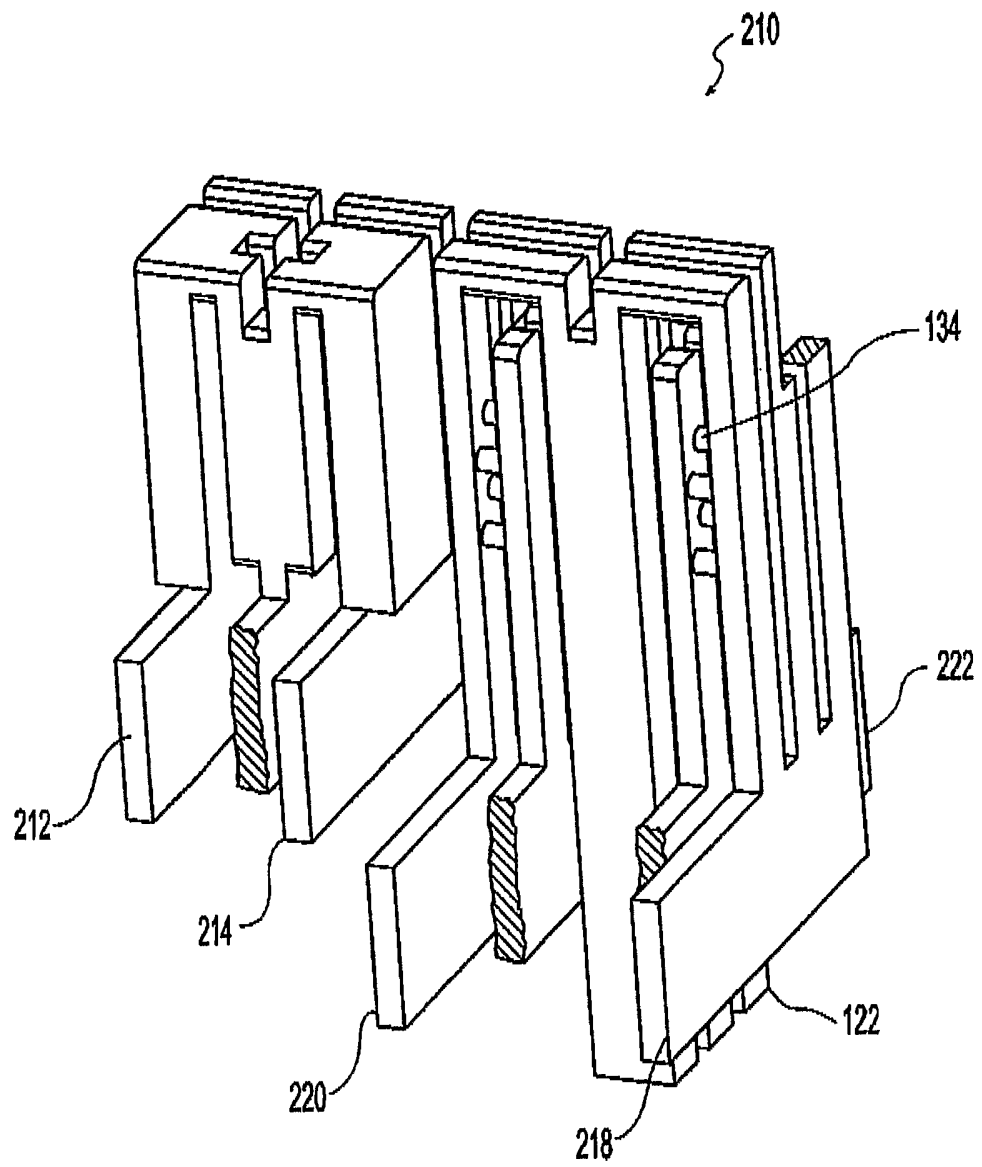
**Fig. 6b**



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*Fig. 7a*

