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Authors: Junaid Haider, Muhammad Abdul Qyyum, Arif Hussain, Muhammad Yasin, Moonyong Lee

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Techno-economic analysis of various process schemes for the production of fuel grade 2,3—butanediol from fermentation broth

 $\label{eq:continuous} \mbox{Junaid Haider}^a, \mbox{Muhammad Abdul Qyyum}^a, \mbox{Arif Hussain}^a, \mbox{Muhammad Yasin}^b, \mbox{and Moonyong} \\ \mbox{Lee}^{a, \, *}$

^a School of Chemical Engineering, Yeungnam University, Gyeongsan 712-749, Rep. of Korea.

^b Department of Chemical Engineering, COMSATS Institute of Information Technology (CIIT), Lahore, Pakistan.

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*Correspondence concerning this article should be addressed to:

Prof. Moonyong Lee

Email: mynlee@yu.ac.kr

Telephone: +82-53-810-2512

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