

**METHOD AND SYSTEM OF DEHYDRATING A FEED STREAM PROCESSED IN
A DISTILLATION TOWER**

CROSS REFERENCE TO RELATED APPLICATIONS

5 **[0001]** This application claims the priority benefit of United States patent application number 61/912,970 filed December 6, 2013 entitled METHOD AND SYSTEM OF DEHYDRATING A FEED STREAM PROCESSED IN A DISTILLATION TOWER, the entirety of which is incorporated by reference herein.

10 **[0002]** This application is related to but does not claim priority to U.S. Provisional patent application numbers: 61/912,957 filed December 6, 2013 entitled METHOD AND DEVICE FOR SEPARATING HYDROCARBONS AND CONTAMINANTS WITH A SPRAY ASSEMBLY; 62/044,770 filed September 2, 2014 entitled METHOD AND DEVICE FOR SEPARATING HYDROCARBONS AND CONTAMINANTS WITH A SPRAY ASSEMBLY; 61/912,959 filed on December 6, 2013 entitled METHOD AND SYSTEM OF
15 MAINTAINING A LIQUID LEVEL IN A DISTILLATION TOWER; 61/912,964 filed on December 6, 2013 entitled METHOD AND DEVICE FOR SEPARATING A FEED STREAM USING RADIATION DETECTORS; 61/912,975 filed on December 6, 2013 entitled METHOD AND SYSTEM FOR SEPARATING A FEED STREAM WITH A FEED STREAM DISTRIBUTION MECHANISM; 61/912,978 filed on December 6, 2013 entitled
20 METHOD AND SYSTEM FOR PREVENTING ACCUMULATION OF SOLIDS IN A DISTILLATION TOWER; 61/912,983 filed on December 6, 2013 entitled METHOD OF REMOVING SOLIDS BY MODIFYING A LIQUID LEVEL IN A DISTILLATION TOWER; 61/912,984 filed on December 6, 2013 entitled METHOD AND SYSTEM OF MODIFYING A LIQUID LEVEL DURING START-UP OPERATIONS; 61/912,986 filed
25 on December 6, 2013 entitled METHOD AND DEVICE FOR SEPARATING HYDROCARBONS AND CONTAMINANTS WITH A HEATING MECHANISM TO DESTABILIZE AND/OR PREVENT ADHESION OF SOLIDS; 61/912,987 filed on December 6, 2013 entitled METHOD AND DEVICE FOR SEPARATING HYDROCARBONS AND CONTAMINANTS WITH A SURFACE TREATMENT
30 MECHANISM.

BACKGROUND

Fields of Disclosure

[0003] The disclosure relates generally to the field of fluid separation. More specifically, the disclosure relates to the cryogenic separation of contaminants, such as acid gas, from a hydrocarbon.

Description of Related Art

[0004] This section is intended to introduce various aspects of the art, which may be associated with the present disclosure. This discussion is intended to provide a framework to facilitate a better understanding of particular aspects of the present disclosure. Accordingly, it should be understood that this section should be read in this light, and not necessarily as admissions of prior art.

[0005] The production of natural gas hydrocarbons, such as methane and ethane, from a reservoir oftentimes carries with it the incidental production of non-hydrocarbon gases. Such gases include contaminants, such as at least one of carbon dioxide (“CO₂”), hydrogen sulfide (“H₂S”), carbonyl sulfide, carbon disulfide and various mercaptans. When a feed stream being produced from a reservoir includes these contaminants mixed with hydrocarbons, the stream is oftentimes referred to as “sour gas.”

[0006] Many natural gas reservoirs have relatively low percentages of hydrocarbons and relatively high percentages of contaminants. Contaminants may act as a diluent and lower the heat content of hydrocarbons. Some contaminants, like sulfur-bearing compounds, are noxious and may even be lethal. Additionally, in the presence of water some contaminants can become quite corrosive.

[0007] It is desirable to remove contaminants from a stream containing hydrocarbons to produce sweet and concentrated hydrocarbons. Specifications for pipeline quality natural gas typically call for a maximum of 2 – 4% CO₂ and ¼ grain H₂S per 100 scf (4 ppmv) or 5 mg/Nm³ H₂S. Specifications for lower temperature processes such as natural gas liquefaction plants or nitrogen rejection units typically require less than 50 ppm CO₂.

[0008] Separation by distillation of some mixtures can be relatively simple and, as such, is widely used in the natural gas industry. However, distillation of mixtures of natural gas hydrocarbons, primarily methane, and one of the most common contaminants in natural gas, carbon dioxide, can present significant difficulties. Conventional distillation principles and

conventional distillation equipment are predicated on the presence of only vapor and liquid phases throughout the distillation tower. The separation of CO₂ from methane by distillation involves temperature and pressure conditions that result in solidification of CO₂ if a pipeline or better quality hydrocarbon product is desired. The required temperatures are cold
5 temperatures typically referred to as cryogenic temperatures.

[0009] Certain cryogenic distillations can overcome the above mentioned difficulties. These cryogenic distillations provide the appropriate mechanism to handle the formation and subsequent melting of solids during the separation of solid-forming contaminants from hydrocarbons. The formation of solid contaminants in equilibrium with vapor-liquid
10 mixtures of hydrocarbons and contaminants at particular conditions of temperature and pressure takes place in a controlled freeze zone section.

[0010] Certain cryogenic distillations can overcome the above mentioned difficulties. These cryogenic distillations provide the appropriate mechanism to handle the formation and subsequent melting of solids during the separation of solid forming contaminants from
15 hydrocarbons. The formation of solid contaminants in equilibrium with vapor-liquid mixtures of the hydrocarbons and contaminants at particular conditions of temperature and pressure takes place in a controlled freeze zone section.

[0011] For cryogenic distillation and the controlled freeze zone section to work properly, the feed stream entering the distillation tower must be sufficiently dehydrated. Most often
20 the feed stream for cryogenic distillation is dehydrated in a dehydration unit comprising a molecular sieve. The dehydration unit removes water from the feed stream to prevent the water from later presenting a problem in the distillation tower. Water can present a problem by forming a separate water phase (i.e., ice and/or hydrate) that negatively affects the distillation process in the distillation tower.

