



ARTICLE INFO

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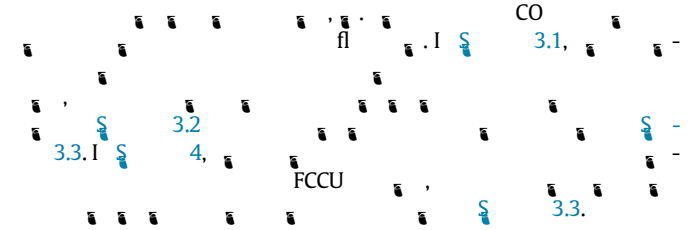
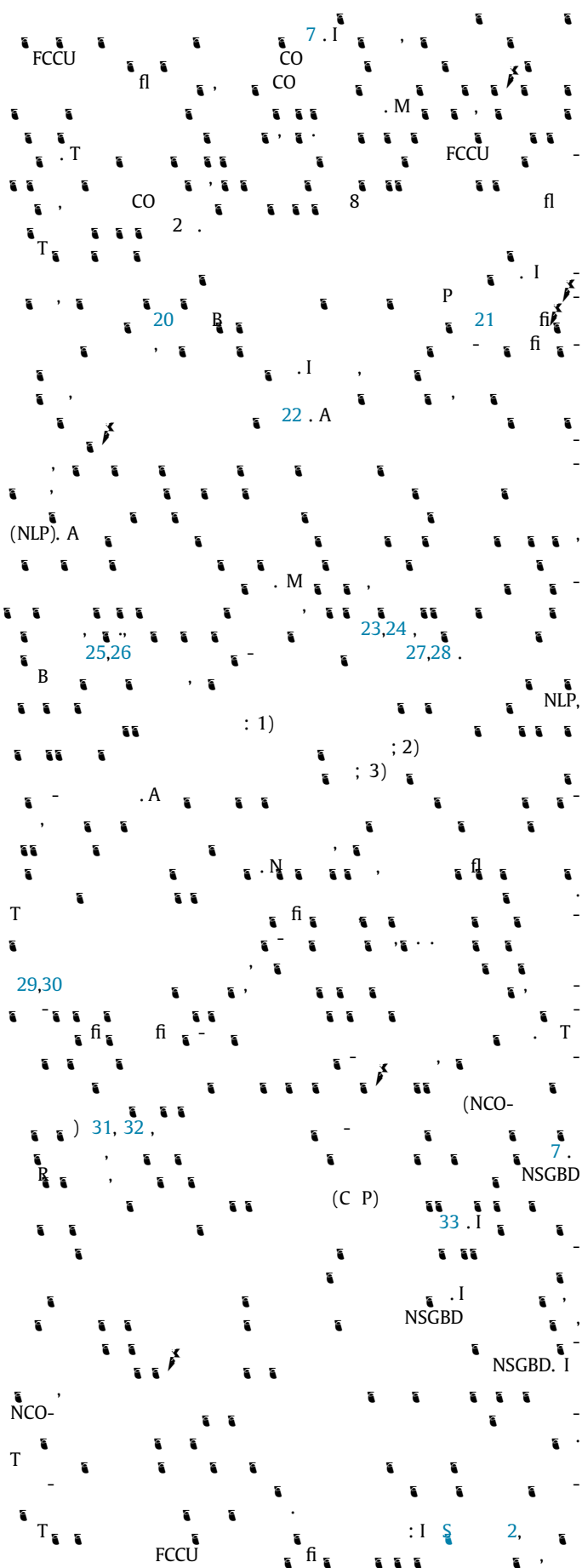
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ABSTRACT

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1. Introduction

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### 2. Batch properties of FCCU

