NACT 284

Volatile Organic Compound Control Devices

Course Overview

- Volatile Organic Compound (VOC) Controls
- Examples of VOC Calculations
- Particulate Matter (PM) Options
- Inspection Strategies

Volatile Organic Compounds

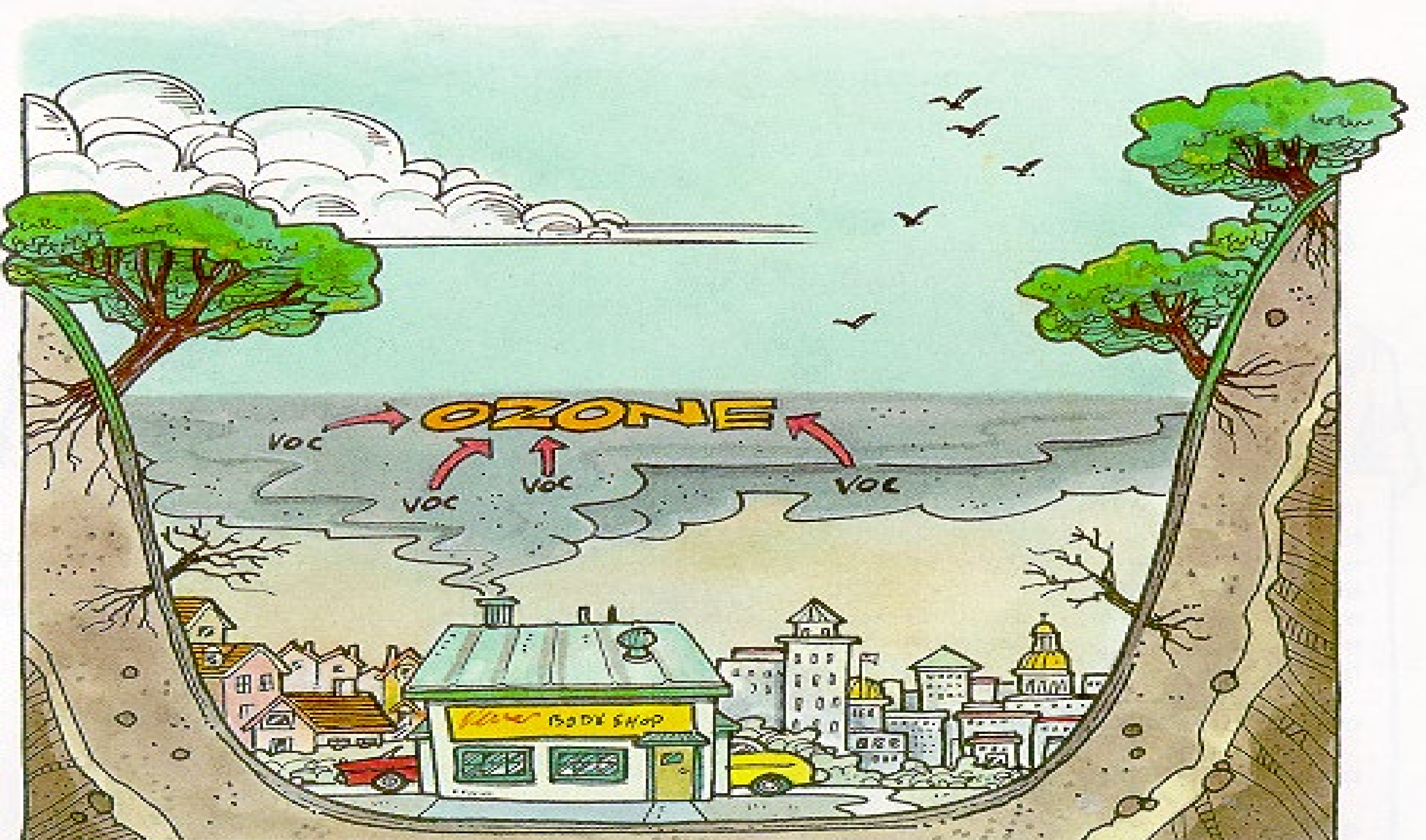
Chemical definition of VOCs:

- Molecules which contain carbon
  &
- High evaporative rate at low temperatures
- [VP > 0.1mm Hg]

Legal Definition of VOCs

- Federal and State laws & regulations
  - * 40CFR51 § 51.100
  - * Latest Definitions of VOCs and ROGs as of...
- Total Organic Gases (TOGs)
- Reactive Organic Gases (ROGs)
- Fraction of Organic Gases (FROGS)
- Local Agency rules and permit conditions

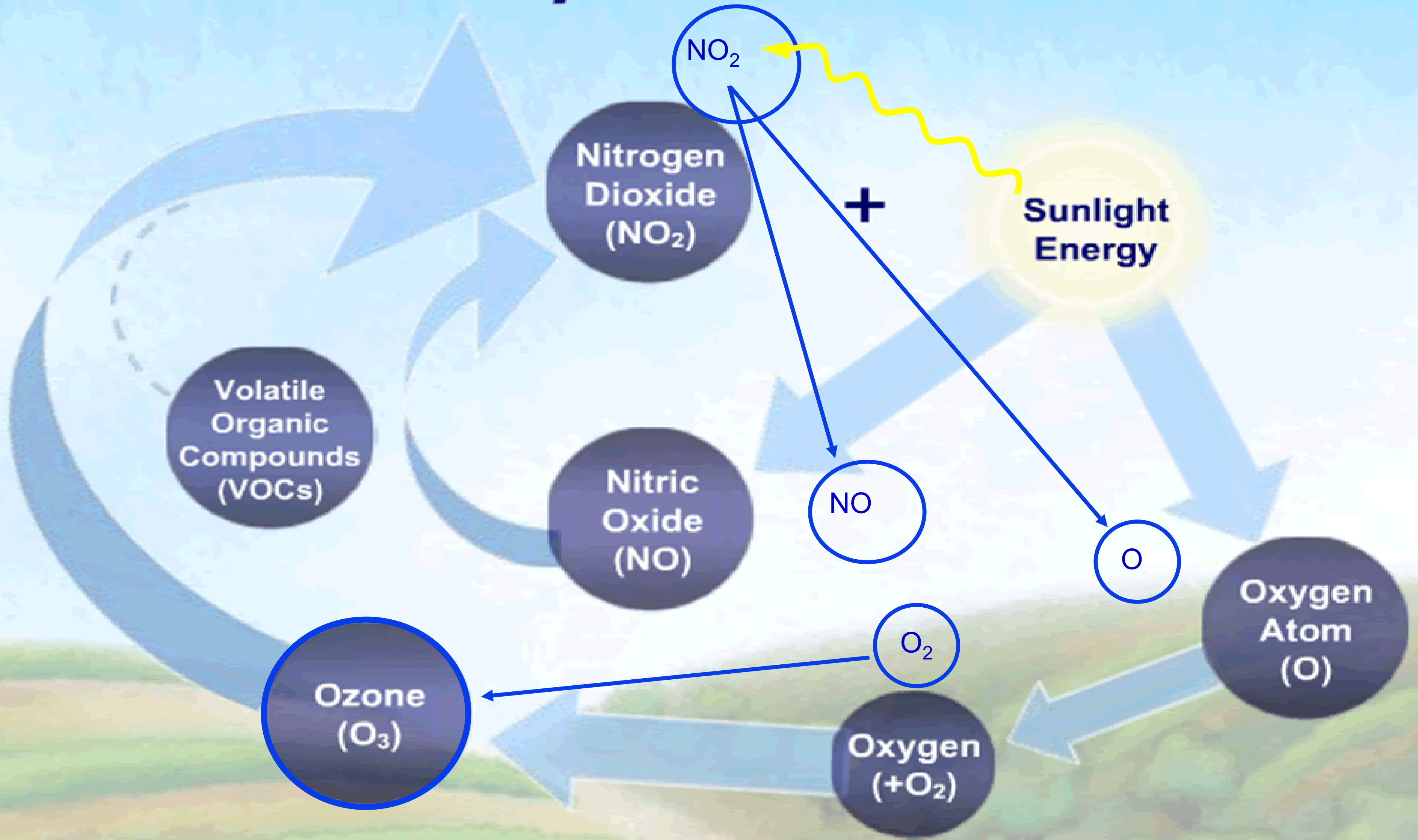
Why are VOCs Regulated?



Why is Ozone Regulated?

Air Resources Board

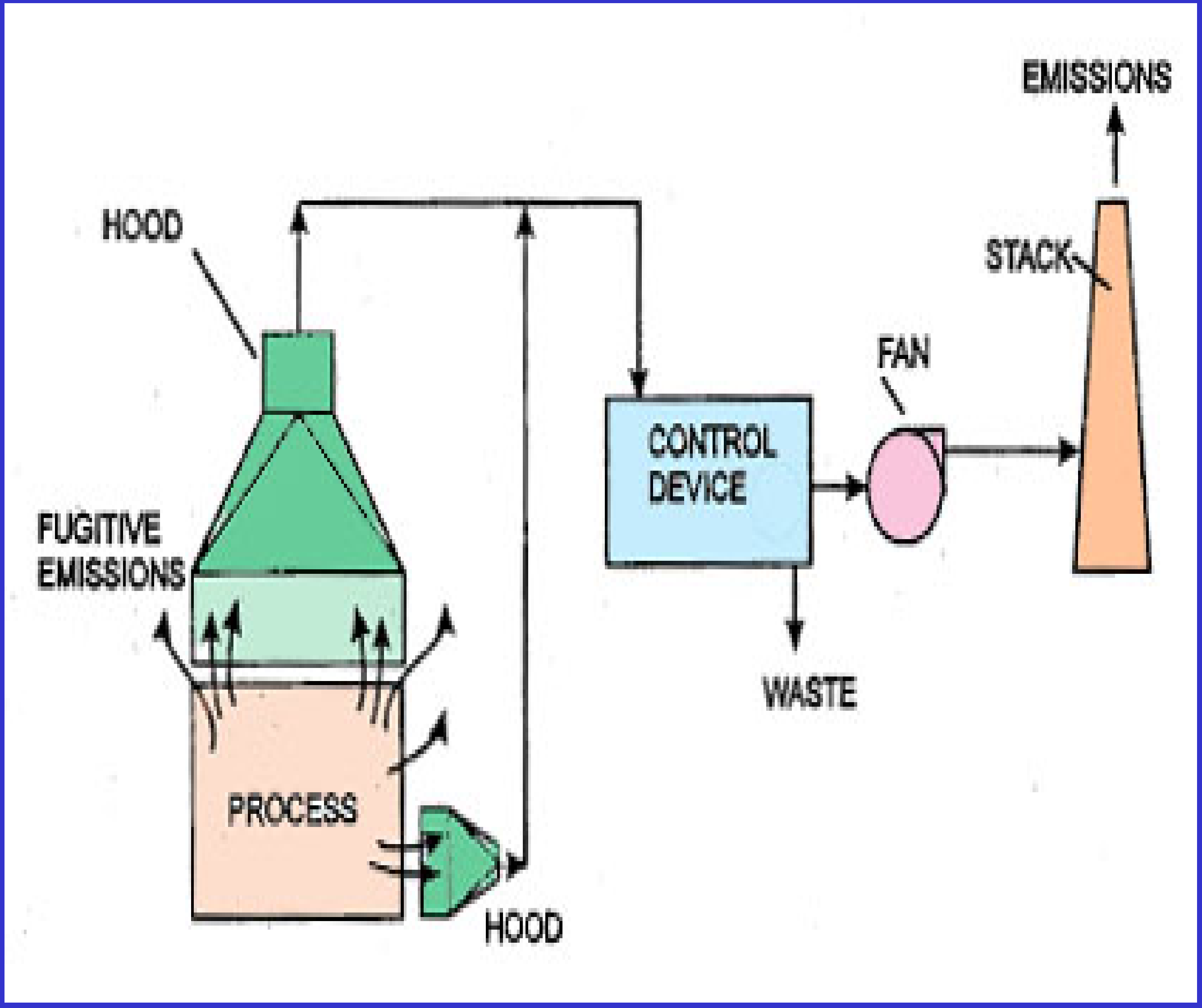
Ozone Photochemistry



Ozone Formation

- VOCs + NO_x + sunlight > O_3
- Ozone is formed when NO_x and Volatile Organic Compounds react in sunlight

VOC Control Process



- Capture
- Control

  Recovery, Disposal or Destruction

VOC Calculations : Capture & Control & Retention

- General Categories of VOC Emissions
  - * Fugitive (Not reasonably captured)
  - * Captured > Ducted to control device
  - * Consumed > Oxidized
  - * Retained > Retention factors vary

VOC Capture Efficiency *

VOC Capture Efficiency = $\frac{\text{VOCs captured}}{\text{VOCs used}}$ **x 100**

VOCs used (and therefore emitted)	**100 lbs**
VOCs captured (entering control device)	**80 lbs**
VOC capture efficiency (by calculation)	**?????**

** Capture Efficiency is the percentage of emissions captured and vented to a control device. -- EPA*

VOC Capture Efficiency *

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VOCs captured (entering control device)	**80 lbs**
VOC capture efficiency (by calculation)	**80%**

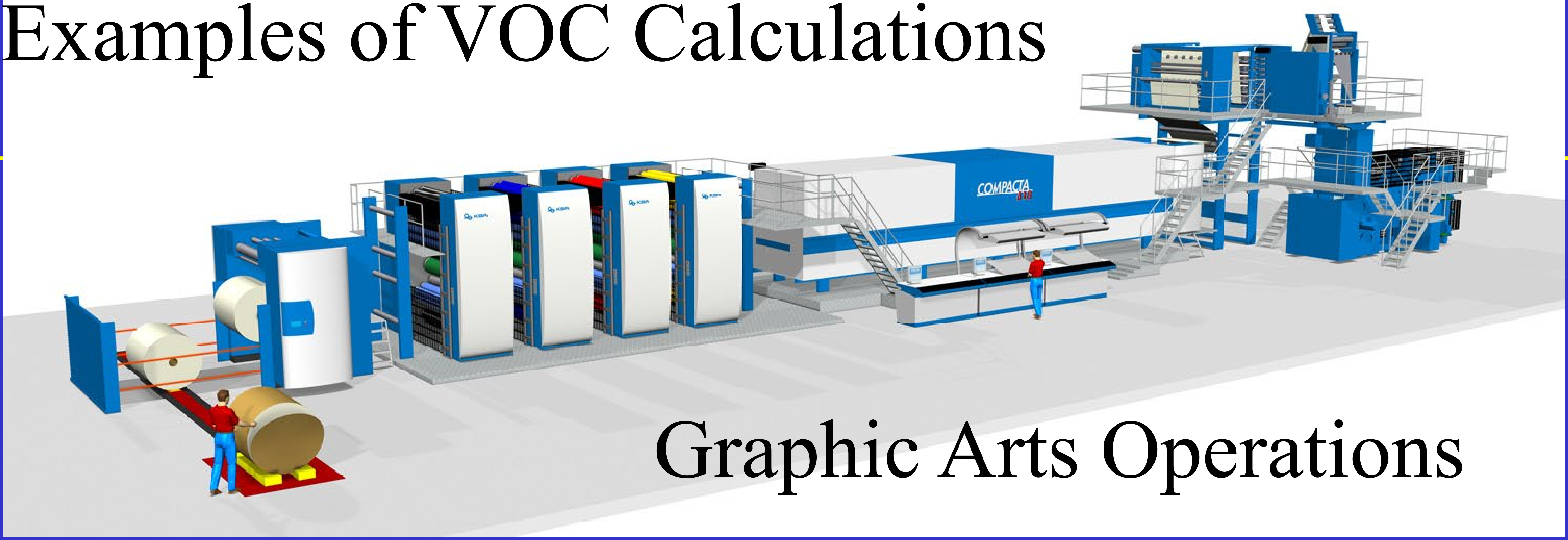
** Capture Efficiency is the percentage of emissions captured and vented to a control device. -- EPA*

VOC Control Efficiency

$$\% CE = \left[1 - \frac{\text{outlet emission rate}}{\text{inlet emission rate}} \right] \times 100$$

$$\% CE = \left[1 - \frac{2 \text{ lbs/hr}}{100 \text{ lbs/hr}} \right] \times 100 = 98$$

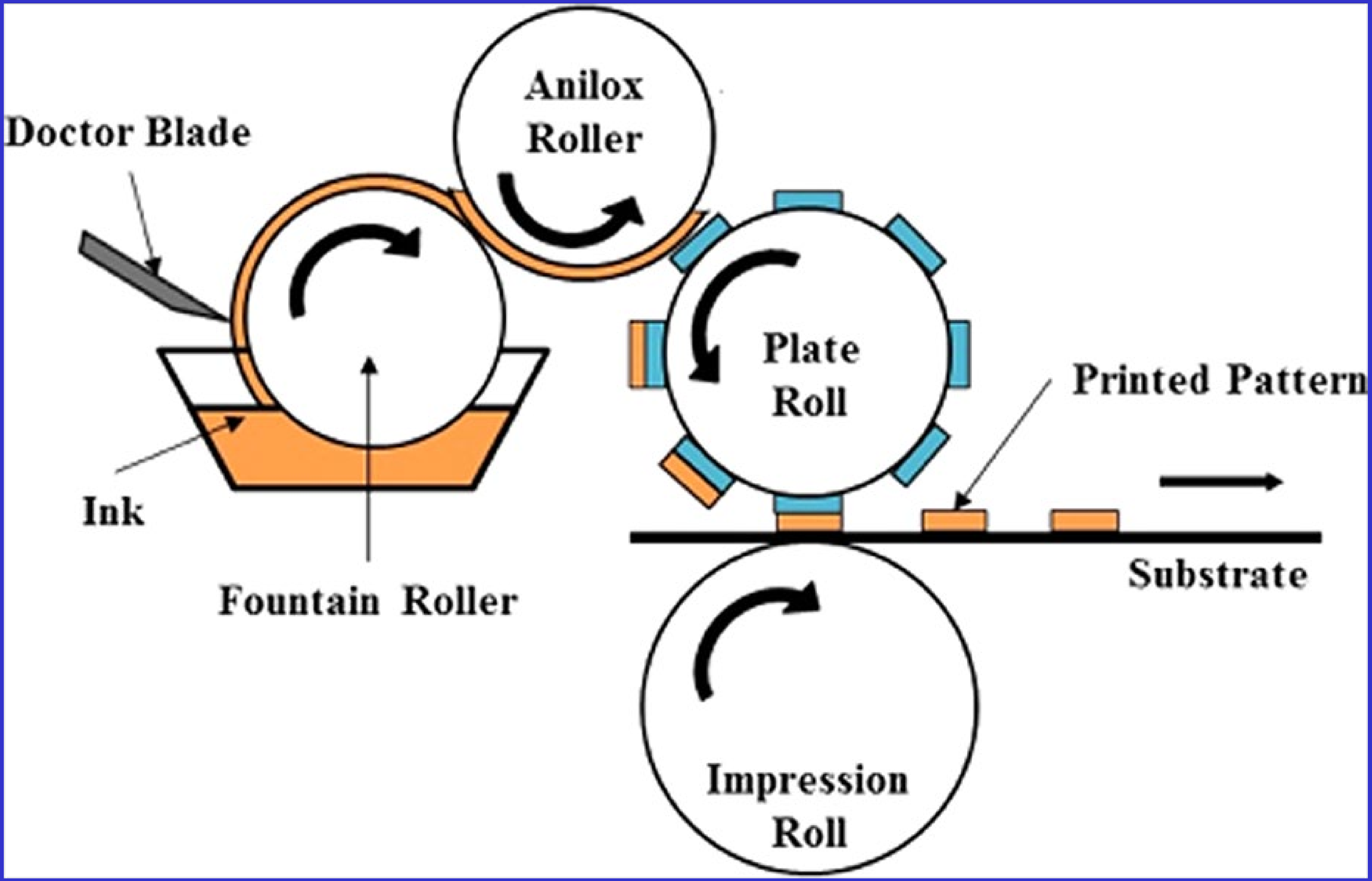
Examples of VOC Calculations



Graphic Arts Operations

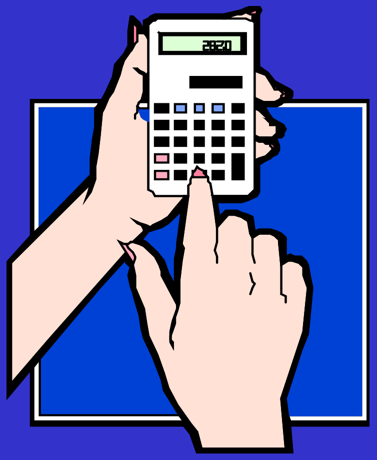
With VOC Retained in Substrate

Graphic Arts Operation



VOC Calculations

- A facility uses 100 lbs/hr of ink that has a VOC content of 35% by weight.
- 20% of the VOC is retained in the substrate
- The incinerator has a 95% control efficiency



How many lbs/hr of VOC is emitted?