[0012] Although the molecular sieve can sufficiently dehydrate the feed stream, molecular sieves can be expensive, be heavy, and require a lot of energy. Thus, there is a desire to use a dehydration unit that is less expensive, lighter and/or does not require as much energy as a molecular sieve. Some to all of these requirements could be met if the amount of carbon dioxide in the feed stream entering the distillation tower is greater than 25% as liquid
30 carbon dioxide has a significant water moisture carrying capacity that can be used advantageously to reduce dehydration requirements. But many feed streams do not contain this much carbon dioxide when the feed stream enters the distillation tower.

[0013] While there are other dehydration units or systems, such as glycol-based units, that can dehydrate the feed stream and use less energy than a molecular sieve, glycol-based units alone cannot dehydrate the feed stream enough to prevent the formation of a separate water phase without the help of the moisture carrying capacity of sufficient carbon dioxide in the feed stream. Consequently, separate water phases may result when the feed stream entering the distillation tower has less than 25% carbon dioxide and the dehydration unit comprises a glycol-based dehydration unit. As a result, the distillation tower cannot successfully operate to separate contaminants from methane.

[0014] A need, therefore, exists for improved technology, including technology that may address one or more of the above described disadvantages. Specifically, a need exists for a method and system that dehydrates a feed stream processed in a distillation tower.

SUMMARY

[0015] The present disclosure provides a device and method for separating contaminants from hydrocarbons, among other things.

[0016] A method of dehydrating a feed stream processed in a distillation tower may comprise (a) introducing a feed stream comprising a first contaminant stream into a distillation tower; (b) forming a solid from the feed stream in a controlled freeze zone section of the distillation tower; (c) feeding a second contaminant stream into the feed stream outside of the distillation tower; and (d) removing water from the feed stream with a second contaminant stream by feeding the second contaminant stream.

[0017] A method of producing hydrocarbons may comprise (a) introducing a feed stream comprising a first contaminant stream and a hydrocarbon into a distillation tower; (b) forming a solid from the feed stream in a controlled freeze zone section of the distillation tower; (c) feeding a second contaminant stream into the feed stream outside of the distillation tower; (d) removing water from the feed stream with a second contaminant stream by feeding the second contaminant stream; and (e) producing the hydrocarbon from the distillation tower after forming the solid.

[0018] A system of dehydrating a feed stream processed in a distillation tower may comprise a dehydration unit that dehydrates a feed stream comprising a first contaminant stream; a feed stream inlet channel extending from the dehydration unit; a distillation tower comprising a controlled freeze zone section constructed and arranged to form a solid from the feed stream; and at least one of: (a) a second contaminant storage tank holding a second

contaminant stream and connected to the feed stream inlet channel, and (b) a distillation tower outlet channel extending from the distillation tower to the feed stream inlet channel and configured to transport the second contaminant stream. The feed stream inlet channel extends to the distillation tower and is constructed and arranged to transport the first
5 contaminant stream and the second contaminant stream.

[0019] The foregoing has broadly outlined the features of the present disclosure in order that the detailed description that follows may be better understood. Additional features will also be described herein.

BRIEF DESCRIPTION OF THE DRAWINGS

10 [0020] These and other features, aspects and advantages of the disclosure will become apparent from the following description, appending claims and the accompanying drawings, which are briefly described below.

[0021] Figure 1 is a schematic diagram of a tower with sections within a single vessel.

[0022] Figure 2 is a schematic diagram of a tower with sections within multiple vessels.

15 [0023] Figure 3 is a schematic diagram of a tower with sections within a single vessel.

[0024] Figure 4 is a schematic diagram of a tower with sections within multiple vessels.

[0025] Figure 5 is a schematic diagram of system for increasing the carbon dioxide in a feed stream.

[0026] Figure 6 is a flowchart of a method within the scope of the present disclosure.

20 [0027] It should be noted that the figures are merely examples and no limitations on the scope of the present disclosure are intended thereby. Further, the figures are generally not drawn to scale, but are drafted for purposes of convenience and clarity in illustrating various aspects of the disclosure.

DETAILED DESCRIPTION

25 [0028] For the purpose of promoting an understanding of the principles of the disclosure, reference will now be made to the features illustrated in the drawings and specific language will be used to describe the same. It will nevertheless be understood that no limitation of the scope of the disclosure is thereby intended. Any alterations and further modifications, and any further applications of the principles of the disclosure as described herein are
30 contemplated as would normally occur to one skilled in the art to which the disclosure relates.

It will be apparent to those skilled in the relevant art that some features that are not relevant to the present disclosure may not be shown in the drawings for the sake of clarity.

[0029] As referenced in this application, the terms “stream,” “gas stream,” “vapor stream,” and “liquid stream” refer to different stages of a feed stream as the feed stream is processed in a distillation tower that separates methane, the primary hydrocarbon in natural gas, from contaminants. Although the phrases “gas stream,” “vapor stream,” and “liquid stream,” refer to situations where a gas, vapor, and liquid is mainly present in the stream, respectively, there may be other phases also present within the stream. For example, a gas may also be present in a “liquid stream.” In some instances, the terms “gas stream” and “vapor stream” may be used interchangeably.

[0030] The disclosure relates to a system and method for dehydrating a feed stream processed in a distillation tower. To dehydrate the feed stream, an amount of second contaminant (e.g. liquid carbon dioxide) in the feed stream, which will enter the distillation tower, may be increased before the feed stream enters the distillation tower. Figures 1-6 of the disclosure display various aspects of the system and method.

[0031] The system and method of dehydrating a feed stream may comprise a distillation tower **104, 204** (Figures 1-2). The distillation tower **104, 204** may separate the contaminants in the feed stream from the methane in the feed stream.

[0032] The distillation tower **104, 204** may be separated into three functional sections: a lower section **106**, a middle controlled freeze zone section **108** and an upper section **110**. The distillation tower **104, 204** may incorporate three functional sections when the upper section **110** is needed and/or desired.

[0033] The distillation tower **104, 204** may incorporate only two functional sections when the upper section **110** is not needed and/or desired. When the distillation tower does not include an upper section **110**, a portion of vapor leaving the middle controlled freeze zone section **108** may be condensed in a condenser **122** and returned as a liquid stream via a spray assembly **129**. Moreover, lines **18** and **20** may be eliminated, elements **124** and **126** may be one and the same, and elements **150** and **128** may be one and the same. The stream in line **14**, now taking the vapors leaving the middle controlled freeze section **108**, directs these vapors to the condenser **122**.

[0034] The lower section **106** may also be referred to as a stripper section. The middle controlled freeze zone section **108** may also be referred to as a controlled freeze zone section.

The upper section **110** may also be referred to as a rectifier section.

