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(54) Titre : PROCEDE D'ISOMERISATION
(54) Title: ISOMERISATION PROCESS

(57) **Abrégé/Abstract:**

A process for the production of triptane, said process comprising: isomerising a hydrocarbon feedstock by containing said feedstock with an isomerisation catalyst at a reaction temperature of -50 to 25 °C , and a contact time of 0.01 to 150 hours, such that the triptane selectivity of the isomerisation reaction is at least 5 % as a proportion of said hydrocarbon feedstock.



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(54) Title: ISOMERISATION PROCESS

(57) Abstract: A process for the production of triptane, said process comprising: isomerising a hydrocarbon feedstock by containing said feedstock with an isomerisation catalyst at a reaction temperature of -50 to 25 °C, and a contact time of 0.01 to 150 hours, such that the triptane selectivity of the isomerisation reaction is at least 5 % as a proportion of said hydrocarbon feedstock.

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Isomerisation Process

The present invention relates to a process for isomerising hydrocarbons. In particular, the present invention relates to a process for selectively isomerising hydrocarbons to obtain triptane (2,2,3-trimethyl butane).

Triptane is a highly branched hydrocarbon which can be used as a fuel additive for motor and aviation gasoline because of its high octane rating. It is generally produced by isomerising or reacting aliphatic, cycloaliphatic and/or alkyl aromatic hydrocarbons in the presence of an isomerisation catalyst. An example of such a process is described in US 3 766 286. This document describes the use of reaction temperatures of -30 to 100°C and contact times of 0.1 to 10 hours. The preferred embodiment, for instance, describes the isomerisation of n-heptane at 25°C for 5 to 6 hours. The triptane yields obtained were between 0.4 and 1.4 wt %.

We have now found that by careful selection of reaction temperature and contact time, the selectivity of the isomerisation process towards triptane may be increased.

According to the present invention, there is provided a process for the production of triptane, said process comprising:

isomerising a hydrocarbon feedstock by contacting said feedstock with an isomerisation catalyst at a reaction temperature of -50 to 25°C , and a contact time of 0.01 to 150 hours, such that the triptane selectivity of the isomerisation reaction is at least 5 % as a proportion of said hydrocarbon feedstock.

Preferably, the reaction temperature is -30 to 15°C , more preferably, -25 to 10°C , even more preferably, -15 to 5°C , most preferably, -10 to 0°C .

The contact time may be 0.05 to 50 hours, preferably, 0.08 to 24 hours, more

preferably, 0.1 to 15 hours, even more preferably, 1 to 10 hours, yet more preferably, 2 to 7 hours and most preferably, 4 to 6 hours.

Preferably, the triptane selectivity is at least 7 %, more preferably, at least 9%. For example, the triptane selectivity may be between 9 and 60 % of the initial hydrocarbon feedstock.

The isomerisation catalyst employed is preferably a superacid. Suitable superacids include those comprising a Lewis acid of the formula MX_n , where M is an element selected from the transition metal series, Group 13, 14, 15 or 16 of the Periodic Table, X is a halogen, or an anion derived from fluorosulfuric acid, trifluoromethanesulfonic acid, or trifluoroacetic acid. n is an integer of 3 to 6. Bronsted acids selected from HX, where X has the same meaning as discussed above and mixtures thereof may also be employed.

Preferably, M is selected from Groups 13 and 15 of the Periodic Table. More preferably, M is Sb. X may be F, Cl, Br or I, and is preferably F or Cl. In preferred embodiments of the invention, M is employed in its highest valency state with the selected halogen. For example, in a most preferred embodiment of the invention, the Lewis acid is SbF_5 .

M may alternatively be selected from the transition metal series. Where M is a transition metal, it is preferably a metal from Group IV or V of the transition metal series. Preferred transition metals include Ti, Zr, Hf, V, Nb, Ta. More preferably, M is selected from Ti, Nb and Ta, and most preferably, M is Ta.

Preferably, the Bronsted acid is selected from HF, trifluoromethanesulfonic and fluorosulfuric acid.

Preferred examples of suitable isomerisation catalysts are HSO_3F-SbF_5 and SbF_5-HF .