VOC Emissions = (100 lbs/hr) (0.35) (1-0.20) (1-0.95) = 1.4 lbs/hr

Let’s Discuss Control of VOC

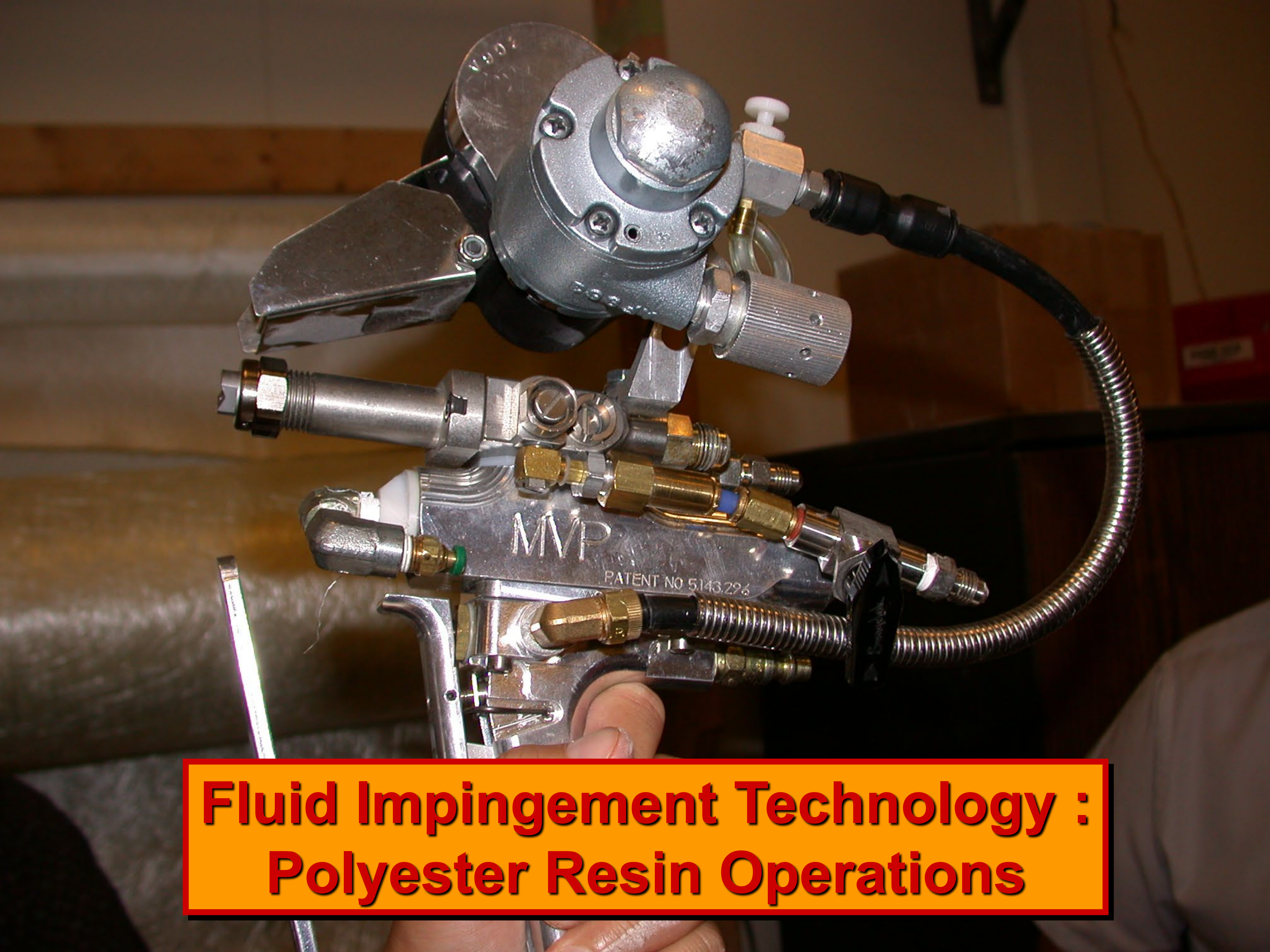
- Containment
- Transfer Efficiency
- Absorption
- Adsorption
- Condensation
- Oxidation

Controlled Spraying
aka
Pollution Prevention

- Reduces VOC emissions
- Increases transfer efficiency
- Low fluid tip pressure
- Employee gun handling training

High Volume Low Pressure (HVLP) Spray Guns

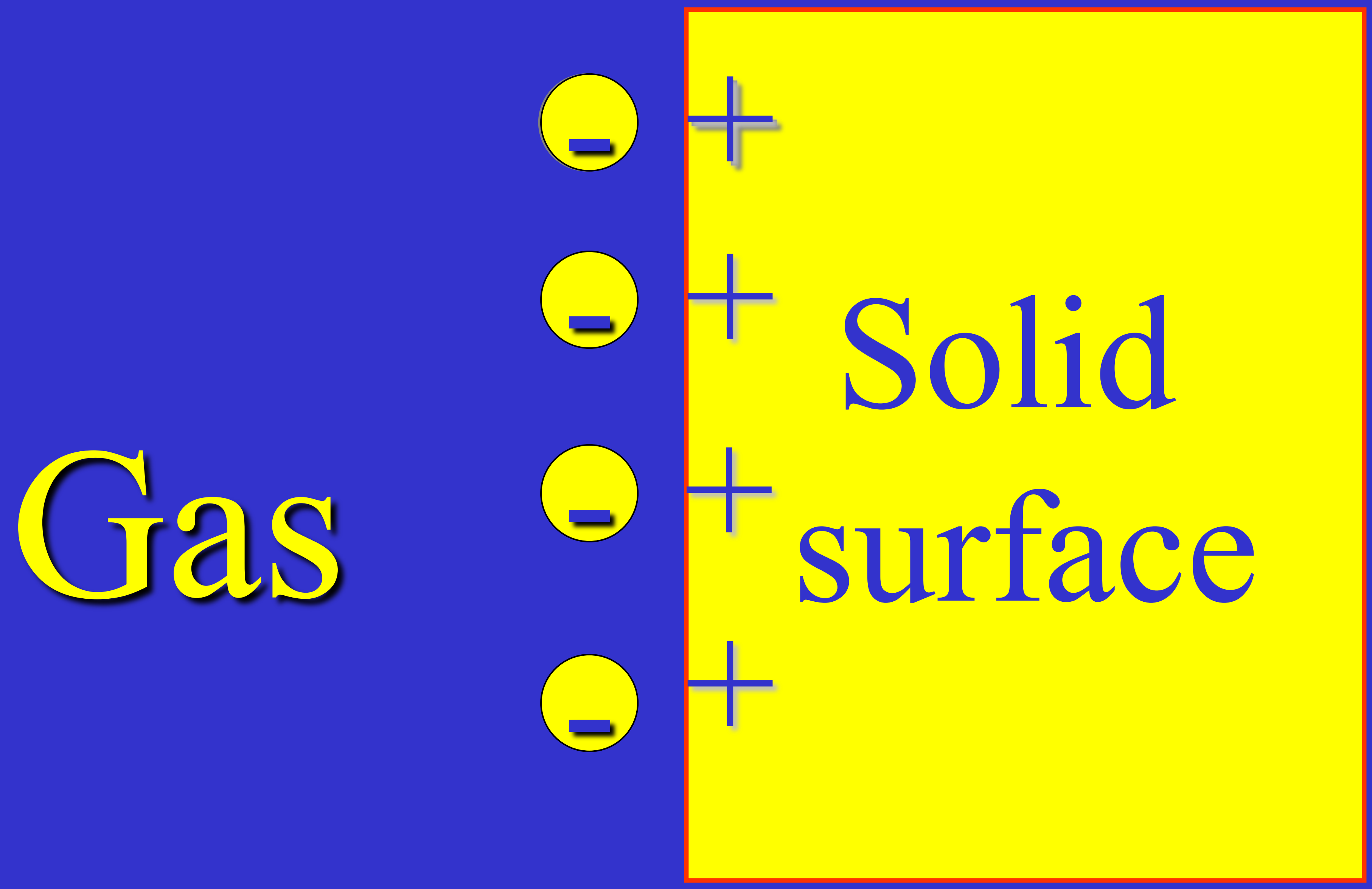
(HVLP) Spray Gun :
Polyester Resin Operations


MVP
PATENT NO 5,143,296
Fluid Impingement Technology :
Polyester Resin Operations

Gel Coat Application in a Spray Booth

Let's Discuss Adsorption Systems

Adsorption Mechanism

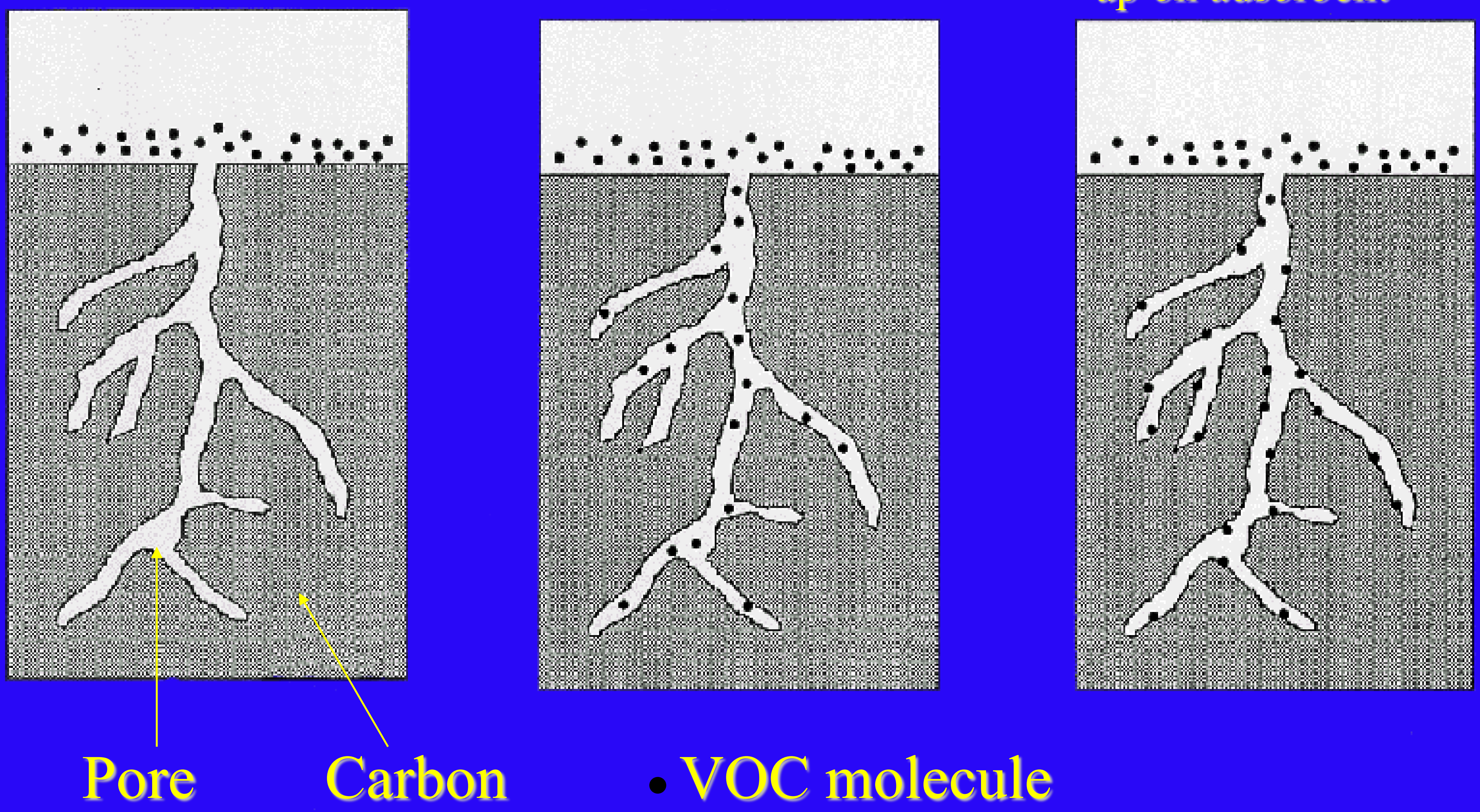


Adsorption Mechanism

Step 1. VOC diffuses to adsorbent surface

Step 2. VOC migrates into pores

Step 3. VOC adsorbed and builds up on adsorbent



Adsorption Mechanism

- Chemically unchanged
- Desorbed and recovered
- Polar and non-polar adsorbates
- Mixed adsorbates separated by distillation

Adsorption

- Adsorption materials (adsorbents)
  - * Activated carbon
  - * Hydrous oxides
    - Silica gel
    - Aluminum oxide
    - Magnesium silicate
  - * Zeolites (molecular sieves)
  - * Naturals
    - Clays
    - Bauxite
    - Fuller’s Earth
  - * Metals

Carbon Adsorbers at a Soil Remediation Site

Factors Affecting Adsorption

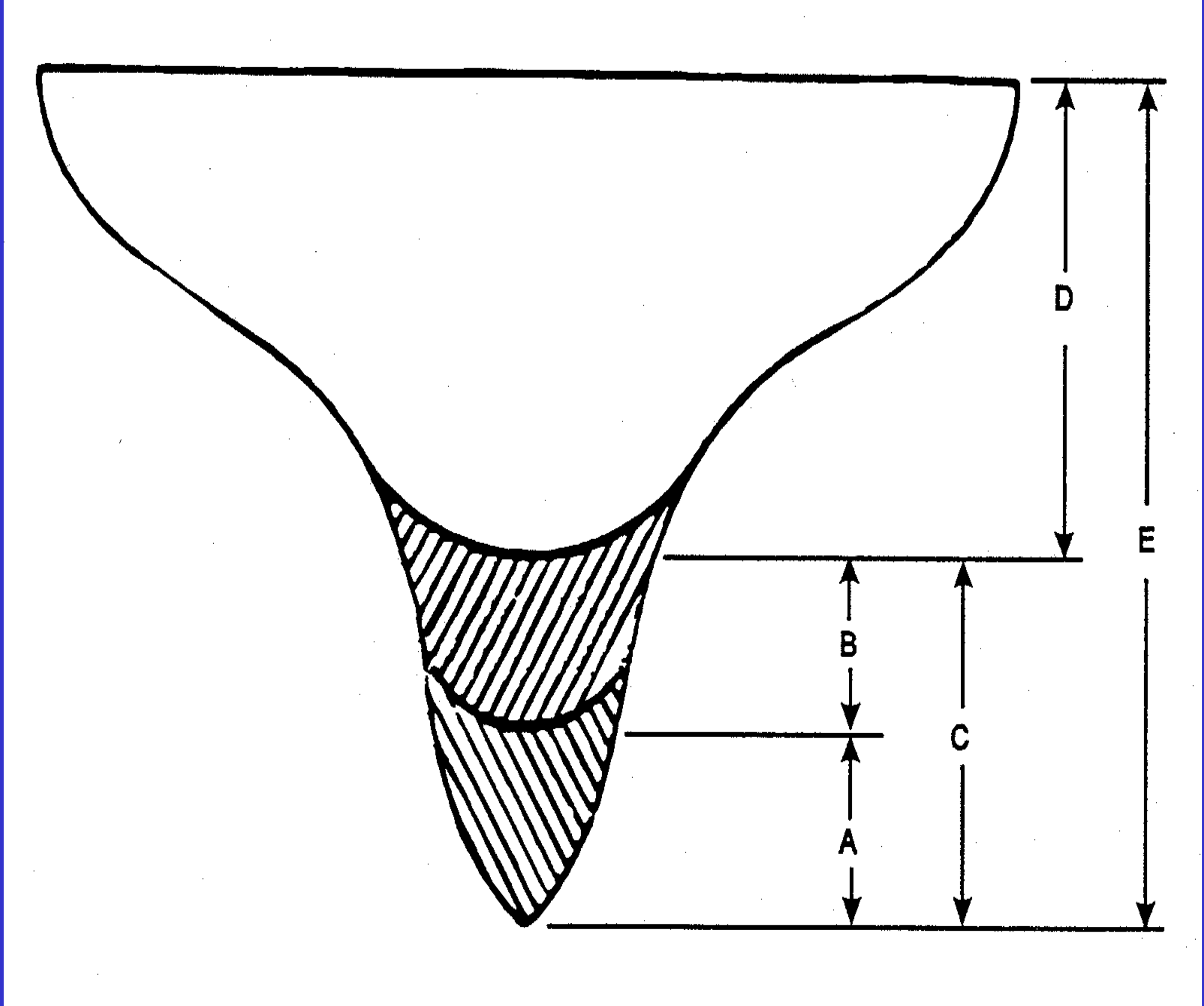
- Temperature
- Pressure
- Gas velocity
- Particulate matter

Adsorber Design Considerations

- Porosity of Adsorbent
- Bed Cross-Sectional Area
- Bed Length
- Multiple Organic Compounds
- Steaming Requirements
- Fouling
- Timers/Monitors
- Channeling

Pore Space Representation

- A = Residual VOCs or heel
- B = Working capacity
- C = Equilibrium Capacity
- D = Empty pore space
- E = Total pore space (total capacity)