[0035] The sections of the distillation tower **104** may be housed within a single vessel (Figures 1 and 3). For example, the lower section **106**, the middle controlled freeze zone section **108**, and the upper section **110** may be housed within a single vessel **164**.

5 [0036] The sections of the distillation tower **204** may be housed within a plurality of vessels to form a split-tower configuration (Figures 2 and 4). Each of the vessels may be separate from the other vessels. Piping and/or another suitable mechanism may connect one vessel to another vessel. In this instance, the lower section **106**, middle controlled freeze zone section **108** and upper section **110** may be housed within two or more vessels. For
10 example, as shown in Figures 2 and 4, the upper section **110** may be housed within a single vessel **254** and the lower and middle controlled freeze zone sections **106**, **108** may be housed within a single vessel **264**. When this is the case, a liquid stream exiting the upper section **110**, may exit through a liquid outlet bottom **260**. The liquid outlet bottom **260** is at the bottom of the upper section **110**. Although not shown, each of the sections may be housed
15 within its own separate vessel, or one or more section may be housed within separate vessels, or the upper and middle controlled freeze zone sections may be housed within a single vessel and the lower section may be housed within a single vessel, etc. When sections of the distillation tower are housed within vessels, the vessels may be side-by-side along a horizontal line and/or above each other along a vertical line.

20 [0037] The split-tower configuration may be beneficial in situations where the height of the distillation tower, motion considerations, and/or transportation issues, such as for remote locations, need to be considered. This split-tower configuration allows for the independent operation of one or more sections. For example, when the upper section is housed within a single vessel and the lower and middle controlled freeze zone sections are housed within a
25 single vessel, independent generation of reflux liquids using a substantially contaminant-free, largely hydrocarbon stream from a packed gas pipeline or an adjacent hydrocarbon line, may occur in the upper section. And the reflux may be used to cool the upper section, establish an appropriate temperature profile in the upper section, and/or build up liquid inventory at the bottom of the upper section to serve as an initial source of spray liquids for the middle
30 controlled freeze zone section. Moreover, the middle controlled freeze zone and lower sections may be independently prepared by chilling the feed stream, feeding it to the optimal location be that in the lower section or in the middle controlled freeze zone section, generating liquids for the lower and the middle controlled freeze zone sections, and disposing

the vapors off the middle controlled freeze zone section while they are off specification with too high a contaminant content. Also, liquid from the upper section may be intermittently or continuously sprayed, building up liquid level in the bottom of the middle controlled freeze zone section and bringing the contaminant content in the middle controlled freeze zone section down and near steady state level so that the two vessels may be connected to send the vapor stream from the middle controlled freeze zone section to the upper section, continuously spraying liquid from the bottom of the upper section into the middle controlled freeze zone section and stabilizing operations into steady state conditions. The split tower configuration may utilize a sump of the upper section as a liquid receiver for the pump **128**, therefore obviating the need for a liquid receiver **126** in Figures 1 and 3.

[0038] The system may also include a heat exchanger **100** (Figures 1-4). The feed stream **10** may enter the heat exchanger **100** before entering the distillation tower **104**, **204**. The feed stream **10** may be cooled within the heat exchanger **100**. The heat exchanger **100** helps drop the temperature of the feed stream **10** to a level suitable for introduction into the distillation tower **104**, **204**.

[0039] The system may include an expander device **102** (Figures 1-4). The feed stream **10** may enter the expander device **102** before entering the distillation tower **104**, **204**. The feed stream **10** may be expanded in the expander device **102** after exiting the heat exchanger **100**. The expander device **102** helps drop the temperature of the feed stream **10** to a level suitable for introduction into the distillation tower **104**, **204**. The expander device **102** may be any suitable device, such as a valve. If the expander device **102** is a valve, the valve may be any suitable valve that may aid in cooling the feed stream **10** before it enters the distillation tower **104**, **204**. For example, the valve **102** may comprise a Joule-Thompson (J-T) valve.

[0040] The system may include a feed separator **103** (Figures 3-4). The feed stream may enter the feed separator before entering the distillation tower **104**, **204**. The feed separator may separate a feed stream having a mixed liquid and vapor stream into a liquid stream and a vapor stream. Lines **12** may extend from the feed separator to the distillation tower **104**, **204**. One of the lines **12** may receive the vapor stream from the feed separator. Another one of the lines **12** may receive the liquid stream from the feed separator. Each of the lines **12** may extend to the same and/or different sections (i.e. middle controlled freeze zone, and lower sections) of the distillation tower **104**, **204**. The expander device **102** may or may not be downstream of the feed separator **103**. The expander device **102** may comprise a plurality of

expander devices **102** such that each line **12** has an expander device **102**.

[0041] The system includes a dehydration unit **261** that dehydrates the feed stream **10** (Figures 1-5). The dehydration unit **261** dehydrates the feed stream to a dew point sufficiently low to ensure a separate water phase does not form at any point downstream during the rest of the process. The dehydration unit **261** dehydrates the feed stream before the feed stream enters the distillation tower **104, 204**. The feed stream may comprise a contaminant and the contaminant in the feed stream **10** may comprise a first contaminant stream.

[0042] The dehydration unit **261** removes water from the feed stream **10** to prevent water from later presenting a problem in the heat exchanger **100**, expander device **102**, feed separator **103** or distillation tower **104, 204**. The water can present a problem by forming a separate water phase (i.e., ice and/or hydrate) that plugs lines, equipment or negatively affects the distillation process. When removing water from the feed stream, the dehydration unit **261** may dehydrate the feed stream to a dew point sufficiently low to ensure a separate water phase will not form at any point downstream during the rest of the process.

[0043] The system may include a feed stream inlet channel **12** (Figures 1-5) that extends to the dehydration unit **261**. The feed stream inlet channel **12** may also extend to the distillation tower **104, 204**. The feed stream inlet channel **12** may extend to the lower section **106** or the middle controlled freeze zone section **108** of the distillation tower **104, 204**. For example, the feed stream inlet channel **12** may extend to the lower section **106** such that the feed stream **10** may enter the lower section **106** of the distillation tower **104, 204** (Figures 1-4). The feed stream inlet channel **12** may directly or indirectly extend to the lower section **106** or the middle controlled freeze zone section **108**. The feed stream inlet channel **12** may extend to an outer surface of the distillation tower **104, 204** before entering the distillation tower.

[0044] If the system includes the feed separator **103** (Figures 3-4), the line **12** may comprise a plurality of lines **12**. Each line may be the same line as one of the lines that extends from the feed separator to a specific portion of the distillation tower **104, 204**.