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*Fig. 7b*



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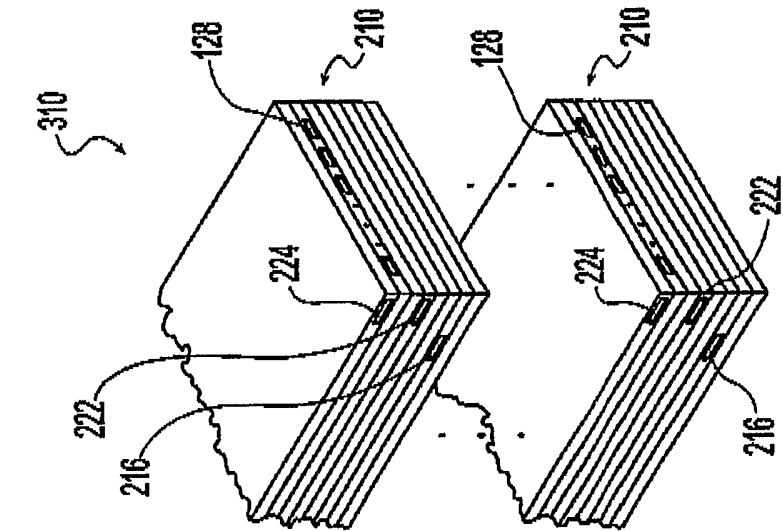


Fig. 8b

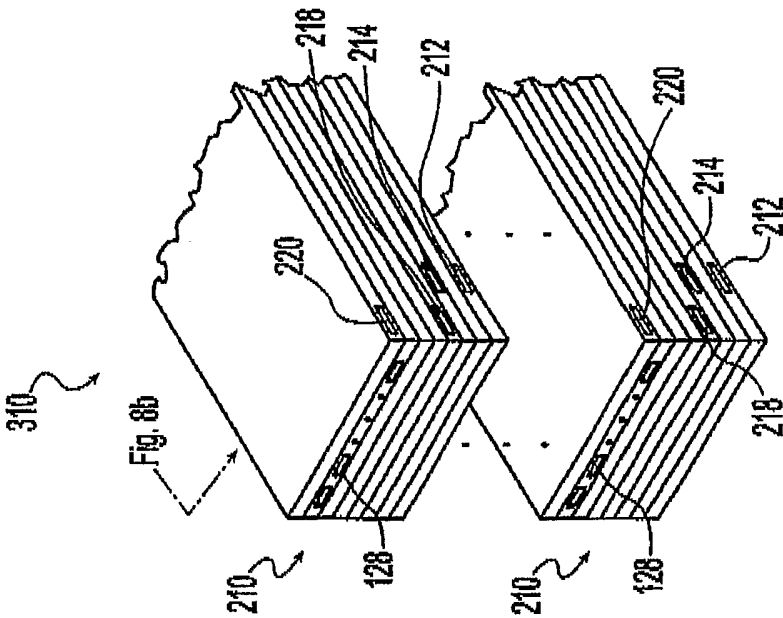
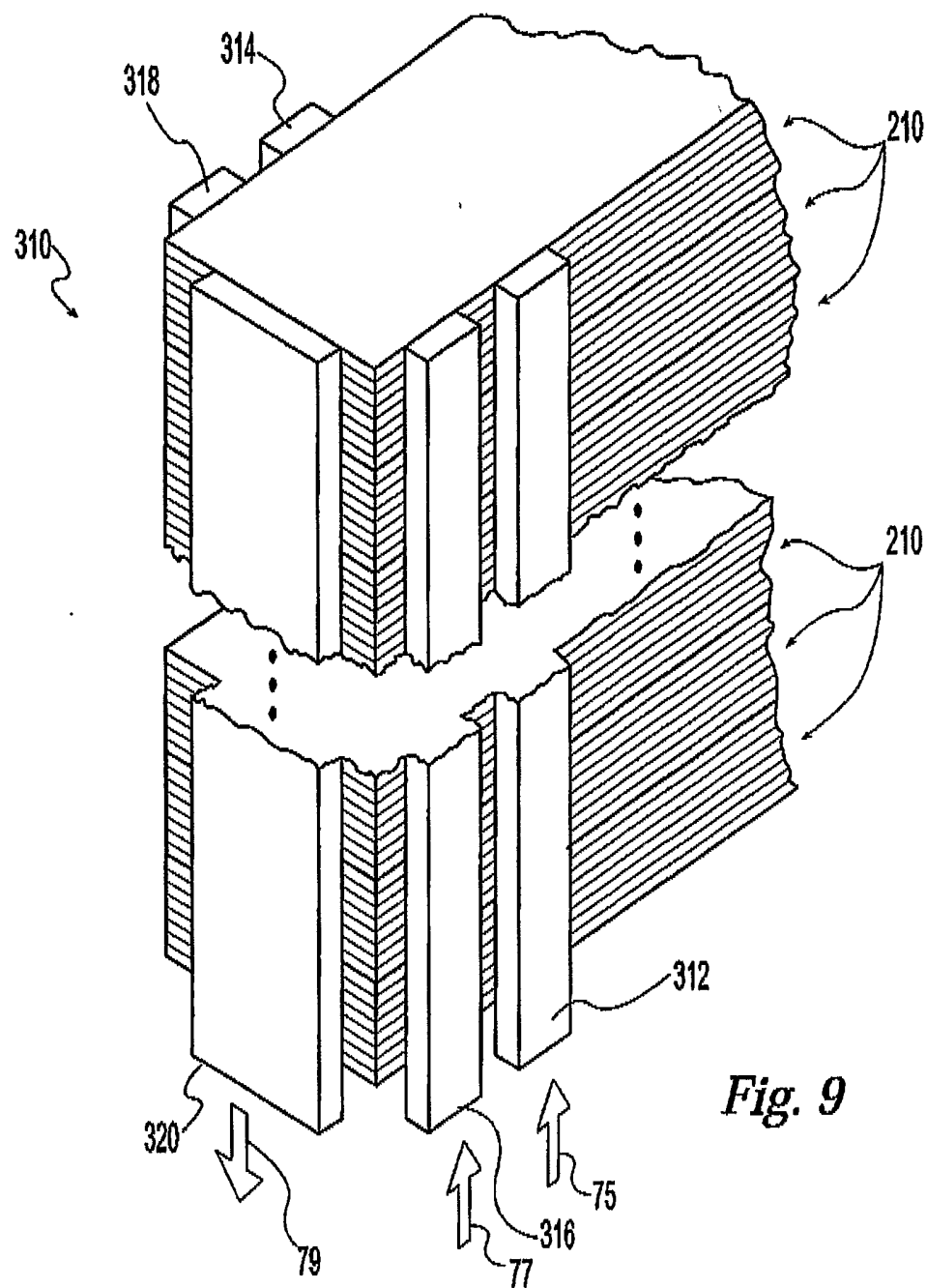