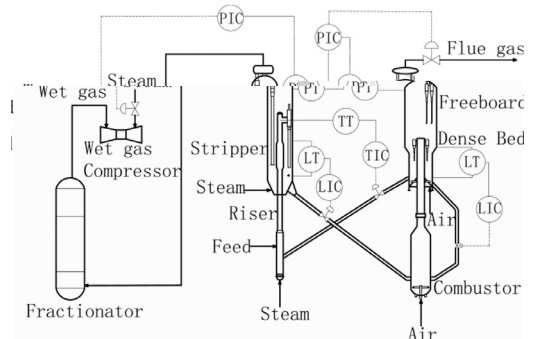
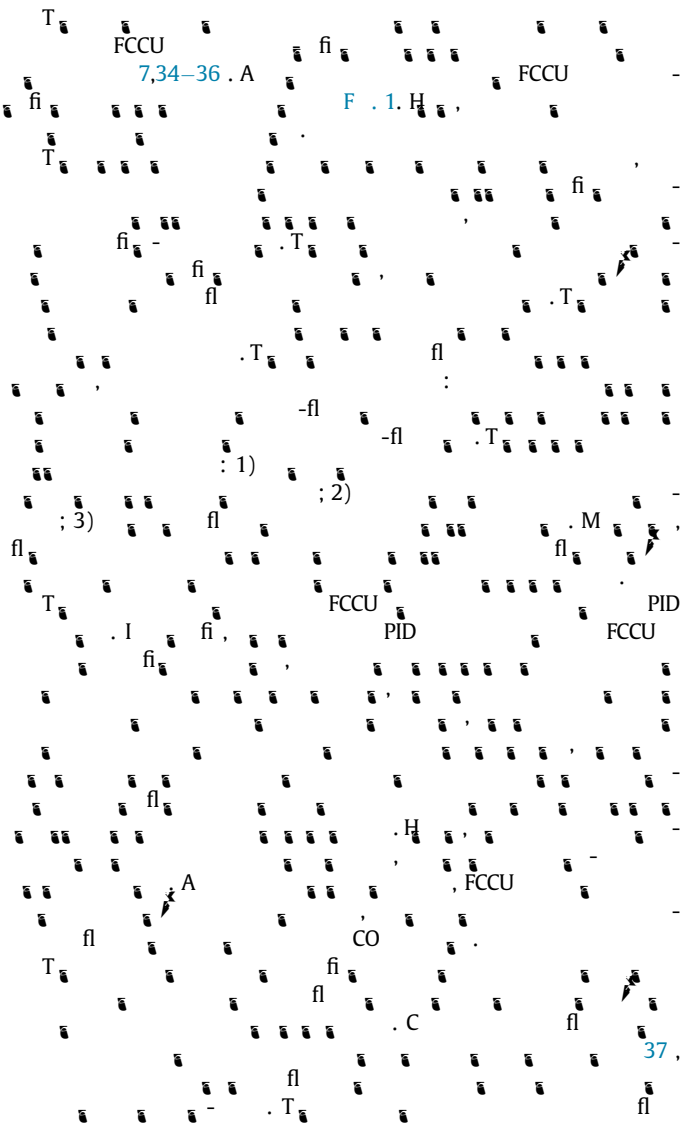
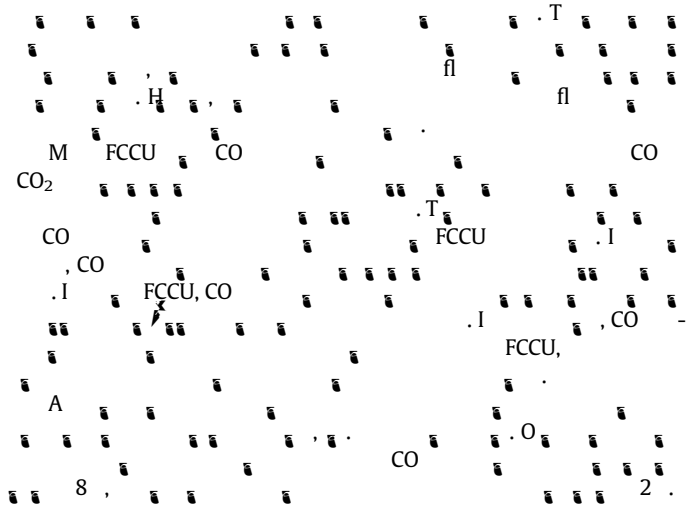


Fig. 1. Schematic diagram of the FCCU process.



**3. Hybrid parametric dynamic optimization**

**3.1. Mathematical formulation of hybrid parametric dynamic optimization**

$$\begin{aligned} & \dot{\mathbf{x}}_d = \mathbf{f}_d(t, \mathbf{x}_d(t), \mathbf{x}_a(t), \mathbf{u}(t), \bar{\mathbf{u}}) \\ & \mathbf{0} = \mathbf{f}_a(t, \mathbf{x}_d(t), \mathbf{x}_a(t), \mathbf{u}(t), \bar{\mathbf{u}}) \end{aligned} \quad (1)$$

$$\mathbf{x}_d(t) \in R^{n_d} / \mathbf{x}_a(t) \in R^{n_a} ; \mathbf{u}(t) / \bar{\mathbf{u}} \quad (2)$$

$$J(\mathbf{u}(t), \bar{\mathbf{u}}) = \int_{t_0}^{t_f} (-r(t, \mathbf{x}_d(t), \mathbf{x}_a(t), \mathbf{u}, \bar{\mathbf{u}}) + c_1(t, \mathbf{x}_d(t), \mathbf{x}_a(t), \mathbf{u}, \bar{\mathbf{u}})) dt + c_2(\bar{\mathbf{u}}) \quad (3)$$