[0045] The feed stream inlet channel **12** may be constructed and arranged to transport the feed stream. The feed stream inlet channel **12** transports the feed stream from a feed stream location **269** (Figure 5) to the distillation tower **104, 204**. In other words, the feed stream inlet channel **12** introduces the feed stream **10** into the distillation tower **104, 204, 301**

(Figure 6). The feed stream location **269** may be any suitable location, such as a gas reservoir. The feed stream inlet channel **12** may also be referred to as a line.

[0046] The feed stream **10** from the feed stream location **269** may have a low concentration of a first contaminant. For example, the feed stream **10** from the feed stream location **269** may comprise less than 25% of the first contaminant. When the feed stream **10** comprises less than 25% of the first contaminant, a total amount of contaminant in the feed stream may need to be increased. By increasing the total amount of contaminant in the feed stream, water in the feed stream can be prevented from forming any undesired phases in the distillation tower **104, 204**.

[0047] To prevent the water in the feed stream from forming any undesired phases in the distillation tower **104, 204**, the system may include at least one of (a) a second contaminant storage tank **264** and (b) a distillation tower outlet channel **262, 263, 268** that extends from the distillation tower **104, 204** (Figure 5). While Figure 5 shows both a second contaminant storage tank **264**, a storage tank channel **265, 266, 267** and a distillation tower outlet channel **262, 263, 268**, the system may include, for example, only the second contaminant storage tank **264** and the storage tank channel **265, 266, 267**, only the distillation tower outlet channel **262, 263** or the second contaminant storage tank **264**, or the storage tank channel **265, 266, 267** and the distillation tower outlet channel **262, 263**. Moreover, while Figure 5 shows lines **263** and **266** as separate lines and lines **262** and **267** as separate lines, lines **263** and **266** may be the same line and/or lines **262** and **267** may be the same line.

[0048] The second contaminant storage tank **264** holds a second contaminant stream and connects to the feed stream inlet channel **12**. The second contaminant storage tank **264** connects to the feed stream inlet channel **12** via storage tank channel **265, 266, 267**. The storage tank channel **265, 266, 267** transports the second contaminant stream from the second contaminant storage tank **264** to the feed stream inlet channel **12**. The second contaminant storage tank **264** is outside of the distillation tower **104, 204**. The second contaminant storage tank **264** is separate and distinct from the distillation tower **104, 204**.

[0049] The storage tank channel **265, 266, 267** connects to the feed stream inlet channel **12** at one or more locations. The storage tank channel **265, 266, 267** may transport the second contaminant stream from the second contaminant storage tank **264** to before the dehydration unit **261** via lines **265** and **266** of the storage tank channel **265, 266, 267**. The storage tank channel **265, 266, 267** may transport the second contaminant stream from the

second contaminant storage tank **264** to between the dehydration unit **261** and the heat exchanger **100** via lines **265** and **267** of the storage tank channel **265, 266, 267**.

[0050] The distillation tower outlet channel **262, 263, 268** is constructed and arranged to transport the second contaminant stream. The distillation tower outlet channel **262, 263, 268** extends from a liquid outlet **160** of the lower section **106** (Figures 1-5) to the feed stream inlet channel **12**. The distillation tower outlet channel **262, 263, 268** transports the second contaminant stream from the liquid outlet **160** to the feed stream inlet channel **12** (Figure 5).

[0051] The distillation tower outlet channel **262, 263, 268** may transport the second contaminant stream to one or more locations along the feed stream inlet channel **12**. The distillation tower outlet channel **262, 263, 268** may transport the second contaminant stream from the lower section **108** to before the dehydration unit **261** via lines **263** and **268** of the distillation tower outlet channel **262, 263, 268**. The distillation tower outlet channel **262, 263, 268** may transport the second contaminant stream from the lower section **108** to between the dehydration unit **261** and the heat exchanger **100** via lines **262** and **268** of the distillation tower outlet channel **262, 263, 268**. The second contaminant stream is transported in the distillation tower outlet channel **262, 263, 268**. It may be more beneficial to transport the second contaminant stream to between the dehydration unit **261** and heat exchanger **100** than before the dehydration unit **261** to polish the feed stream to a lower water content. Polishing the feed stream to a lower water content helps prevent undesired water phases from forming in the distillation tower **104, 204**. The feed stream may be polished to a lower water content by transporting the second contaminant stream to between the dehydration unit **261** and heat exchanger **100** because the second contaminant stream is more likely to have sufficient capacity to absorb residual water if the stream enters after the dehydration unit **261**.

[0052] The second contaminant stream may comprise any suitable contaminant. For example, the second contaminant stream may be at least a portion of the first contaminant stream. Alternatively, the second contaminant stream may be one of a same type and a different type of contaminant from the second contaminant stream. If the first contaminant stream comprises carbon dioxide and the second contaminant stream is the same type of contaminant as the first contaminant stream, then the second contaminant stream also comprises carbon dioxide. If the second contaminant stream is transported by the distillation tower outlet channel **262, 263, 268**, the second contaminant stream may comprise feed stream processed in the distillation tower **104, 204**. Oftentimes, the stream exiting the distillation tower **104, 204** via liquid outlet **160**, comprises more contaminant from the feed stream than

of methane. The feed stream exiting the tower may be referred to as an enriched contaminant bottom liquid stream, which is formed in the lower section **106** (Figure 6).

[0053] When the feed stream is dehydrated, in part by using a second contaminant stream, before being processed in the distillation tower **104, 204**, water is removed from the vapor phase of the feed stream, **304**. Water is removed from the vapor phase of the feed stream by feeding the second contaminant stream into the feed stream outside of the distillation tower, **303** (Figure 6). Specifically, the second contaminant stream is fed to the feed stream inlet channel **12**. The second contaminant stream may be fed to the feed stream inlet channel **12** via the storage tank channel **265, 266, 267** and/or the distillation tower outlet channel **262, 263, 268**. When the second contaminant stream is fed to the feed stream inlet channel **12** via the storage tank channel **265, 266, 267** the second contaminant stream is transported from the second contaminant storage tank **264**. When the second contaminant stream is fed to the feed stream inlet channel **12** via the distillation tower outlet channel **262, 263, 268**, the second contaminant stream is transported from the liquid outlet **160** of the lower section **106**.