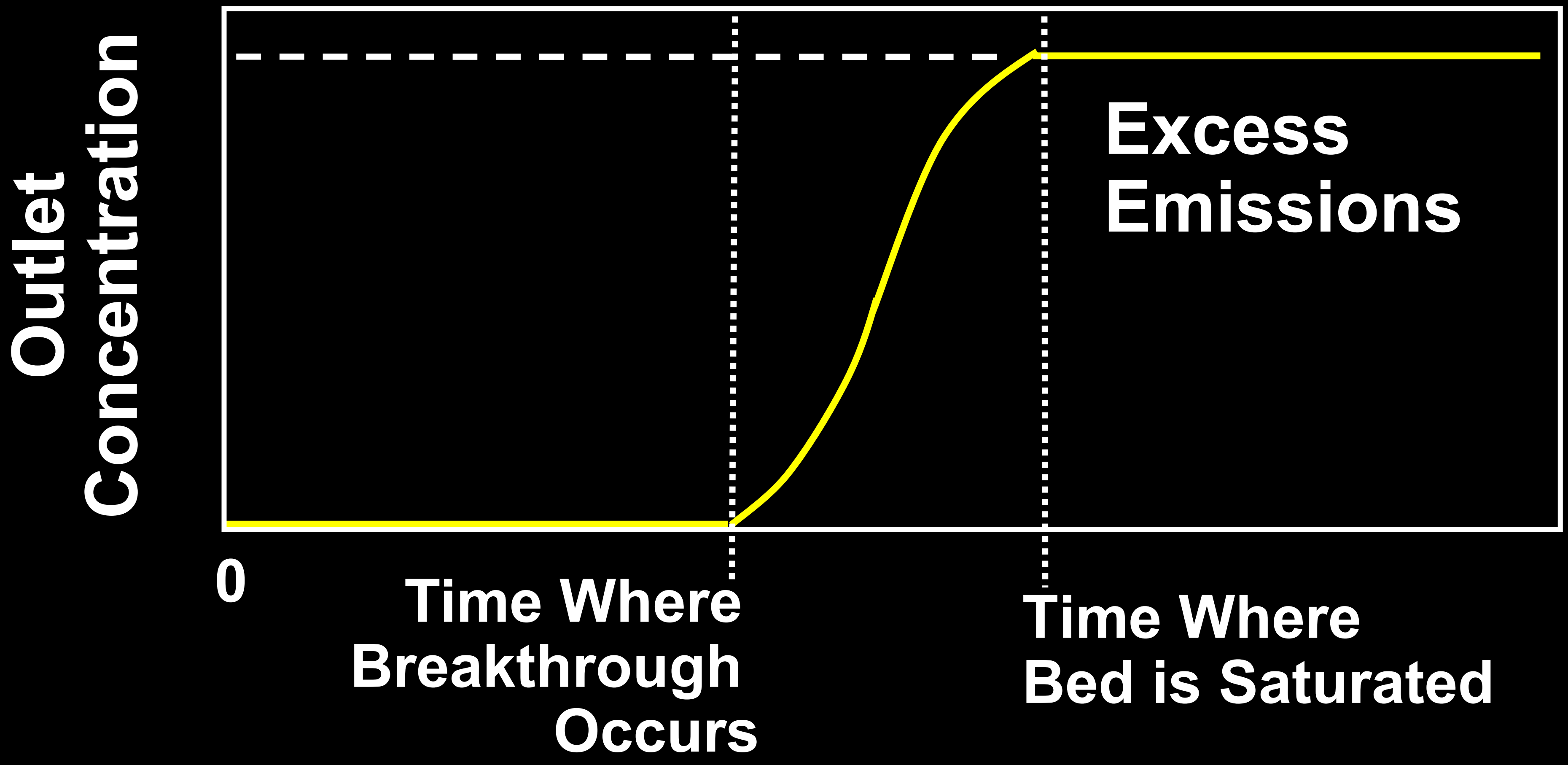
Carbon Adsorption Keywords

- Fresh zone
  - * Area where adsorption will occur
- Mass transfer zone
  - * Where adsorption occurs
- Saturated zone
  - * Area where adsorption has already occurred

Keywords (continued)

- Heel
  - *Amount of VOCs left in the carbon after regeneration
- Breakthrough
  - *VOCs that do not get captured

Adsorber Breakthrough



Types of Adsorption Systems

*Non-regenerative systems

*Regenerative systems

- on site
- off site

Characteristics of Activated Carbon

- Sources
  - * Wood, coal, peat, nut shells
- Porosity
  - * 600-1600 m^2/g (2-3 football fields per 1/28 ounce)
- Preparation
  - * Anaerobic heat then steam or CO_2,
- Degree of adsorption depends on adsorbate
  - * MW, BP, polarity, surfactive index, solubility

Examples of Activated Carbon

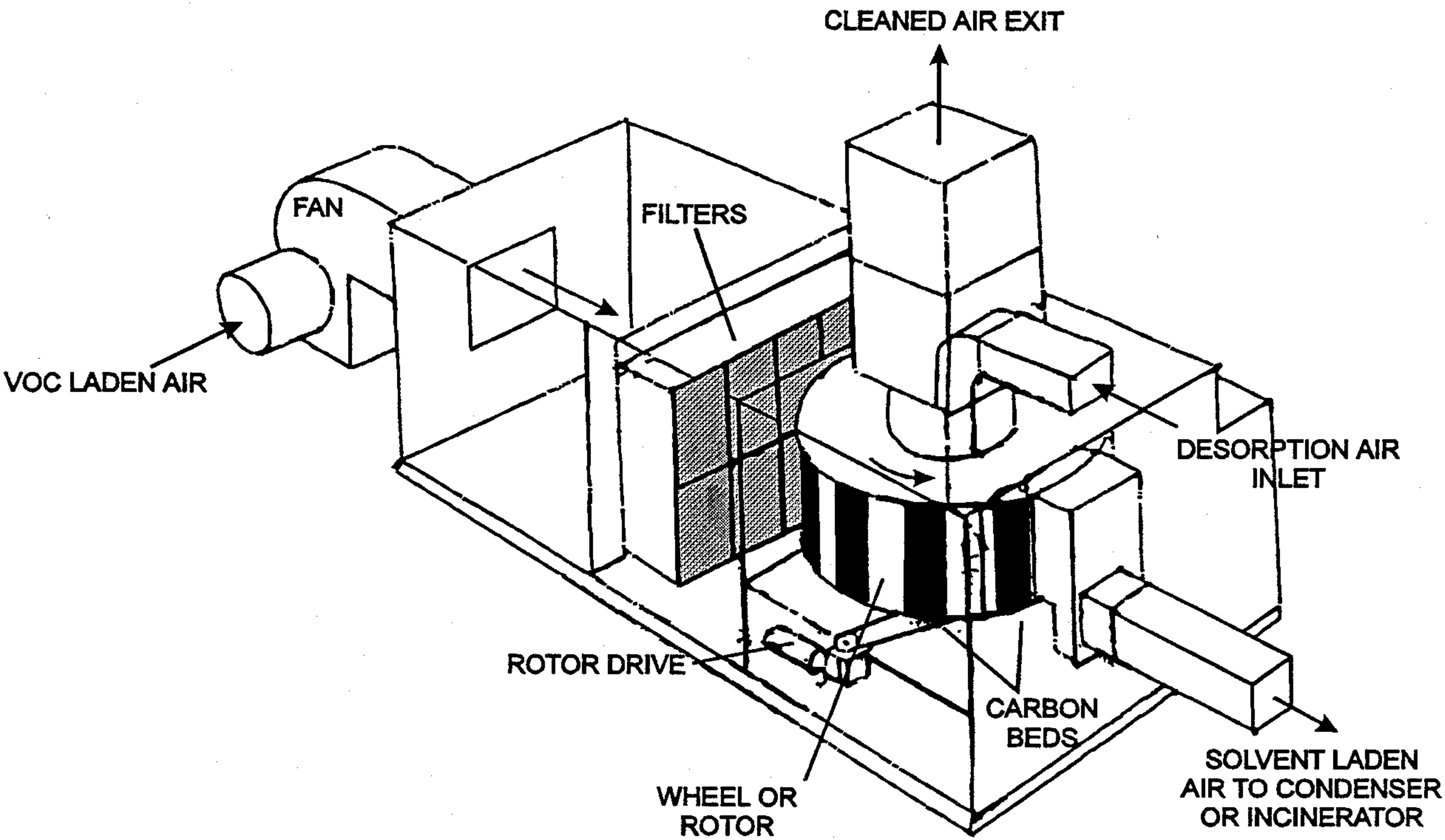

Finely Granulated Carbon

Types of Carbon Adsorption Systems

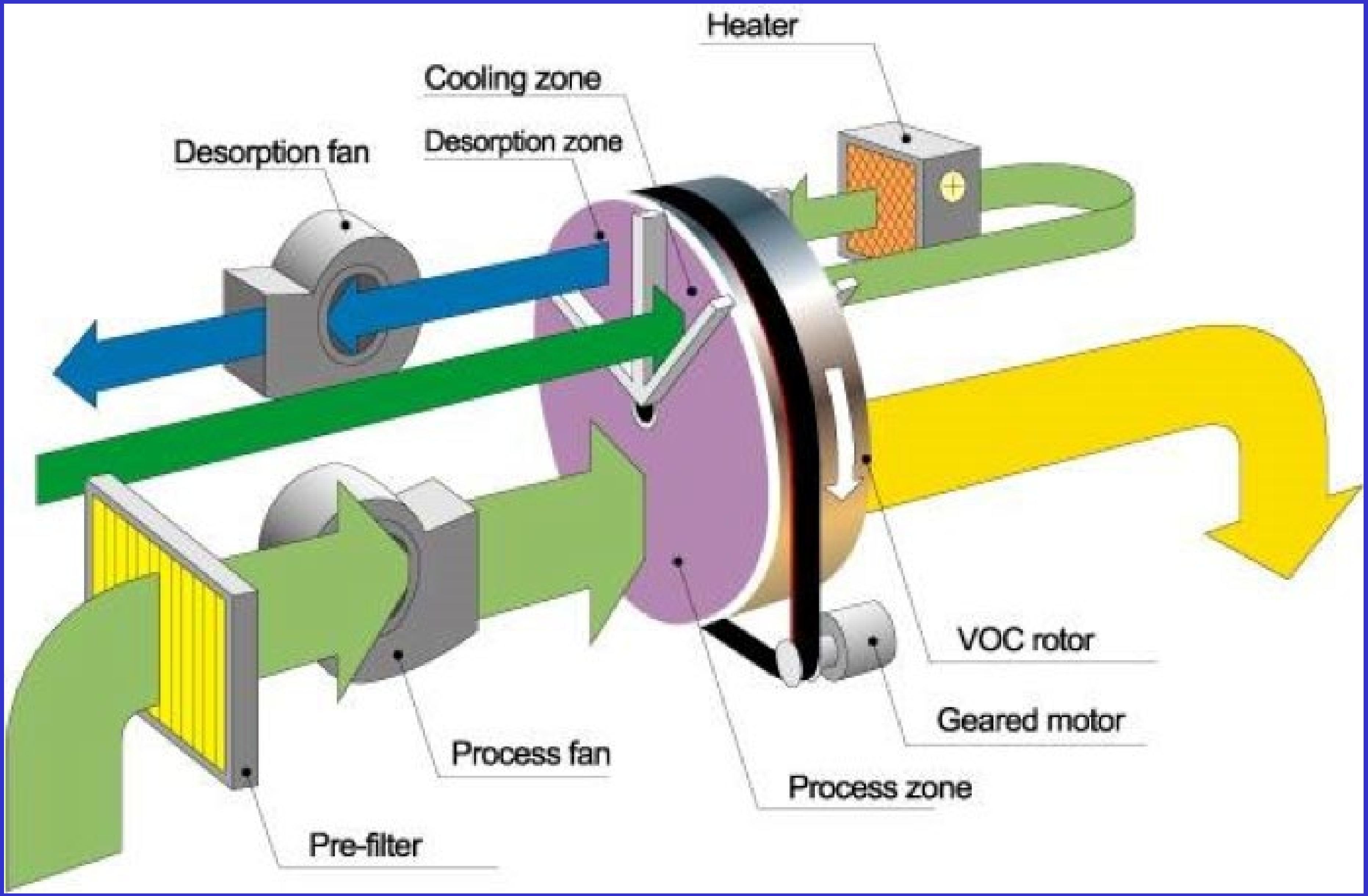
- Open
- Closed
- Rotary
- Fluidized bed
- Bulk plant a<u>d</u>sorber and a<u>b</u>sorber

Bulk plant a<u>d</u>sorber & a<u>b</u>sorber

Rotary Concentrator Adsorption System



Rotary Concentrator Adsorption System



Adsorber Inspections

- Hood static pressures
- Inlet VOC concentrations
- Inlet temperatures
- Inlet VOC concentration not > 25% LEL
- Outlet VOC concentrations
- Fan motor current
- Solvent recovery rates


Let's Discuss
Absorbers

Absorbers

- Pollutants dissolved in liquid
- Absorbate dissolves in absorbent

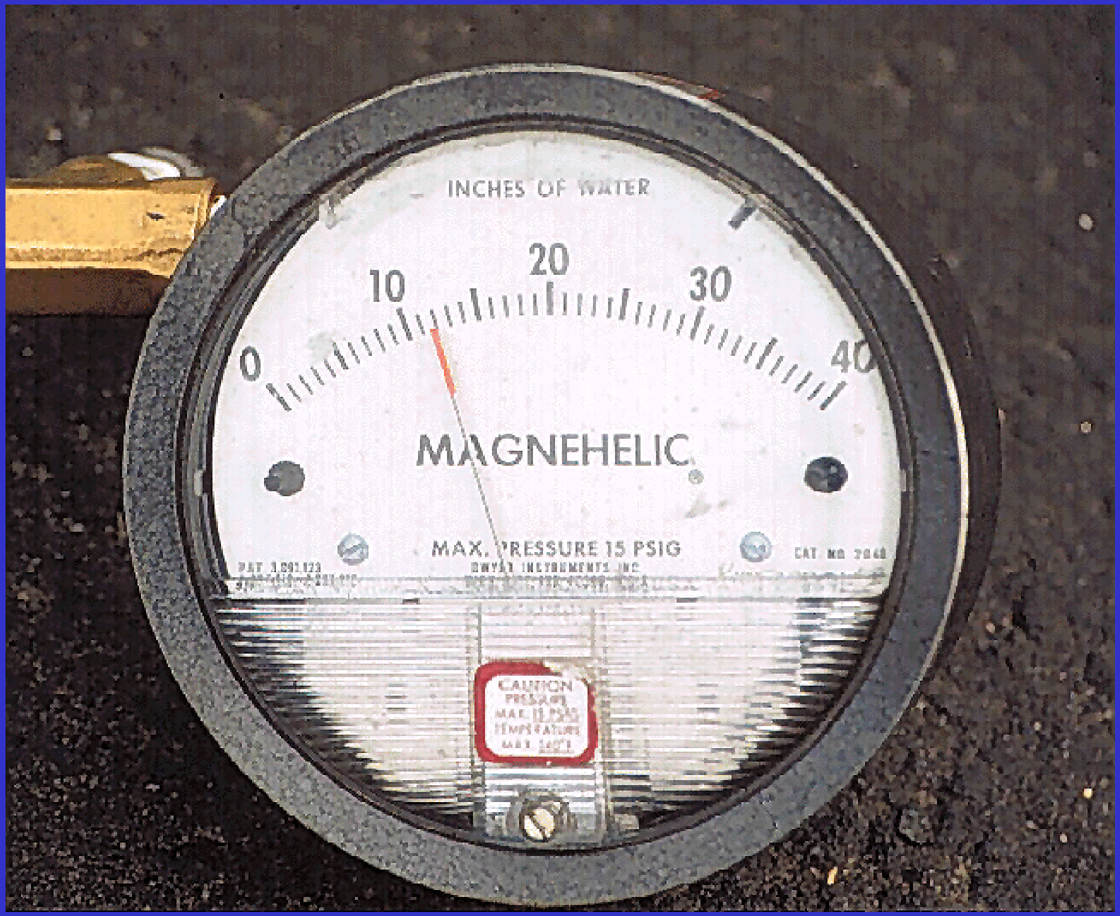
Factors Favoring Absorption

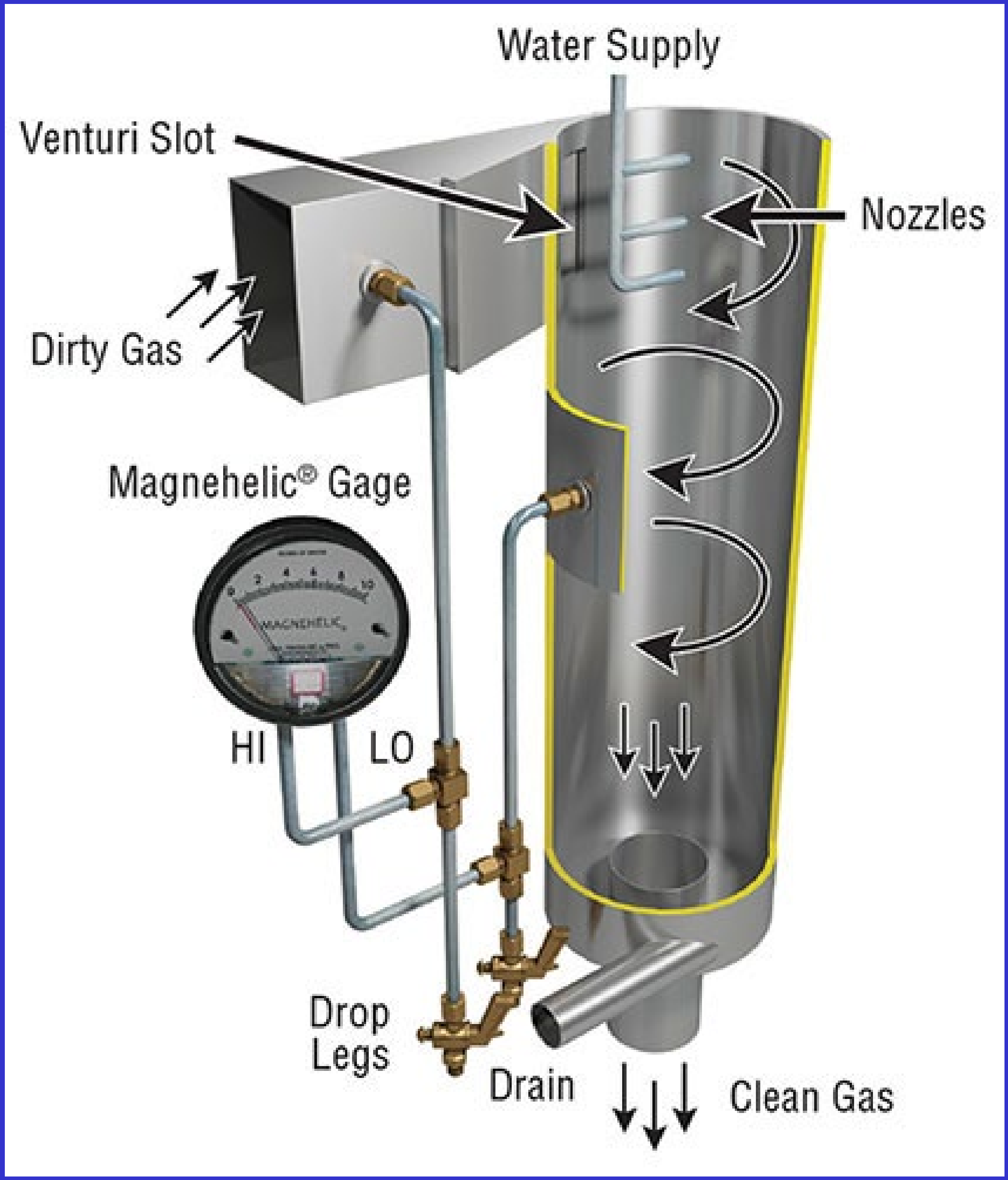
- Pollutant solubility in liquid
- Adequate diffusion at liquid / gas interface
- Maximized contact between gas and liquid

