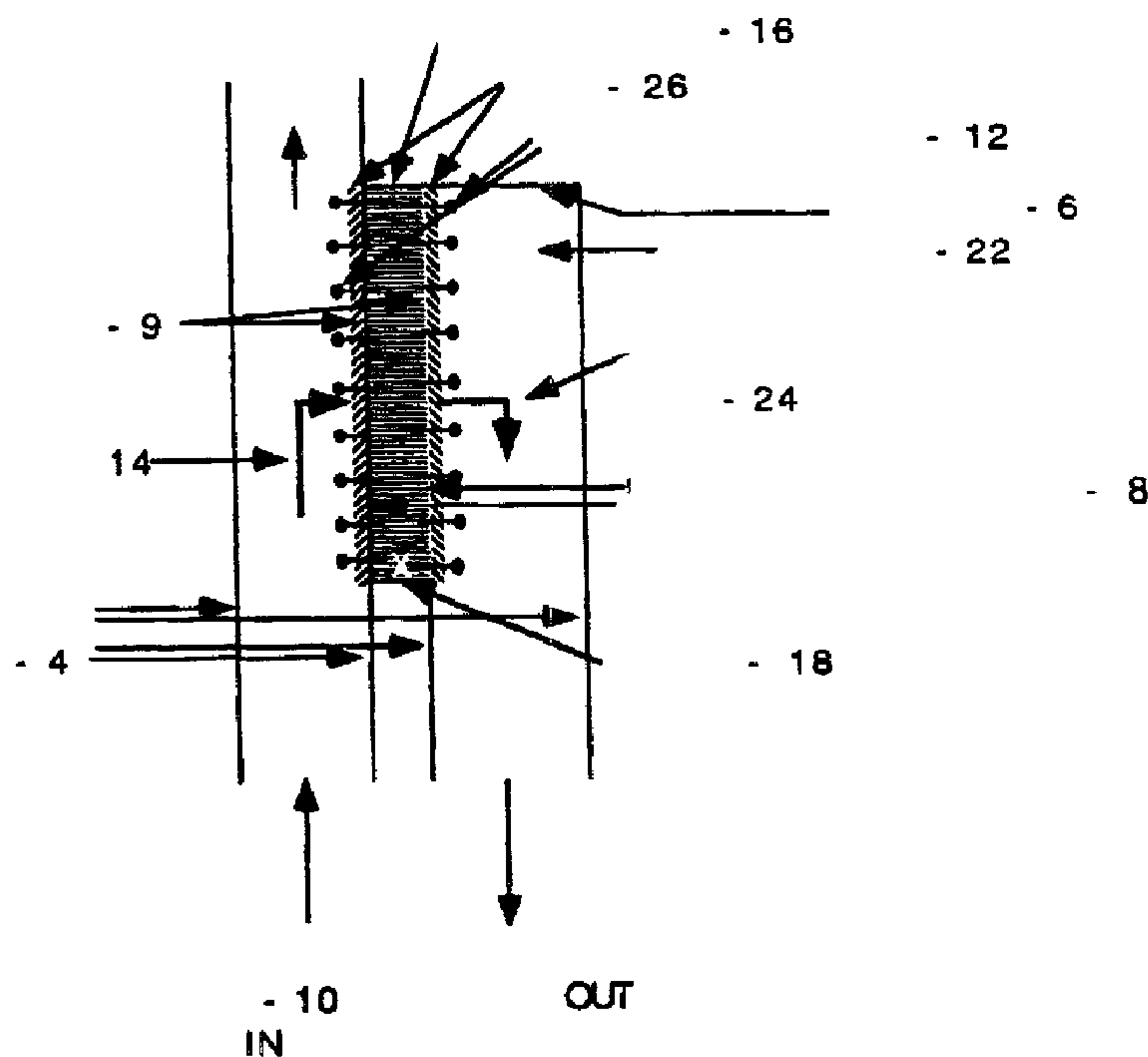




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(54) Title: ENZYME SYSTEMS FOR GAS PROCESSING



Bioreactor
Gas to Liquid to Gas Phase Transfer

(57) Abrégé/Abstract:

The invention provides a process for gas separation wherein a selected gas in a mixed gas stream is contacted by an enzyme having an active site directly contacted by the mixed gas stream, and the selected gas is at least partially removed from the mixed

(57) Abrégé(suite)/Abstract(continued):

gas stream. In one embodiment a selected gas in a gas phase is contacted by a solvated enzyme wherein the enzyme active site is in direct contact with the gas phase, and the selected gas is converted to a first product in a condensed phase by contact with the solvated enzyme. The invention also provides a bioreactor which comprises a vessel having at least one first wall enclosing an inlet zone, and at least one second wall enclosing a second phase zone, a portion of the second wall is permeable to at least one selected gas in the inlet zone, and retains the second phase in the second phase zone; a portion of the second wall also comprises a support surface with at least one enzyme fixed thereon, such that a mixed gas stream entering the inlet zone contacts enzyme which removes a selected gas from the mixed gas stream and passes the selected gas to the second phase zone. The invention also provides an alternative bioreactor which comprises buoyant beads coated with enzyme, floating on the surface of a condensed fluid phase, in contact with a gas phase such that the active site of the enzyme is in direct contact with the gas phase, and the beads are free to rotate in response to motion in either phase, and means for producing motion in at least one phase such that portions of the beads alternately contact the gas phase and the fluid phase, bringing a selected gas into the condensed fluid phase.

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(54) Title: ENZYME SYSTEMS FOR GAS PROCESSING (57) Abstract The invention provides a process for gas separation wherein a selected gas in a mixed gas stream is contacted by an enzyme having an active site directly contacted by the mixed gas stream, and the selected gas is at least partially removed from the mixed gas stream. In one embodiment a selected gas in a gas phase is contacted by a solvated enzyme wherein the enzyme active site is in direct contact with the gas phase, and the selected gas is converted to a first product in a condensed phase by contact with the solvated enzyme. The invention also provides a bioreactor which comprises a vessel having at least one first wall enclosing an inlet zone, and at least one second wall enclosing a second phase zone, a portion of the second wall is permeable to at least one selected gas in the inlet zone, and retains the second phase in the second phase zone; a portion of the second wall also comprises a support surface with at least one enzyme fixed thereon, such that a mixed gas stream entering the inlet zone contacts enzyme which removes a selected gas from the mixed gas stream and passes the selected gas to the second phase zone. The invention also provides an alternative bioreactor which comprises buoyant beads coated with enzyme, floating on the surface of a condensed fluid phase, in contact with a gas phase such that the active site of the enzyme is in direct contact with the gas phase, and the beads are free to rotate in response to motion in either phase, and means for producing motion in at least one phase such that portions of the beads alternately contact the gas phase and the fluid phase, bringing a selected gas into the condensed fluid phase.		

ENZYME SYSTEMS FOR GAS PROCESSING

TECHNICAL FIELD

5 This invention relates to a process utilizing natural, modified or engineered enzymes as agents, alone or immobilized in conjunction with membranes or other techniques or cells or cell fragments for the extraction of one or more specific molecules from a mixture of molecules in a first gaseous phase and moving at least one specific molecule to a second phase. Preferably the mixture of molecules is in a first gas phase and a specific molecule type is transported to a second mobile fluid phase. The specific gases to be separated may be present in a gas mixture, or in solution of mixed gases. In a mixed gas
10 solution in a liquid phase, the specific gases can be treated either in their dissolved or solvated molecular state or after they have been converted to an ionic or ionized state either by reaction with water, reaction with another solvent, or by other prior chemical reaction. The invention process may also be used to regenerate a specific gas from the second phase. The invention further relates
15 to the extraction of gases, molecules or ions from a liquid solution, aqueous or non-aqueous, to concentrate or isolate specific materials alone or in chemical combination and in ionic or non-ionic form.

BACKGROUND OF THE INVENTION

Traditional means of isolating selected gases from a mixed stream involve physical, chemical reactions or a combination thereof, and inert semipermeable membranes. Among such processes are cryogenic, gas-liquid and gas-solid
5 sorptive techniques (e.g. pressure swing adsorption, amine treatment, iron sponge, etc.), and immiscible liquid-liquid extraction (for recent summaries see Michaels AS: New vistas for membrane technology. Chemtech. 19:160-172, 1989;

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and Babcock RE, Spillman RW, Goddin CS & Cooley TE: Natural gas cleanup: A comparison of membrane and amine treatment processes. Energy Prog. 8(3):135-142, 1988.) Newer technologies focus on the use of inert semipermeable membranes but these do not offer a separation solution that is particularly
5 unique over existing processes (Spillman RW: Economics of gas separation membranes. Chem. Engr. Prog. 85:41-62, 1989). Membrane systems have been said never to achieve complete separation (Spillman, *id.* 1989). Prior art physical or chemical means do not readily allow segregation among gases with similar physical or chemical properties or those in low concentrations. In general prior
10 art does not effectively deal with extracting gases or gas equivalents from a dissolved or ionized state to regenerate a purified gas. The prior art generally treats gases already dissolved in water such as carbon dioxide or oxygen in Bonventura et al., U. S. Patent 4,761,209 and 4,602,987 and carbon dioxide in Henley and Chang U. S. Patent 3,910,780. No reference has been located in
15 which the enzyme contacts a gas in a gas stream, separates the gas and in a subsequent step regenerates a purified gas.