[0054] Once the second contaminant stream is fed to the feed stream, the total amount of contaminant in the feed stream comprises the first contaminant stream and the second contaminant stream. While the second contaminant stream may be fed to the feed stream any amount of times, the second contaminant stream is preferably fed to the feed stream until the total amount of contaminant in the feed stream transported through the feed stream inlet channel **12** is between about 25 to 35%, between 25 to 35% of the feed stream, or within a range that includes or is bounded by any of the preceding examples of total amount of contaminant. Once the total amount of contaminant reaches this level, the dehydration unit **261** may be any suitable dehydration unit, such as a glycol-based unit or a molecular sieve. The dehydration unit **261** may be any suitable dehydration unit because the amount of contaminant in the feed stream being processed in the distillation tower **104, 204** is enough to sufficiently dehydrate the feed stream before it enters the distillation tower **104, 204** so as to prevent undesired water phases from forming.

[0055] The second contaminant stream may be fed to the feed stream continuously or intermittently. For example, the second contaminant stream may be intermittently or continuously fed to the feed stream from any combination or lack thereof of at least one of the lower section **106** and the second contaminant storage tank **264**.

[0056] The second contaminant stream may be at least partially dehydrated prior to introducing it into the feed stream. The second contaminant stream may be withdrawn after contact with the feed stream. The second contaminant stream may be introduced into a lower section of the stripper. A third enriched contaminant stream may be generated from the first
5 contaminant stream and/or from the second contaminant stream. This third contaminant stream may be more hygroscopic than the other contaminant streams (i.e., the first contaminant stream and/or the second contaminant stream). The third contaminant stream may be under-saturated with respect to water so that it will absorb water vapor from the feed stream when the third contaminant stream is placed in contact with the feed stream.

10 [0057] While the above paragraphs disclose increasing the total amount of contaminant in the feed stream until the total amount of contaminant is between about 25 – 35% of the feed stream, the total amount of contaminant in the feed stream could be increased to a higher amount. For example, the total amount of contaminant in the feed stream could be increased to above 25 – 35%.

15 [0058] The system may include a filtering unit (not shown). The feed stream **10** may enter the filtering unit before entering the distillation tower **104, 204**. The filtering unit may remove undesirable contaminants from the feed stream before the feed stream enters the distillation tower **104, 204**. Depending on what contaminants are to be removed, the filtering unit may be before or after the dehydration unit **261** and/or before or after the heat exchanger
20 **100**.

[0059] The lower section **106** is constructed and arranged to separate the feed stream **10** into an enriched contaminant bottom liquid stream (i.e., liquid stream) and a freezing zone vapor stream (i.e., vapor stream). The enriched contaminant liquids bottom stream is what exits the lower outlet **160** and at least part of this stream may be what is fed to the inlet
25 channel **12** to increase the total amount of contaminant in the feed stream. The lower section **106** separates the feed stream at a temperature and pressure at which no solids form. The liquid stream may comprise a greater quantity of contaminants than of methane. The vapor stream may comprise a greater quantity of methane than of contaminants. In any case, the vapor stream is lighter than the liquid stream. As a result, the vapor stream rises from the
30 lower section **106** and the liquid stream falls to the bottom of the lower section **106**.

[0060] The lower section **106** may include and/or connect to equipment that separates the feed stream. The equipment may comprise any suitable equipment for separating methane

from contaminants, such as one or more packed sections **181**, or one or more distillation trays with perforations downcomers and weirs (Figures 1-4).

[0061] The equipment may include components that apply heat to the stream to form the vapor stream and the liquid stream. For example, the equipment may comprise a first reboiler **112** that applies heat to the stream. The first reboiler **112** may be located outside of the distillation tower **104**, **204**. The equipment may also comprise a second reboiler **172** that applies heat to the stream. The second reboiler **172** may be located outside of the distillation tower **104**, **204**. Line **117** may lead from the distillation tower to the second reboiler **172**. Line **17** may lead from the second reboiler **172** to the distillation tower. Additional reboilers, set up similarly to the second reboiler described above, may also be used.

[0062] The first reboiler **112** may apply heat to the liquid stream that exits the lower section **106** through a liquid outlet **160** of the lower section **106**. The liquid stream may travel from the liquid outlet **160** through line **28** to reach the first reboiler **112** (Figures 1-4). The amount of heat applied to the liquid stream by the first reboiler **112** can be increased to separate more methane from contaminants. The more heat applied by the reboiler **112** to the stream, the more methane separated from the liquid contaminants, though more contaminants will also be vaporized.

[0063] The first reboiler **112** may also apply heat to the stream within the distillation tower **104**, **204**. Specifically, the heat applied by the first reboiler **112** warms up the lower section **106**. This heat travels up the lower section **106** and supplies heat to warm solids entering a melt tray assembly **139** (Figures 1-4) of the middle controlled freeze zone section **108** so that the solids form a liquid and/or slurry mix.

[0064] The second reboiler **172** applies heat to the stream within the lower section **106**. This heat is applied closer to the middle controlled freeze zone section **108** than the heat applied by the first reboiler **112**. As a result, the heat applied by the second reboiler **172** reaches the middle controlled freeze zone section **108** faster than the heat applied by the first reboiler **112**. The second reboiler **172** may also help with energy integration.

[0065] The equipment may include a chimney assembly **135** (Figures 1-4). While falling to the bottom of the lower section **106**, the liquid stream may encounter one or more of the chimney assemblies **135**.

[0066] Each chimney assembly **135** includes a chimney tray **131** that collects the liquid stream within the lower section **106**. The liquid stream that collects on the chimney tray **131**

may be fed to the second reboiler **172**. After the liquid stream is heated in the second reboiler **172**, the stream may return to the middle controlled freeze zone section **106** to supply heat to the middle controlled freeze zone section **106** and/or the melt tray assembly **139**. Unvaporized stream exiting the second reboiler **172** may be fed back to the distillation tower

5 **104, 204** below the chimney tray **131**. Vapor stream exiting the second reboiler **172** may be routed under or above the chimney tray **131** when the vapor stream enters the distillation tower **104, 204**.

[0067] The chimney tray **131** may include one or more chimneys **137**. The chimney **137** serves as a channel that the vapor stream in the lower section **106** traverses. The vapor

10 stream travels through an opening in the chimney tray **131** at the bottom of the chimney **137** to the top of the chimney **137**. The opening is closer to the bottom of the lower section **106** than it is to the bottom of the middle controlled freeze zone section **108**. The top is closer to the bottom of the middle controlled freeze zone section **108** than it is to the bottom of the lower section **106**.

