

## Accepted Manuscript

Title: An energy-efficient operation system for a natural gas liquefaction process: Development and application to a 100 ton-per-day plant

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PII: S0098-1354(16)30394-5  
DOI: <http://dx.doi.org/doi:10.1016/j.compchemeng.2016.11.046>  
Reference: CACE 5635

To appear in: *Computers and Chemical Engineering*

Received date: 27-7-2016  
Revised date: 29-11-2016  
Accepted date: 30-11-2016

Please cite this article as: Won, Wangyun., & Lee, Kwang Soon., An energy-efficient operation system for a natural gas liquefaction process: Development and application to a 100 ton-per-day plant. *Computers and Chemical Engineering* <http://dx.doi.org/10.1016/j.compchemeng.2016.11.046>

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An energy-efficient operation system for a natural gas liquefaction process:  
Development and application to a 100 ton-per-day plant

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**Submitted to Computers & Chemical Engineering**

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