Traditional gas separation means commonly exhibit one or more of the following problems: they are energy inefficient, commonly nonspecific, quite slow, require a relatively pure feedstock, depend on a significant pressure head, or use
20 ecologically questionable or toxic compounds. The relatively pure feed stock requirement may result in a geographical restriction of available feed materials. The geographic availability may require shipment from distant locations such that transportation costs may be high, and even prohibitive for some uses. The preceding limitations present restrictions on the growth and application of gas
25 extraction/purification systems. A gas separation or enrichment process that did not require highly concentrated feed-stocks thus eliminating or reducing transportation requirements would be beneficial.

In contrast to the disadvantages enumerated above for traditional physical/chemical methods, biological catalysts (enzymes) present several
30 advantages including enhanced efficiency, speed, and increased specificity.

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Enzymes also commonly distinguish optical isomers. Further, they can be used at moderate temperatures and pressures, enhancing safety.

Prior use of enzymes has focused very largely on the food processing industry, cleansing or detergent applications, or processing of sewerage.

5 Industrial applications in the gas field have been limited. Prior application of enzymes to gas extraction are found in patents to Bonaventura et al, U. S. Patents 4,761,209 and 4,602,987 and Henley and Chang U. S. Patent 3,910,780. Bonaventura uses membranes impregnated with carbonic anhydrase to facilitate transport of CO₂ across a membrane into water in an underwater rebreathing

10 apparatus. Henley and Chang make a similar use carbonic anhydrase. Both processes operate on dissolved carbon dioxide. Neither taught fixation of the enzyme with the active site exposed to the gaseous phase with sufficient hydration to maintain a reactive conformation. Neither taught modification of DNA coding for enzymes to build in specific structure for fixation or enhanced

15 catalysis. Indeed Bonaventura took for granted that the crude coupling techniques disclosed would deactivate a large fraction of the active enzyme. The Bonaventura patents contain computations showing that only a small fraction (1%) of the carbonic anhydrase need retain its activity in the bonded membrane to provide adequate capacity to remove carbon dioxide from the proposed

20 apparatus in the illustrative uses. Henley and Chang do not discuss activity losses nor provide any description of fixation techniques to enhance enzyme activity when in the active site is directly exposed to a nonaqueous environment.

Despite some significant advantages, a variety of major problems have limited the application of enzymes in industrial settings. These include short

25 lifetime of either free or immobilized enzyme, fouling and biofouling, separation of the enzyme from the immobilization surface, limited availability of enzymes in sufficient quantity, and expense of manufacture.

These problems have resulted in relatively few efforts to use enzymes for manipulation of gases. Further, physical/chemical means are in place

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commercially; they are understood and represent established technology and significant investment.

Despite these historic considerations a number of recent developments now allow broad based enzymatic applications. First, the development of DNA
5 libraries and the techniques needed to generate such libraries so that large amounts of enzyme can be made economically. Previously, and even today, many enzymes are derived by purification from a biological source. Second, development of techniques to generate membrane expression of enzymes and even direct secretion such that harvesting the enzymes is easier and economically
10 feasible. Third, the development of new immobilization techniques which allow long lifetime and high efficiency.

SUMMARY OF THE INVENTION

The invention provides a process for gas separation wherein a selected gas in a mixed gas stream is contacted by an enzyme, and the selected gas is
15 removed from the gas stream. The selected gas may also be recovered as a separated gas. In one embodiment the invention provides a process for gas treatment wherein a selected gas in a gas phase is contacted by a solvated enzyme wherein the enzyme active site is in direct contact with the gas phase, the selected gas is converted to a first product in a condensed phase by contact with
20 the solvated enzyme. In a preferred embodiment the hydrated enzyme is partially covered with a hydrocarbon film. In another preferred embodiment the hydrocarbon film is a lipid layer, more preferably the lipid layer is a phospholipid and most preferably the phospholipid is a bilayer. In a preferred embodiment, the first product is further contacted with a second enzyme in the condensed
25 phase and converted to a second product, which maybe the originally selected gas or a different material. In an alternative embodiment the invention provides a process for gas treatment wherein a selected gas in a gas phase is contacted by a solvated enzyme wherein the enzyme active site is in direct contact with the gas phase, the selected gas is converted to a first product in a condensed phase by
30 contact with the solvated enzyme, the first product is further contacted with a

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second enzyme in the condensed phase and converted to a second product. In an alternative embodiment a simplified bioreactor is provided which comprises buoyant beads coated with enzyme, floating on the surface of a condensed fluid phase, in contact with a gas phase such that the active site of a portion of the enzyme coating is in direct contact with the gas phase, and the beads are free to rotate in response to motion in either phase, and means for producing motion in at least one phase such that portions of the beads alternately contact the gas phase and the fluid phase, bringing a selected gas into the condensed fluid phase. In a preferred embodiment the enzyme is immobilized on the bead surface. In an especially preferred embodiment the enzyme is carbonic anhydrase, and the condensed fluid phase is water.

The invention also provides novel apparatus for practicing the process for gas separations. The method couples use of selective enzymes and immobilization by several distinct means in conjunction with a variety of support structures or membranes to achieve gas enrichment, purification, separation and processing of gas mixtures. The process of the invention can be used in a selective or subtractive manner, and provides on location separation and purification, thereby avoiding transportation problems. The invention also encompasses advanced enzyme fixation methods resulting in higher enzyme activity than the crude cross linking techniques fixation of Bonaventura et al. The present invention is the first to provide enzyme immobilization with active site exposure directly to gas phase substrates.

The invention is a process to achieve vectorial movement and separation of one or more gas substrates admixed with several other gases, thus isolating a selected gas from a mixture. The invention may be used to detect and measure the gas, to subsequently purifying the selected gas, or to convert selected gases to new chemical entities.

In apparatus provided for practicing the invention, an appropriate enzyme or enzymes are present at the supply side to effect a change in state or chemistry of the selected gas and thereby generate a reaction product and reduce or

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prevent exit of the enzyme reaction product back to the gaseous supply side. Solubility and concentration factors favor movement of the enzyme reaction product into a second phase which also contacts the enzyme. The second phase may be a second gas stream, or a solvent or a solvent doped with ions or other
5 chemical materials to facilitate retention of the enzyme reaction product. Further treatment of the second phase may recover the selected gas as a purified or concentrated stream, or further react the selected gas or gases to produce a desired chemical entity.

Accordingly, the several objects the invention are to provide a process
10 wherein gas mixtures are effectively separated so that at least one species may be isolated and/or enriched. Another object is to extract a selected gas for independent use or to serve as a start material or substrate for another physical, chemical or biological operation. Another object is to process ionic equivalents of a gas, present in a solution, to extract the ionic gas equivalents in the form of
15 a gas or to use the material as a substrate for another physical, chemical or biological operation. Another object of the present invention is to allow serial, parallel or sequential processing of gas mixtures for sequential isolation or enrichment of gases. Another object is to allow very large volumes of gas to be produced, not heretofore possible. Another object is to allow enrichment or
20 removal from gas mixtures in which the object gas species is in low concentration. Another object is to allow location of the separation facility at or near to the site of final use to reduce or eliminate transportation. Another object of the invention is to allow appropriately sized production facilities to meet the needs of each user. Another object is to allow placement of gas generating facilities
25 anywhere in the world, or in space.

Further objects of the present invention are to utilize a low purity gas source. Yet another object is to treat the effluent from any kind of smoke stack, stationary or mobile, to process gases including carbon dioxide, oxides of nitrogen, oxides of sulfur, hydrogen sulfide, methane, ozone, or

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chlorofluorocarbons. Carbon dioxide removal from gas streams is a particularly preferred objective for gas processing.

The invention also provides apparatus for practicing the processes of the invention selected embodiments of which are illustrated by the drawings. Those skilled in the art will recognize that many changes and substitutions may be made without departing from the spirit of the invention as described herein. The drawings and descriptions are provided for illustration and not for limitation. The invention is defined and limited by the claims set out below.

BRIEF DESCRIPTION OF THE DRAWINGS:

- 10 Fig. 1 illustrates a simplified bioreactor for separation of a selected gas.
- Fig. 2 shows a reactor set up for recovery of carbon dioxide from a flue gas stream.
- Fig. 3 shows a multienzyme reactor for production of urea.
- Fig. 4 shows a reactor for conversion of oxygen and water to hydrogen peroxide.
- 15 Fig. 5 illustrates buoyant beads for positioning enzyme at a liquid surface to facilitate transfer of a selected gas to a liquid phase.
- Fig. 6 Phase rotating immobilized enzyme carrier, plan view.
- Fig. 7 Phase rotating immobilized enzyme carrier, side view.

DETAILED DESCRIPTION OF THE INVENTION

Figure 1 illustrates an apparatus for practicing the invention as a process for gas separation wherein a selected gas in a mixed gas stream is contacted by an enzyme, and the selected gas is removed from the gas stream. The apparatus allows the selected gas to be recovered as a separated gas.