15 [0068] Each chimney **137** has attached to it a chimney cap **133**. The chimney cap **133** covers a chimney top opening **138** of the chimney **137**. The chimney cap **133** prevents the liquid stream from entering the chimney **137**. The vapor stream exits the chimney assembly **135** via the chimney top opening **138**.

[0069] After falling to the bottom of the lower section **106**, the liquid stream exits the

20 distillation tower **104, 204** through the liquid outlet **160**. The liquid outlet **160** is within the lower section **106** (Figures 1-4). The liquid outlet **160** may be located at the bottom of the lower section **106**.

[0070] After exiting through the liquid outlet **160**, the feed stream may travel via line **28** to the first reboiler **112**. The feed stream may be heated by the first reboiler **112** and vapor

25 may then re-enter the lower section **106** through line **30**. Unvaporized liquid may continue out of the distillation process via line **24**.

[0071] The systems may include an expander device **114** (Figures 1-4). After entering line **24**, the heated liquid stream may be expanded in the expander device **114**. The expander device **114** may be any suitable device, such as a valve. The valve **114** may be any suitable

30 valve, such as a J-T valve.

[0072] The systems may include a heat exchanger **116** (Figures 1-4). The liquid stream heated by the first reboiler **112** may be cooled or heated by the heat exchanger **116**. The heat

exchanger **116** may be a direct heat exchanger or an indirect heat exchanger. The heat exchanger **116** may comprise any suitable heat exchanger.

5 [0073] The vapor stream in the lower section **106** rises from the lower section **106** to the middle controlled freeze zone section **108**. The middle controlled freeze zone section **108** is constructed and arranged to separate the feed stream **10** introduced into the middle controlled freeze zone section, or into the top of lower section **106**, into a solid and a vapor stream. The solid may be comprised more of contaminants than of methane. The vapor stream (i.e., methane-enriched vapor stream) may comprise more methane than contaminants.

10 [0074] The middle controlled freeze zone section **108** includes a lower section **40** and an upper section **39**. The lower section **40** is below the upper section **39**. The lower section **40** directly abuts the upper section **39**. The lower section **40** is primarily but not exclusively a heating section of the middle controlled freeze zone section **108**. The upper section **39** is primarily but not exclusively a cooling section of the middle controlled freeze zone section **108**. The temperature and pressure of the upper section **39** are chosen so that the solid can
15 form in the middle controlled freeze zone section **108**.

[0075] The middle controlled freeze zone section **108** may comprise a melt tray assembly **139** that is maintained in the middle controlled freeze zone section **108** (Figures 1-4). The melt tray assembly **139** is within the lower section **40** of the middle controlled freeze zone section **108**. The melt tray assembly **139** is not within the upper section **39** of the middle
20 controlled freeze zone section **108**.

[0076] The melt tray assembly **139** is constructed and arranged to melt solids formed in the middle controlled freeze zone section **108**. When the warm vapor stream rises from the lower section **106** to the middle controlled freeze zone section **108**, the vapor stream immediately encounters the melt tray assembly **139** and supplies heat to melt the solids. The
25 melt tray assembly **139** may comprise at least one of a melt tray **118**, a bubble cap **132**, a liquid **130** and heat mechanism(s) **134**.

[0077] The melt tray **118** may collect a liquid and/or slurry mix. The melt tray **118** divides at least a portion of the middle controlled freeze zone section **108** from the lower section **106**. The melt tray **118** is at the bottom **45** of the middle controlled freeze zone
30 section **108**.

[0078] One or more bubble caps **132** may act as a channel for the vapor stream rising from the lower section **106** to the middle controlled freeze zone section **108**. The bubble cap

132 may provide a path for the vapor stream up the riser **140** and then down and around the riser **140** to the melt tray **118**. The riser **140** is covered by a cap **141**. The cap **141** prevents the liquid **130** from travelling into the riser and it also helps prevent solids from travelling into the riser **140**. The vapor stream's traversal through the bubble cap **132** allows the vapor stream to transfer heat to the liquid **130** within the melt tray assembly **139**.

[0079] One or more heat mechanisms **134** may further heat up the liquid **130** to facilitate melting of the solids into a liquid and/or slurry mix. The heat mechanism(s) **134** may be located anywhere within the melt tray assembly **139**. For example, as shown in Figures 1-4, a heat mechanism **134** may be located around bubble caps **132**. The heat mechanism **134** may be any suitable mechanism, such as a heat coil. The heat source of the heat mechanism **134** may be any suitable heat source.

[0080] The liquid **130** in the melt tray assembly is heated by the vapor stream. The liquid **130** may also be heated by the one or more heat mechanisms **134**. The liquid **130** helps melt the solids formed in the middle controlled freeze zone section **108** into a liquid and/or slurry mix. Specifically, the heat transferred by the vapor stream heats up the liquid, thereby enabling the heat to melt the solids. The liquid **130** is at a level sufficient to melt the solids.

[0081] The middle controlled freeze zone section **108** may also comprise a spray assembly **129**. The spray assembly **129** cools the vapor stream that rises from the lower section **40**. The spray assembly **129** sprays liquid, which is cooler than the vapor stream, on the vapor stream to cool the vapor stream. The spray assembly **129** is within the upper section **39**. The spray assembly **129** is not within the lower section **40**. The spray assembly **129** is above the melt tray assembly **139**. In other words, the melt tray assembly **139** is below the spray assembly **129**.

[0082] The spray assembly **129** includes one or more spray nozzles **120** (Figures 1-4). Each spray nozzle **120** sprays liquid on the vapor stream. The spray assembly **129** may also include a spray pump **128** (Figures 1-4) that pumps the liquid. Instead of a spray pump **128**, gravity may induce flow in the liquid.

[0083] The liquid sprayed by the spray assembly **129** contacts the vapor stream at a temperature and pressure at which solids form. Solids, containing mainly contaminants, form when the sprayed liquid contacts the vapor stream, **302** (Figure 6). The solids fall toward the melt tray assembly **139**.

[0084] The temperature in the middle controlled freeze zone section **108** cools down as

the vapor stream travels from the bottom of the middle controlled freeze zone section **108** to the top of the middle controlled freeze zone section **108**. The methane in the vapor stream rises from the middle controlled freeze zone section **108** to the upper section **110**. Some contaminants may remain in the methane and also rise. The contaminants in the vapor stream
5 tend to condense or solidify with the colder temperatures and fall to the bottom of the middle controlled freeze zone section **108**.