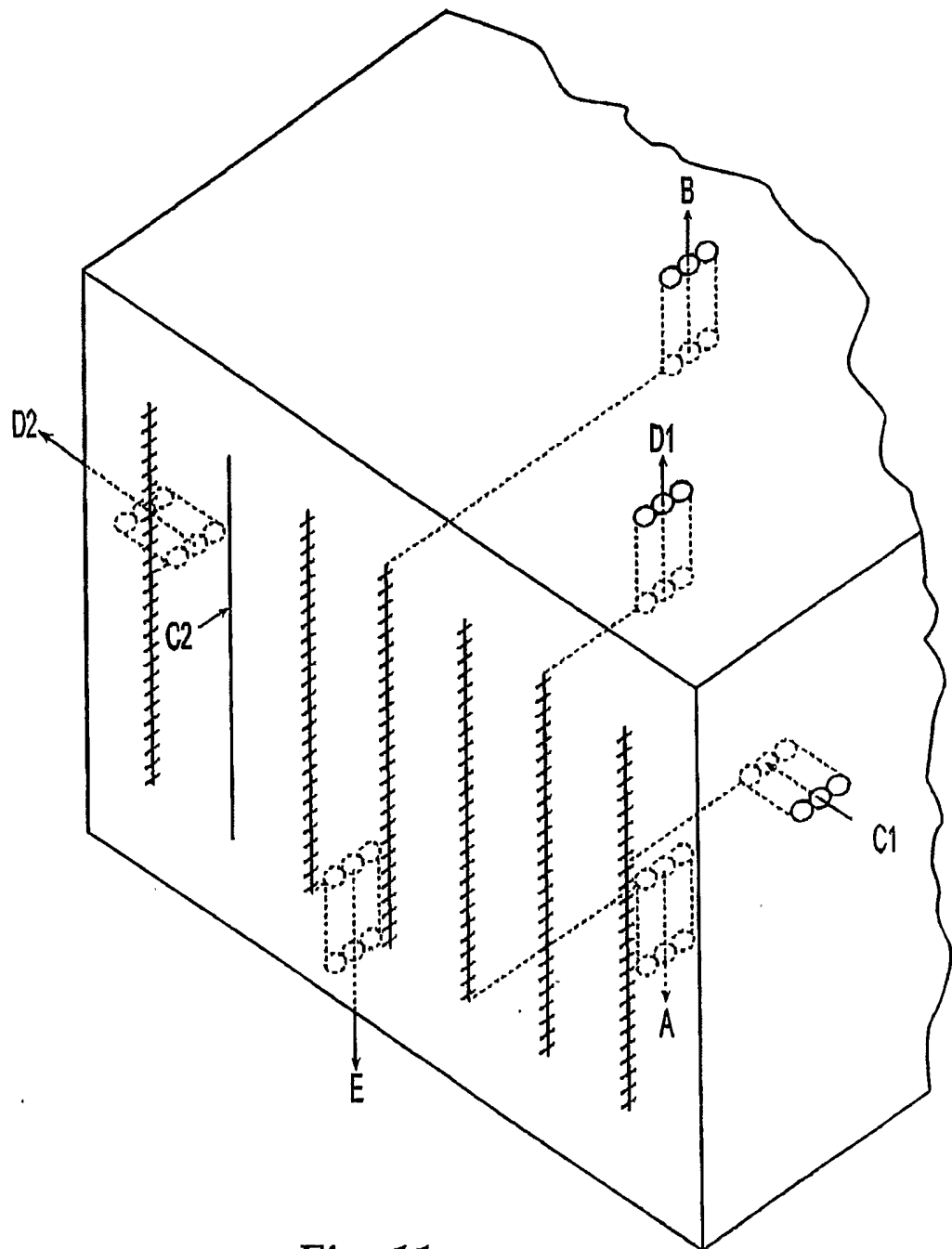
Fig. 8a

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*Fig. 11a*



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Volumetric Flowrate							
Experimental Run No.	Stream A	Stream B	Stream C1	Stream C2	Stream D1	Stream D2	Stream E
	SLPM	SLPM	SLPM	SLPM	SLPM	SLPM	SLPM
1	13.76	7.38	4.66	3.11	3.80	3.80	2.41
2	13.76	7.38	4.66	3.11	3.80	3.80	2.41
3	9.17	4.92	3.11	2.07	2.53	2.53	1.61
4	6.88	3.69	2.33	1.55	1.90	1.90	1.21
5	5.50	2.95	1.87	1.24	1.52	1.52	0.96
6	4.59	2.46	1.55	1.04	1.27	1.27	0.80

Outlet Pressure							
Experimental Run No.	Stream A	Stream B	Stream C1	Stream C2	Stream D1	Stream D2	Stream E
	psia	psia	psia	psia	psia	psia	psia
1	70	70	14.7	14.7	14.7	14.7	14.7
2	161	169	14.7	14.7	14.7	14.7	14.7
3	161	169	14.7	14.7	14.7	14.7	14.7
4	161	169	14.7	14.7	14.7	14.7	14.7
5	161	169	14.7	14.7	14.7	14.7	14.7
6	161	169	14.7	14.7	14.7	14.7	14.7

Fluid Composition					
Fluid	A	B	C	D	E
Composition Mole %					
Hydrogen	0.68				1.00
Nitrogen	0.20		1.00	1.00	
Water	0.12	0.50			
Methane		0.50			

Residence times (all in ms)							
Experimental Run No.	Stream A	Stream B	Stream C1	Stream C2	Stream D1	Stream D2	Stream E
1	4.30	8.96	3.74	4.01	3.80	3.73	11.03
2	9.89	21.64	3.74	4.01	3.80	3.73	11.03
3	14.84	32.45	5.61	6.03	5.71	5.61	16.51
4	19.78	43.27	7.48	8.05	7.60	7.47	21.97
5	24.74	54.13	9.33	10.06	9.50	9.33	27.69
6	29.65	64.91	11.25	11.99	11.37	11.17	33.22