$$\tilde{\mathbf{x}} = -r + c_1 \quad (4)$$

$$\tilde{\mathbf{x}}(t_0) = 0 \quad (5)$$

$$\mathbf{u}(t), \bar{\mathbf{u}} J(\mathbf{x}(t_f), \bar{\mathbf{u}}) = \tilde{\mathbf{x}}(t_f) + c_2(\bar{\mathbf{u}}) \quad (6)$$

$$\mathbf{x}(t) = (\mathbf{x}_d(t)^T, \mathbf{x}_a(t)^T)^T \quad (7)$$

$$\mathbf{x}^{lb} \leq \mathbf{x}(t) \leq \mathbf{x}^{ub} \quad (8)$$

$$\mathbf{u}^{lb} \leq \mathbf{u}(t) \leq \mathbf{u}^{ub} \quad (9)$$

$$\mathbf{x}^{lb} = ((x_d^{lb})^T, (x_a^{lb})^T)^T, \mathbf{x}^{ub} = ((x_d^{ub})^T, (x_a^{ub})^T)^T, \mathbf{x}_d^{lb}, \mathbf{x}_d^{ub}, \mathbf{x}_a^{lb}, \mathbf{x}_a^{ub} \quad (10)$$

$$\bar{\mathbf{u}}^{lb} \leq \bar{\mathbf{u}} \leq \bar{\mathbf{u}}^{ub} \quad (11)$$

$$\mathbf{x}^{lb} \leq \mathbf{x}(t_f) \leq \mathbf{x}^{ub} \quad (12)$$

$$\mathbf{x}^{flb} = ((x_d^{flb})^T, (x_a^{flb})^T)^T, \mathbf{x}^{fub} = ((x_d^{fub})^T, (x_a^{fub})^T)^T, \mathbf{x}_d^{flb}, \mathbf{x}_d^{fub}, \mathbf{x}_a^{flb}, \mathbf{x}_a^{fub} \quad (13)$$

$$\bar{\mathbf{u}} \quad (14)$$

$$\mathbf{u}(t) \quad (15)$$

$$\mathbf{E} \cdot (5), \quad (16)$$

$$\mathbf{E} \cdot (1), (6), (7) \quad (17)$$

$$\mathbf{P} \quad (18)$$

$$\mathbf{G}_{\bar{\mathbf{u}}}(\bar{\mathbf{u}}) \leq 0 \quad (19)$$

$$\mathbf{G}_{\mathbf{u}}(\mathbf{u}(t)) \leq 0 \quad (20)$$

$$\mathbf{G}_{\mathbf{p}}(\mathbf{x}(t)) \leq 0 \quad (21)$$

$$\mathbf{G}_{\mathbf{e}}(\mathbf{x}(t_f)) \leq 0 \quad (22)$$

$$\mathbf{G}_{\bar{\mathbf{u}}}(\bar{\mathbf{u}}) = \begin{pmatrix} \bar{\mathbf{u}} - \bar{\mathbf{u}}^{ub} \\ \bar{\mathbf{u}}^{lb} - \bar{\mathbf{u}} \end{pmatrix} \quad (23)$$

$$\mathbf{G}_{\mathbf{u}}(\mathbf{u}(t)) = \begin{pmatrix} \mathbf{u}(t) - \mathbf{u}^{ub} \\ \mathbf{u}^{lb} - \mathbf{u}(t) \end{pmatrix} \quad (24)$$

$$\mathbf{G}_{\mathbf{p}}(\mathbf{x}(t)) = \begin{pmatrix} \mathbf{x}(t) - \mathbf{x}^{ub} \\ \mathbf{x}^{lb} - \mathbf{x}(t) \end{pmatrix} \quad (25)$$

$$\mathbf{G}_{\mathbf{e}}(\mathbf{x}(t_f)) = \begin{pmatrix} \mathbf{x}(t_f) - \mathbf{x}^{fub} \\ \mathbf{x}^{flb} - \mathbf{x}(t_f) \end{pmatrix} \quad (26)$$

$$\mathbf{A} \quad (27)$$

$$\mathbf{NLP} \quad (28)$$

$$u(t) \in D, \quad u(t) \approx \hat{u}^N(t) = \sum_{i=1}^N u_i^N \phi_i^N(t) \quad (10)$$

$$D^N = \{ \phi_1^N(t), \phi_2^N(t), \dots, \phi_N^N(t) \}, \quad u_i^N \in U, \quad u(t) \in D$$