[0085] The solids form the liquid and/or slurry mix when in the liquid **130**. The liquid and/or slurry mix flows from the middle controlled freeze zone section **108** to the lower distillation section **106**. The liquid and/or slurry mix flows from the bottom of the middle
10 controlled freeze zone section **108** to the top of the lower section **106** via a line **22** (Figures 1-4). The line **22** may be an exterior line. The line **22** may extend from the distillation tower **104, 204**. The line **22** may extend from the middle controlled freeze zone section **108**. The line may extend to the lower section **106**. The line **22** may extend from an outer surface of the distillation tower **104, 204**.

15 **[0086]** The vapor stream that rises in the middle controlled freeze zone section **108** and does not form solids or otherwise fall to the bottom of the middle controlled freeze zone section **108**, rises to the upper section **110**. The upper section **110** operates at a temperature and pressure and contaminant concentration at which no solid forms. The upper section **110** is constructed and arranged to cool the vapor stream to separate the methane from the
20 contaminants. Reflux in the upper section **110** cools the vapor stream. The reflux is introduced into the upper section **110** via line **18**. Line **18** may extend to the upper section **110**. Line **18** may extend from an outer surface of the distillation tower **104, 204**.

[0087] After contacting the reflux in the upper section **110**, the feed stream forms a vapor stream and a liquid stream. The vapor stream mainly comprises methane. The liquid stream
25 comprises relatively more contaminants. The vapor stream rises in the upper section **110** and the liquid falls to a bottom of the upper section **110**.

[0088] To facilitate separation of the methane from the contaminants when the stream contacts the reflux, the upper section **110** may include one or more mass transfer devices **176**. Each mass transfer device **176** helps separate the methane from the contaminants. Each mass
30 transfer device **176** may comprise any suitable separation device, such as a tray with perforations, or a section of random or structured packing to facilitate contact of the vapor and liquid phases.

[0089] After rising, the vapor stream may exit the distillation tower **104, 204** through line **14**. The line **14** may emanate from an upper part of the upper section **110**. The line **14** may extend from an outer surface of the upper section **110**.

5 [0090] From line **14**, the vapor stream may enter a condenser **122**. The condenser **122** cools the vapor stream to form a cooled stream. The condenser **122** at least partially condenses the stream.

[0091] After exiting the condenser **122**, the cooled stream may enter a separator **124**. The separator **124** separates the vapor stream into liquid and vapor streams. The separator may be any suitable separator that can separate a stream into liquid and vapor streams, such as a
10 reflux drum.

[0092] Once separated, the vapor stream may exit the separator **124** as sales product. The sales product may travel through line **16** for subsequent sale to a pipeline and/or condensation to be liquefied natural gas.

[0093] Once separated, the liquid stream may return to the upper section **110** through line
15 **18** as the reflux. The reflux may travel to the upper section **110** via any suitable mechanism, such as a reflux pump **150** (Figures 1 and 3) or gravity (Figures 2 and 4).

[0094] The liquid stream (i.e., freezing zone liquid stream) that falls to the bottom of the upper section **110** collects at the bottom of the upper section **110**. The liquid may collect on tray **183** (Figures 1 and 3) or at the bottommost portion of the upper section **110** (Figures 2
20 and 4). The collected liquid may exit the distillation tower **104, 204** through line **20** (Figures 1 and 3) or outlet **260** (Figures 2 and 4). The line **20** may emanate from the upper section **110**. The line **20** may emanate from a bottom end of the upper section **110**. The line **20** may extend from an outer surface of the upper section **110**.

[0095] The line **20** and/or outlet **260** connect to a line **41**. The line **41** leads to the spray
25 assembly **129** in the middle controlled freeze zone section **108**. The line **41** emanates from the holding vessel **126**. The line **41** may extend to an outer surface of the middle controlled freeze zone section **110**.

[0096] The line **20** and/or outlet **260** may directly or indirectly (Figures 1-4) connect to the line **41**. When the line **20** and/or outlet **260** directly connect to the line **41**, the liquid
30 spray may be pumped to the spray nozzle(s) **120** via any suitable mechanism, such as the spray pump **128** or gravity. When the line **20** and/or outlet **260** indirectly connect to the line **41**, the lines **20, 41** and/or outlet **260** and line **41** may directly connect to a holding vessel **126**

(Figures 1 and 3). The holding vessel **126** may house at least some of the liquid spray before it is sprayed by the nozzle(s). The liquid spray may be pumped from the holding vessel **126** to the spray nozzle(s) **120** via any suitable mechanism, such as the spray pump **128** (Figures 1-4) or gravity. The holding vessel **126** may be needed when there is not a sufficient amount of liquid stream at the bottom of the upper section **110** to feed the spray nozzles **120**.

[0097] It is important to note that the steps depicted in Figure 6 provided for illustrative purposes only and a particular step may not be required to perform the inventive methodology. The claims, and only the claims, define the inventive system and methodology.

10 [0098] Disclosed aspects may be used in hydrocarbon management activities. As used herein, "hydrocarbon management" or "managing hydrocarbons" includes hydrocarbon extraction, hydrocarbon production, hydrocarbon exploration, identifying potential hydrocarbon resources, identifying well locations, determining well injection and/or extraction rates, identifying reservoir connectivity, acquiring, disposing of and/ or abandoning hydrocarbon resources, reviewing prior hydrocarbon management decisions, and any other hydrocarbon-related acts or activities. The term "hydrocarbon management" is also used for the injection or storage of hydrocarbons or CO₂, for example the sequestration of CO₂, such as reservoir evaluation, development planning, and reservoir management. The disclosed methodologies and techniques may be used to produce hydrocarbons in a feed stream extracted from, for example, a subsurface region. The feed stream extracted may be processed in the distillation tower **104**, **204** and separated into hydrocarbons and contaminants. The separated hydrocarbons exit the middle controlled freeze zone section **108** or the upper section **110** of the distillation tower. Some or all of the hydrocarbons that exit are produced, **307** (Figure 6). Hydrocarbon extraction may be conducted to remove the feed stream from for example, the subsurface region, which may be accomplished by drilling a well using oil well drilling equipment. The equipment and techniques used to drill a well and/or extract the hydrocarbons are well known by those skilled in the relevant art. Other hydrocarbon extraction activities and, more generally, other hydrocarbon management activities, may be performed according to known principles.