Fig. 12

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Inlet Temperature deg. C	Test	Experimental Run No.					
		# 1	# 2	# 3	# 4	# 5	# 6
Stream E	Test X	149.7	157.8	148.7	141.2	151.1	165.3
	Test Y		152.2	143.8	131.9	129.8	134.1
	Test Z		114.9	114.8	113.7	119.1	121.2
Stream C1	Test X	852.3	855.9	858.6	859.2	852.7	854.8
	Test Y		848.8	857.4	851.6	850.5	853.1
	Test Z		852.1	854.6	852.5	851.1	849.6
Stream C2	Test X	850.7	852.9	852.3	858.7	851.2	852.4
	Test Y		851.9	856.1	850.5	850.6	854.7
	Test Z		850.2	848.8	847.6	846.9	846.5
Stream D2	Test X	83.6	87.5	89.9	86.3	98.2	111.1
	Test Y		82.3	83.3	82.3	85.2	90.7
	Test Z		44.5	43.4	43.8	46.3	47.4
Stream D1	Test X	43.6	45.2	49.8	51.0	64.7	75.1
	Test Y		43.2	45.1	46.3	52.6	58.7
	Test Z		36.1	35.0	35.8	38.3	39.1
Stream B	Test X	228.6	241.0	230.3	212.3	230.2	239.1
	Test Y		180.4	172.2	162.3	164.0	172.8
	Test Z		185.9	178.7	173.5	180.5	181.2
Stream A	Test X	852.2	857.8	849.3	859.5	849.3	846.8
	Test Y		855.0	853.5	848.1	846.9	851.0
	Test Z		852.9	854.3	854.6	854.1	850.3

*Fig. 13*

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Outlet Temperature deg. C	Test	Outlet Temperature					
		Experimental Run No.					
		# 1	# 2	# 3	# 4	# 5	# 6
Stream E	Test X	774.0	778.5	789.7	806.0	804.1	809.1
	Test Y		785.1	803	803.3	806.8	813.7
	Test Z		794.3	811.0	816.2	818.7	819.1
Stream C1	Test X	282.1	288.6	237.0	208.7	192.3	205.4
	Test Y		288.6	236.1	199.3	179.3	173.4
	Test Z		155.5	137.8	126.7	126.2	124.0
Stream C2	Test X	169.7	177.8	158.7	142.2	148.0	160.0
	Test Y		172.1	150.9	133.8	128.0	130.0
	Test Z		166.2	145.6	133.0	131.7	128.8
Stream D2	Test X	747.0	750.6	773.0	795.2	796.9	804.2
	Test Y		760.2	787.7	793.1	799.8	808.8
	Test Z		768.6	788.2	794.1	797.0	797.8
Stream D1	Test X	762.8	766.6	779.6	797.0	797.2	804.0
	Test Y		774.7	793.7	795.4	800.8	808.9
	Test Z		782.0	798.1	802.2	804.5	805.0
Stream B	Test X	695.4	699.0	728.1	759.1	765.0	776.0
	Test Y		710.5	745.0	758.2	766.1	776.5
	Test Z		723.3	755.2	769.9	780.2	786.3
Stream A	Test X	245.0	252.3	220.6	208.9	209.2	218.0
	Test Y		251.0	219.3	193.0	178.4	178.7
	Test Z		248.6	214.3	194.0	186.0	177.2
Energy Balance (%)	Test X		83.8	81.7	78.4	79.3	78.4
	Test Y		80.0	76.0	76.0	83.7	82.9
	Test Z		76.8	75.3	75.2	74.7	81.5