Absorber Design

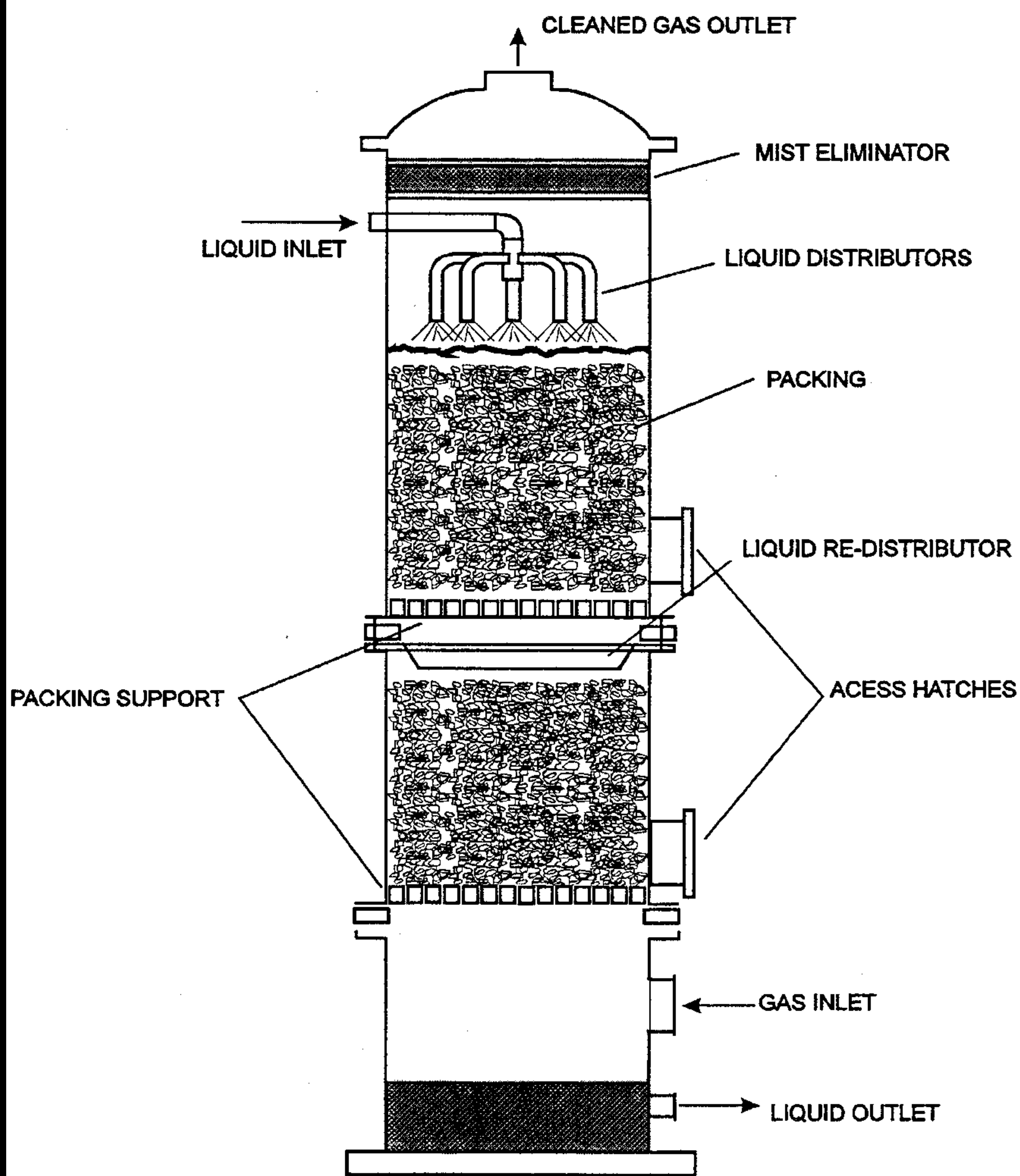
- Produce large surface area
- Minimize air flow resistance to reduce pressure drop
- Inlet pressure - outlet pressure = pressure drop

Pressure Drop : Magnehelic





Packed Bed Wet Scrubber



Packed-Bed Wet Scrubber

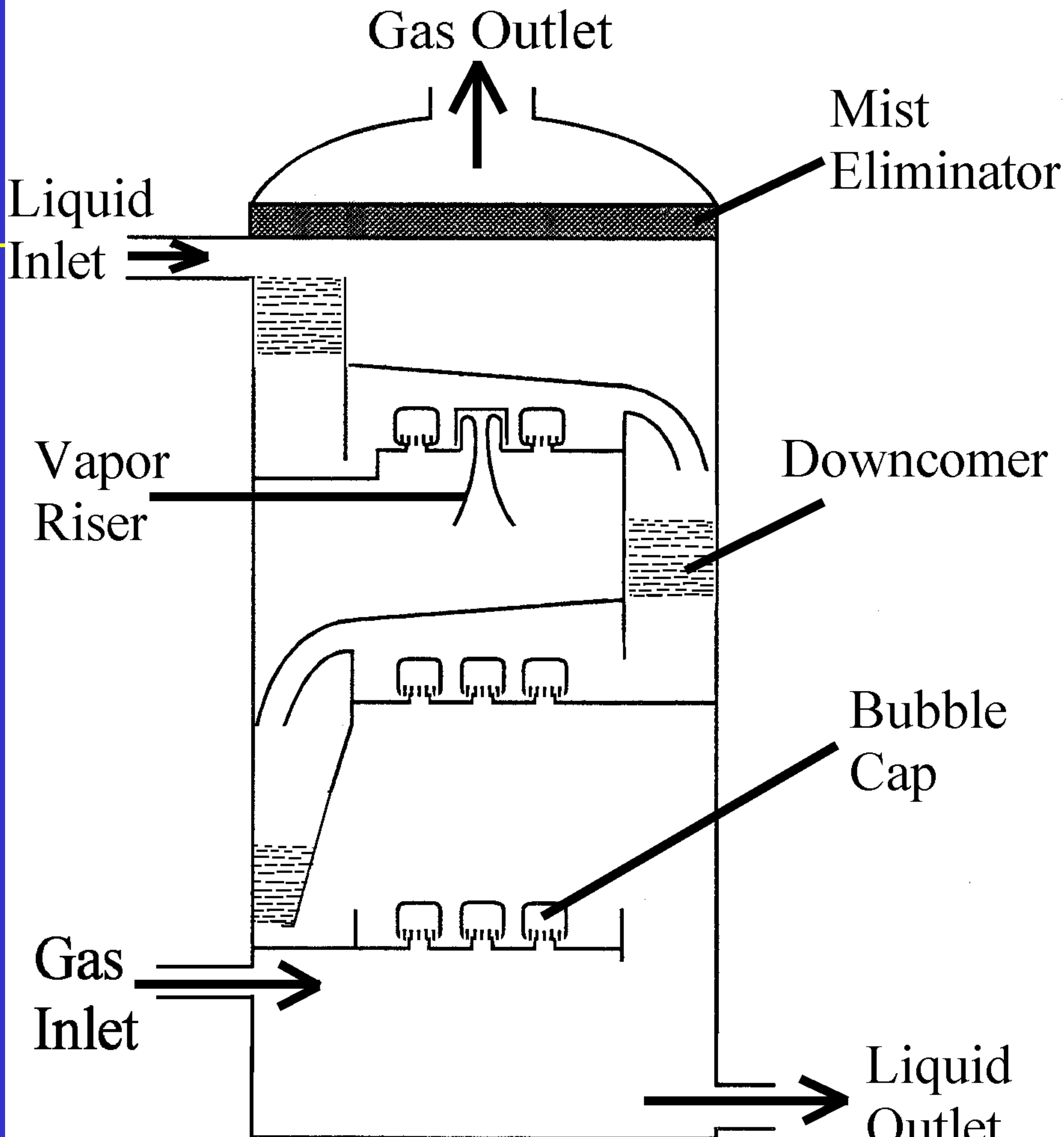
Absorber Design Factors

- Select liquid solvent
- Column material
- Column size
- Column height
- Number of plates
- Pressure drop

Absorbers: Packed Columns

- Flow patterns
- Liquid reuse and treatment
- Packing material
- Packing quality

Absorbers: Plate Columns



Absorbers: Plate Columns

- Maximize contact between liquid & gas
- Diameter of column
- Plates

  * Number

  * Type

  * Layout

Packed vs Plate Columns

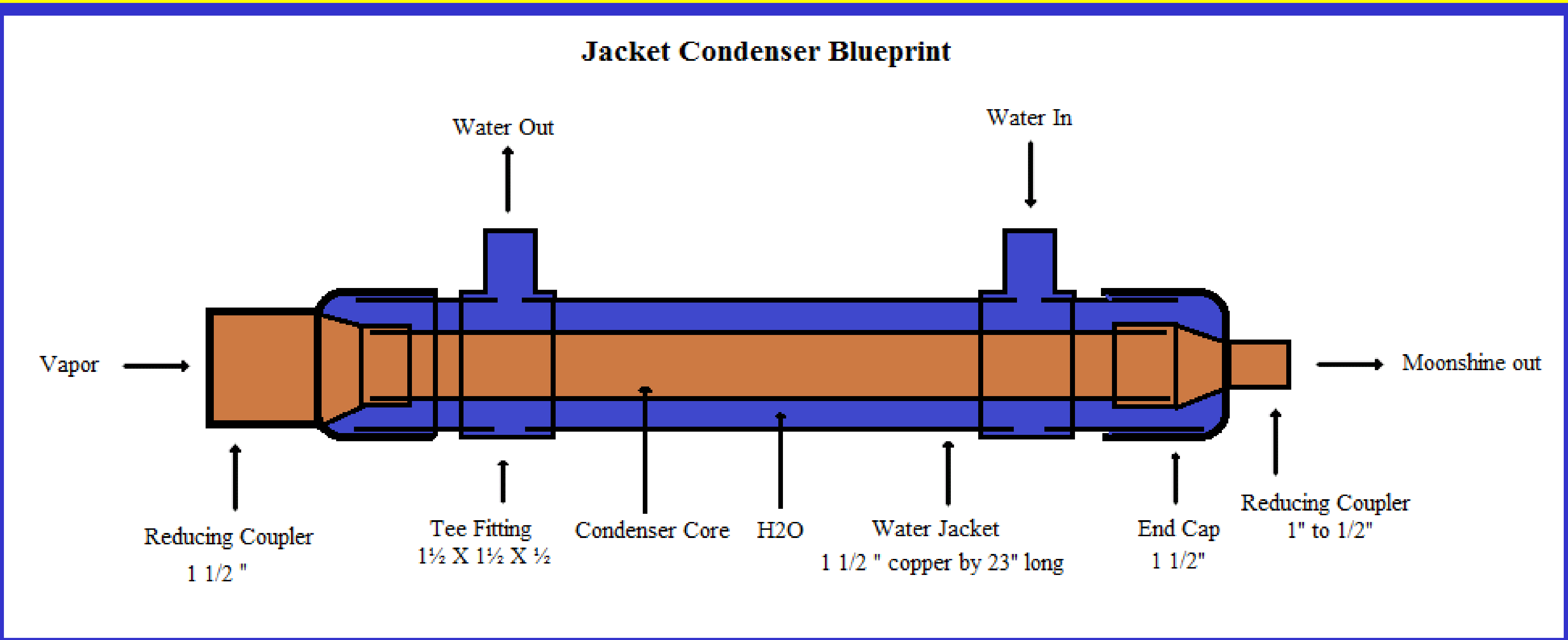
- Packed columns
  - +More common
  - –Plugged by particles
  - +Better for corrosive pollutants
  - +Lighter than plate

Packed versus Plate Columns

- Plate columns are better for:
  - Large temperature changes
  - Lower liquid flow rates
  - Higher gas flow rates
  - Foaming liquids
  - Chemical reactions
  - Large systems


Let's Discuss
Condensers

Condensers : Surface & Contact

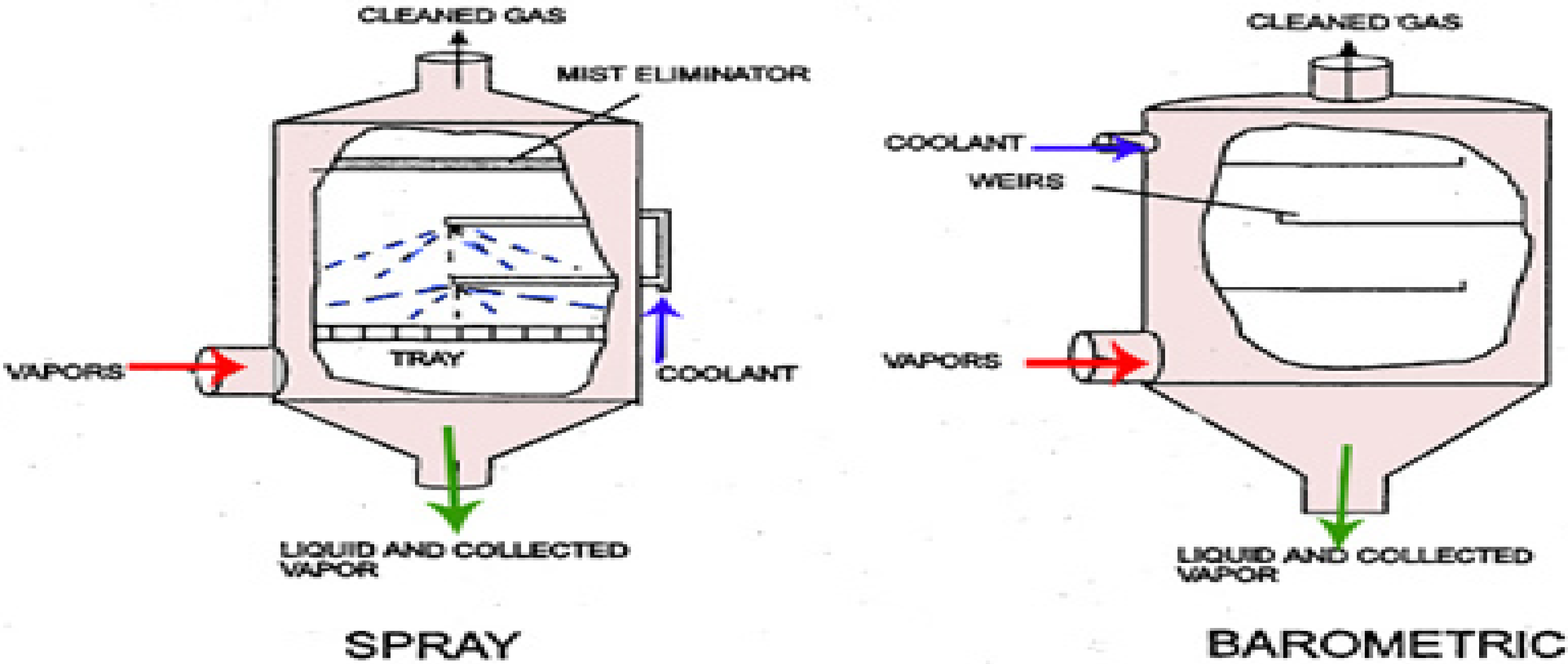


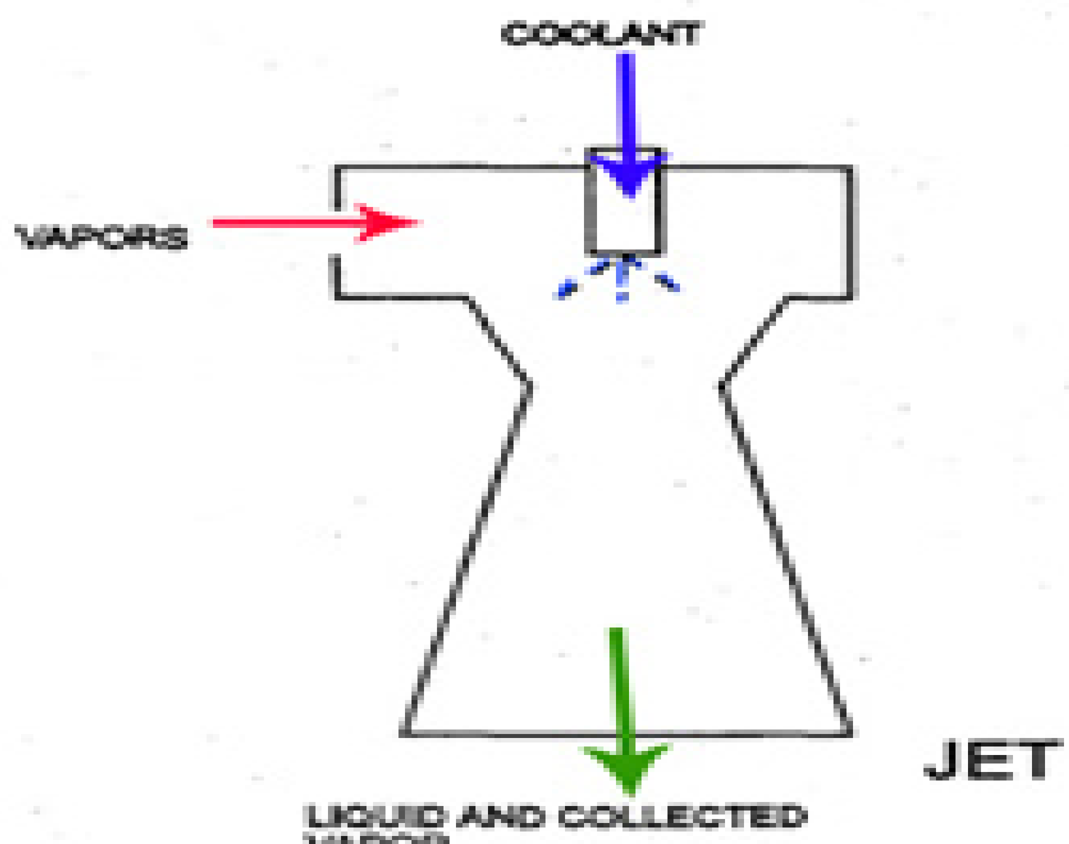
- Condensation = Process of changing a gas to a liquid.
- Condensation allows recovery of solvents and air pollution control

Contact Condensers

- Contact condensers +/-
  - + Cheaper
  - + More flexible
  - + Less repair time
  - – Wet waste disposal problem