The molar ratio of Bronsted acid to Lewis acid can range from about 20:1 to 1:5. Preferably, a 5:1 to 1:1 molar ratio is employed. The amount of the catalyst employed with reference to the total amount of hydrocarbon used may range from about 0.01 to 100 parts by weight of the catalyst per part by weight of hydrocarbon. Preferably, the amount of catalyst employed is 1 to 10 parts by weight of the catalyst per part by weight of the hydrocarbon.

The catalyst may be used as the neat liquid, as a diluted solution or adsorbed on a

methylpentane, methylhexane and the like. The cycloaliphatic hydrocarbons (naphthenes) can contain 6 to 20 carbon atoms per molecule, preferably 6-12 carbon atoms, and may be exemplified by methylcyclopentane, the dimethylcyclopentanes, ethylecyclohexane, n-pentylcyclohexane and the like. Depending on reaction conditions, summarization of the ring, i.e. ring expansion or contraction, may compete with side chain isomerisation. The alkyl substituted aromatic hydrocarbons can contain 7 to 20 carbon atoms per molecule, preferably 7 to 12 carbon atoms, and may include in principle all isomerisable alkylaromatic or polyalkylaromatic hydrocarbons such as the xylenes, n-butyl benzene and the like. Both positional isomerisation of the alkyl groups substituted on the ring and side chain isomerisation may occur depending on reaction conditions. Other aliphatic or alicyclic hydrocarbons commonly found in conventional petroleum hydrocarbon light naphtha streams may also be present.

In a preferred embodiment of the invention, the hydrocarbon feedstock comprises a C₅ to C₉ alkane, for example, a C₇ alkane. C₇ naphtha streams, for instance, may be employed. Examples of suitable C₇ alkanes include n-heptane, 2-methyl hexane, 3-methyl hexane, ethyl pentane, 2,3-dimethyl pentane, 3,3-dimethyl pentane, 2,2-dimethyl pentane and 2,4-dimethyl pentane. The hydrocarbon feedstock may consist essentially of one of these C₇ alkanes, or may comprise a mixture of two or more of them. Suitable alkane mixtures include mixtures of 3-methyl hexane and 2,3-dimethyl pentane and mixtures of heptane and 2,4-dimethyl pentane. The C₇ alkanes may be present in combination with other hydrocarbon species such as naphthenes (eg 0 to 40%, preferably 30 to 36%), and aromatics, such as toluene (eg 0 to 10%, preferably 2 to 5%). An example of such a combination comprises 25 to 40%, preferably, 32 to 38% n-heptane; 10 to 28 %, preferably, 15 to 23% mono-branched heptane; 5 to 15%, preferably, 7 to 11% dibranched heptane; 20 to 40%, preferably, 32 to 38% naphthenes and 0 to 5%, for example, 2 to 3% aromatics. Preferably, however, the aromatic content of the feeds is low, for example, less than 1%. The C₇ alkanes may also be present in the feed together with other alkanes such as C₅, C₆ and C₈ alkanes. An example of such a mixture is an alkylate-C₇ stream comprising 2 to 6, preferably, 4% i-C₅; 3 to 7, preferably, 5% C₆; 50 to 70, preferably, 60 to 62% 2, 3-dimethyl pentane; 20 to 30, preferably, 22 to 26% 2, 4 – dimethyl pentane and 2 to 8, preferably, 4 to 6% C₈.

The hydrocarbon feedstock may contain various cracking inhibitors or moderators

such as hydrogen and/or iso-butane. The inhibitors act to depress excessive cleavage reactions that may occur during the isomerisation. When hydrogen or iso-butane is used, it is employed in amounts ranging, preferably, from 1 to 3 mole percent based on hydrocarbon feed.

5 The process of the invention may be conducted as a batch or continuous type operation. In general, the various means customarily employed in extraction processes to increase the contact area between the hydrocarbon phase and the catalyst phase may be used. In one embodiment of the invention, the hydrocarbon phase and catalyst phase may be contacted substantially in the liquid phase. The apparatus employed may be of
10 a conventional nature. For example, the apparatus may comprise a single reactor, such as a fluidised-bed reactor, or multiple reactors provided, for example, with efficient stirring devices, such as mechanical agitators, ultra-sonic agitators, jets of restricted internal diameter, and turbo mixers. The hydrocarbon phase and the catalyst phase may be passed through one or more reactors in concurrent, cross-current or counter-current
15 flow. Unreacted reactants, catalysts, inhibitors and heavier products of the reaction may be separated from the desired isomeric product and from one another such as by distillation and returned in whole or in part to the isomerisation reaction. The resultant product may be further processed as by alkylation and the like, or be employed directly as a high octane gasoline blending agent.

