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It is smart to benchmark a new plant design against an existing plant or pilot plant. Raw materials are typically the largest contributor to overall variable costs. For bulk chemicals and petrochemicals, raw

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materials represent 80-90% of the total cash cost of production (CCOP).

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By Robin Cook

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engineering design of

new chemical and

petrochemical plants

and the expansion or

revision of existing

ones require the use

of engineering

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Estimation of
production cost and
revenue -

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A rough rule of thumb
for the chemical
industry is that \$1 of
annual sales requires
\$2 of fixed-capital
investment. In a
chemical processing
plant where this rule
applies, the total
capital investment is

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\$2,500,000, and the working capital is 20 percent of the total capital investment. The annual total product cost amounts to \$1,500,000.

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, then editor of
Chemical and
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Engineering, served as chairman and was joined subsequently by S. D. Kirkpatrick as consulting editor.

After several meetings, this committee submitted its report to the McGraw-Hill Book Company in September

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