Contact Condensers





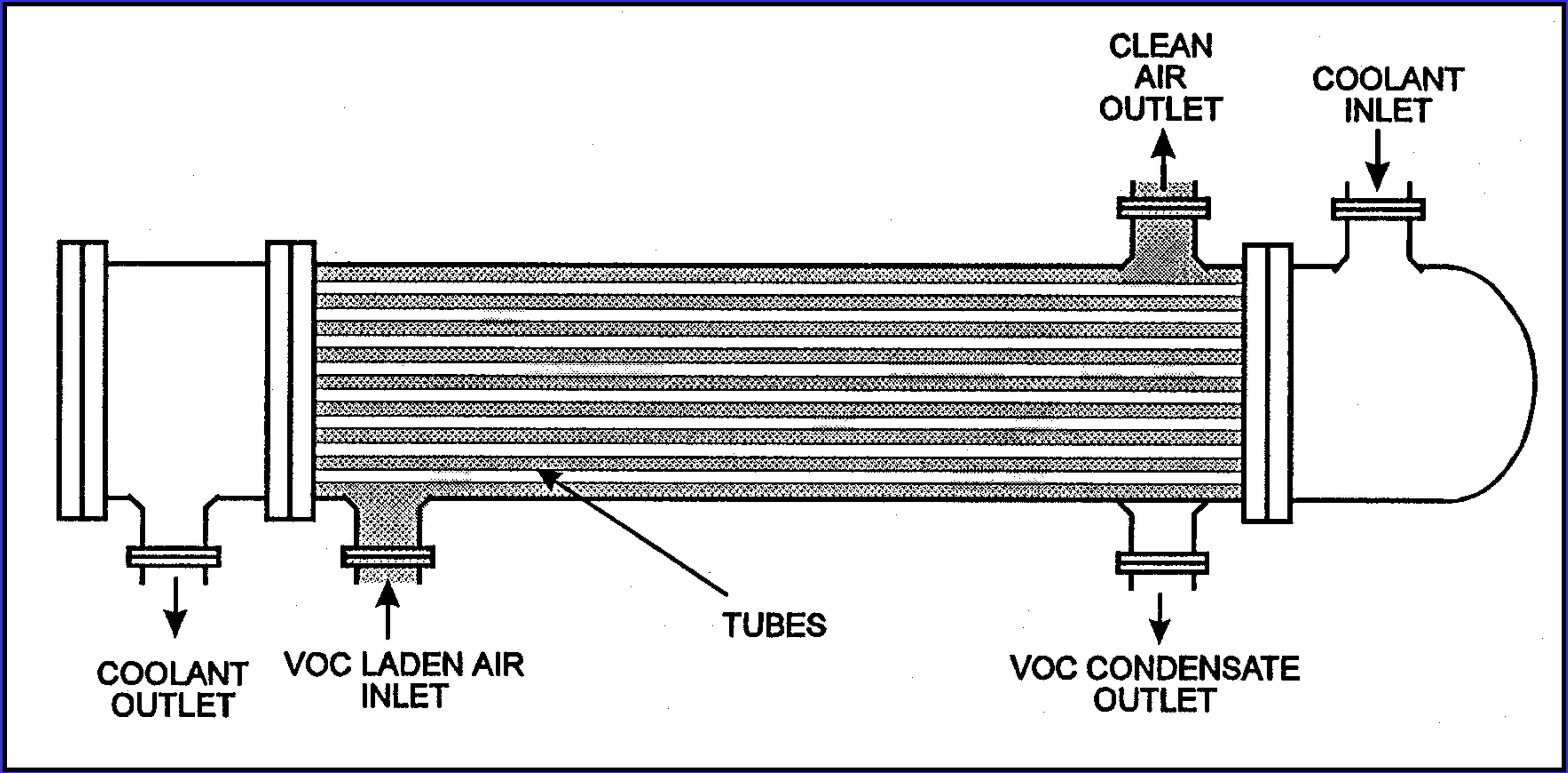
Surface Condensers

- *Shell and tube (most common)
- *Fin Fan
- *Tubular
- *Double pipe
- *Spiral plate
- *Flat plate

Condensers

- Surface condensers +/-
  - \+ Better recovery
  - \+ Commonly used for air pollutants
  - \+ Reduced waste disposal problems
  - – More costly

Shell and Tube



Dry Air-Cooled Heat Exchanger : Steam Condenser

Dry Air-Cooled Condenser Fans

Condenser Concerns

- Freezing
- Fouling
- Cleaning
- Pressure drop

Condenser Inspection

- Look for
  - Excessive corrosion and rusting
  - Leaking coolant or VOC
  - Excessive odors
  - Continuous emissions monitor

Condenser Inspection

– Record
  – VOC outlet concentration
  – Waste stream flow rate
  – Condenser pressure drop
  – Coolant pressure
  – Coolant flow rate


Let’s Discuss Oxidizers

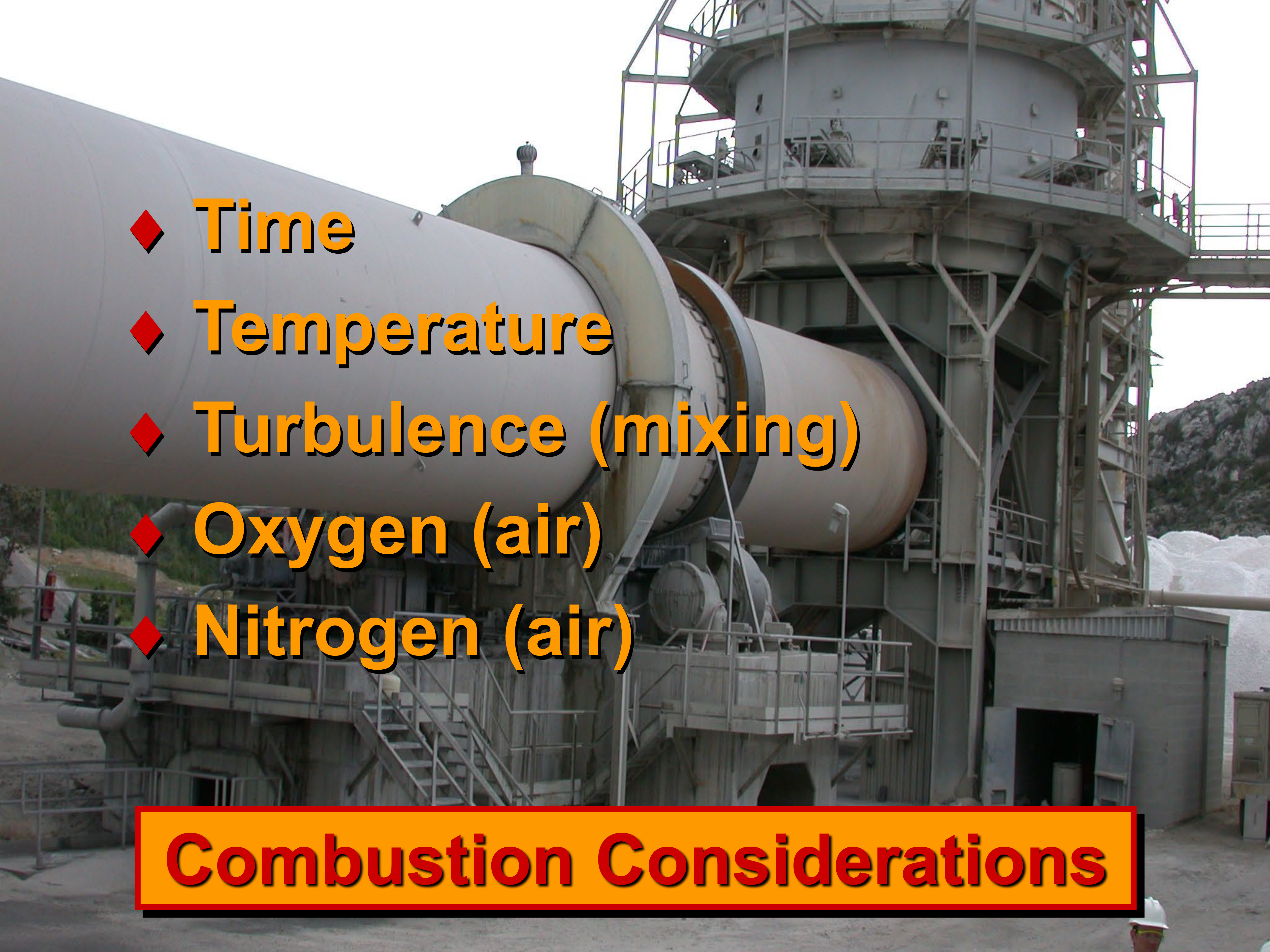
Oxidation

- Destruction of VOCs by Combustion

Reactions with oxygen

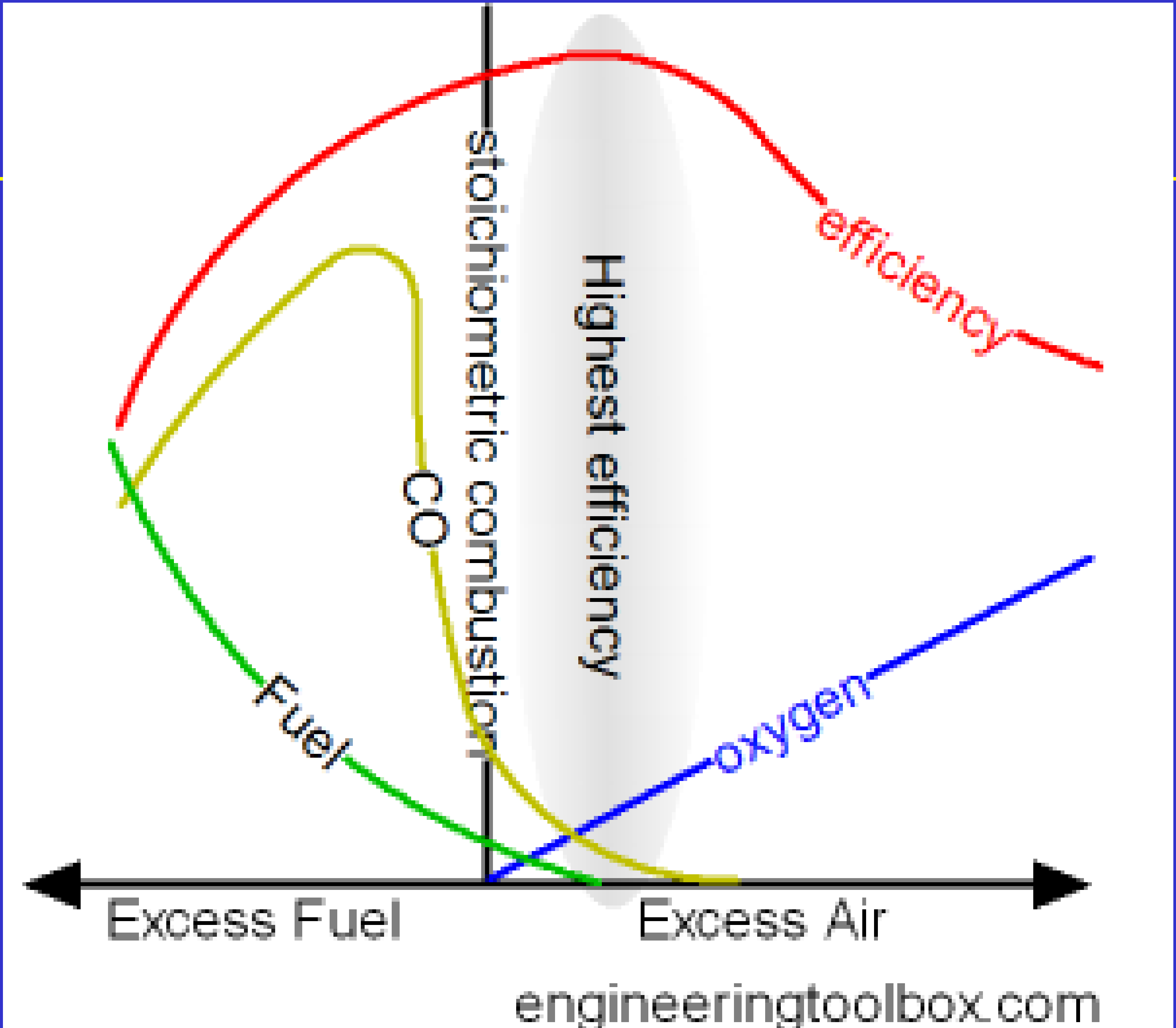
$$C_7 H_8 + 9O_2 = 7CO_2 + 4H_2O$$

Toluene + Oxygen = Carbon Dioxide + Water



Combustion Considerations

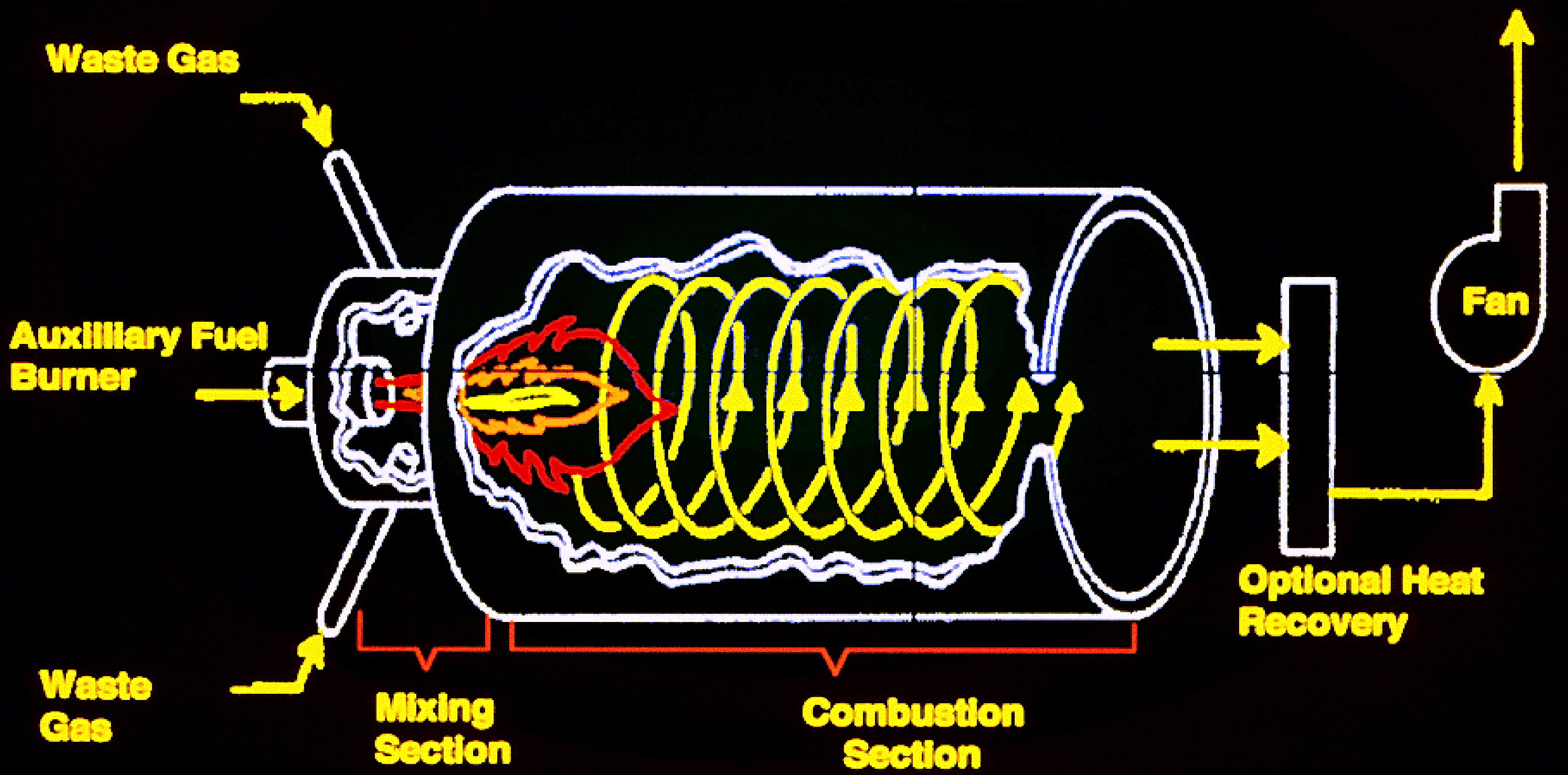
- Time
- Temperature
- Turbulence (mixing)
- Oxygen (air)
- Nitrogen (air)


efficiency
stoichiometric combustion
Highest efficiency
CO
Fuel
oxygen
Excess Fuel
Excess Air
engineeringtoolbox.com