$$\phi_i^N(t) \cap \phi_j^N(t) = 0 \quad \forall i \neq j, \quad \langle \phi_i^N(t), \phi_j^N(t) \rangle = 0 \quad \forall i \neq j, \quad D_N, F$$

$$N \geq 1, \quad t_0 < t_1 < t_2 < \dots < t_N = t_f$$

$$\phi_i^N(t) = \begin{cases} 1, & t_{i-1} \leq t \leq t_i \\ 0, & \text{otherwise} \end{cases} \quad (11)$$

$$\hat{u}_N = ((u_1^N)^T, \dots, (u_N^N)^T)^T$$

$$y^j = \int_0^t f^j(0, y(t) - y^{ub}, y^{lb}) dt$$

$$y^l(t) = y^u(t) - (y^{lb} - y(t))$$

$$y^l(t_0) = 0, \quad y^u(t_0) = 0, \quad y^l(t_f) = 0, \quad y^u(t_f) = 0$$

**Problem (P2):**

$$\hat{u}_N, \bar{u} J(x(t_f), \bar{u}) \quad (12)$$

$$MX(t_0) = X_0 \quad (12)$$

$$M\dot{X}(t) = F(t, X(t), \hat{u}_N, \bar{u}) \quad (12)$$

$$G(\bar{u}, \hat{u}_N, X(t_f)) \leq 0 \quad (12)$$

$$M = \begin{pmatrix} 1, \dots, 1, 0, \dots, 0 \\ 3n_d + 2n_a & n_a \end{pmatrix} \quad (12)$$

$$X(t) = \begin{pmatrix} x_d(t) \\ x^b(t) \\ x_a(t) \end{pmatrix} \quad (12)$$

$$X_0 = \begin{pmatrix} x_d^0 \\ 0 \\ 0 \end{pmatrix} \quad (12)$$

$$F(t, X(t), \hat{u}_N, \bar{u}) = \begin{pmatrix} f_d(t, x_d(t), x_a(t), \hat{u}_N, \bar{u}^j) \\ f_b(t, x(t)) \\ f_a(t, x_d(t), x_a(t), \hat{u}_N, \bar{u}^j) \end{pmatrix} \quad (12)$$

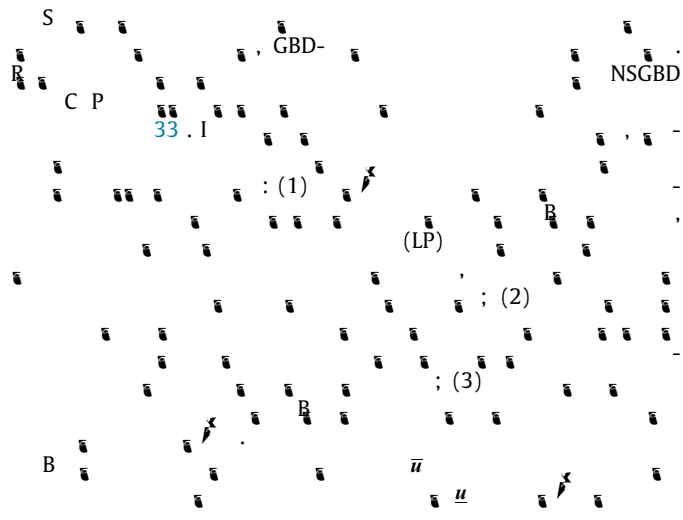
$$f_b(t, x(t)) = \begin{pmatrix} f^x(0, x^{lb} - x(t)) \\ f^x(0, x(t) - x^{ub}) \end{pmatrix} \quad (12)$$

$$G(\bar{u}, \hat{u}_N, X(t_f)) = \begin{pmatrix} G_u(\bar{u}) \\ G'_u(\hat{u}_N) \\ G'_e(x^b(t_f)) \\ G_e(x(t_f)) \end{pmatrix} \quad (12)$$

$$G'_u(\hat{u}_N) = \begin{pmatrix} G_u(u_1^N) \\ \vdots \\ G_u(u_N^N) \end{pmatrix} \quad (12)$$

$$G'_e(x^b(t_f)) = x^b(t_f) \quad (12)$$

3.2. Nonconvex sensitivity-based generalized Benders decomposition



$$h(\bar{u}, u) = u - \bar{u} = 0 \quad (13)$$

**Problem (P3):**

$$(\hat{u}_{N,a}^j, \bar{u}_a^j) = \hat{u}_N J(x(t_f), \bar{u}_a^j) \quad (14)$$

$$MX(t_0) = X_0 \quad (14)$$

$$M\dot{X}(t) = F(t, X(t), \hat{u}_N, \bar{u}^j) \quad (14)$$

$$G(\bar{u}_a^j, \hat{u}_N, X(t_f)) \leq 0 \quad (14)$$

**Problem (P4):**

$$(\hat{u}_{N,b}^j, \bar{u}_b^j, \mu_a^j) = \hat{u}_N J(x(t_f), \bar{u}) \quad (15)$$