20 The triptane product may be recovered from the product mixture using any suitable technique. Examples include distillation, extractive distillation, and selective crystallisation. Membranes may also be employed.

 According to a further aspect of the present invention, there is provided a continuous process for the production of triptane, said process comprising:

25 feeding a hydrocarbon feedstock into a reactor,
 contacting the feedstock with an isomerisation catalyst, under reaction conditions effective to produce a product mixture comprising triptane,
 characterised in that the product mixture comprises at least two liquid phases, one liquid phase being denser than the other.

30 The two liquid phases may be separated by simple separation techniques, such as decantation. This separation step may be carried out continuously or at periodic intervals.

The denser of the two liquid phases is typically a polar or ionic phase comprising the isomerisation catalyst, and optionally, any catalyst diluent and/or catalyst support employed in the reaction. The denser liquid phase may be retained in the reactor. Alternatively, the denser liquid phase may be recovered from the reactor, and recycled, preferably, once at least some of the catalyst diluent has been removed from the recovered phase. The catalyst may also be regenerated prior to recycling. It should be noted that the denser of the two phases may be present as an emulsion.

The less dense of the two liquid phases is typically a less or non-polar phase comprising the triptane product. Optionally, other oily products, such as by-products of the reaction may also be present in the second phase. Examples of possible by-products include aliphatic hydrocarbons, for example, those comprising 3 to 10 carbon atoms. Other by-products include aromatic and polymeric species (C_{12} and above). Such species may be fluorinated and/or sulphonated. In a preferred embodiment, the less dense phase is separated from the denser phase, and recovered from the reactor.

In addition to the two liquid phases, the product mixture may also comprise a vapour phase. The vapour phase may comprise triptane, other light aliphatic and aromatic hydrocarbons (eg C_1 to C_9), hydrogen and iso-butane. In a preferred embodiment, at least some of the vapour phase is withdrawn from the reactor. The vapour phase may be purified by condensation and distillation to produce a triptane-containing stream.

Any triptane recovered from the vapour phase may be used in the production of motor or aviation gasoline, especially, unleaded motor or unleaded aviation gasoline. In a preferred embodiment, the condensed vapour is purified further, for example, by distillation, to enhance its concentration of triptane. The remainder of the condensed vapour may be recycled to the reactor. At least one motor or aviation gasoline additive may then be added to the triptane-enhanced product. The resulting mixture may be employed as, or as an additive for a motor or aviation gasoline, preferably, an unleaded motor or aviation gasoline.

The contents of the reactor may be mixed. This mixing step may be carried out using any suitable technique, for example, by using a mechanical stirrer, an ultrasonic agitator and/or by introducing a gas or liquid into the reactor. Any suitable mechanical stirrer may be employed. Gases that may be bubbled through the reactor to agitate its

contents include nitrogen, argon, hydrogen and light hydrocarbons (eg methane, isobutane). Additionally or alternatively, the mixing may be achieved simply as a result of the reactants and/or catalyst being introduced into the reactor.

Although mixing is important for facilitating reaction, it can also inhibit the
5 separation of the two liquid phases. This problem may be alleviated by reducing the rate of agitation. Preferably, however, at least a portion of the product mixture is at least partially shielded from the full force of the agitation, so that it can separate into at least two liquid phases.

Thus, according to a preferred embodiment, there is provided a continuous
10 process for the production of triptane said process comprising:

providing a reactor having a reaction zone and a separation zone,

feeding a hydrocarbon feedstock into a reactor,

contacting the feedstock with an isomerisation catalyst, under reaction conditions effective to produce a product mixture comprising triptane,

15 said process being characterised by having at least a portion of the product mixture in the separation zone, so that it can separate into at least two liquid phases.

The reaction zone and separation zone are preferably in fluid communication with each other. The reaction zone and separation zone may be provided in a single piece of apparatus, for example, by using a reactor having a reaction zone and a separation zone.

