



Pharos University in Alexandria

**Faculty of Engineering
Department of Petrochemicals Engineering**

**Production of Biojet Fuel using Hydrodynamic Cavitation
Reactor**

**A Thesis submitted in partial fulfillment of the requirement for
the degree of Master of Science**

**In
Petrochemicals Engineering**

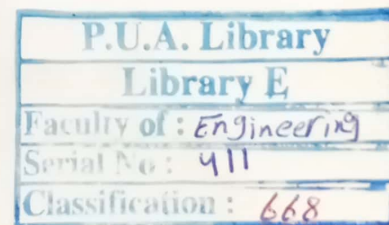
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**B. Sc. in Petrochemicals Engineering, Faculty of Engineering, Pharos
University, 2017**

2024



ACKNOWLEDGEMENT

First of all, thanks to **Allah** for help and strength offered to me during this work.

I wish to express my deepest gratitude to all those who assisted me to complete this work. First and foremost, my thanks are directed to **Prof. Abbas Anwar Ezzat** Professor of Petrochemicals Engineering Department, Faculty of Engineering, Pharos University in Alexandria, for his unlimited help and continuous insistence on perfection, without his constant supervision, this thesis could not have achieved its present form; I will never forget how co-operative he was.

I am greatly indebted to **Prof. Nour Shafik El-Gendy**, Professor of Petroleum and Environmental Biotechnology, Egyptian Petroleum Research Institute (EPRI) for fruitful suggestion and wise guidance created this thesis.

Many thanks and appreciation to **Dr. Aya Soliman Mohamed Moustafa** Lecturer, Petrochemicals Engineering Department, Faculty of Engineering, Pharos University in Alexandria, for her supervision and encouragement and for her kindness throughout the work.

Great thanks also extend to **Dr. Abdallah. R. Ismail** for their help during the period of practical work

I would like to thank **Dr. Hossam Anwar** for his help, continuous support and encouragement.

Great thanks also extend to **Eng. Daa El-Azizi** and **Eng. Ali El-Makawy** for their help during this thesis.

The author would like also to express her deepest appreciations to his family especially my **Father** my **Mother**, my **Brother**, and my **sister** for their support through the course of this research and for their encouraging and praying for me during all my studies.

ABSTRACT

Designing and implementing rotor-stator hydrodynamic cavitation reactor to produce biodiesel from castor oil as a first step to produce bio-jet. Response surface methodology based on one-factor-at-a-time design of experiments was employed for modelling and optimizing the biodiesel yield and the impact of the decrease in feedstock viscosity, density, and total acid number (TAN). The predicted optimum parameters of 8.15:1 M:O, 1499 rpm, 29.38 min, 48.43°C, and a KOH catalyst concentration of 0.74 wt.% resulted in a 96% biodiesel yield with a concomitant decrease in viscosity, density, and TAN of approximately 95%, 5.12%, and 90.02%, respectively. According to the results of the kinetic calculations, the reaction is pseudo-second order, with the activation energy, frequency factor, and reaction rate constant being $0.23 \text{ M}^{-1}\text{min}^{-1}$, 18.77 kJ/mol, and $6.32 \text{ M}^{-1}\text{min}^{-1}$, respectively. By designing and implementing the modified Teflon rotor-stator hydrodynamic cavitation reactor in order to model and optimize the biodiesel yield, response surface methodology based on $1/2$ fraction-three-levels face center composite design of three levels-five experimental factors was used. The predicted ideal operating parameters were found to be 52.51°C, 1164.8 rpm rotor speed, 27.43 min, 8.4:1 methanol to oil molar ratio, and 0.89% KOH concentration. That yielded 95.51% biodiesel of 99% fatty acid methyl ester content, with a relatively low energy consumption and high cavitation yield of $6.09 \times 10^5 \text{ J}$ and $12 \times 10^{-3} \text{ g/J}$, respectively. The fuel properties of the produced biodiesel and bio-petro-diesel blends were good, comparable to international standards and the marketed Egyptian petro-diesel.