- 5 The bioreactor comprises a vessel having at least one first wall 2 and at least one second wall 4, and an optional end wall 6 which closes a portion of the volume enclosed by first wall 2 and second wall 4. A portion 9 of second wall 4 is permeable to at least one selected gas and also comprises a support surface 8 for enzyme immobilization; a mixed gas stream 10, from a gas source not
- 10 shown, enters a space between first wall 2 and second wall 4 wherein the mixed

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gas stream 10 contacts immobilized enzyme 12 fixed to support surface 8 which removes selected gas 14 from mixed gas stream 10; selected gas 14 interacts with immobilized enzyme 12 and is caused to enter second phase 16 which is in fluid contact with immobilization support 8 and immobilized enzyme 12 and confined
5 with the volume enclosed by second wall 4 and optionally end wall 6; second phase 16 may be a low pressure carrier gas stream or vacuum line, or a liquid or gas permeable gel, alternatively second phase 16 may be stirred by optional stirrer 18 or circulated by an optional pump, not illustrated. An appropriate enzyme or enzymes are present at permeable portion 9 to effect a change of
10 state or chemistry of selected gas 14 and thereby reduce or prevent exit of the selected gas 14 back to the supply side. The desired vectorial movement of selected gas 14 into phase 16 may be promoted by concentration effects, solvation, chemical conversion, ionization, or other means to favor movement of selected gas 14 or its enzyme reaction product 15 into second phase 16.
15 If desired, second phase 16 may flow through the area enclosed by second walls 4 by use of a suitable port, not shown, and second phase 16 may also be recirculated through a recycling loop not shown. The selected gas 14 or its enzyme reaction product 15 may be used in second phase or may optionally be further processed. Additional support surface 8, permeable area 9 and
20 immobilized enzyme may be provided in second wall 4 to connect second phase 16 to a recovery zone 22 enclosed by first wall 2, or second wall 4, or a combination thereof, and optionally end wall 6 and recovered as a further reacted product or as a concentrated gas by, for example, reverse reaction with the same immobilized enzyme to generate a recovered purified selected gas 14.
25 A concentration gradient or other means will be used to favor vectorial movement of selected gas 14 or enzyme reaction product 15 from second phase 16 to recovery zone 22. Any of the means previously listed can be also be applied at this stage to provide movement into recovery zone 22. If desired, one or more different enzymes or other catalysts may be placed between second
30 phase 16 and recovery zone 22 to further convert selected gas 14 to a new

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product. Additional stages may be added to further change or process selected gas 14 or its enzyme reaction product 15 as may be desired. Figure 2 illustrates a reactor removing carbon dioxide from a mixed gas stream such as animal respiratory gases by contact with carbonic anhydrase, conversion of carbon dioxide to bicarbonate, and subsequently reconverting bicarbonate to carbon dioxide as a concentrated gas stream. Figure 3 illustrates a multienzyme reactor system which converts carbon dioxide and ammonia to urea.

In a reactor of the type illustrated by Fig. 1, elements and areas may be interchanged to provide many alternative structures as will be apparent to those skilled in the art. The mixed gas stream 10 may be pretreated to provide an optimal temperature or pressure, or to remove components that would lower the reactor's efficiency, or contribute components that may pass through the selection media to contaminate purified selected gas stream 24, or recovered product 25. Examples of pretreatment include mechanical screening by filters, chemical screening by adsorbents or absorbents, or scrubbing, and use of heat exchangers, waste heat recovery processing, compression, expansion and other gas processing steps known in the art.

The immobilization support 8 may be of any conventional material such as polysaccharide surfaces or gels, ion exchange resin, treated silicon oxides, porous metal structures, carbon rods or tubes, graphite fibers, silica beads, cellulose membranes, gel matrices such as polyacrylamide gels, poly(acryloyl morpholine) gels, nylon or other polymer meshes, or other suitable binding surface. Alternatively the enzyme may be wholly or partially encapsulated in a suitable material such as cellulose nitrate capsules, polyvinyl alcohol capsules, starch capsules or liposome preparations. In another alternative the enzyme may be fixed at a phase boundary, as illustrated in Figures 5, 6 and 7 or by use of nonionic surfactants as described, for example in Li et al., U.S. Patent 3,897,308.

The enzyme may be fixed to the surface by binding, covalent bonding, physical attraction, coordination bonds, chelation, or other binding means or mechanical trapping or other means known to those skilled in the art. The

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support may also be a membrane of selective permeability. The selectivity may be by size, or other characteristic. The membrane may be a lipid bilayer doped with passive porins, channels or ionophores of the co-porter or antiporter type which commonly rely on properties such as charge and/or hydrated radius for separation. Further examples of suitable materials for permeable portion 9 and support surface 8 include permeable membranes, natural and artificial, including semipermeable plastic membranes, black lipid membranes, alternatively doped with ionophores to provide ion conducting channels. In yet another embodiment the porins may be active, i.e., dependent on an energy flux. For example with a cell wall membrane, the energy flux may be tied to an endogenous high energy compound such as a labile triphosphate bond or to an exogenous supply of energy via photons, electrons or protons. In all these cases the immobilization support works as membrane with selective permeability to maintain separation of the mixed gas stream 10 from the second phase 16 while passing selected gas 14 into contact with second phase 16.

The enzymes immobilized on support surface 8 are of two types, simple enzymes and those requiring cofactors for activity. Simple enzymes may be fixed to the support surface by any of the means known to the art. Preferably the enzymes are modified by adding an amino acid sequence that binds to the support without substantially reducing enzyme activity. In a preferred embodiment the enzyme is modified by altering the DNA segment coding for the enzyme to add a sequence coding for an amino acid sequence that yields a binding moiety to the enzyme in a manner that enhances enzyme binding. The modification may provide a sequence that binds to a metal such as a poly-histidine sequence, or may code for an epitope or antigen moiety that binds to an antibody or may be a portion of an antibody that binds a known antigen. For example, a polyhistidine sequence can be added to an enzyme such as carbonic anhydrase by splicing a DNA fragment coding for the desired polyhistidine sequence into the DNA coding for the enzyme at either terminus of the protein

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sequence, and expressing the DNA in a suitable organism and recovering the new enzyme.

5 In the case of enzymes requiring cofactors the cofactor maybe supplied in second phase 16 or also fixed to the support surface 8 or supplied by pretreatment of surface 8 with the cofactor to activate bound enzyme. If multiple materials are to be bound to the support surface 8 they may be exposed to a prepared surface sequentially or as a mixture.

10 The second phase 16 may be selected from the group consisting of gases, aqueous solvents, protic solvents, aprotic solvents, hydrocarbon solvents, aromatic hydrocarbon solvents and supercritical fluids. The second phase may be stirred or a flow introduced by a pump to move fresh material into contact with the immobilized enzyme at the support surface. A flow may be introduced into second phase 16 by a stirrer or pump or other conventional means. Flow or other means is applied to maintain a concentration or other gradient to produce vectorial movement of the selected gas 14 into condensed phase 16. In some 15 embodiments immobilization support 8 and film 26 maybe combined as, for example, in a lipid bilayer wherein a portion of the enzyme extends into the lipid bilayer to provide both support and an evaporation barrier.

20 In a preferred embodiment a film 26 is provided in which the selected gas is soluble, and which decreases the escape of second phase 16 into mixed gas stream 10. The film maybe a gel, hydrocarbon layer, or preferably a lipid or phospholipid layer or bilayer.

25 When the recovery zone 22 is used, the condensed phase 16 is contacted by a second surface which may carry a catalyst, enzyme or simply be selectively permeable such that selected gas 14 or its equivalent or derivative is transported to recovery zone 22. Again a concentration or other gradient may be used to enhance vectorial movement from second phase 16 into recovery zone 22.

30 Gases are defined as materials which are in the gas phase at ambient temperature and pressure (taken to be 20 degrees C. and one atmosphere). Suitable gases include nitrogen, oxygen, oxides of carbon, nitrogen, sulfur,

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methane, ammonia, hydrogen sulfide and the like. Any gas that interacts with an enzyme directly from the gas phase may be a selected gas 14 in combination with a suitable enzyme 12 which interacts with the selected gas 14. An enzyme is a protein or peptide that selectively binds or reacts with a gas molecule. An enzyme is composed of amino acids with an active site which binds a specific molecule and facilitates a change in the bound molecule. An enzyme may include nonnaturally occurring amino acids, and maybe natural or artificial. Examples of suitable enzymes include:

	ENZYME	EC NUMBER
<u>10</u>	glucose oxidase	1.1.3.4
	aldehyde oxidase	1.2.3.1
	hydroxylamine oxidase	1.7.3.4
	sulfite oxidase	1.8.3.1
	sulfur-ferric ion	1.8.99.-
<u>15</u>	oxidoreductase	
	catechol oxidase	1.1.3.14
	(dimerizing)	
	laccase	1.10.3.2
	L-ascorbate oxidase	1.10.3.3
<u>20</u>	catalase	1.11.1.6
	sulfur dioxygenase	1.13.11.18
	superoxide dismutase	1.15.1.1
	B galactosidase	3.2.1.23
	urease	3.5.1.5
<u>25</u>	carbonate dehydratase	4.2.1.1
	(carbonic anhydrase)	
	lactic acid oxygenase	
	inositol oxygenase	
	lysine oxygenase	
<u>30</u>	octane oxygenase	
	pyrocatechase	
	3-hydroxyanthranilate	
	oxygenase	
	tryptophan oxygenase	
<u>35</u>	homogentisate oxygenase	

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CLASS II - GAS ENZYMES REQUIRING COFACTORS OR COENZYMES

	ENZYME	E NUMBER	COFACTOR/COENZYME
	formate dehydrogenase	1.2.1.2	NADH
<u>5</u>	formate dehydrogenase (cytochrome)	1.2.2.1	ferricytochrome b ₁
	carbon monoxide- methylene blue oxidoreductase	1.2.3.-	methylene blue
	carbon monoxide dehydrogenase	1.2.99.2	methyl viologen
<u>10</u>	nitrate reductase (NADH)	1.6.6.1	NADH
	nitrate reductase (NAD(P)H)	1.6.6.2	NAD(P)H
	nitrate reductase (NADPH)	1.6.6.3	NADPH
<u>15</u>	nitrite reductase (NAD(P)H)	1.6.6.4	NAD(P)H
	superoxide-forming enzyme	1.6.99.-	NADPH
<u>20</u>	nitrite reductase (cytochrome)	1.7.2.1	ferricytochrome c
	ferredoxin-nitrate hydroxylamine reductase	1.7.7.1 1.7.99.1	ferredoxin pyocyanine; methylene blue; flavins
<u>25</u>	nitric-oxide reductase	1.7.99.2	pyocyanine
	nitrite reductase	1.7.99.3	pyocyanine; flavins
	nitrate reductase	1.7.99.4	benzyl viologen
	sulfite reductase (NADPH)	1.8.1.2	NADP
<u>30</u>	sulfite reductase (ferredoxin)	1.8.7.1	ferredoxin
	sulfite reductase	1.8.99.1	methyl viologen
	adenyl sulfate reductase	1.8.99.2	methyl viologen
	cytochrome c oxidase	1.9.3.1	ferrocyanochrome
<u>35</u>	Pseudomonas cytochrome c oxidase	1.9.3.2	ferrocyanochrome
	nitrate reductase	1.9.6.1	ferrocyanochrome
	methane monooxygenase	1.14.13.25	NAD(P)H
	nitrogenase	1.18.2.1	ferredoxin + ATP
<u>40</u>	carbamoyl-phosphate synthetase	6.3.4.16	ATP

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One skilled in the art will add other enzymes as need to satisfy the intent of this invention. As used herein the term enzyme should be taken to mean the enzyme *per se*, its cofactors and co-enzymes, i.e., all of the elements needed for a functional enzyme system to effect biochemical transformations.