20 An advantage of this arrangement is that it keeps pipe-work requirements to a minimum, reducing the material cost of the overall reactor. It should be noted, however, that it is possible to provide the reaction zone and separation zone using separate pieces of apparatus, for example, by coupling a reactor to a separation tank. Multiple reaction zones and/or separation zones may be employed. For example, a
25 reactor having a reaction zone and a separation zone may be coupled to a separate separation tank.

In preferred embodiments of the invention, a reactor having at least one reaction zone and at least one separation zone is employed. For example, the reaction and separation zones may be separated using one or more grids and/or perforated plates. In
30 use, the product mixture is allowed to flow freely between the reaction and separation zones through the apertures or perforations in the grid/plate. When the contents of the reactor on one side of the plate/grid is mixed, the reactor contents on the opposite side

of the plate/grid is shielded at least in part from the full force of the mixing. Thus, the reactor contents on the opposite side of the grid is in the separation zone, and can separate into at least two phases. The stirrer may be employed in combination with one or more baffles, which may be located in the reactor to enhance the mixing effect of in
5 the reaction zone.

The grid or perforated plate may be located in the reactor and placed 0 to 60°, preferably, 0 to 45°, more preferably, 0 to 30° and most preferably, 0 to 15° to the horizontal. In one embodiment, the grid or plate is positioned substantially horizontally. The reactor contents below the grid or plate is agitated, allowing the separation zone to
10 form above the grid or plate. Preferably, the edge(s) of the grid or plate is adjacent to the inner walls of the reactor. The edge(s) may be spaced or in physical engagement with the inner walls of the reactor.

In the embodiment described above, the contents of the reactor is allowed to flow relatively freely through the apertures or perforations of the grid /plate. In an
15 alternative embodiment, the flow of product mixture from the reaction zone to the separation zone may be driven by a mechanical impellor or by the gas lift effect of any bubbles in the reactor. Flow through the separation zone in this mode may be controlled, for example, by positioning a barrier or weir between the reaction zone and separation zone and controlling the driving force across it by controlling the
20 liquid/vapour or liquid/liquid interface levels on either side. Thus, product mixture is allowed to flow from the reaction zone to the separation zone either continuously or at periodic intervals.

The hydrocarbon feedstock may be introduced continuously or at periodic intervals. Preferably, the feedstock is fed to the reactor continuously. The feedstock
25 may be fed into the reactor at a rate of more than 25 g of hydrocarbon per kg of catalyst per hour, for example, from 50 to 2500 g of hydrocarbon per kg of catalyst per hour.

These and other aspects of the present invention will now be described with reference to the drawings, in which:

Figure 1 is a schematic diagram of an apparatus suitable for carrying out an
30 embodiment of the process of the invention, and

Figure 2 is a schematic diagram of an alternative apparatus suitable for carrying out an embodiment of the process of the invention

Referring to Figure 1, the apparatus comprises a reactor 10, which is divided into a reaction zone 12 and a separation zone 14 by a grid 16. The reactor is provided with a pair of baffle plates 18, 20 and a mechanical stirrer 22. The stirrer 22 extends into the reaction zone 12.

5 In operation, the reaction zone 12 is charged with 30 mol % SbF_5 in FSO_3H via line "A". A reactant stream comprising naphtha is also continuously fed to the reaction zone 12 via line "B", and the contents of the reaction zone 12 is agitated by the mechanical stirrer 22. The reaction zone 12 is maintained at -30 to 10°C , and a pressure of less than 50 bar. Under the reaction conditions, the naphtha is isomerised to
10 produce a product mixture comprising triptane.

The contents of the reactor 10 is free to flow between the reaction zone 12 and the separation zone 14 through the apertures (not shown) of the grid 16. The grid 16, however, shields the product mixture in the separation zone at least in part from the full force of the agitation caused by the stirrer 22. Thus, the product mixture in the
15 separation zone 14 is allowed to settle and separate into a less dense phase, and a dense phase. The less dense phase contains the triptane product, and is continuously recovered from the separation zone via line "C". The dense phase may be present as an emulsion because of the agitational forces in the reaction zone 12.

Figure 2 depicts an alternative apparatus for carrying out an embodiment of the
20 present invention. The apparatus comprises a reactor 110, which is divided into a reaction zone 112 and a separation zone 114 by a separator 116. The separator 116 comprises an inlet 118, and an outlet 120. The reactor 110 is also provided with a mechanical stirrer 122, which extends into the reaction zone 112.