$$MX(t_0) = X_0 \quad (15)$$

$$M\dot{X}(t) = F(t, X(t), \hat{u}_N, \bar{u}) \quad (15)$$

$$G(\bar{u}, \hat{u}_N, X(t_f)) \leq 0 \quad (15)$$

$$h(\bar{u}, \bar{u}_a^j) = 0 \quad (15)$$

$$\mu_a^j \quad (15)$$

**Problem (P5):**

$$(\hat{u}_{N,c}^j, \hat{u}_c^j) = \min_{\hat{u}_N, \bar{u}} \|\bar{u} - \hat{u}_t^j\|_A^2 \quad (16)$$

$$MX(t_0) = X_0 \quad (16)$$

$$M\dot{X}(t) = F(t, X(t), \hat{u}_N, \bar{u}) \quad (16)$$

$$G(\bar{u}, \hat{u}_N, X(t_f)) \leq 0 \quad (16)$$

$$\|\bar{u} - \hat{u}^j\|_A^2 = (\bar{u} - \hat{u}^j)^T A (\bar{u} - \hat{u}^j) \quad (16)$$

**Problem (P6):**

$$(\alpha_d^j, \hat{u}_{N,d}^j, \hat{u}_d^j | \mu_b^j) = \min_{\alpha, \hat{u}_N, \bar{u}} \alpha \quad (17)$$

$$MX(t_0) = X_0 \quad (17)$$

$$M\dot{X}(t) = F(t, X(t), \hat{u}_N, \bar{u}) \quad (17)$$

$$G(\bar{u}, \hat{u}_N, X(t_f)) - \alpha \leq 0 \quad (17)$$

$$h(\bar{u}, \hat{u}_c^j) = 0 \quad (17)$$

$$\mu_b^j \cdot (\underline{u} - \bar{u}^{ub}) \leq 0, i \in K_u \quad (17)$$

$$\mu_c^i \cdot (\underline{u} - \bar{u}^{ub}) \leq 0, i \in K_u \quad (18)$$

$$\mu_d^i \cdot (\underline{u} - \bar{u}^{ub}) \leq 0, i \in K_l \quad (18)$$

$$\mu_c^i = (0, \dots, 0, 1, 0, \dots, 0) \quad \mu_d^i = (0, \dots, 0, -1, 0, \dots, 0) \quad (17)$$

**Problem (P7):**

$$(\eta_b^k, \underline{u}_b^k | \nu_a^k, \nu_b^k, \nu_c^k, \nu_d^k) = \min_{\underline{u}} \eta \quad (19)$$

$$\eta \geq J_a^j + \mu_a^j \cdot (\underline{u} - \bar{u}_a^j), j \in K_{feas} \quad (19)$$

$$\mu_b^j \cdot (\underline{u} - \bar{u}_c^j) \leq 0, j' \in K_{infeas} \quad (19)$$

$$\mu_c^i \cdot (\underline{u} - \bar{u}^{ub}) \leq 0, i \in K_u \quad (19)$$

$$\mu_d^i \cdot (\underline{u} - \bar{u}^{ub}) \leq 0, i \in K_l \quad (19)$$

$$K_u = \{i \in \{1, \dots, n\} : \nu_c^i \neq 0\} \quad K_l = \{i \in \{1, \dots, n\} : \nu_d^i \neq 0\} \quad (20)$$

$$\Xi_a = \{j \in \{1, \dots, m\} : \nu_a^j \neq 0\} \quad (20)$$

$$\Xi_b = \{j' \in \{1, \dots, m\} : \nu_b^{j'} \neq 0\} \quad (20)$$

$$\Xi_c = \{i \in \{1, \dots, n\} : \nu_c^i \neq 0\} \quad (20)$$

$$\Xi_d = \{i' \in \{1, \dots, n\} : \nu_d^{i'} \neq 0\} \quad (20)$$

**Problem (P8):**

$$(\underline{u}_c^k) = \min_{\underline{u}} \mu_a^k \cdot \underline{u} \quad (21)$$

$$\mu_b^j \cdot (\underline{u} - \bar{u}_c^j) \leq 0, j' \in K_{infeas} \quad (21)$$