5 Example 1

To immobilize the enzyme on a membrane or mesh surface, such as, for example, nylon, one proceeds as follows: The material is activated by exposure to a 0.2 M nitric acid wash. The activated surface is exposed to 2 M sodium carbonate solution containing 20 g of disodium iminodiacetic acid (IDA) for 24
10 h at 60-65 C. The material is then rinsed with 0.1 M sodium carbonate, 0.01 M sodium acetate and water. It is then charged using zinc chloride at 1 mg/ml. Additional immobilized metal affinity chromatography (IMAC) procedures are found in Smith MC, Furman TC, Ingolia TD, and Pidgeon C (1988) Chelating Peptide-immobilized Metal Ion Affinity Chromatography: a new concept in
15 affinity chromatography for recombinant proteins. J. Biol. Chem. 263:7211-7215., and Sulkowski E (1987) Immobilized metal ion affinity chromatography of proteins. In: Burgess R (ed.) Protein Purification. Micro to Macro. Alan R. Liss, Inc. New York pp. 149-162. The basis of protein retention is binding of amino acids on the protein surface (notably histidine) to the vacant coordination sites
20 of metals (e.g., copper, zinc) complexed to chelating groups such as N-(carboxymethyl) glycine. The IDA ligand is favored because it is resistant to Ph between 2 and 13, and temperatures to at least 120 C.

EXAMPLE 2

In a reactor as illustrated by Figure 2, a carbonic anhydrase (CA) (E
25 4.2.1.1) is immobilized on both sides of a reservoir of aqueous buffer. As noted above CA is the one of the fastest enzymes known with a turnover number of 600,000 katal. Thus it has the ability to catalyze the hydration of 600,000 molecules of carbon dioxide per second per molecule of CA. Carbonic anhydrase is a diffusion limited enzyme. Thus, any CO₂ molecule which comes
30 into contact with the enzyme will be converted virtually immediately into HCO₃⁻.

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Any carbon dioxide containing mixed gas supply might be used. The scale of the equipment to be used must be adjusted accordingly. In this example, the mixed gas supply is taken from the exhaust stack of a gas fired electric power plant following appropriate heat exchangers and after passage of the exhaust through an air house. The make up of a typical gas is N_2 - 64.92%, O_2 - 2.04%, CO_2 - 7.06%, and H_2O - 25.98%.

Any heavy metals which could foul the enzyme are first extracted from the mixed gas supply 10. Such metals could be present in the exhaust of a coal fired furnace. CA contains a zinc atom and other divalent cations can, under correct circumstances, displace the zinc and alter the reactivity of the enzyme. Cobalt is a particularly potent divalent cation of this class.

The enzyme is covered with a thin oil film 26 to prevent water loss from the second phase 16. In this example the second phase is an aqueous 20 mM sodium phosphate buffer. CA catalyzes the hydration of CO_2 to HCO_3^- . The bicarbonate is delivered to the flowing buffer stream of the second phase 16 and carried to contact the permeable wall area adjacent recovery zone 22 where it contacts a second layer of CA fixed to support surface 8 at permeable wall area 9. The CA layer reverses the reaction and converts HCO_3^- to CO_2 . The second phase 16 buffer stream is constantly flowing to deliver lean buffered medium to the bicarbonate rich zone adjacent to the mixed gas supply 10 and then carry the bicarbonate rich fluid to the surface adjacent the recovery zone 22. The flow removes bicarbonate from the first surface where it can act as a competitive inhibitor of CA and slow the reaction. The overall effect is to create a continuous removal of product adjacent the enzyme surfaces and maintain a gradient that favors vectorial movement of CO_2 into solution as bicarbonate adjacent mixed gas stream 10 and from bicarbonate to CO_2 adjacent zone 22.

Carbonic anhydrase has a dehydrating rate constant which is slightly slower than the hydrating rate constant. For equal molar volumes of carbon dioxide and bicarbonate this favors the hydration of carbon dioxide. However,

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adjusting the relative surface area of the two enzyme surfaces will compensate for this difference. The newly generated CO_2 is drawn into recovery zone 22 at low pressure for extraction. This guarantees a vectorial flow for the entire system.

The kinetics and the specificity of the enzyme greatly favor the removal of CO_2 from the mixed gas supply above all other gases. Carbonic anhydrase does not recognize or interact with any of the other gases in the flue gas mixture. However, under steady state conditions the concentration and solubility of the several gases in the mixed gas stream will determine the degree to which they may pollute the purified gas stream. The solubility of these gases in oil and in water at 37°Cs given in Table I. The permeability of CO_2 in water is $210 \times 10^{-9} \text{ cm}^3 \text{ (STP)} \times \text{cm/sec} \times \text{cm}^2 \times \text{cm-Hg}$. The diffusivity of CO_2 in water is $1.96 \times 10^{-5} \text{ cm}^2/\text{sec}$. The solubility of CO_2 in water is $3.39 \times 10^{-5} \text{ gmoles} \times \text{cm} \times 10^{-3}/\text{atm}$.

TABLE I

15	GAS	OIL	RATIO to CO_2	WATER	RATIO to CO_2
		ml gas/ml oil		ml gas/ ml water	
	Nitrogen	0.067	0.037:1	0.014	0.023:1
	Oxygen	0.13	0.099:1	0.027	0.043:1
	Carbon dioxide	1.34	1:1	0.63	1:1
20	Carbon monoxide	0.097	0.073:1	0.012	0.034:1
	Methane	0.31	0.231:1	0.029	0.046:1

Given the solubility ratio, vis-a-vis CO_2 dissolving into the system and the respective concentrations the expected contamination of purified gas stream by each gas in the exhaust stream of the electric power plant in a single pass is: N_2 - 0.9%, O_2 - 0.006%, H_2O - 0%, CO - 0%, CH_4 - 0%. The buffer and other salts do not appreciably alter the gas solubility and the rate of dissolution of carbon

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dioxide in water is 10^7 times slower in the absence of carbonic anhydrase. In the absence of enzymatic conversion over 99% of the CO_2 remains in the dissolved gas form and less than 1% is spontaneously converted to bicarbonate, and very little gas would be recovered in recovery zone 22.

5 EXAMPLE 3

In Figure 3 a two stage reactor of the same general design and operation as that illustrated in Example 2 is shown. The inlet mixed gas 10 is preferably a carbon dioxide rich stream. On the mixed gas stream side carbonic anhydrase is the immobilized enzyme 12 which is covered by a lipid film 26 as in Example 2. Carbon dioxide is converted to bicarbonate adjacent the mixed gas side also as described in Example 2. A separate supply line 28 injects ammonia into the aqueous phase 16, which is converted to ammonium carbonate by conventional chemical reaction with the bicarbonate. The ammonium carbonate rich aqueous phase is circulated to contact urease 12 immobilized on a semipermeable membrane 9 adjacent urea recovery zone 22. The ammonium carbonate from the aqueous buffer is converted to urea by urease and transported across the membrane to the recovery zone via absorption. An organic solvent in the recovery zone dissolves the urea which is conveyed away from permeable zone 9, for recovery. The urea stream is flash evaporated to concentrate the urea while the solvent is returned to zone 22 and recycled.

EXAMPLE 4

The operation of a gas phase to gas phase bioreactor is illustrated in Fig 4. The immobilized enzyme 12 is catalase and the selected gas from mixed gas stream 10 is oxygen. Catalase normally catalyzes the reaction $\text{H}_2\text{O}_2 \Rightarrow 1/2 \text{O}_2 + \text{H}_2\text{O}$. Catalase is a diffusion limited or "perfect enzyme". Its reaction rate is about 5.6×10^6 mol/mol/min. ΔG for the reaction of hydrogen peroxide to produce oxygen and water in the uncatalyzed state is 18 kcal/mol. When catalyzed by a typical physical catalyst, platinum, this value drops to 13 kcal/mol, an improvement of only 38%. However, when catalyzed by catalase it declines

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dramatically to 7 kcal/mol, an improvement over platinum of 86% and a total improvement of 257%. This reaction is exothermal in the amount of 45.68 kcal/gmol in aqueous phase and 25.97 kcal/gmol in gas phase.