In operation, the reaction zone 112 is charged with 30 mol % SbF_5 in FSO_3H via
25 line "A". A reactant stream comprising naphtha is also continuously fed to the reaction zone 112 via line "B", and the contents of the reaction zone 112 is agitated by the mechanical stirrer 122. The reaction zone 112 is maintained at -30 to 10°C , and a pressure of less than 50 bar. Under the reaction conditions, the naphtha is isomerised to produce a product mixture comprising triptane.

30 The reaction mixture of the reaction zone 112 is present as an emulsion because of the agitational forces caused by the stirrer 122. The reaction mixture of the reaction zone 112, however, is free to flow from the reaction zone 112 into the separation zone

114 via the outlet 120 of the separator 116. In the separation zone, the reaction mixture is shielded from the full force of the agitation caused by the stirrer 122. Thus, the reaction mixture is allowed to settle and separate into three phases: a less dense phase 124, a middle phase 126 and a dense phase 128. The less dense phase 124 contains the triptane product, and is continuously recovered from the separation zone via line "C".
5 The dense phase 128 comprises the acid catalyst (30 mol % SbF_5 in FSO_3H). Some of this phase 128 is allowed to flow back into the reaction zone 112 via the inlet 118.

Examples

A hydrocarbon (100ml) was intimately mixed with a dense catalyst consisting of
10 30 mol % SbF_5 in FSO_3H in a batch autoclave at temperature of -30 to 10°C . To ensure good mixing a baffle was employed, and the reaction mixture was stirred at 2000 rpm. Samples were removed from the reaction mixture at timed intervals and analysed by gas chromatography. The results are shown in Table 1 below.

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| | | | Selectivity | | | Yield |
|-------------------|------|-----------|-------------|---------------------|-------|--------|
| Feed | Temp | Res. time | 223TMB | C ₇ Isom | Conv. | 223TMB |
| | °C | minutes | % | % | % | wt % |
| Heptane | -30 | 7440 | 12.8 | 94.4 | 68.3 | 8.7 |
| “ | -20 | 1890 | 11.4 | 94.2 | 45.3 | 5.2 |
| “ | -10 | 300 | 10.4 | 93.8 | 50.5 | 5.3 |
| “ | 0 | 120 | 8.6 | 91.4 | 26.8 | 2.3 |
| “ | 10 | 25 | 8.5 | 94.6 | 9.9 | 0.8 |
| | | | | | | |
| 3MHx | -30 | 4260 | 15.9 | 99.8 | 87.0 | 13.8 |
| “ | -20 | 525 | 15.1 | 92.7 | 85.1 | 12.9 |
| “ | -10 | 90 | 10.0 | 96.1 | 82.1 | 8.2 |
| “ | 0 | 36 | 8.0 | 97.7 | 80.0 | 6.4 |
| | | | | | | |
| 23DMP | -30 | 4260 | 14.4 | 99.8 | 90.0 | 13.0 |
| “ | -20 | 1440 | 13.9 | 91.4 | 92.2 | 12.8 |
| “ | -10 | 310 | 13.4 | 93.6 | 92.1 | 12.3 |
| “ | 0 | 75 | 11.7 | 91.6 | 91.9 | 10.8 |
| | | | | | | |
| 3MHx/23DM | | | | | | |
| P | -30 | 4860 | 16.2 | 99.7 | 78.0 | 12.6 |
| “ | -20 | 1020 | 15.1 | 99.7 | 77.0 | 11.6 |
| “ | -10 | 310 | 14.0 | 90.4 | 72.7 | 10.2 |
| “ | 0 | 60 | 10.0 | 99.6 | 76.0 | 7.6 |
| | | | | | | |
| Heptane/ 24DMP | -30 | 4200 | 14.5 | 99.8 | 59.0 | 8.6 |
| “ | -20 | 1044 | 13.8 | 99.6 | 58.0 | 8.0 |
| “ | -10 | 240 | 12.2 | 99.6 | 54.0 | 6.6 |
| “ | 0 | 60 | 10.6 | 99.5 | 51.0 | 5.4 |
| | | | | | | |

Cont/...