$$\mu_c^i \cdot (\underline{u} - \bar{u}_i) \leq 0, i \in K_u \quad (21)$$

$$\mu_d^i \cdot (\underline{u} - \bar{u}_i) \leq 0, i' \in K_l \quad (21)$$

$$LBD > UBD \quad (22)$$

$$UBD - LBD < \varepsilon_1 \quad (22)$$

$$\|\mu_a^k / J_a^k\|_B \leq \varepsilon_2 \quad (23)$$

$$\|\underline{u}_b^k - \underline{u}_c^k\|_B \leq \varepsilon_3 \quad (23)$$

**Algorithm 1: NSGBD with CVP for Problem (P1)**

**Step 1.**  $t_0, t_f, t_0 < t_1 < t_2 < \dots < t_N = t_f$

**E . (7);**  $j = 1, j' = 1, K_{feas} = \emptyset, K_{infeas} = \emptyset, LBD = -\infty;$   
 $\gamma, \varepsilon_1, \varepsilon_2, \varepsilon_3.$

**Step 2.**  $S$  (P3)  $\bar{u}_a^j = \bar{u}_t^j, O$

(1) P (P4)  $\underline{u}_a^j = \bar{u}_a^j, \hat{u}_{N,a}^j, \mu_a^j, UBD = J_a^j; O$

(a)  $LBD > UBD, \mu_a^l = \gamma \mu_a^l, l \in \Xi_a.$

(b)  $|\Xi_b| + |\Xi_c| + |\Xi_d| = 0 (\bar{u}_a^j)$ . I E . (23)

(P8)  $\bar{u}_a^j, \underline{u}_c^j, I E . (23)$

(2)  $O$

$K_{feas} = \{K_{feas}, j\}; j = j + 1.$

(2) P (P3)  $S$  (P5)  $\bar{u}_t^j$

$(\hat{u}_{N,c}^j, \hat{u}_c^j), S$  (P6)  $\bar{u}_c^j (\hat{u}_{N,c}^j, \hat{u}_c^j) \alpha = 0$

$\mu_b^j \cdot K_{infeas} = K_{infeas}, j' = j' + 1, R$  (P7)  $\eta_b^j, \underline{u}_b^j, \nu_a^j, \nu_b^j, \nu_c^j, \nu_d^j;$

$LBD = \eta_b^j, \bar{u}_t^j = \underline{u}_b^j, R$  (P7)  $S$  2.

**Remark 1.** T (P4) NSGBD 13 F . 2.

P (P3) (P4) P (P3)  $\mu_a^k, \bar{u}_a^j$

(P5)  $\mu_b^j, \bar{u}_c^j$  (P6)  $\bar{u}_t^j$  (P5) (P6)

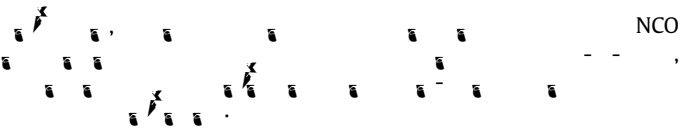
$\alpha = 0, P$  (P7) LP  $\Xi_a$  (P5)

$\gamma, LBD, \Xi_b, \Xi_c, \Xi_d$

$K_{infeas}, K_u, K_l$ ,  
 E . (22 )  
 LBD,  
 E . (23 ) (23 )  
 P (P8)  
 E . (23 ),  
 T NSGBD  
 S<sub>2</sub> A 1.  
**Remark 2.** T NSGBD  
 : 1)  $\mu_a^j$  ( )  
 38 13  $\bar{u}; 2)$   
 NSGBD, .

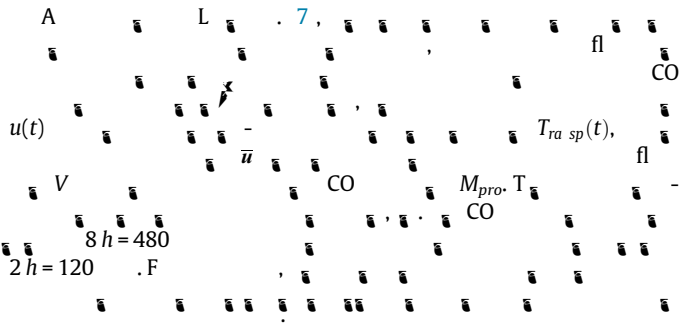
### 3.3. Novel implementation framework of optimal solution