5 The reaction can be forced to proceed in the opposite direction, using O₂ and H₂O vapor to produce H₂O₂. If the raw materials O₂ and H₂O vapor are supplied at elevated temperature, or other means, sufficient to overcome the energy barrier, then H₂O₂ can be generated. It is important to maintain this reaction in the gas phase first to minimize the energy differences and second to prevent the deleterious effect of even moderate concentrations of peroxide on the integrity of the enzyme. It is also important that the second side is at lower pressure than the first side to provide vectorial flow to the system and remove the peroxide from the enzyme before an appreciable concentration accumulates. Due to its specificity catalase is unreactive to other gases commonly found in air, for example. Water vapor is supplied to the enzyme by increasing the humidity of the mixed gas stream 10, preferably to near 100%. Water vapor at near 100% humidity provides sufficient water to hydrate the active site of the enzyme. The consequence of the exemplified operation is the production of enriched peroxide in the second phase 16.

EXAMPLE 5

20 A simplified bioreactor is illustrated in Fig. 5 wherein an enzyme 12 such as carbonic anhydrase is coated on the surface of a buoyant bead 30 which floats at the surface of a fluid. A gas stream contacts the exposed enzyme on the exposed surface of the floating bead, and the enzyme binds its gas substrate. Turbulence of the fluid at the surface rotates the bead to immerse enzyme with bound substrate and wash away the product of the enzymatic reaction into the fluid phase. In the case of carbonic anhydrase, carbon dioxide in a mixed gas such as the atmosphere is bound and converted to bicarbonate. Rotation of the bead immerses enzyme carrying bound carbon dioxide or bicarbonate and exposes fresh enzyme to the atmosphere. When the beads float on a water surface, the net effect is to facilitate the conversion of carbon dioxide in the

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mixed gas to bicarbonate in aqueous solution. Such a bead reactor may be incorporated for example into a conventional scrubber to reduce the amount of carbon dioxide released into the atmosphere by a fossil fuel fired power generation plant. Beads floating on the surface of a pond may be useful to
5 remove carbon dioxide from the atmosphere and increase the available bicarbonate concentration in the water. Also shown in Figure 5 are oblong beads 32 which may be partially coated with enzyme and weighted to maintain the enzyme exposed to the gas phase. An alternate embodiment uses fully coated beads 30 of a selected density to float at the fluid surface with a portion of the
10 enzyme directly exposed to the gas phase. While any fluid may be employed provided that the enzyme remains active and product is washed off into the fluid phase, water or aqueous buffers are the preferred fluids.

An alternative embodiment uses a structure similar to that shown in Fig. 6. Beads having enzyme immobilized on the surface are fixed to a lattice 34 in
15 such a manner that the beads can rotate around a lattice element. The lattice 34 is positioned such that the beads are fixed at the surface of a fluid phase in contact with a gas stream. The gas stream impinges on the beads such that the force of the gas stream 10 is sufficient to rotate the beads exposing fresh enzyme surface to the gas and carrying bound gas into contact with the fluid phase 16.
20 The turbulence is such that the bead 30 carrying the immobilized enzyme rotates to be successively exposed to the gas phase and the fluid phase 16.

EXAMPLE 6

The bioreactor illustrated in Figs. 6 and 7 utilizes countercurrent flow of the two phases on opposite sides of the immobilized enzyme affixed to axially
25 tethered bead-like immobilization surfaces. Under these circumstances the beads will rotate moving the surface from contacting the first fluid to contacting the second fluid and vice versa. Gases or products will be delivered from the first fluid to the second fluid where they will be deposited. The effect of the immobilized enzyme at the bead surface is to facilitate transfer of a gas or
30 product from the first fluid to the second fluid. Preferably the countercurrent

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fluids are immiscible or are separated by a semipermeable layer which may partially overlay the bead support lattice 34 to separate the countercurrent fluids. The beads are sized to extend beyond the separating layer and contact each fluid. In another embodiment the beads of Figures 6 or 7 may include vanes to
5 facilitate rotation by the fluid flow. Disks or other shaped supports may be substituted for spherical beads in this embodiment.

In the bioreactors of Examples 5 and 6, material choices for beads, immobilization methods, solvents, buffers and enzymes are the same as those discussed above for the other systems. In the floating bead reactor of Examples
10 5 and 6 much of the structure is eliminated while the essential features of the invention are retained.

In each of the preceding examples, the choice of fluid, buffer and salt content is determined by both the solubility and ionization potential of ionic equivalents of the gas of interest in the fluid, on both an absolute scale and in
15 relation to the solubility and formation of ionic equivalents of other gases in the mixed gas stream. The following factors guide the choice. One is to increase the fractional concentration of the gas of interest. Another is to decrease the fractional concentration of contaminants. Yet another is to increase the ability of chemical reactions to occur in the medium and to increase the ability of the
20 enzyme to generate ionic equivalents. Another is to optimize the miscibility of the gas with the phase surrounding the enzyme.

Many variations of structure and design may be made to combine the elements of the disclosed invention in many configuration without departing from the scope and spirit of the present invention as defined by the appended claims.

THE EMBODIMENTS OF THE INVENTION IN WHICH AN EXCLUSIVE PROPERTY OR PRIVILEGE IS CLAIMED ARE DEFINED AS FOLLOWS:

1. A bioreactor which comprises a vessel having at least one first wall enclosing an inlet zone, and at least one second wall enclosing a second phase zone, a portion of the second wall is permeable to at least one selected gas in the inlet zone, and retains a second phase in the second phase zone; a portion of the second wall also comprises a support surface with at least one enzyme fixed thereon, such that a mixed gas stream entering the inlet zone contacts said at least one enzyme which removes a selected gas from the mixed gas stream and passes the selected gas to the second phase zone.
2. A bioreactor according to claim 1 which further comprises a recovery zone enclosed by said second wall which comprises a selectively permeable area which retains the second phase while passing a selected product obtained by action of said at least one enzyme on said selected gas from the mixed gas stream.
3. A bioreactor according to claim 2 wherein a catalyst is fixed to the selectively permeable area between the second phase and the recovery zone such that a chemical change results when a substance in the second phase contacts the catalyst, and the product of the chemical change enters the recovery zone.
4. A bioreactor according to claim 3 wherein the catalyst is an enzyme.
5. A bioreactor according to claim 4 wherein the selected gas removed from the mixed gas stream is recovered in the recovery zone.
6. A bioreactor according to claim 5 wherein the selected gas is carbon dioxide.
7. A bioreactor according to claim 1 wherein the enzyme is carbonic anhydrase.