30 [0100] As utilized herein, the terms "approximately," "about," "substantially," and similar terms are intended to have a broad meaning in harmony with the common and accepted usage by those of ordinary skill in the art to which the subject matter of this disclosure pertains. It should be understood by those of skill in the art who review this

disclosure that these terms are intended to allow a description of certain features described and claimed without restricting the scope of these features to the precise numeral ranges provided. Accordingly, these terms should be interpreted as indicating that insubstantial or inconsequential modifications or alterations of the subject matter described are considered to
5 be within the scope of the disclosure.

[0101] It should be understood that numerous changes, modifications, and alternatives to the preceding disclosure can be made without departing from the scope of the disclosure. The preceding description, therefore, is not meant to limit the scope of the disclosure. Rather, the scope of the disclosure is to be determined only by the appended claims and their
10 equivalents. It is also contemplated that structures and features in the present examples can be altered, rearranged, substituted, deleted, duplicated, combined, or added to each other.

[0102] The articles “the”, “a” and “an” are not necessarily limited to mean only one, but rather are inclusive and open ended so as to include, optionally, multiple such elements.

CLAIMS

What is claimed is:

1. A method of dehydrating a feed stream processed in a distillation tower, the method comprising:
 - 5 (a) introducing a feed stream comprising a first contaminant stream into a distillation tower;
 - (b) forming a solid from the feed stream in a controlled freeze zone section of the distillation tower;
 - (c) feeding a second contaminant stream into the feed stream outside of the distillation
 - 10 tower; and
 - (d) removing water from the feed stream with the second contaminant stream by feeding the second contaminant stream.
2. The method of claim 1, wherein the second contaminant stream is at least a portion of the first contaminant stream.
- 15 3. The method of any one of claim 1-2, wherein the first contaminant stream is one of a same type and a different type of contaminant from the second contaminant stream.
4. The method of any one of claim 1-3, wherein at least one of the first contaminant stream and the second contaminant stream comprises carbon dioxide.
5. The method of any one of claim 1-4, wherein removing the water comprises
- 20 processing the feed stream in one of a glycol-based unit and a molecular sieve unit.
6. The method of any one of claim 1-5, wherein feeding the second contaminant stream comprises at least one of (i) transporting the second contaminant stream from the distillation tower to the feed stream and (ii) transporting the second contaminant stream from a second contaminant storage tank to the feed stream.
- 25 7. The method of claim 6, wherein the second contaminant storage tank is outside of the distillation tower.

8. The method of any one of claim 1-7, wherein feeding the second contaminant stream comprises transporting the second contaminant stream to the feed stream at least one of before the feed stream enters a dehydration unit and before it enters a heat exchanger.
9. The method of any one of claim 1-8,
- 5 wherein a total amount of contaminant comprises the first contaminant stream and the second contaminant stream, and
- wherein the method further comprises increasing the total amount of contaminant in the feed stream to between about 25 to 35 percent.
10. A method of producing hydrocarbons, the method comprising:
- 10 (a) introducing a feed stream comprising a first contaminant stream and a hydrocarbon into a distillation tower;
- (b) forming a solid from the feed stream in a controlled freeze zone section of the distillation tower;
- (c) feeding a second contaminant stream into the feed stream outside of the distillation
- 15 tower;
- (d) removing water from the feed stream with a second contaminant stream by feeding the second contaminant stream; and
- (e) producing the hydrocarbon from the distillation tower after forming the solid.
11. The method of claim 10, wherein the second contaminant stream is at least a portion
- 20 of the first contaminant stream.
12. The method of any one of claim 10-11, wherein the first contaminant stream is one of a same type and a different type of contaminant from the second contaminant stream.
13. The method of any one of claim 10-12, wherein at least one of the first contaminant stream and the second contaminant stream comprises carbon dioxide.
- 25 14. The method of any one of claim 10-13, wherein removing the water comprises processing the feed stream in one of a glycol-based unit and a molecular sieve.
15. The method of any one of claim 10-14, wherein feeding the second contaminant stream comprises at least one of (i) transporting the second contaminant stream from the

distillation tower to the feed stream and (ii) transporting the second contaminant stream from a second contaminant storage tank to the feed stream.

16. The method of claim 15, wherein the second contaminant storage tank is outside of the distillation tower.

5 17. The method of any one of claim 10-16, wherein feeding the second contaminant stream comprises transporting the second contaminant stream to the feed stream at least one of before the feed stream enters a dehydration unit and a heat exchanger.

18. The method of any one of claim 10-17,

wherein a total amount of contaminant comprises the first contaminant stream and the
10 second contaminant stream, and

wherein the method further comprises increasing the total amount of contaminant in the feed stream to between about 25 to 35 percent.

19. A system of dehydrating a feed stream processed in a distillation tower, the system comprising:

15 a dehydration unit that dehydrates a feed stream comprising a first contaminant stream;

a feed stream inlet channel extending from the dehydration unit;

a distillation tower comprising a controlled freeze zone section constructed and arranged to form a solid from the feed stream; and

20 at least one of:

(a) a second contaminant storage tank holding a second contaminant stream and connected to the feed stream inlet channel, and

(b) a distillation tower outlet channel extending from the distillation tower to the feed stream inlet channel and constructed and arranged to transport the second
25 contaminant stream,

wherein the feed stream inlet channel extends to the distillation tower and is constructed and arranged to transport the first contaminant stream and the second contaminant stream.

20. The system of claim 19, wherein the dehydration unit comprises one of a glycol-based unit and a molecular sieve.
21. The system of any one of claim 19-20, wherein the second contaminant stream is at least a portion of the first contaminant stream.
- 5 22. The system of any one of claim 19-21, wherein the first contaminant stream is one of a same type and a different type of contaminant from the second contaminant stream.
23. The system of any one of claim 19-22, wherein at least one of the first contaminant stream and the second contaminant stream comprises carbon dioxide.
24. The system of any one of claim 19-23, wherein the distillation outlet channel connects
10 to the feed stream inlet channel before the dehydration unit and the distillation tower.
25. The system of any one of claim 19-24, wherein the distillation outlet channel connects to the feed stream inlet channel between the dehydration unit and a heat exchanger.
26. The system of any one of claim 19-25, further comprising a storage tank channel that
15 extends from the second contaminant storage tank to the feed stream inlet channel before the dehydration unit and the distillation tower.
27. The system of any one of claim 19-26, further comprising a storage tank channel that extends from the second contaminant storage tank to the feed stream inlet channel between the dehydration unit and a heat exchanger.