| Feed | Temp | Res. time | Selectivity | | Conv. | Yield |
|-------|------|-----------|-------------|---------------------|-------|--------|
| | | | 223TMB | C ₇ Isom | | 223TMB |
| | | | % | % | | wt % |
| | °C | minutes | % | % | % | wt % |
| 24DMP | -30 | 3600 | 15.6 | 99.8 | 75.0 | 11.7 |
| “ | -20 | 900 | 15.0 | 99.7 | 75.0 | 11.3 |
| “ | -10 | 240 | 14.2 | 99.6 | 74.0 | 10.5 |
| “ | 0 | 60 | 12.5 | 99.6 | 74.0 | 9.3 |

Key: heptane = n-heptane; 3MHx = 3-methyl hexane; 23DMP = 2, 3- dimethyl pentane;
 24DMP = 2,4-dimethyl pentane; conv. = conversion; res. = residence

As can be seen from the data, the selectivity of the process towards triptane is at least
 5 8.0% under the reaction conditions are employed.

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Claims

1. A process for the production of triptane, said process comprising:
isomerising a hydrocarbon feedstock by contacting said feedstock with an
isomerisation catalyst at a reaction temperature of -50 to 25°C , and a contact time of
0.01 to 150 hours, such that the triptane selectivity of the isomerisation reaction is at
5 least 5 % as a proportion of said hydrocarbon feedstock.
2. A process as claimed in claim 1, wherein the reaction temperature is -30 to 15°C .
3. A process as claimed in claim 1 or 2, wherein the contact time is 0.08 to 24 hours.
4. A process as claimed in any preceding claim, wherein the triptane selectivity is
between 9 and 60 % of the initial hydrocarbon feedstock.
- 10 5. A process as claimed in any preceding claim, wherein the isomerisation catalyst
employed is a superacid.
6. A process as claimed in claim 5, wherein the isomerisation catalyst comprises
 $\text{HSO}_3\text{F-SbF}_5$, $\text{SbF}_5\text{-HF}$ or a mixture thereof.
7. A process as claimed in any preceding claim, wherein the catalyst is employed as
15 a solution.
8. A process as claimed in claim 7, wherein the catalyst is dissolved in a diluent
selected from the group consisting of sulfuryl chloride fluoride, sulfuryl fluoride,
fluorinated hydrocarbons, fluorosulfuric acid, sulfuric acid, trifluoromethanesulfonic
acid and mixtures thereof.
- 20 9. A process as claimed in any one of claims 1 to 6, wherein the catalyst is
supported.
10. A process as claimed in any preceding claim, wherein the hydrocarbon feedstock

is a naphtha stream.

11. A process as claimed in claim 10, wherein the naphtha stream comprises a major amount of C₅ to C₈ hydrocarbons.
12. A process as claimed in claim 11, wherein the naphtha stream is a C₇ naphtha stream comprising at least one of n- heptane, 2-methyl hexane, 3-methyl hexane, ethyl pentane, 2,3-dimethyl pentane, 3,3-dimethyl pentane. 2,2-dimethyl pentane and 2,4-dimethyl pentane.
13. A process as claimed in any preceding claim, which is carried out in a batch manner or continuously.
14. A continuous process for the production of triptane, said process comprising:
 - feeding a hydrocarbon feedstock into a reactor,
 - contacting the feedstock with an isomerisation catalyst, under reaction conditions effective to produce a product mixture comprising triptane,
 - characterised in that the product mixture comprises at least two liquid phases, one liquid phase being denser than the other.
15. A continuous process as claimed in claim 14, wherein one of the two liquid phases is separated from the other by decantation.
16. A continuous process as claimed in claim 14 or 15, wherein the denser of the two liquid phases is either
 - retained in the reactor, or
 - recovered from the reactor, purified and recycled.
17. A continuous process as claimed in any one of claims 15 to 16, wherein the less dense of the two liquid phases is separated from the denser phase, recovered from the reactor, and optionally, purified to increase its concentration of triptane.
18. A continuous process as claimed in any one of claims 14 to 17, wherein in addition to the two liquid phases, the product mixture also comprises a vapour phase.
19. A continuous process as claimed in claim 18, wherein the vapour phase is condensed and optionally purified to produce a triptane-containing stream.
20. A continuous process as claimed in any one of claims 14 to 19, which comprises:
 - providing a reactor having a reaction zone and a separation zone,
 - feeding a hydrocarbon feedstock into a reactor,
 - contacting the feedstock with an isomerisation catalyst, under reaction conditions

effective to produce a product mixture comprising triptane,

said process being characterised by having at least a portion of the product mixture in the separation zone, so that it can separate into at least two liquid phases.