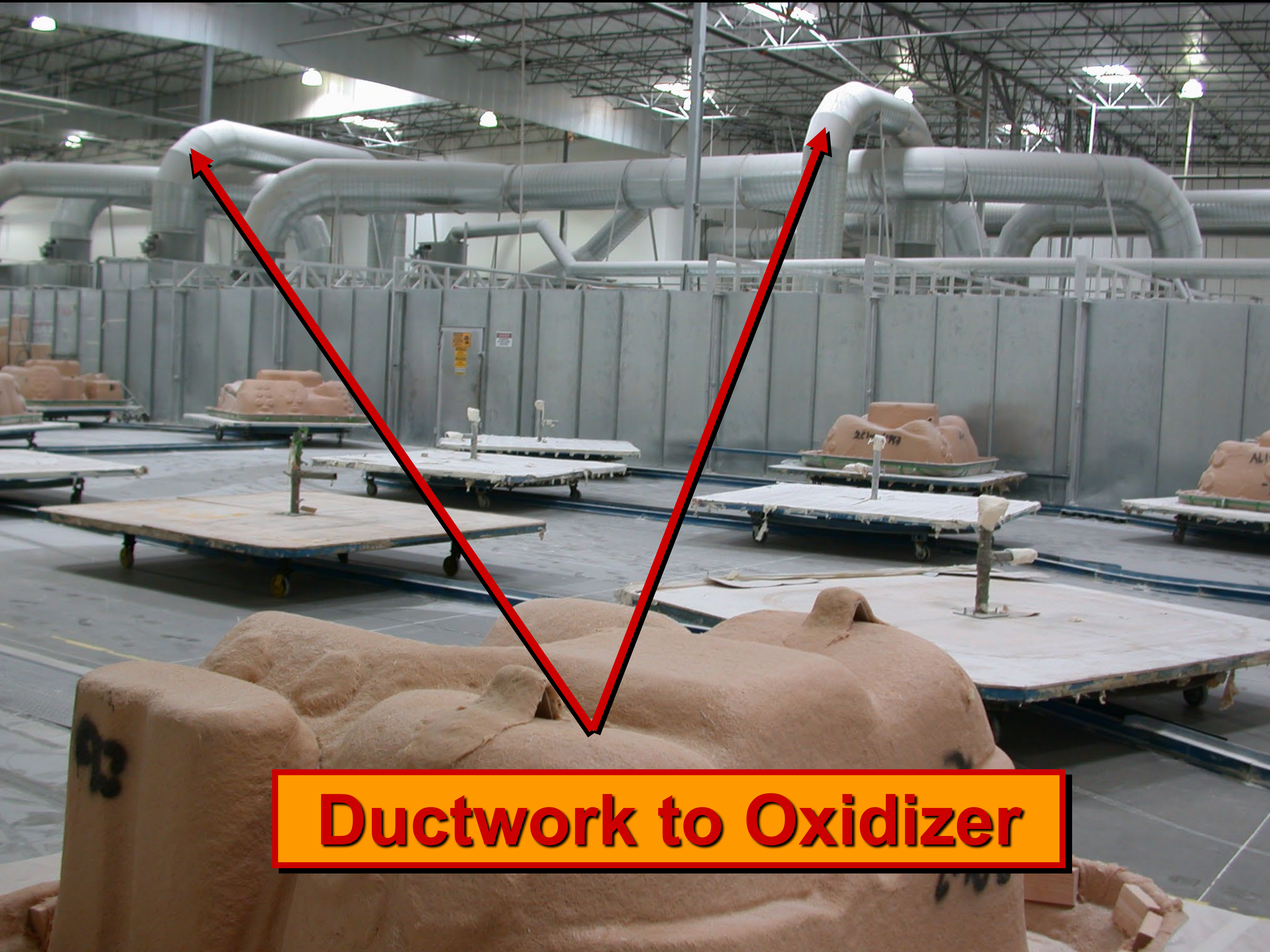
Combustion Devices

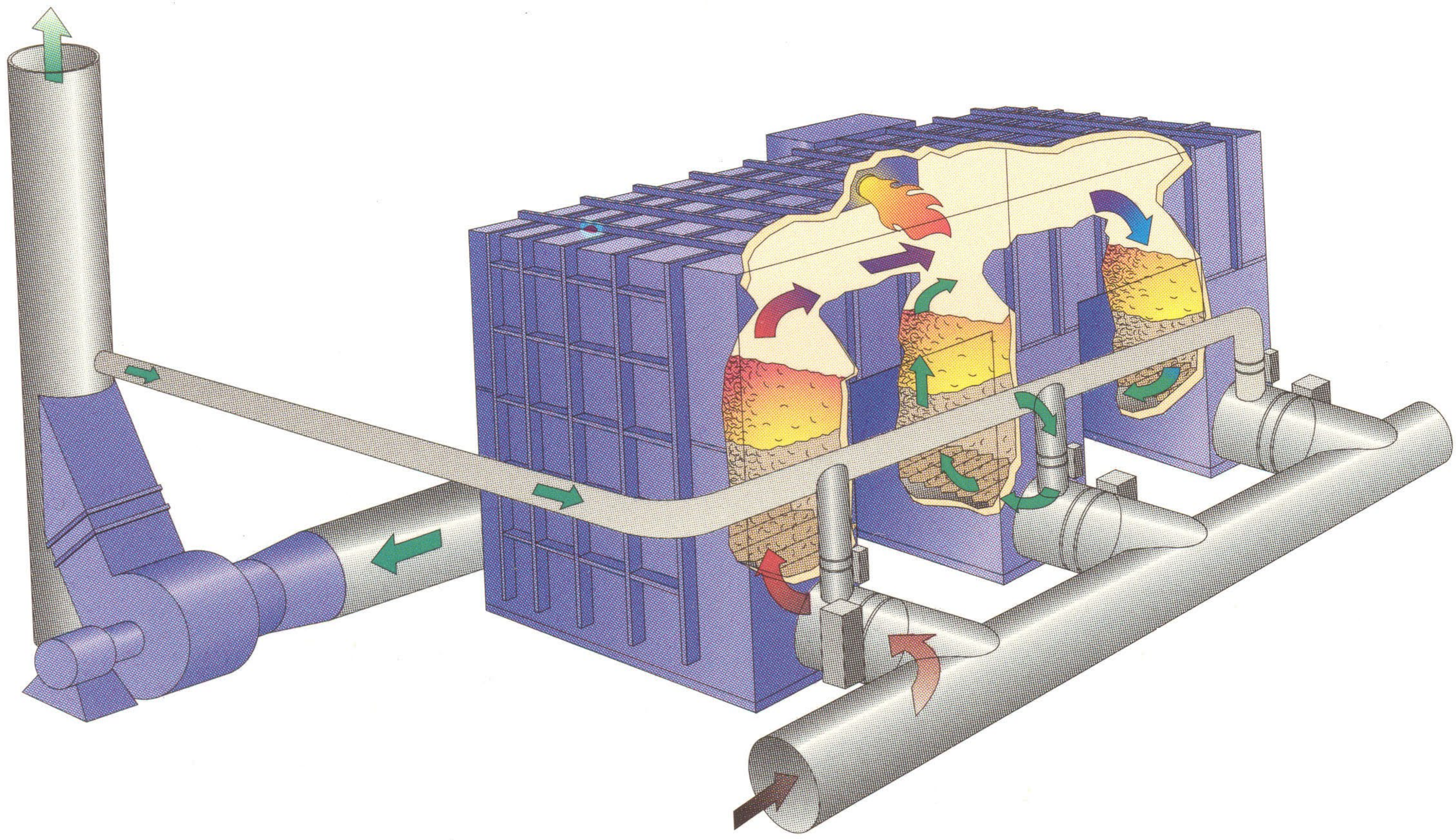
- Thermal incinerator (uses a flame)
- Catalytic incinerators (uses a catalyst)
- Boilers (burn VOCs to make steam)
- Process heaters (burn VOCs to add heat in chemical plants and refineries)
- Flares (simple flame)