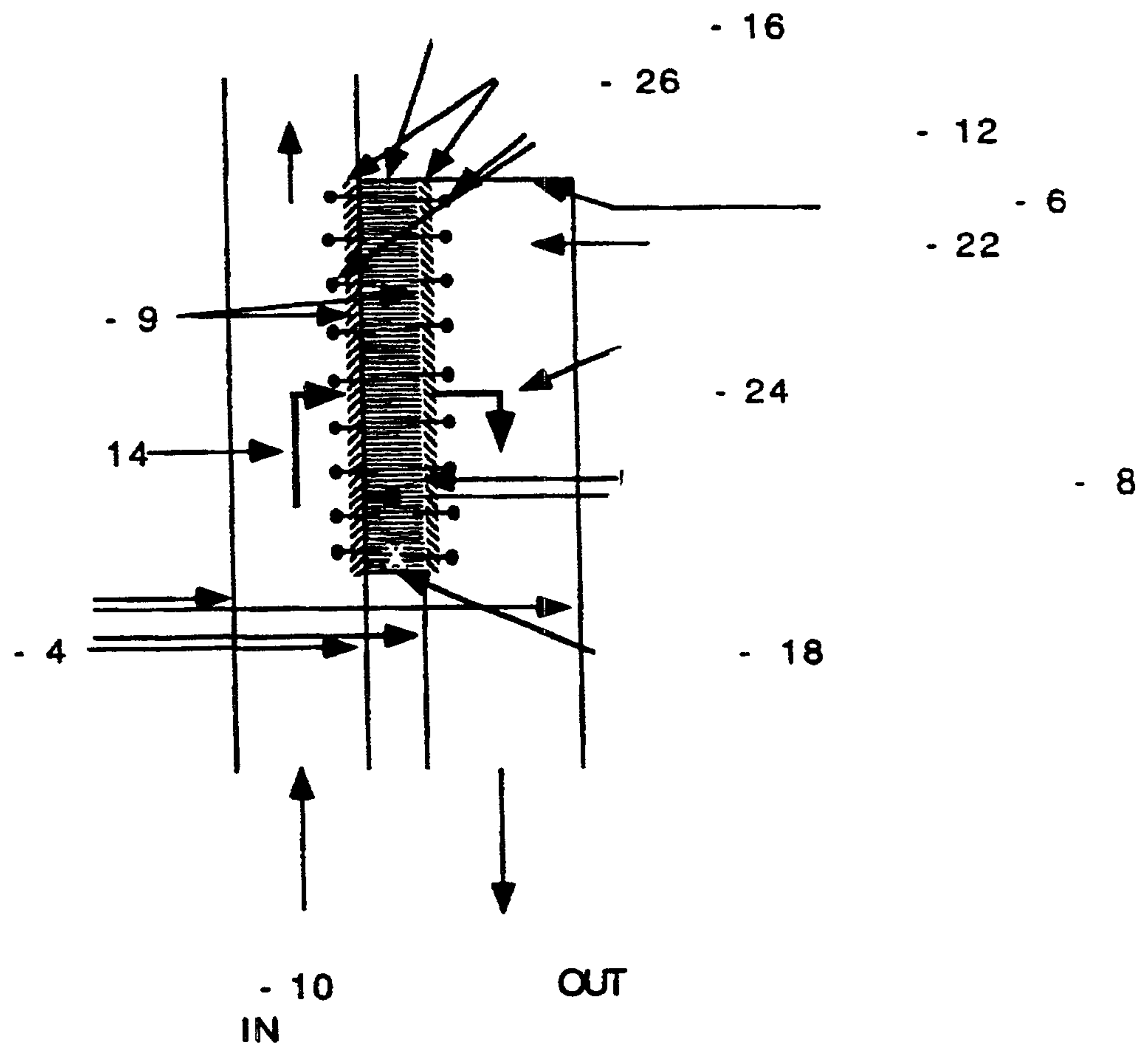


Fig. 1
Bioreactor
Gas to Liquid to Gas Phase Transfer

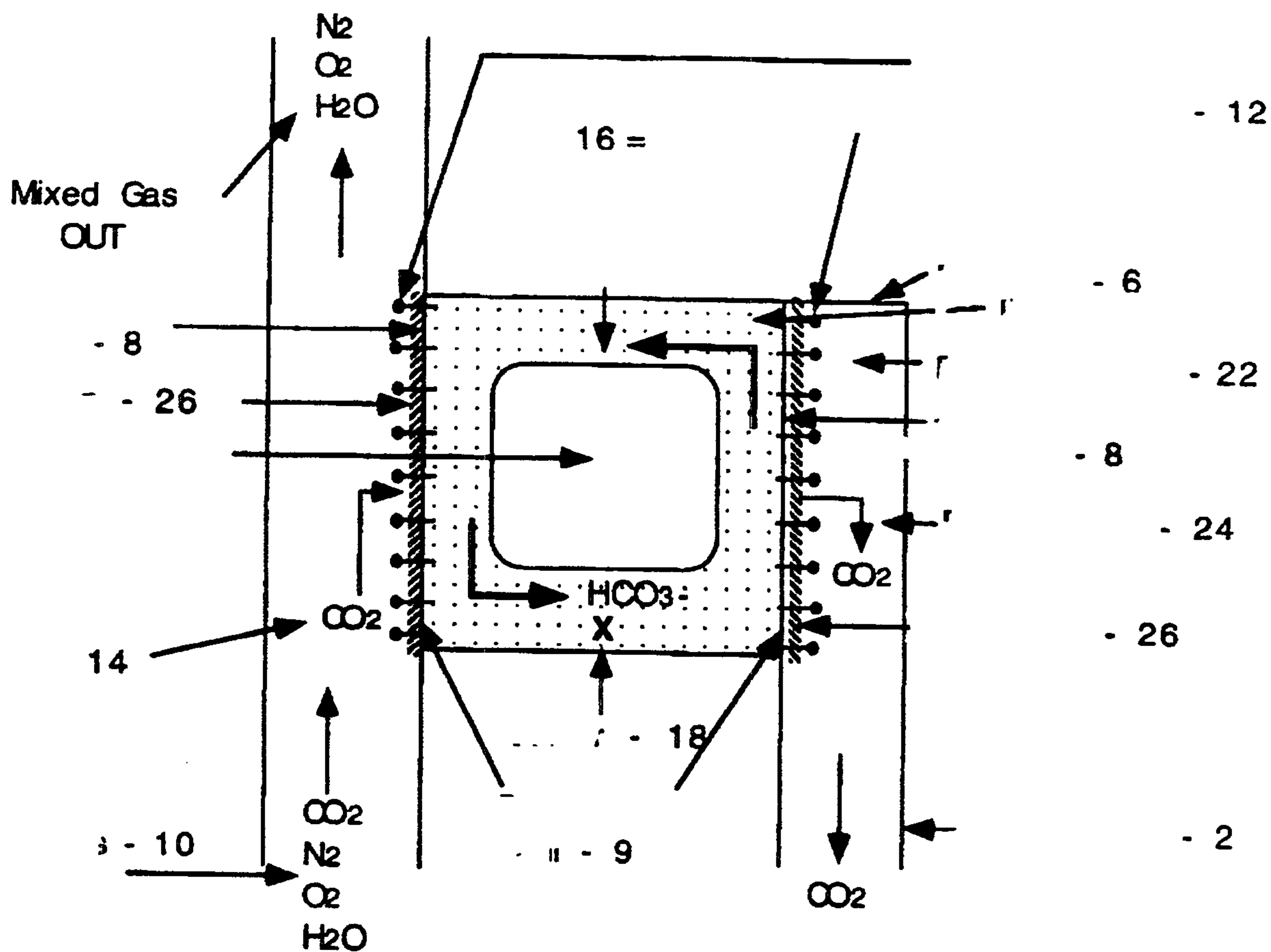


Fig. 2
Carbon Dioxide
Bioreactor
Embodiment

Gas to Liquid to Gas Phase Transfer

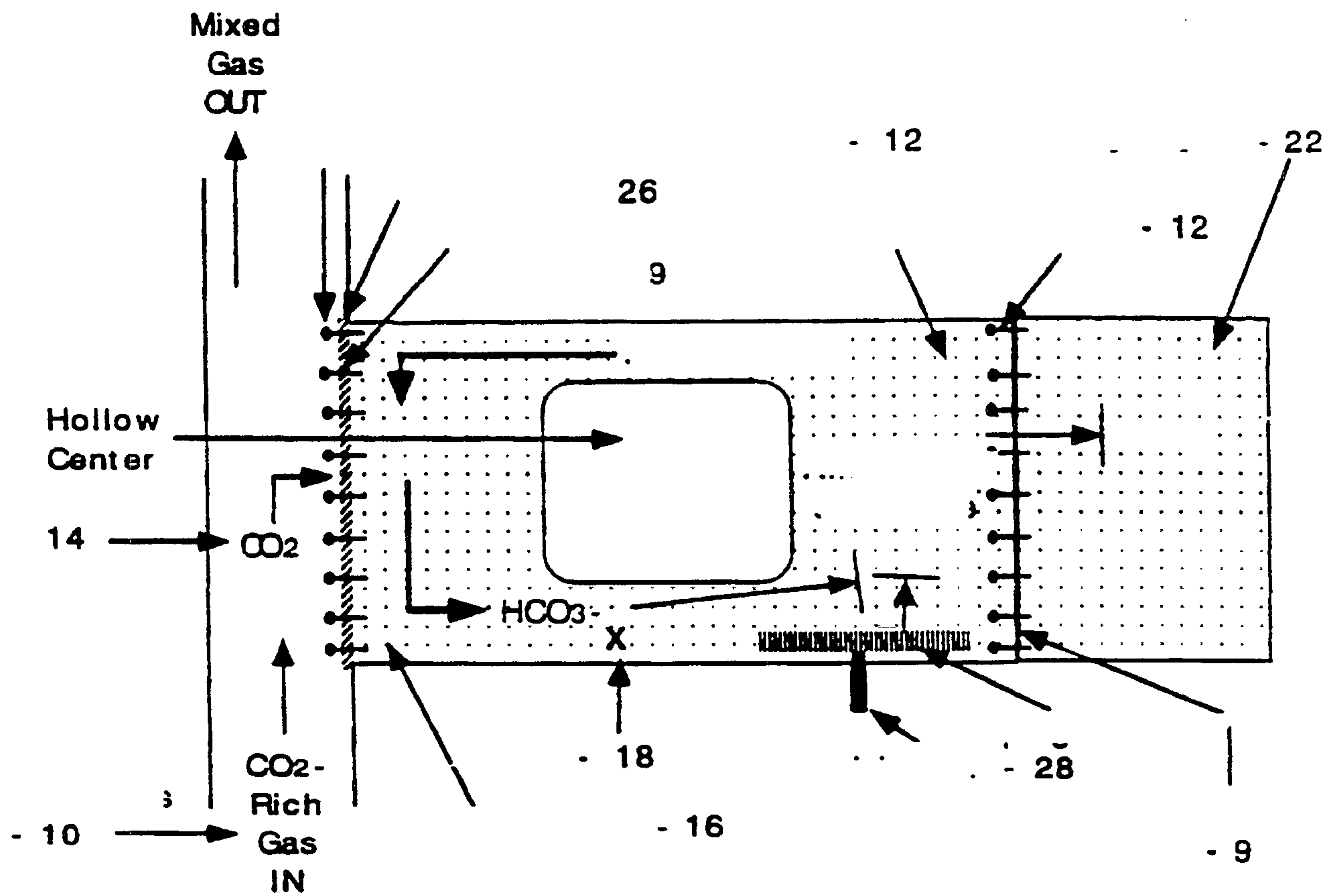


Fig. 3
Urea
Bioreactor