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 T ,  
 T -

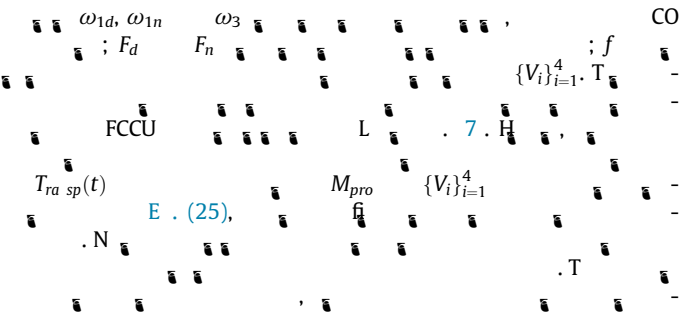


#### 4. Hybrid parametric dynamic optimization of FCCU

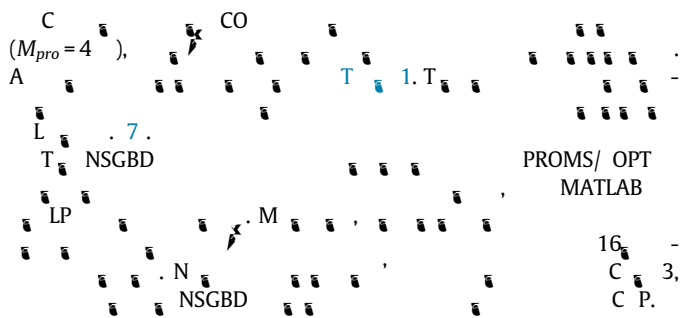
##### 4.1. Mathematical formulation of FCCU



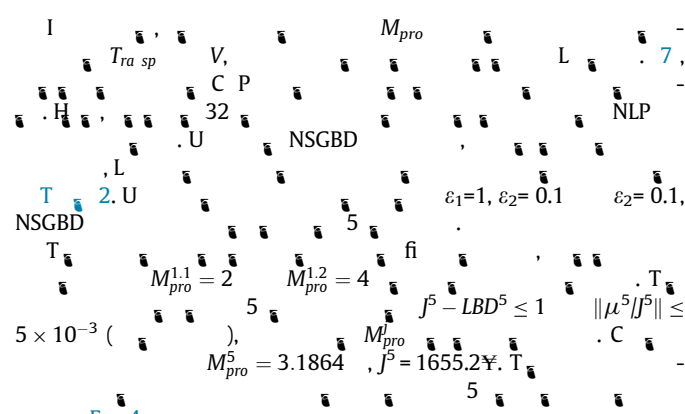
$$J(T_{ra\ sp}(t), \{V_i\}_{i=1}^4, M_{pro}) = \int_0^{480} (-\omega_{1d} F_d(t, T_{ra\ sp}(t), \{V_i\}_{i=1}^4, M_{pro}) - \omega_{1n} F_n(t, T_{ra\ sp}(t), \{V_i\}_{i=1}^4, M_{pro})) dt + \sum_{i=1}^4 \int_{120(i-1)}^{120i} f(V_i) dt + \omega_3 M_{pro} \quad (25)$$



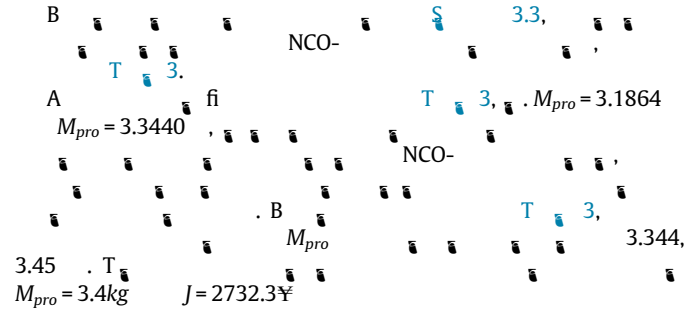
$$J(T_{ra\ sp}(t), V(t), M_{pro}) = \int_0^{480} (-\omega_{1d} F_d(t, T_{ra\ sp}(t), V(t), M_{pro}) - \omega_{1n} F_n(t, T_{ra\ sp}(t), V(t), M_{pro}) + f(V(t))) dt + \omega_3 M_{pro} \quad (26)$$



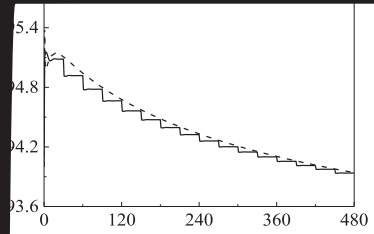
##### 4.2. Case 1: Combustion air as a continuous operation whereas CO promoter as a batch operation



$$M_{pro}^{1,1} = 2, M_{pro}^{1,2} = 4, M_{pro}^3 = 3.1864, J^5 = 1655.2\$, \|\mu^5/J^5\| \leq 5 \times 10^{-3}, \epsilon_1 = 1, \epsilon_2 = 0.1, \epsilon_3 = 0.1$$