21. A continuous process as claimed in claim 20, wherein the reaction zone and
5 separation zone are in fluid communication with each other.
22. A continuous process as claimed in claim 21, wherein the reaction zone and separation zone are separated using one or more grids and/or perforated plates.
23. A continuous process as claimed in claim 22, wherein the reactor contents on one
10 side of the grid or plate is agitated, allowing the separation zone to form on the opposite side of the grid or plate.

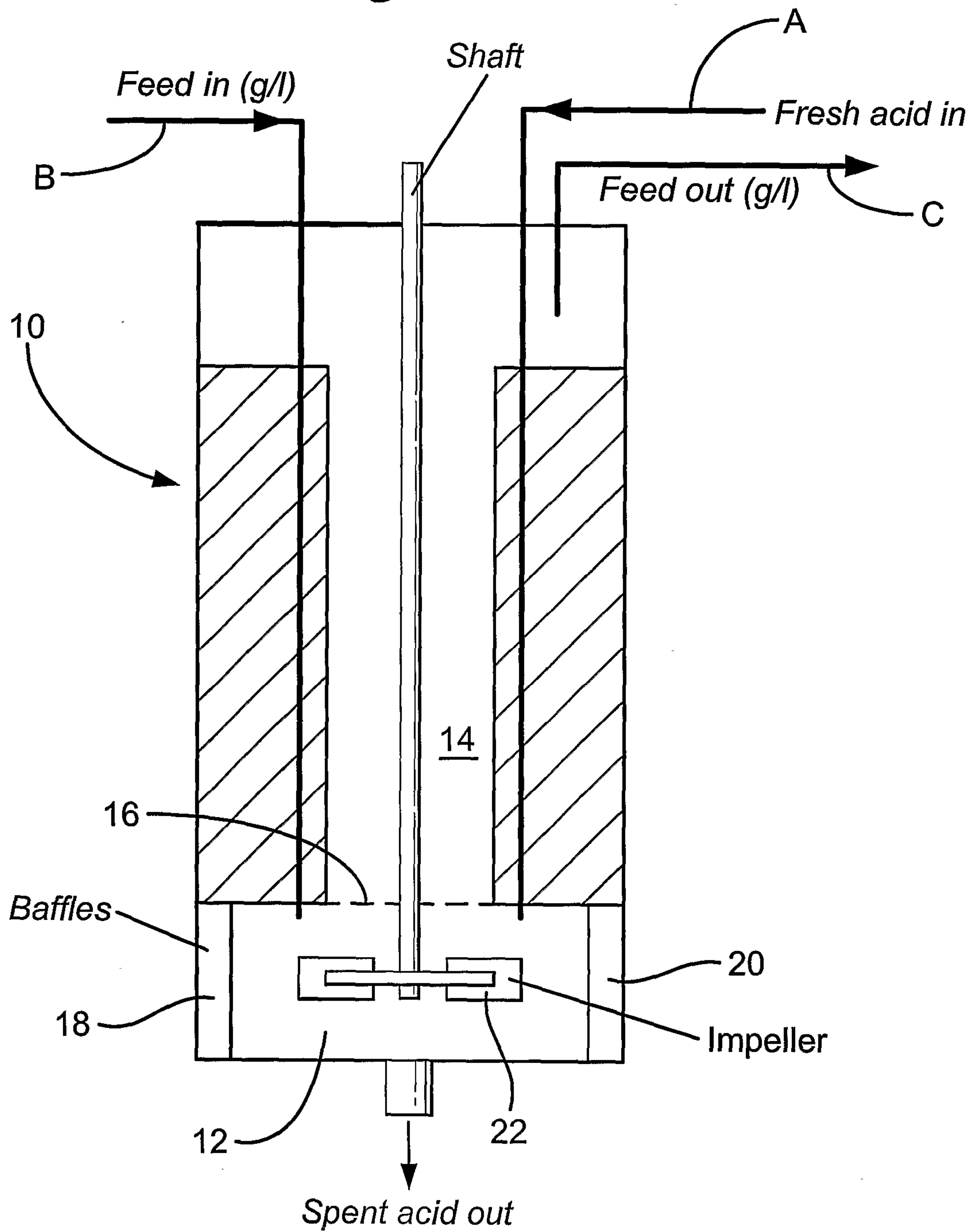
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Fig. 1