Thermal Oxidizer/Afterburner



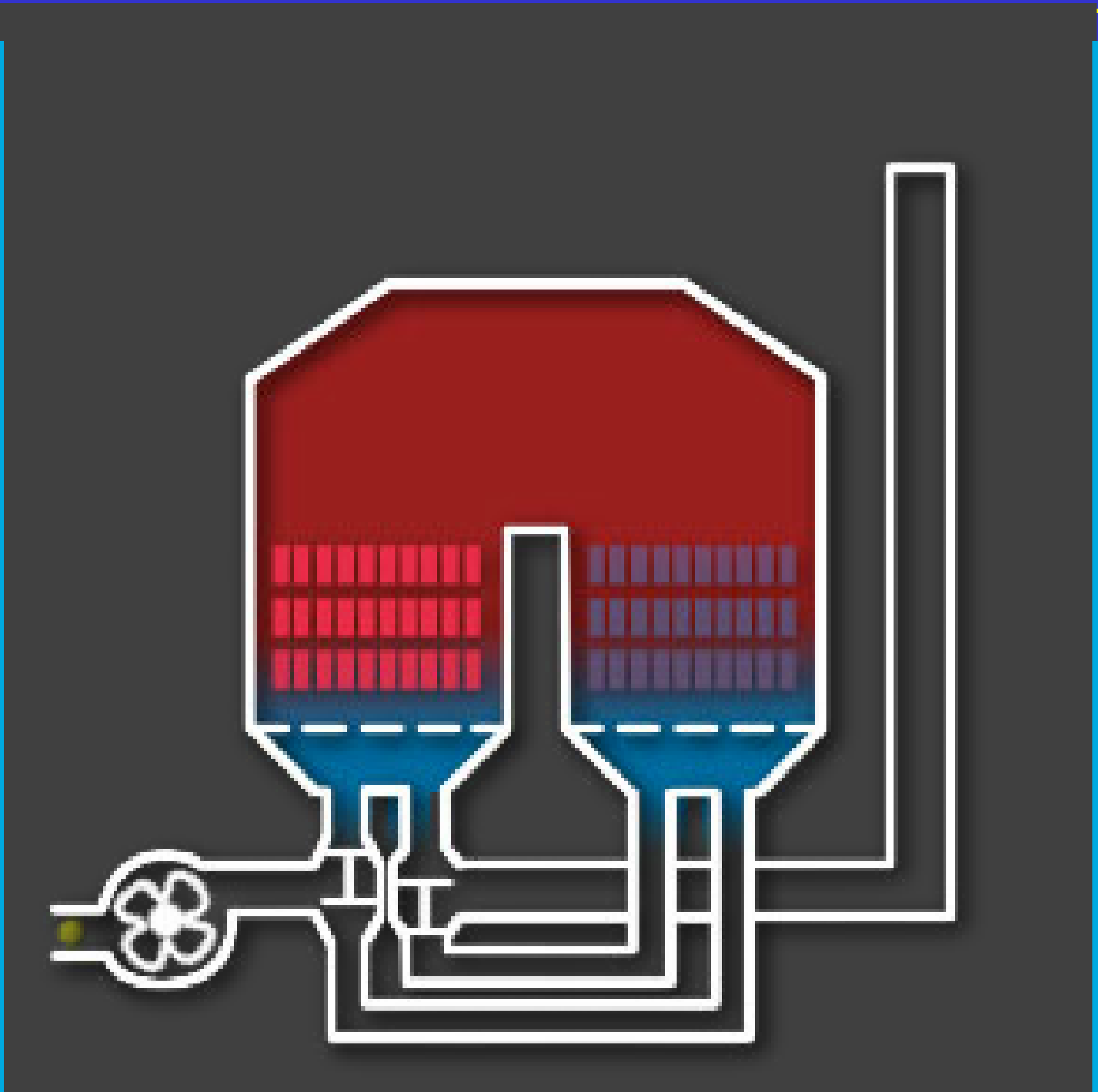
Thermal Incinerator

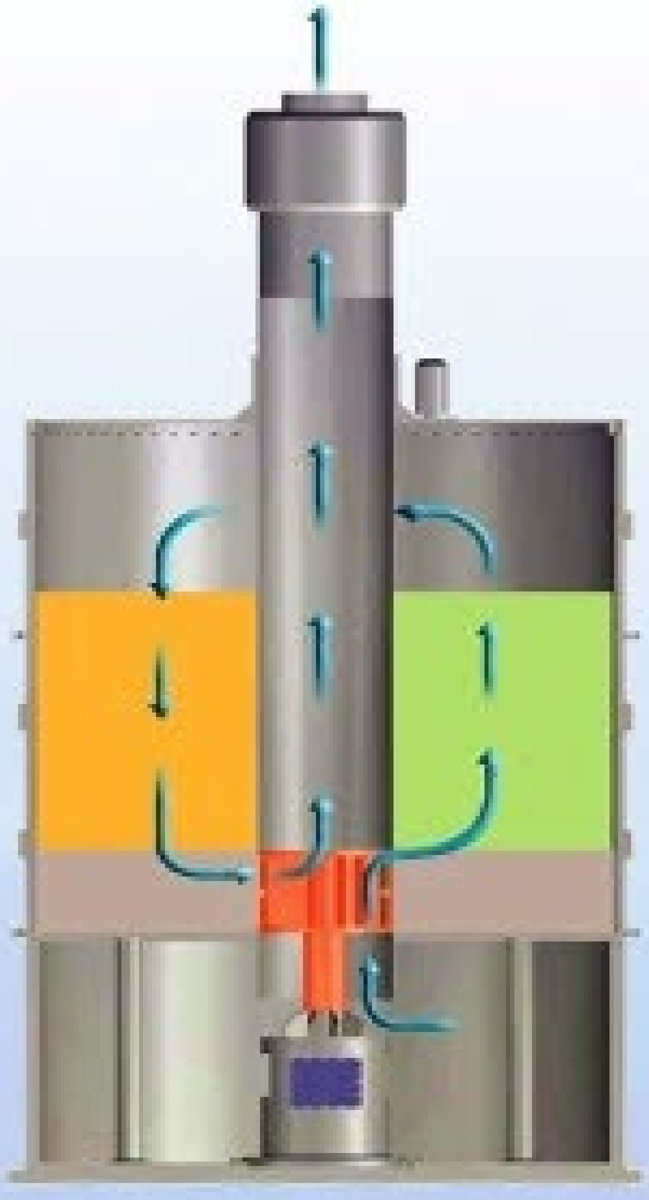

Ductwork to Oxidizer



Regenerative Thermal Oxidizer

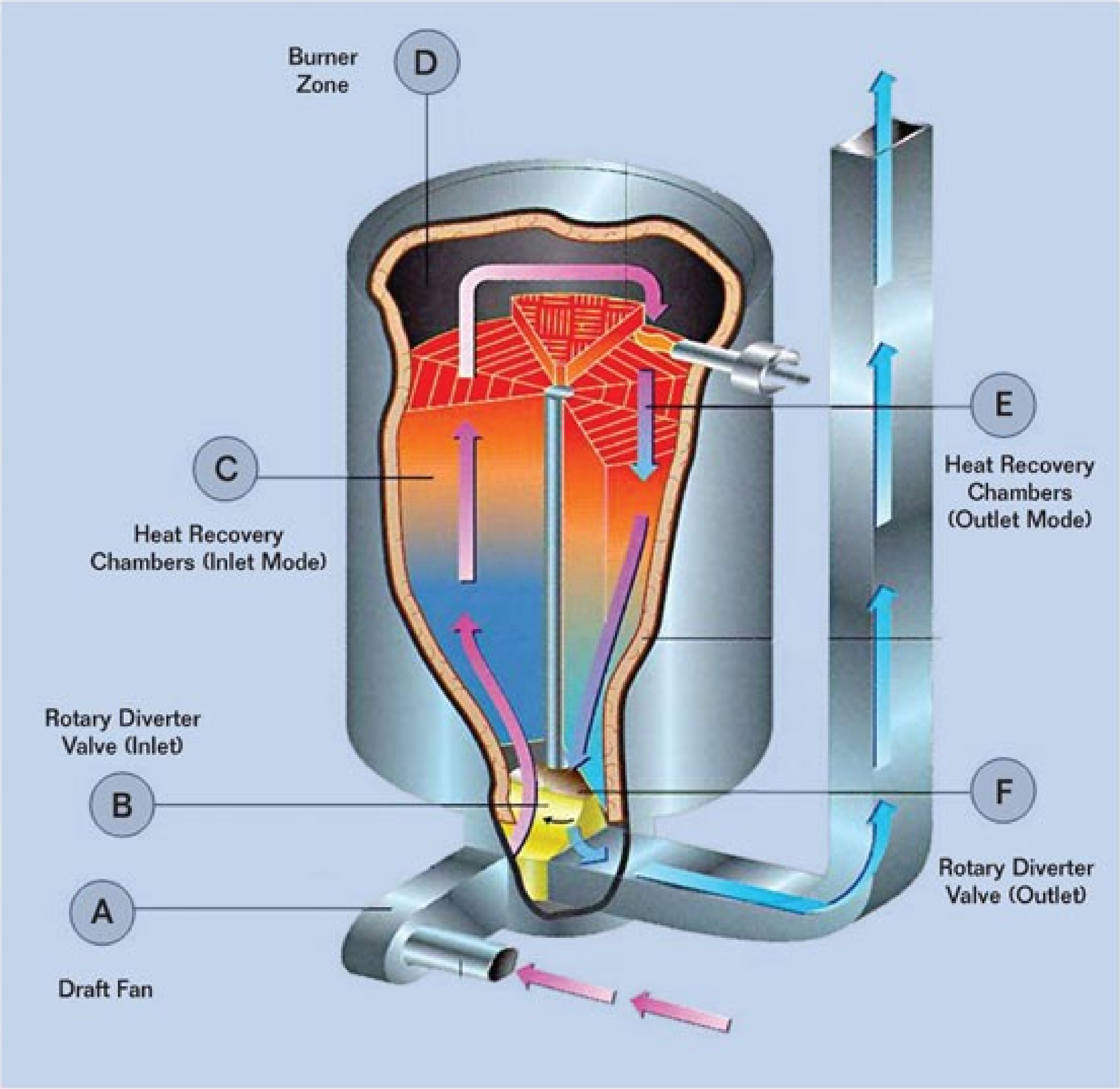
RTO Operation





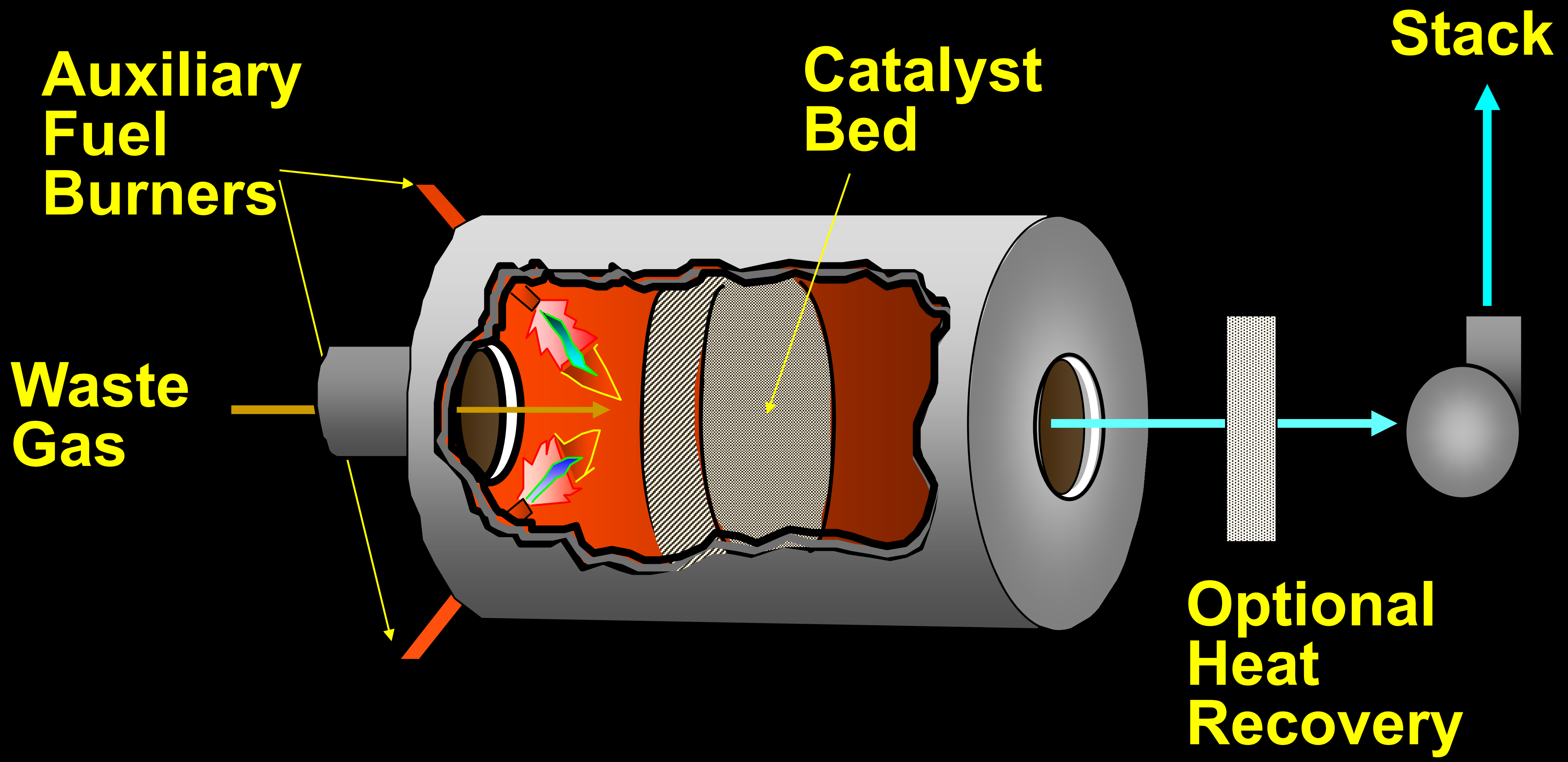
ONE CAN TYPE RTO

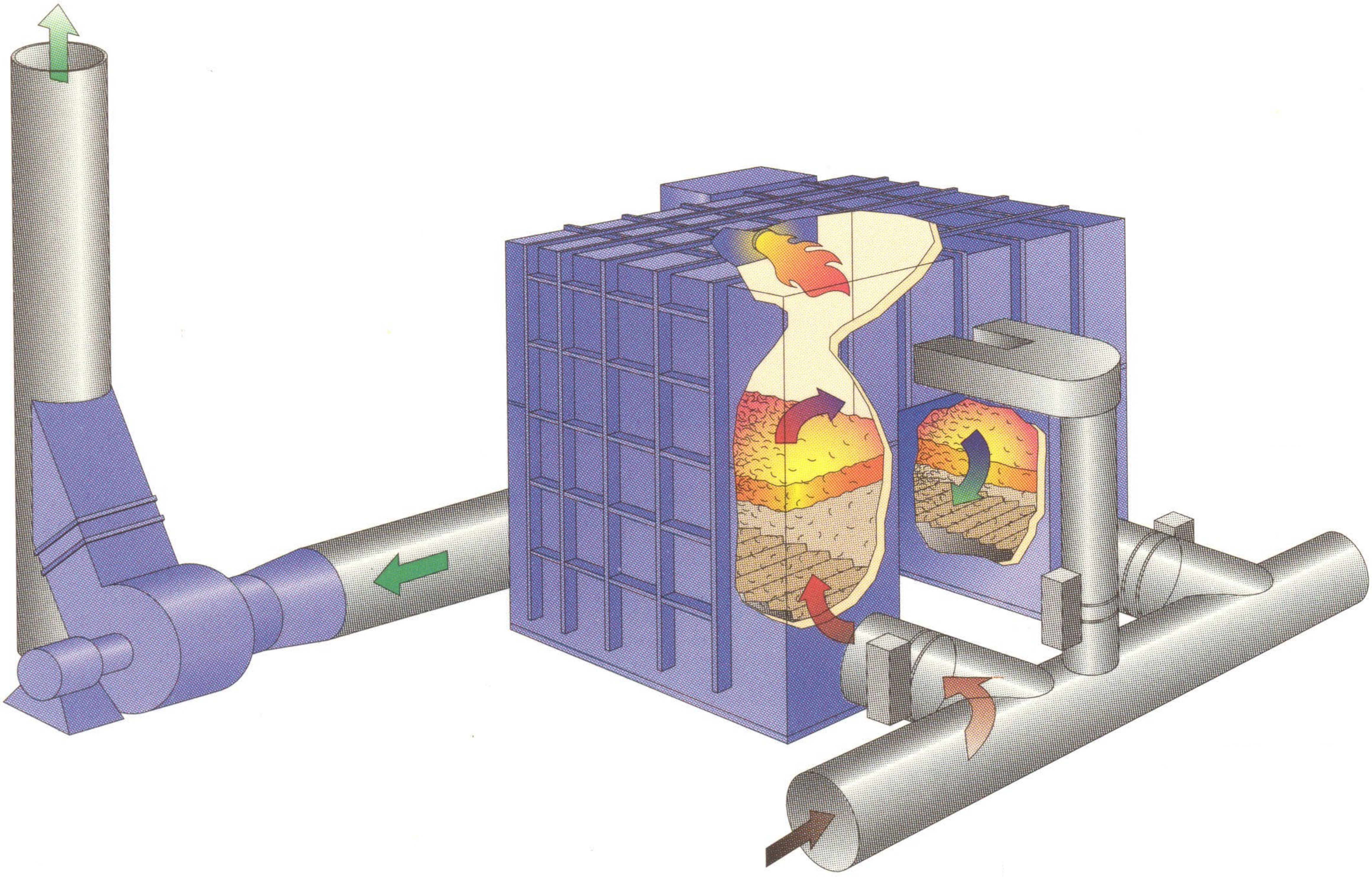
Can Type RTO



In the regenerative thermal oxidizer, the single rotary valve indexes across an open air path and methodically seals it off by reaching the next set position. A continuous air purge captures any scavenging dirty air in the switch and returns it for treatment in the oxidizer.

Catalytic Oxidizer/Incinerator





Regenerative Catalytic Oxidizer

Selection Criteria

- Type of VOCs
- Concentration of VOCs
- Process flow rate
- Economics

Catalytic vs. Thermal for VOC Control

Catalytic	Thermal
Lower Operating Temp. & Lower Fuel Usage	Higher Operating Temp. & Higher Fuel Usage
Higher Capital & Maintenance Costs	Lower Capital & Maintenance Costs
Catalyst Fouling & Poisoning	No Catalyst Involved Here

Catalyst Problems

- Scouring
- Thermal burnout
- Thermal aging
- Masking
- Catalyst fouling and poisoning

Catalytic Poisons

- Fast acting poisons

  * phosphorus P, bismuth Bi, lead Pb, arsenic As, antimony Sb, mercury Hg

- Slow acting

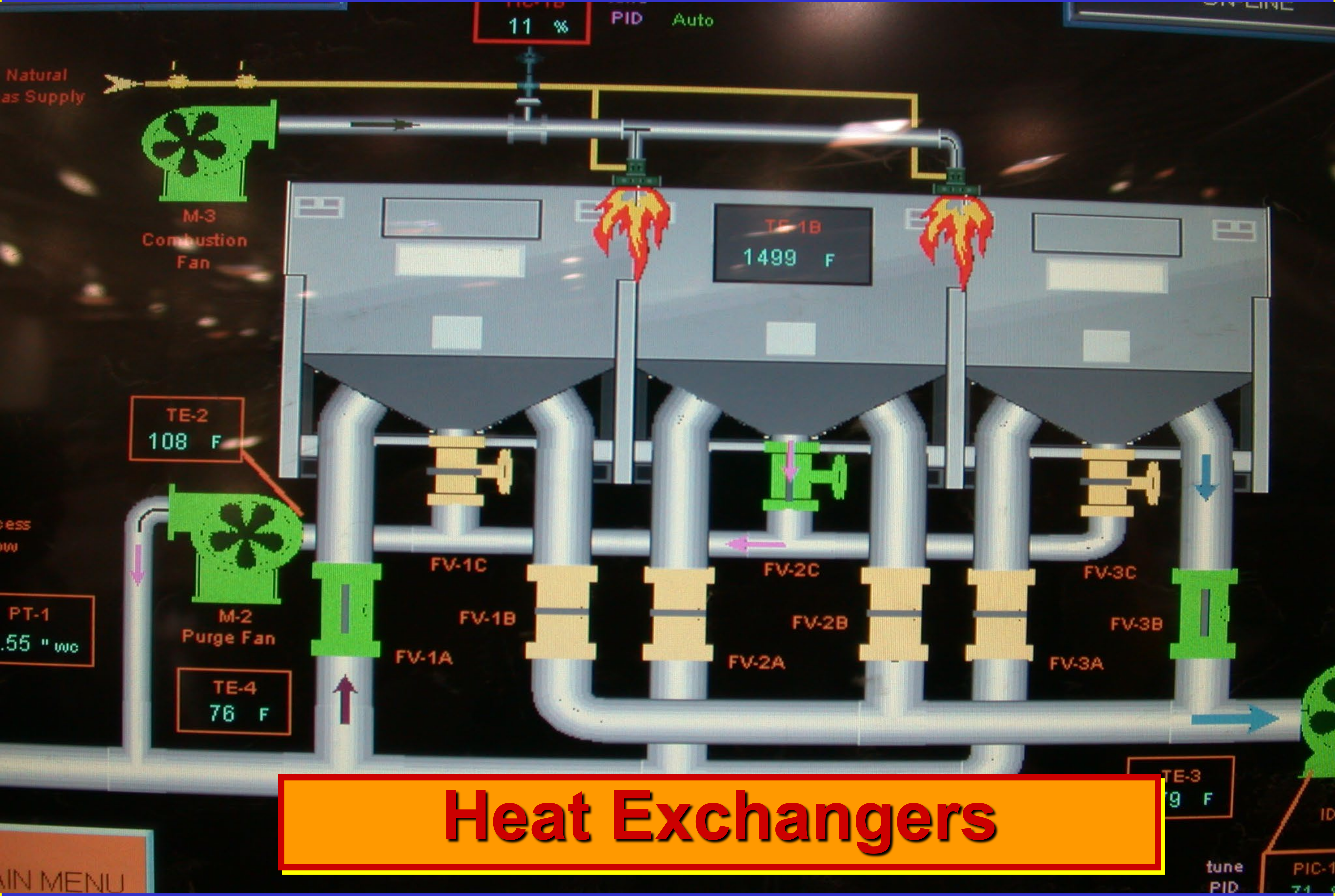
  * iron Fe, tin Sn, silica Si

- Reversible

  * sulfur S, zinc Zn, chlorine, bromine, fluorine etc. halogens

Catalyst Efficiency

- Operating temperature
- Space velocity
- VOC composition
- VOC concentration
- Catalyst properties
- Poisons and inhibitors



Heat Exchangers

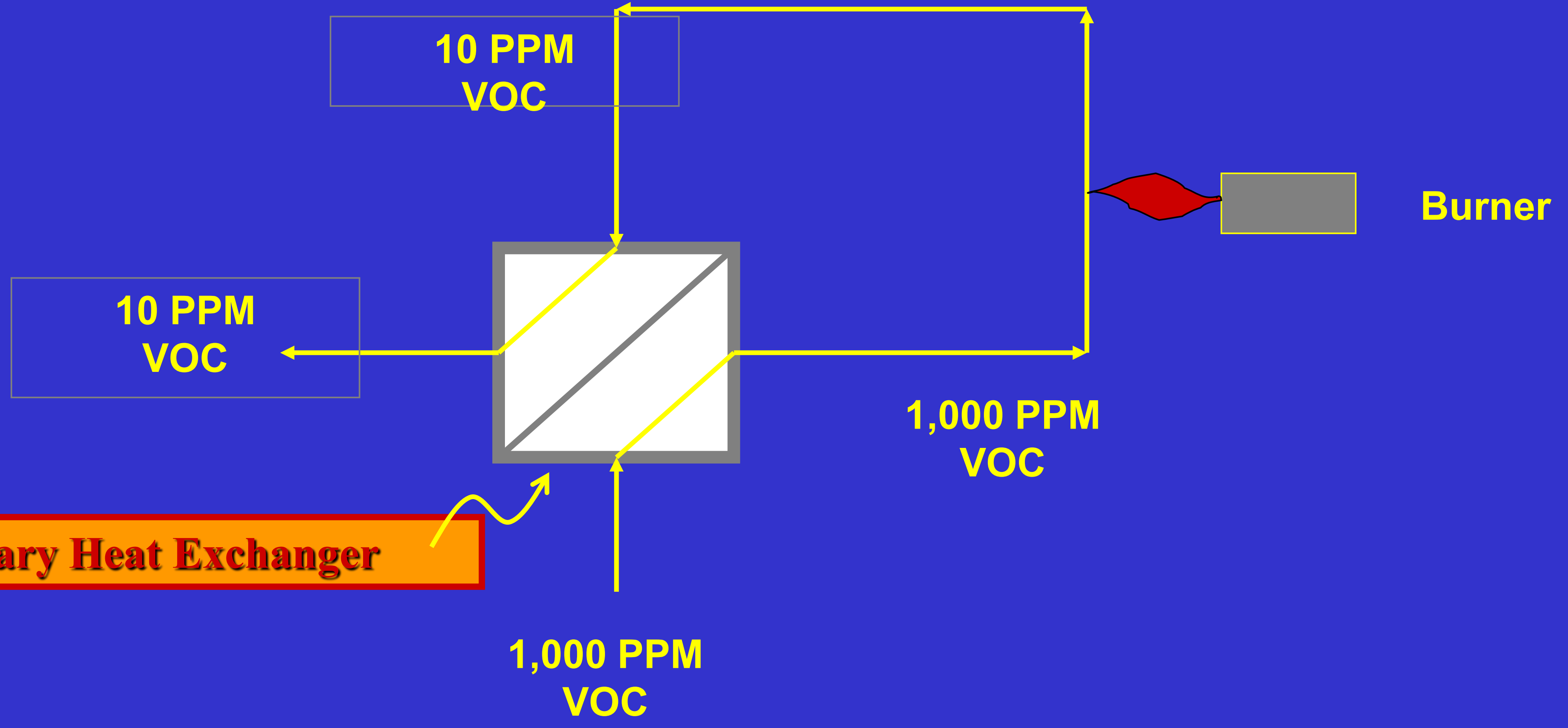
Thermal & Catalytic Oxidizer Heat Exchangers

There are two basic types of heat exchangers used for thermal or catalytic oxidizers

- Metal Heat Exchangers or “recuperative heat exchangers”
- Ceramic Bed Heat Exchangers or “regenerative heat exchangers”

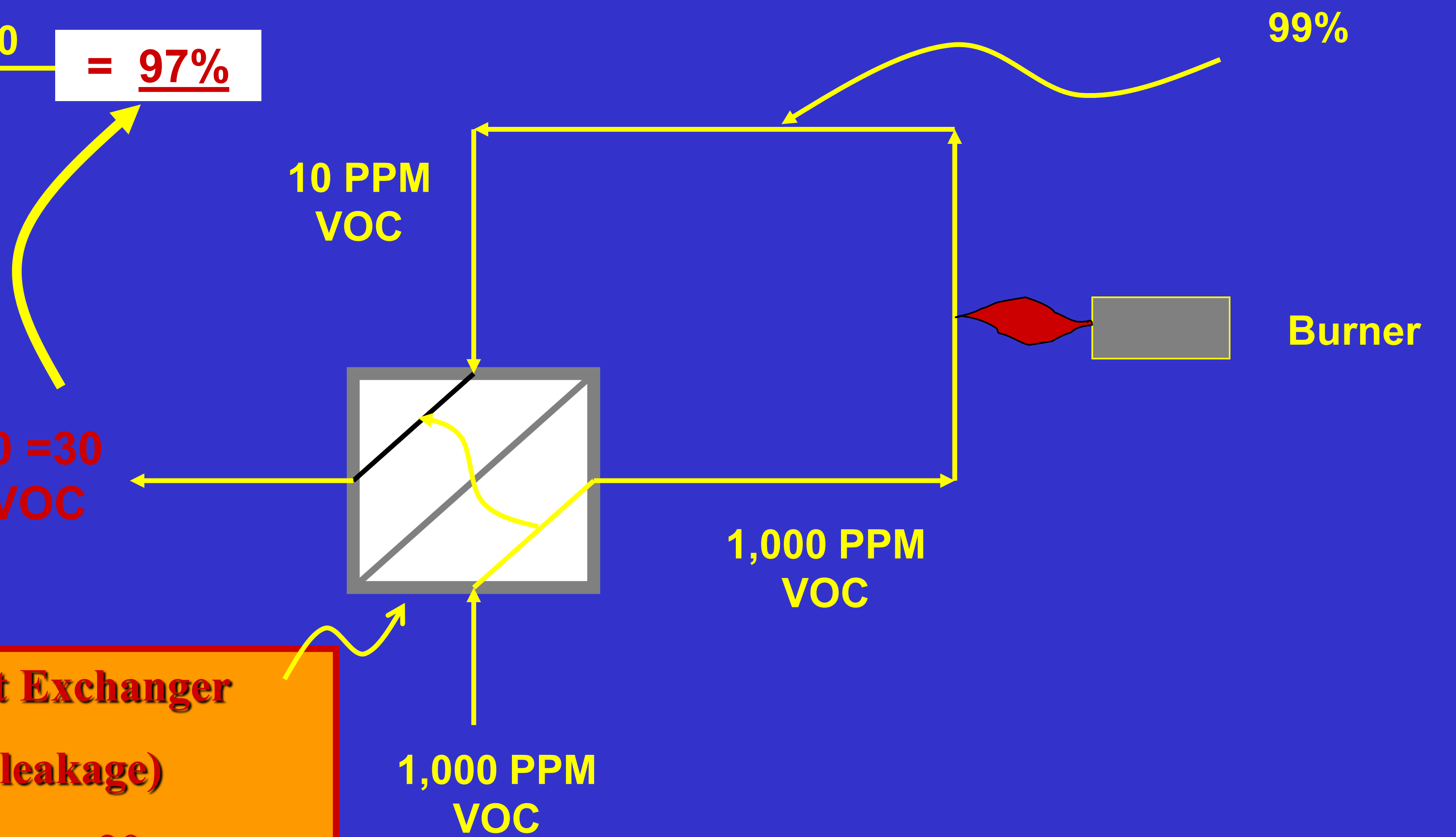
Thermal & Catalytic Oxidizer Heat Exchangers

DRE = $\frac{1,000 - 10}{1,000}$ = 99%



Thermal & Catalytic Oxidizer Heat Exchangers

DRE = $\frac{1{,}000 - 30}{1{,}000}$ = 97%



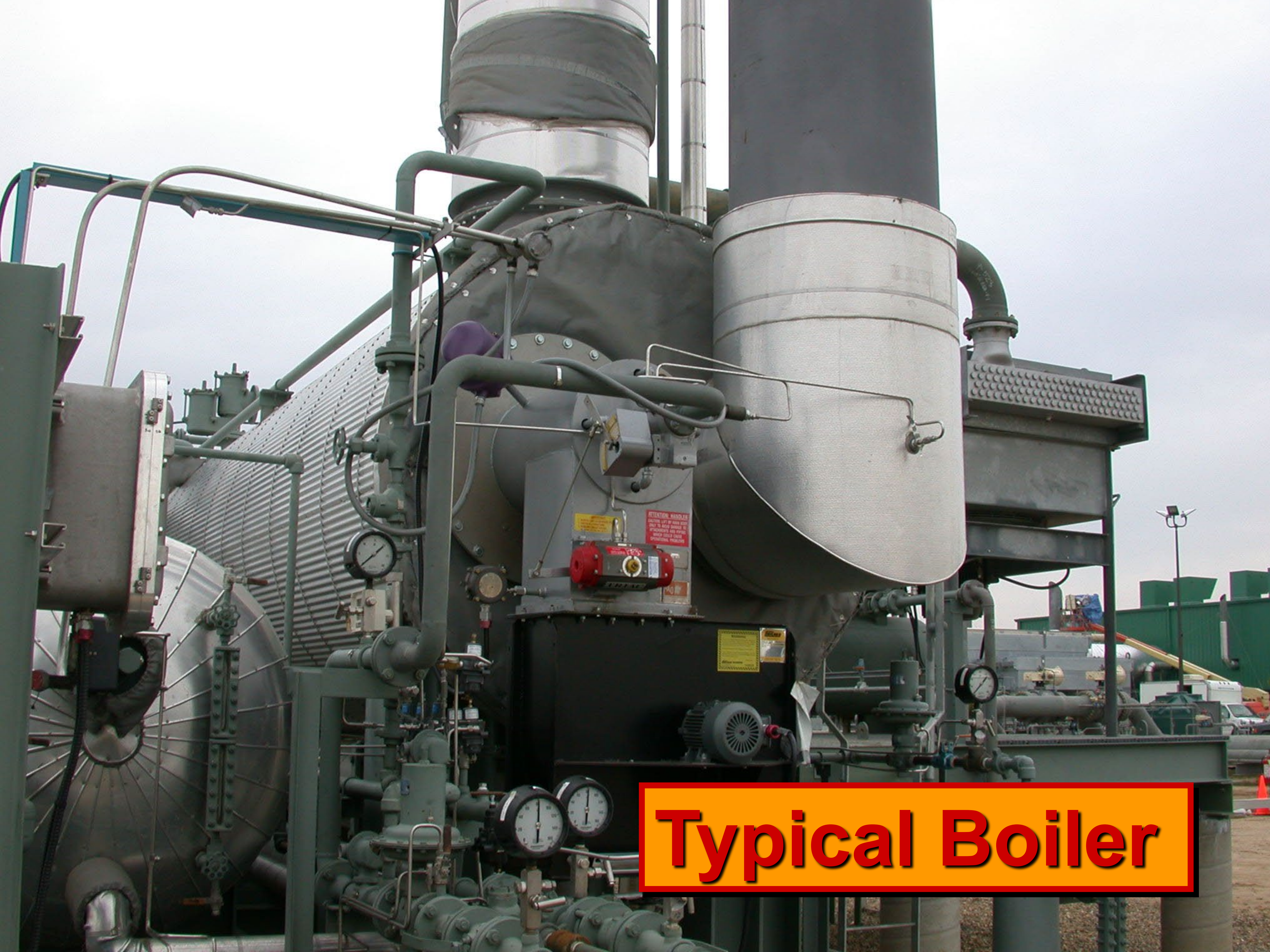
Primary Heat Exchanger

(with 2% leakage)