Riser Temperature



NSGBD  
 NSGBD.A  
 C P  
 fi  
 14  
 43  
 5  
 32  
 (21),  
 NLP  
 C P  
 (16)  
 NSGBD.  
 fi

4.3. Case 2: Combustion air and CO promoter as batch operations

I  
 C  
 T  
 L  
 T  
 0.1, NSGBD  
 T  
 1, 4  
 1.2  
 T  
 1.3  
 1.4  
 16  
 L  
 4,  
 5,  
 T  
 6.U  
 2<sup>3</sup>=32  
 (2, 48, 48, 48, 48)  
 10  
 1, 2, 3  
 4. A  
 T  
 1.1  
 (4, 48, 48, 48, 48)  
 (2, 50, 50, 50, 50)  
 (4, 50, 50, 50, 50)  
 NLP  
 ε<sub>1</sub>=1, ε<sub>2</sub>=0.1 ε<sub>3</sub>=

B  
 . A  
 2.1,  
 , 2  
 (4, 50, 48, 48, 48)  
 2.2  
 2.3. T  
 . B  
 A  
 3.1  
 4.1,  
 4.4,  
 5  
 8,  
 . LBD > UBD,  
 . F  
 1.2  
 4.2 ( T 6),  
 8,  
 V<sub>1</sub><sup>10</sup>, V<sub>2</sub><sup>10</sup>, V<sub>3</sub><sup>10</sup>, V<sub>4</sub><sup>10</sup>)  
 NSGBD : M<sub>pro</sub><sup>10</sup> = 3.3223  
 V<sub>2</sub><sup>10</sup> = 48.981  
 V<sub>3</sub><sup>10</sup> = 48.931  
 J<sub>1</sub><sup>10</sup> = 1279.8¥,  
 A  
 H  
 NCO-  
 P = {k ∈ N : μ<sub>M</sub><sup>k</sup> > 0}, {N<sub>i</sub> = {k ∈ N : μ<sub>V<sub>i</sub></sub><sup>k</sup> < 0}}<sub>i=1</sub><sup>4</sup>. A μ<sub>M</sub> {μ<sub>V<sub>i</sub></sub>}<sub>i=1</sub><sup>4</sup>



**Table 4**

$I_k$	4.4	5	6	7	8	9	10
$M_{pro}$	2.5865	2.4590	2.7855	2.8738	2.8890	3.2639	3.3223
$\mu_M$	8.9744	-21.541	27.047	25.754	20.927	53.115	58.887
$V_1$ (3/)	49.034	49.061	49.064	49.064	49.065	49.068	49.068
$\mu_{V1}$	-3480.3	-3515.4	-3471.9	-3479.8	-3490.8	-3480.0	-3468.3
$V_2$ (3/)	48.952	48.977	48.978	48.979	48.979	48.980	48.981
$\mu_{V2}$	-3456.5	-3462.7	-3447.1	-3476.1	-3461.9	-3428.1	-3434.2
$V$							

$$M_{pro}^* \in (M_{pro}^k, M_{pro}^{10}) = (2.5865, 3.3223) \quad (28)$$

$$V_1^* \in (V_1^{10}, V_1^k) = (49.068, 49.072) \quad (28)$$

$$V_2^* \in (V_2^{10}, V_2^k) = (48.981, 48.983) \quad (28)$$

$$V_3^* \in (V_3^{10}, V_3^k) = (48.931, 48.932) \quad (28)$$

$$V_4^* \in (V_4^{10}, V_4^k) = (48.896, 48.897) \quad (28)$$

$(M_{pro}^{10}, V_1^{10}, V_2^{10}, V_3^{10}, V_4^{10})$ ,  $M_{pro} \in (3.3223, 3.3223)$ ,  $V_1 \in (49.076, 49.080)$  3/,  $V_2 \in (48.988, 48.992)$  3/,  $V_3 \in (48.938, 48.942)$  3/,  $V_4 \in (48.904, 48.908)$  3/. T.  $M_{pro} = 3.3223$ ,  $V_1 = 49.078$  3/,  $V_2 = 48.990$  3/,  $V_3 = 48.940$  3/,  $V_4 = 48.906$  3/ J=1890.4¥, NCO- F .5.A

F .5, NCO- T. 2 0.5 F .5). 8, fi ( M F C 3 4, NCO- T 8.C C 2 1 4 3, T



15 F, L, S, G. A. FCCU I. A. *fi* FCC *fi* .A P S (P  
P S ) 1994;10(2):21–8.

16 F, L, S, G. A. FCCU II. M. *fi* .A  
*fi* FCC .A P S (P P S ) 1994;10(3):25–35.

17 L, F, H, C, S, H, J. A. FCC *fi* -  
1993;24(9):1–8.

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