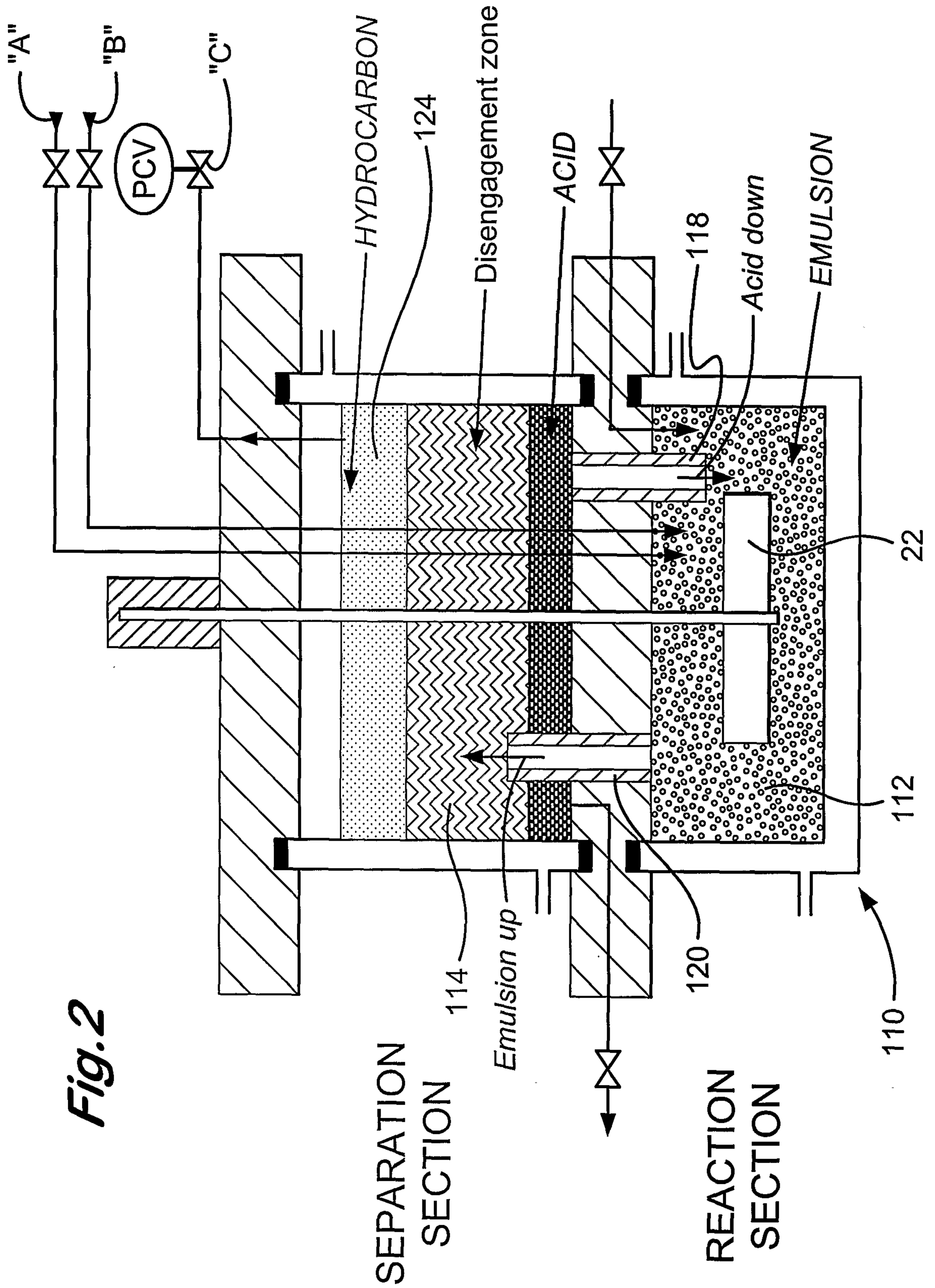


Fig. 2