Gas to Liquid Phase Transfer

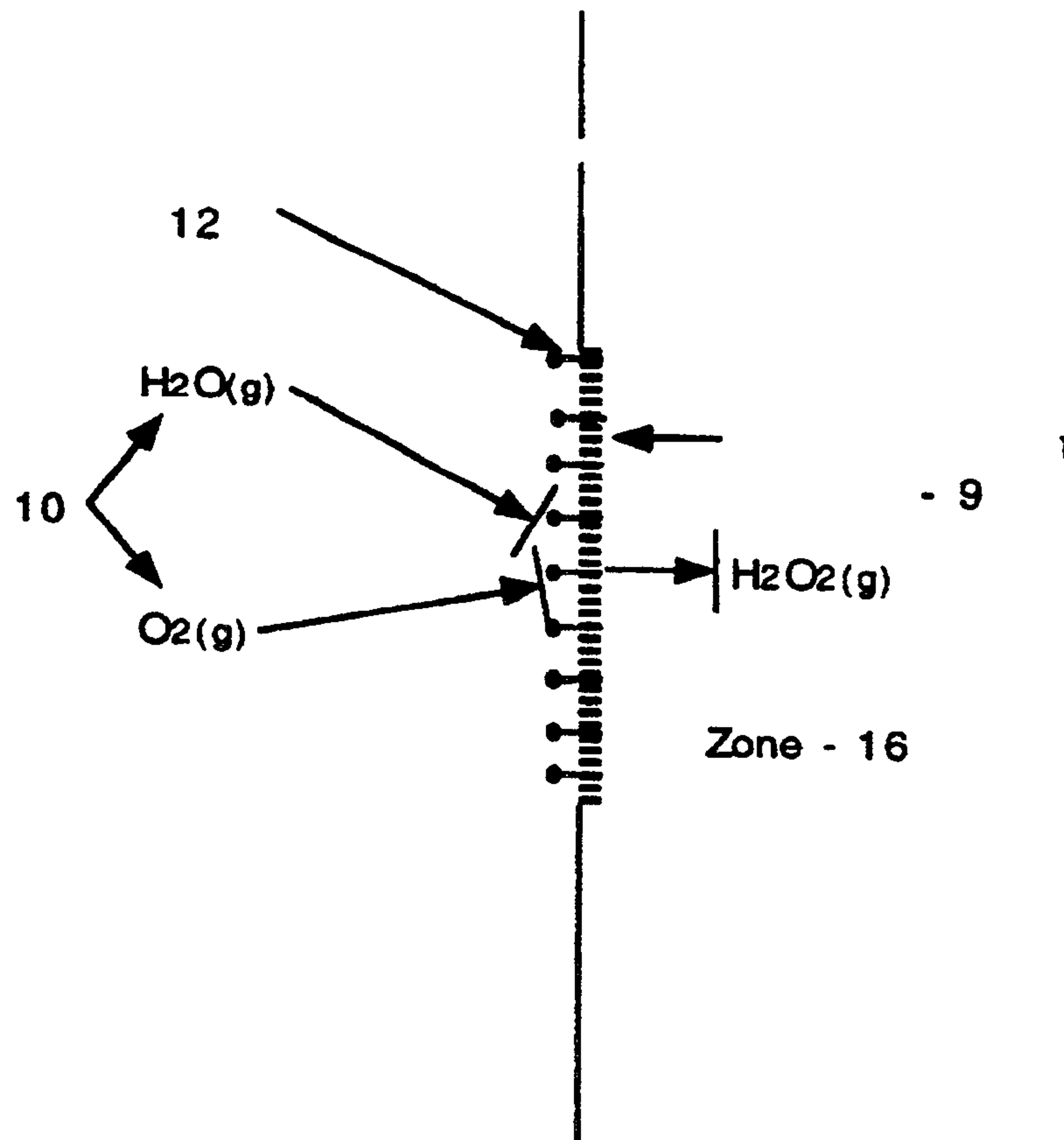


Fig. 4.
Peroxide Bioreactor

Gas to Gas Phase Transfer

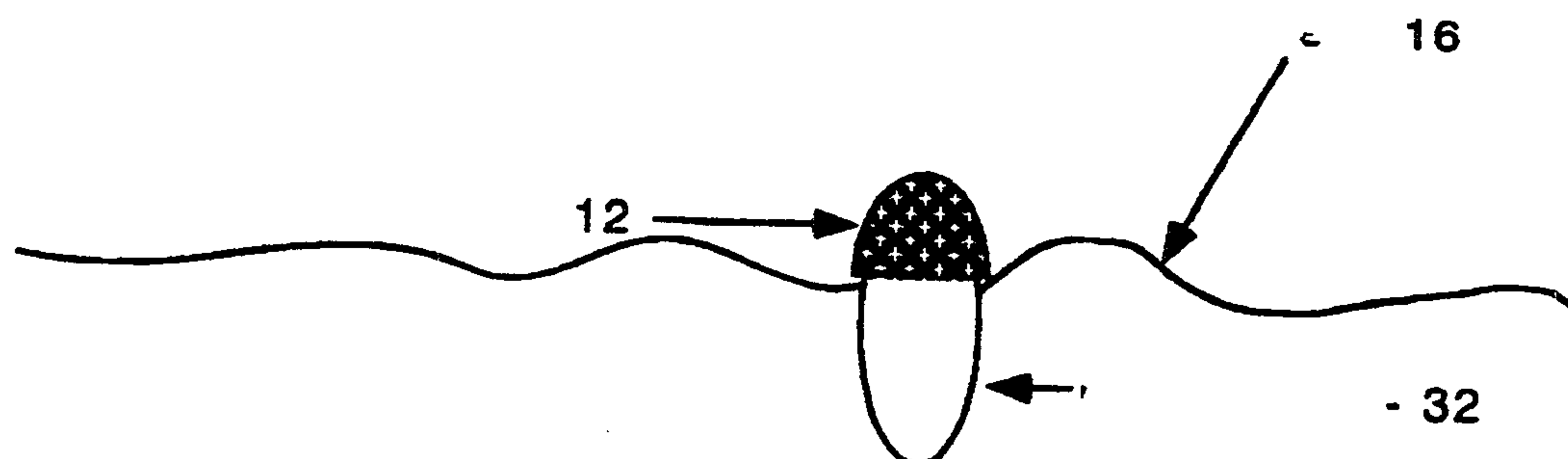


Fig. 5A. Partially Coated Bead

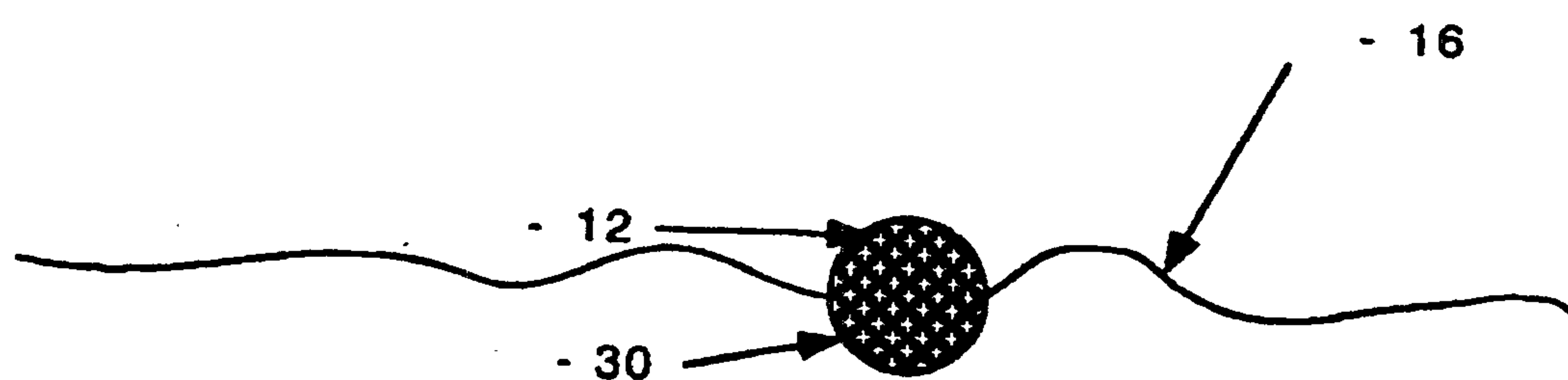


Fig 5B. Fully Coated Bead

Fig. 5