2% of 1000 ppm = 20 ppm

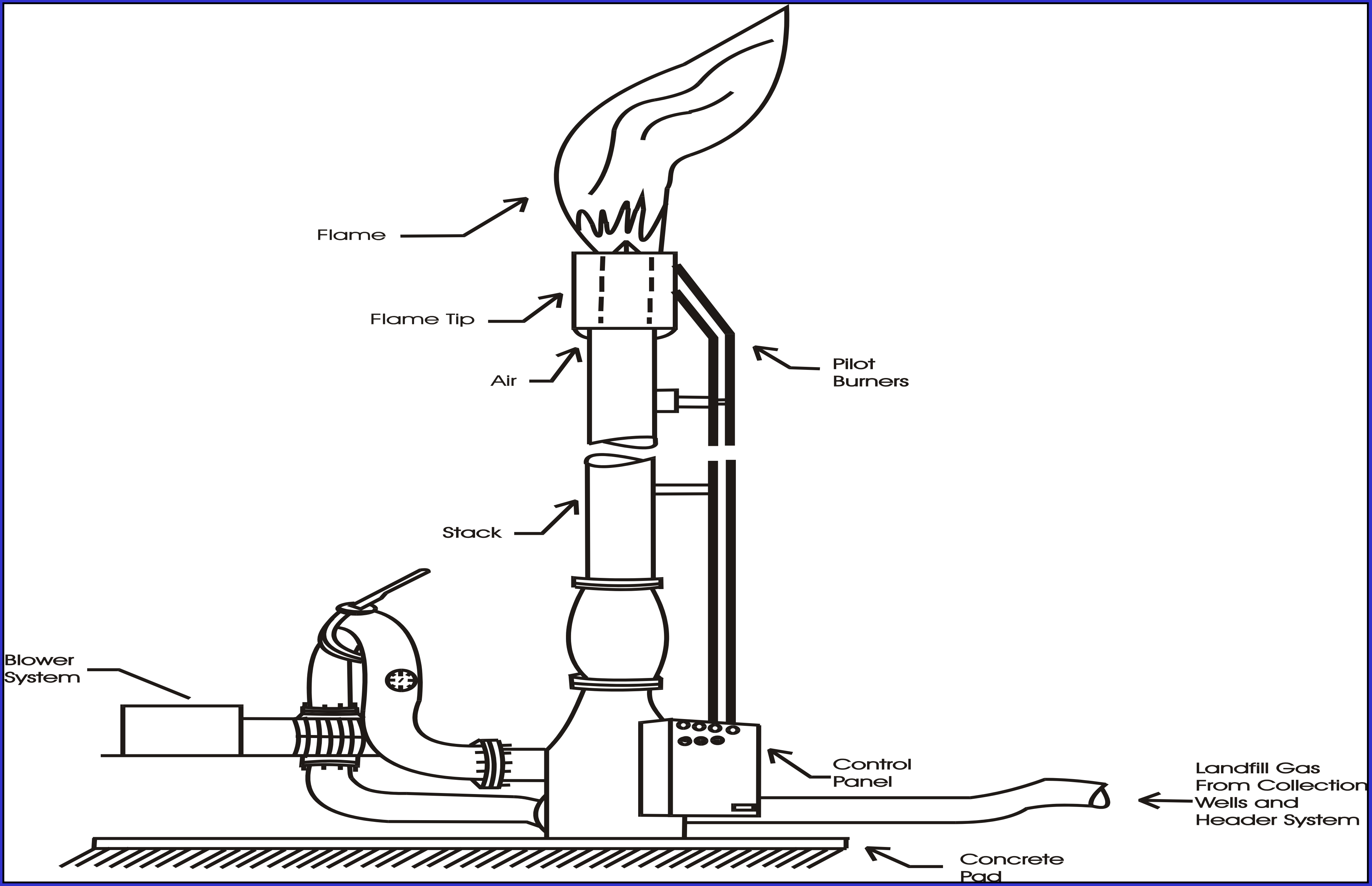
Boilers, Process Heaters & Flares

- Boilers make steam
- Process heaters add heat to material
- Flares are thermal incinerators without a combustion chamber

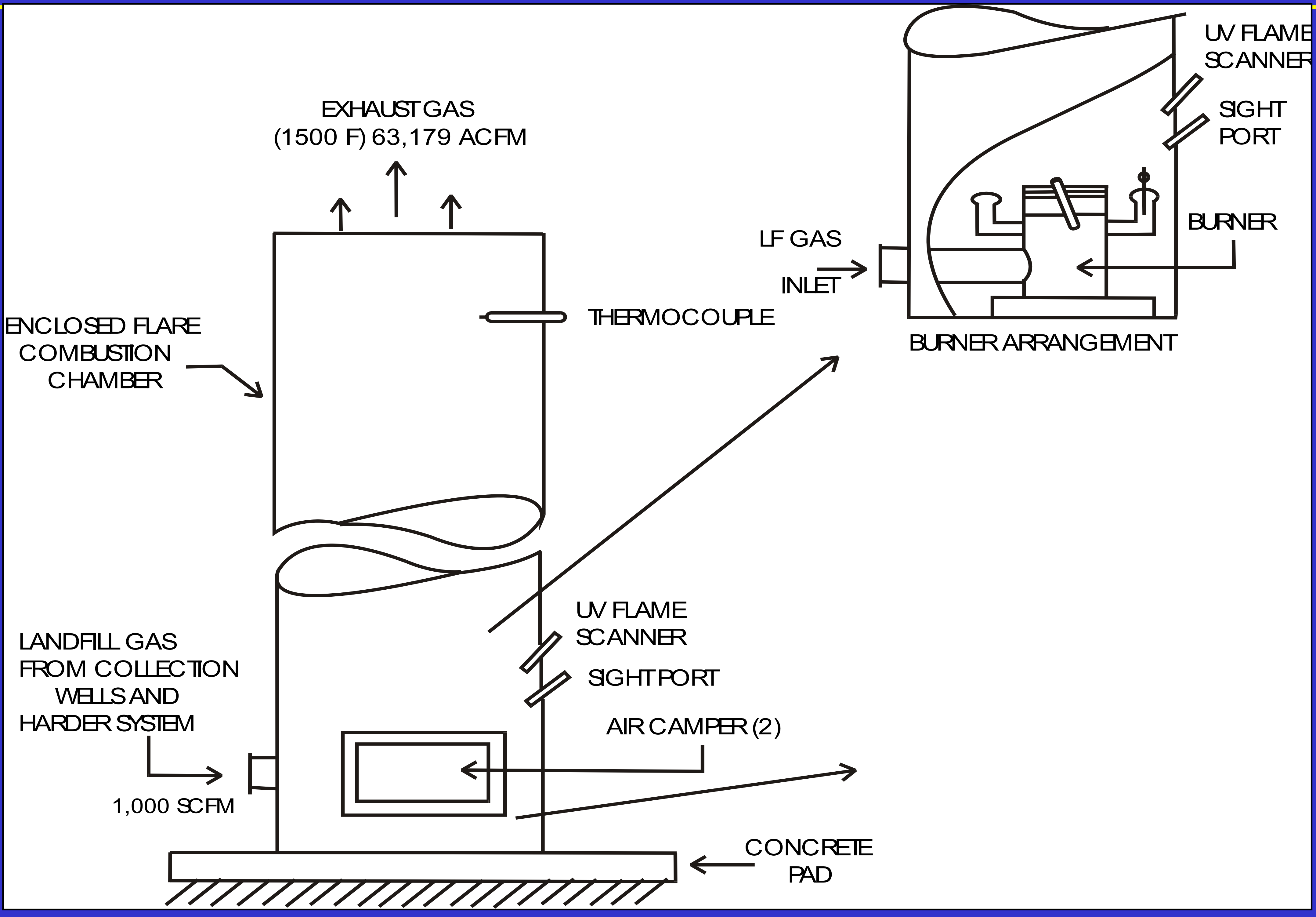

Typical Boiler


Let’s Discuss
Flares

Flare Types – Open or Elevated



Flare Types – Enclosed or Ground



Flares

Gasoline Marketing:

Bulk Terminal

Bluff Road Municipal
Solid Waste Landfill
Lincoln, NE

Waste Gas Collection & Flare

Shell Deer Park Refinery in Texas on the Houston Ship Channel.

Flaring gases from an oil platform.

Incinerator Inspection

- Look for
  - * Excessive corrosion and rust
  - * Holes in incinerator shell or ducts
  - * Visible emissions
  - * Excessive odors
  - * Last time catalyst was replaced

Incinerator Inspection

- Record
  - * VOC outlet concentration
  - * Incinerator inlet temperature
  - * Incinerator outlet temperature
  - * Pressure drop


VOC Control : Three-Way Catalyst

INSPECTIONS

Three Stages

- Pre-Inspection
  - * file review, rule review, inspection forms, copy of permit, safety equipment check
- Inspection
  - * facility safety indoctrination, pre-inspection meeting
- Post-Inspection Interview

Pre-Inspection Guidelines

- Regulation review
- Equipment check
- Pre-entry and entry
- Pre-inspection meeting
- Permit check

Pre-Inspection Meeting

- Facility name and ownership
- Address including city and zip
- Contact name and title
- Phone number including area code
- Production rate

Pre-Inspection Meeting

- Operating schedule
- Operation season
- Date of last source test
- Fuel usage and sulfur content

Inspection Report

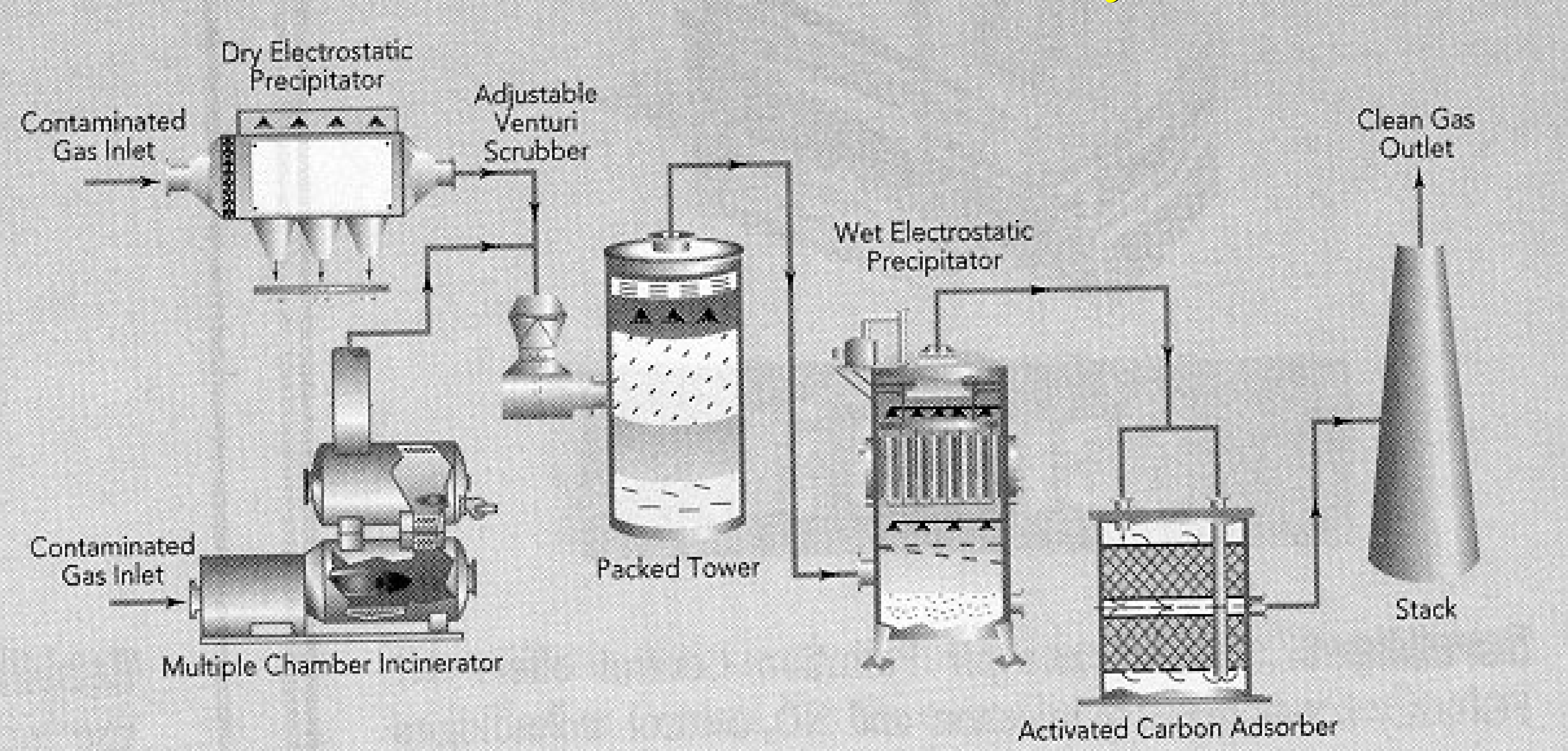
- Description of facility & processes
- Flowchart with equipment location & emission points
- Process diagram (materials handled, flow rates, temperatures, pressures)
- Statement as to compliance or non-compliance
- Enforcement action recommendation

Usage Records

- Review usage records
- Obtain necessary copies

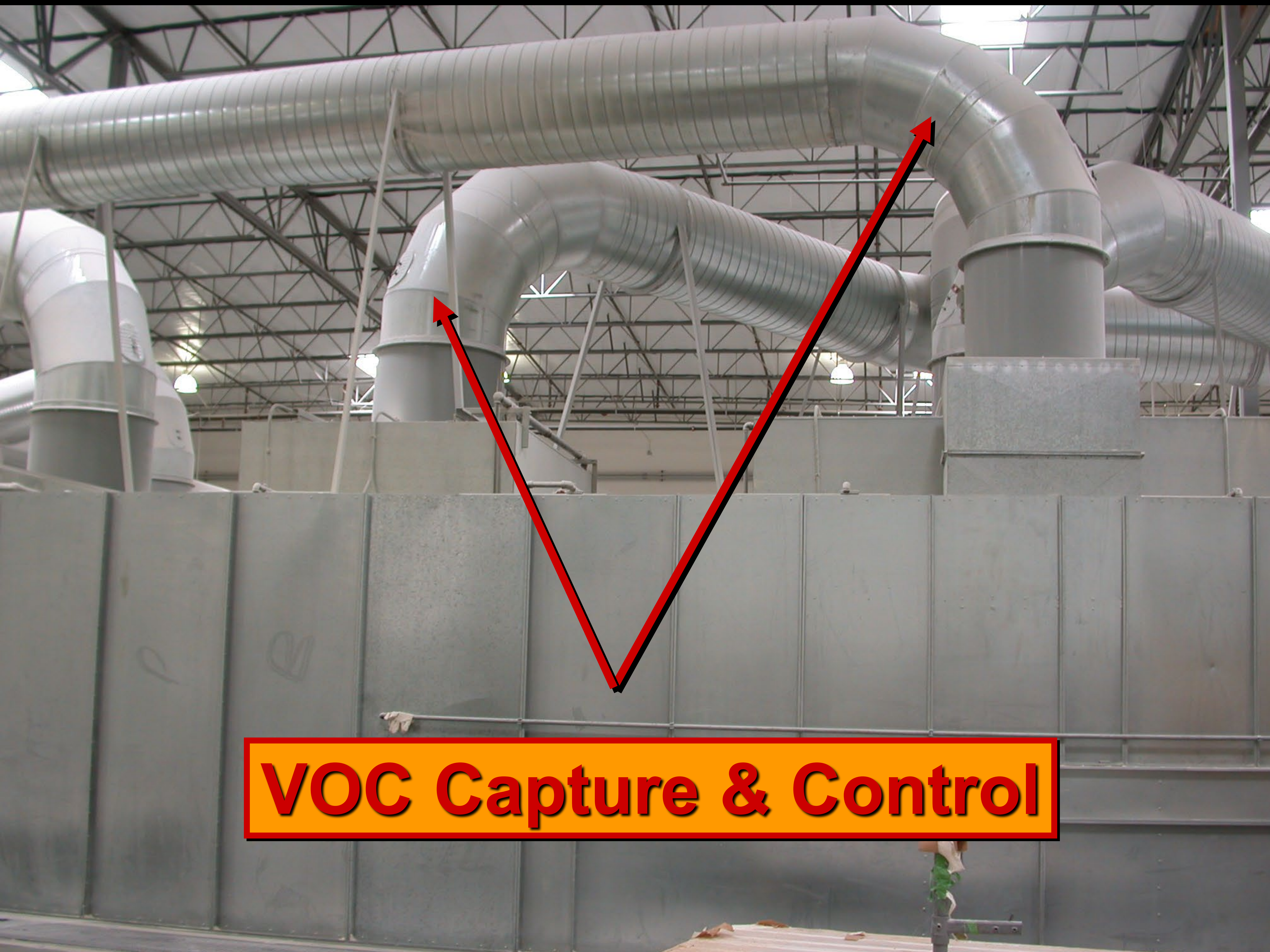
Six points of Inspection

Capture, Transport, Air Mover, Instrumentation, Control, Subsystem



Capture

- Are process emissions drawn into a control device at the point of release?
- Are they drawn into a collection device?


VOC Capture & Control

Transport

- Are the emissions moved to the control device without loss?
- Are there any leaks?

Air Mover

- Is the fan big enough for the job?
- Is it operating as designed and permitted?


Air Movers

Instrumentation

- Are the proper instruments present?
- Are they functioning?
- Are they calibrated regularly?
- Are they showing the proper units?

Instrumentation

Control Device

- Is it functioning?
- Are there any visible leaks?
- Can the device handle the job?

Subsystem

- What is the ultimate fate of captured or concentrated emissions?
- Pressure gauges for accuracy & change
- Fines system for leaks & proper discharge
- Motor for proper operation


The End