*Fig. 14*



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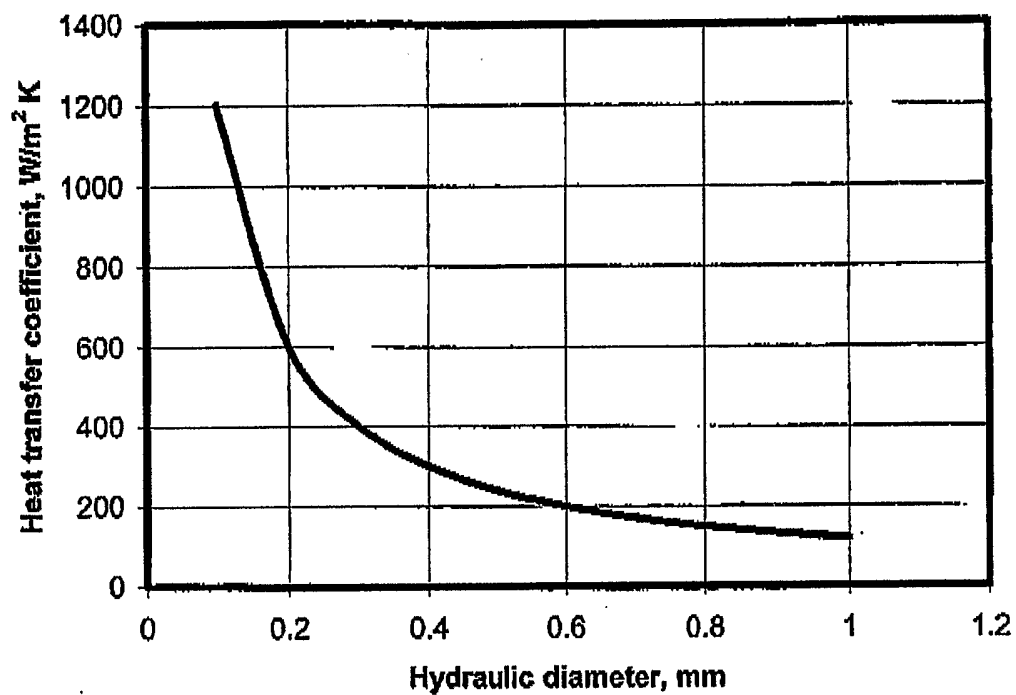
Pressure Drop						
Experimental Run No.	Test	Stream C2 (psi)	Stream D1 (psi)	Stream C1 (psi)	Stream B (psi)	Stream A (psi)
2	A	2.3		2.3		
	B	2.3	7.1	3.1	1.7	3.6
	C	2.5	7.5	3.3	1.6	3.6
3	A	1.5	5.1	2.1		
	B	1.5	4.6	2.1	1.0	2.0
	C	1.6	5.0	2.3	1.1	2.2
4	A	1.1	4.5	1.5		
	B	1.0	3.3	1.5	0.9	1.3
	C	1.2	3.7	1.8	0.7	1.5
5	A	0.7	3.5	1.2		
	B	0.8	2.6	1.2	0.6	0.9
	C	0.9	2.9	1.4	0.4	1.1
6	A	0.7		1.1		
	B	0.7	2.1	1.0	0.5	0.8
	C	0.8	2.4	1.2	0.2	0.9

*Fig. 15*

Streams	C1	D1	A	B	E	C2	D2
Actual $T_{hot}$ deg. C	856	770	858	741	800	853	762
Calc $T_{hot}$	856	751	858	700	779	853	767
Actual $T_{cold}$	328	88	266	242	158	250	45
Calc $T_{cold}$	289	88	253	242	158	178	45

*Fig. 16*

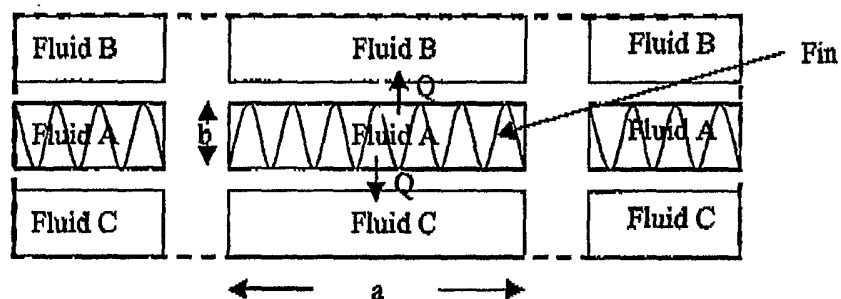
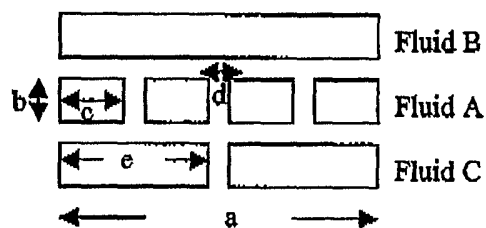
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Air at 400 deg. C and  $Re < 2000$

*Fig. 17*

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*Fig. 18**Fig. 19*