Enzyme Immobilized on Buoyant Beads

Gas to Liquid Phase Transfer

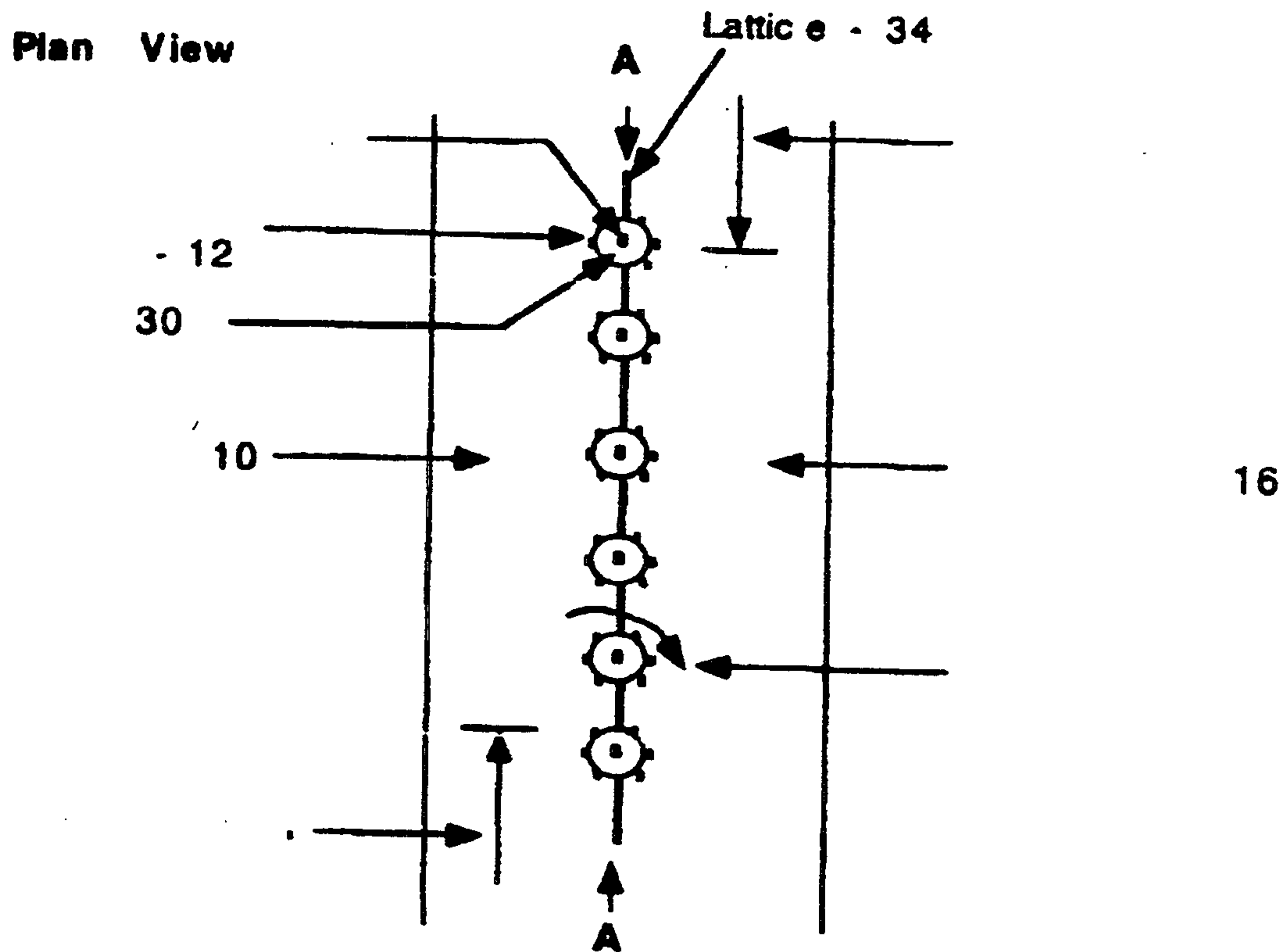


Fig. 6.

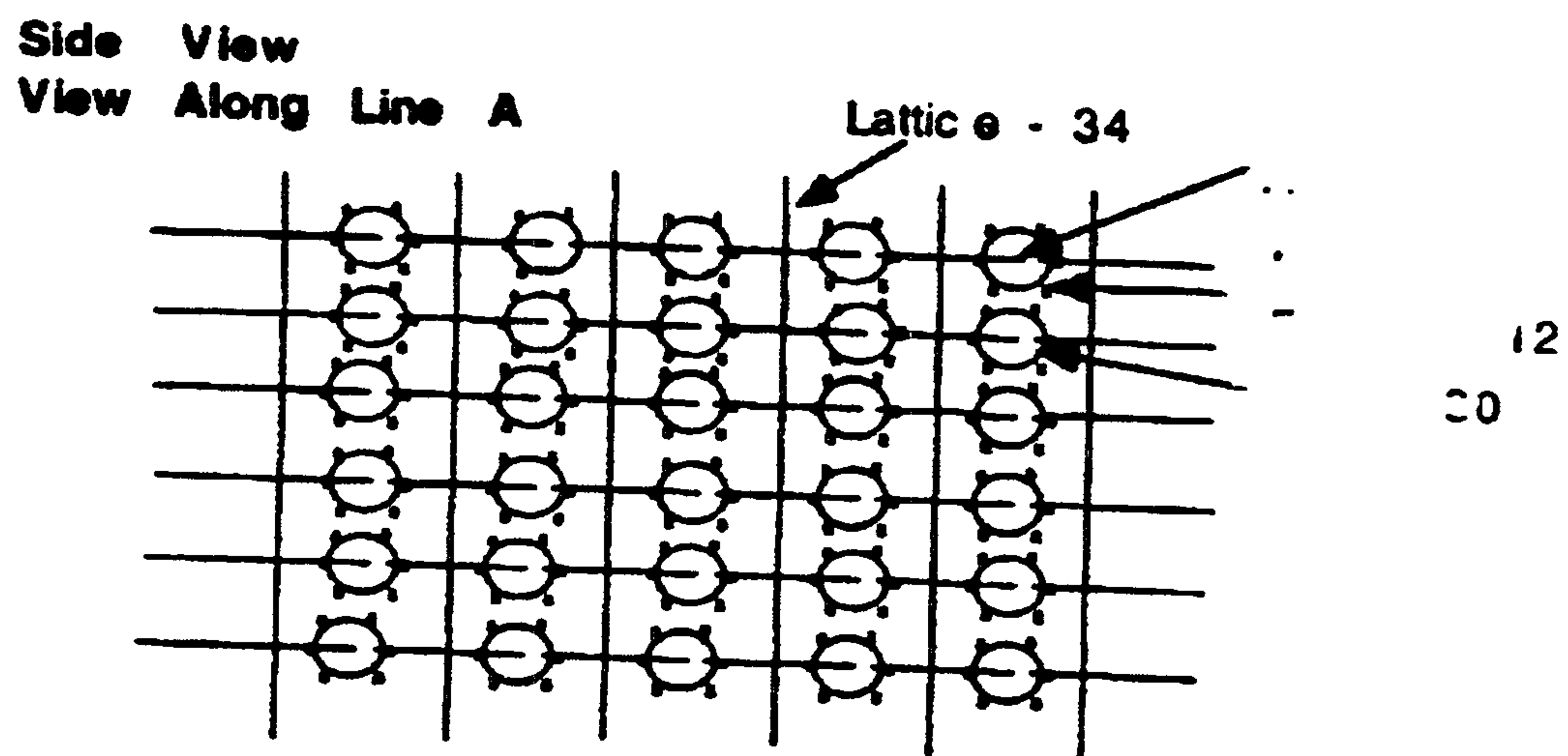
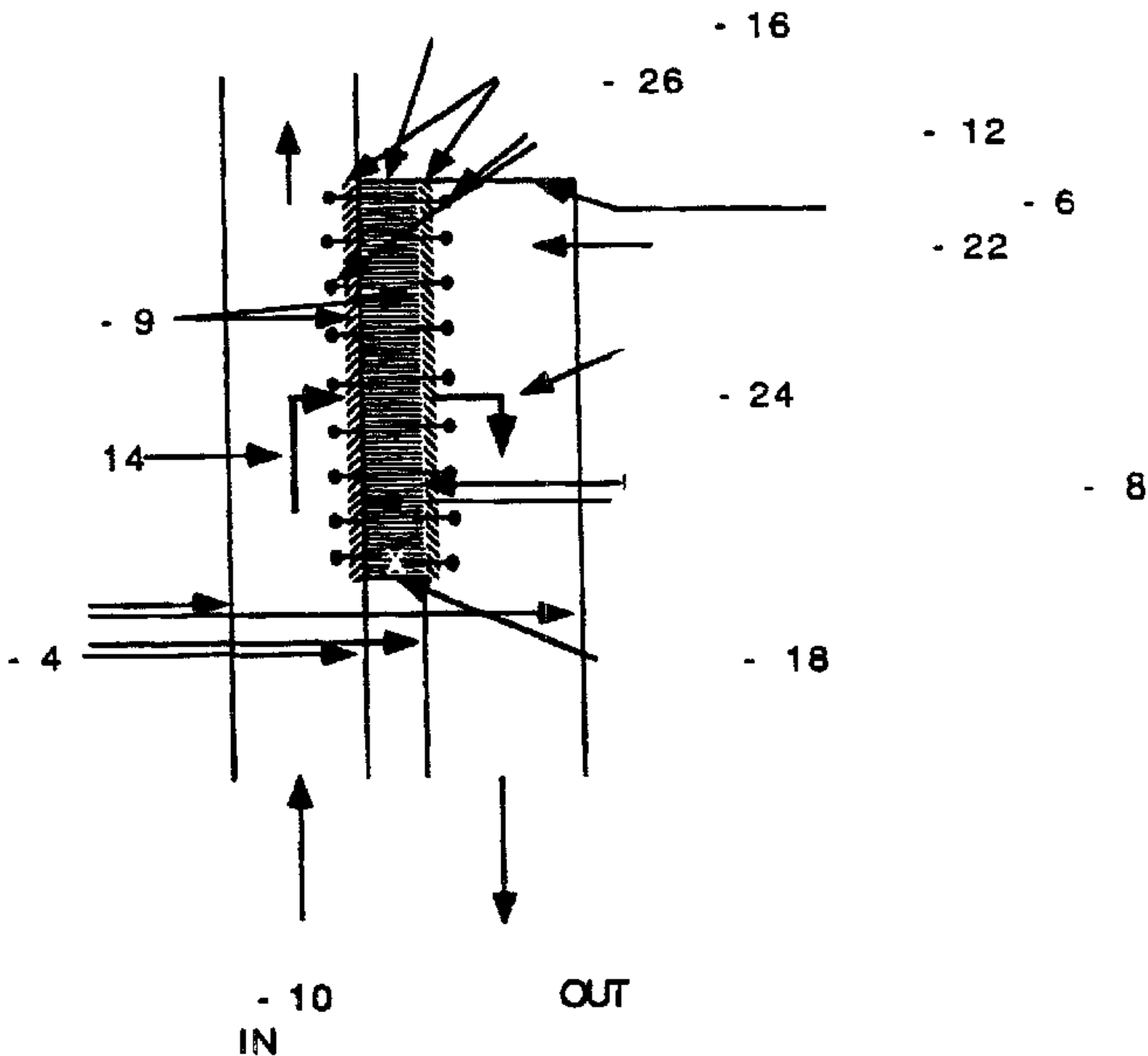


Fig. 7

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Bioreactor
Gas to Liquid to Gas Phase Transfer