



- (51) **International Patent Classification:**
B01J 29/62 (2006.01) *C10G 35/095* (2006.01)
B01J 35/10 (2006.01)
- (21) **International Application Number:**
PCT/US2013/061370
- (22) **International Filing Date:**
24 September 2013 (24.09.2013)
- (25) **Filing Language:** English
- (26) **Publication Language:** English
- (30) **Priority Data:**
13/626,904 26 September 2012 (26.09.2012) US
- (71) **Applicant:** CHEVRON PHILLIPS CHEMICAL COMPANY LP [US/US]; 10001 Six Pines Drive, The Woodlands, Texas 77380 (US).
- (72) **Inventor; and**
- (71) **Applicant :** KHARE, Gyanesh [US/US]; 19418 Texas Laurel Trail, Kingwood, Texas 77346 (US).
- (74) **Agent:** DOCKTER (55120), David; Chevron Phillips Chemical Company LP, 10001 Six Pines Drive, The Woodlands, Texas 77380 (US).

- (81) **Designated States** (*unless otherwise indicated, for every kind of national protection available*): AE, AG, AL, AM, AO, AT, AU, AZ, BA, BB, BG, BH, BN, BR, BW, BY, BZ, CA, CH, CL, CN, CO, CR, CU, CZ, DE, DK, DM, DO, DZ, EC, EE, EG, ES, FI, GB, GD, GE, GH, GM, GT, HN, HR, HU, ID, IL, IN, IS, JP, KE, KG, KN, KP, KR, KZ, LA, LC, LK, LR, LS, LT, LU, LY, MA, MD, ME, MG, MK, MN, MW, MX, MY, MZ, NA, NG, NI, NO, NZ, OM, PA, PE, PG, PH, PL, PT, QA, RO, RS, RU, RW, SA, SC, SD, SE, SG, SK, SL, SM, ST, SV, SY, TH, TJ, TM, TN, TR, TT, TZ, UA, UG, US, UZ, VC, VN, ZA, ZM, ZW.
- (84) **Designated States** (*unless otherwise indicated, for every kind of regional protection available*): ARIPO (BW, GH, GM, KE, LR, LS, MW, MZ, NA, RW, SD, SL, SZ, TZ, UG, ZM, ZW), Eurasian (AM, AZ, BY, KG, KZ, RU, TJ, TM), European (AL, AT, BE, BG, CH, CY, CZ, DE, DK, EE, ES, FI, FR, GB, GR, HR, HU, IE, IS, IT, LT, LU, LV, MC, MK, MT, NL, NO, PL, PT, RO, RS, SE, SI, SK, SM, TR), OAPI (BF, BJ, CF, CG, CI, CM, GA, GN, GQ, GW, KM, ML, MR, NE, SN, TD, TG).

Published:

— with international search report (Art. 21(3))

(54) **Title:** AROMATIZATION CATALYSTS WITH HIGH SURFACE AREA AND PORE VOLUME

(57) **Abstract:** Regenerable aromatization catalysts having high surface area and pore volume, as well as methods for producing these catalysts, are disclosed.



WO 2014/052299 A1

AROMATIZATION CATALYSTS WITH HIGH SURFACE AREA AND PORE VOLUME

BACKGROUND OF THE INVENTION

5 The catalytic conversion of non-aromatic hydrocarbons into aromatic compounds, often referred to as aromatization or reforming, is an important industrial process that can be used to produce benzene, toluene, xylene, and the like. The aromatization or reforming process often is conducted in a reactor system that can contain one or more reactors containing transition metal based catalysts. These catalysts can increase the selectivity to
10 and/or the yield of the desired aromatic compounds. These catalysts also slowly lose their activity over time, often indicated by a loss of the selectivity to desired aromatic compounds and/or a reduction in conversion rates. However, some commercially available catalysts which have high catalyst activity and offer good product selectivity and/or yield are not regenerable. Other commercially available catalysts are regenerable, but often have lower
15 catalyst activity and/or selectivity, as well as higher fouling rates.

Hence, it would be beneficial to have an improved aromatization catalyst which offers high catalyst activity and/or selectivity, low fouling rates, and is regenerable. Accordingly, it is to these ends that the present disclosure is directed.

20 SUMMARY OF THE INVENTION

This summary is provided to introduce a selection of concepts in a simplified form that are further described below in the detailed description. This summary is not intended to identify required or essential features of the claimed subject matter. Nor is this summary intended to be used to limit the scope of the claimed subject matter.

25 Catalysts that can be used in aromatization processes are disclosed and described herein. In one embodiment, such catalysts can have a surface area of at least about 165 m²/g, and can comprise (i) an alkaline earth metal exchanged zeolitic support, and (ii) a Group VIII transition metal. In a further embodiment, this catalyst can be substantially free of fluorine.

30 Methods of producing catalysts also are disclosed herein. One such method of producing a catalyst can comprise (a) contacting a zeolitic base with an alkaline earth metal-containing compound to form an alkaline earth metal exchanged zeolitic support; (b) calcining the alkaline earth metal exchanged zeolitic support at a peak calcining temperature of less than about 550 °C (1022 °F); (c) impregnating the calcined alkaline earth metal exchanged zeolitic support with a Group VIII transition metal-containing compound; and (d)

calcining the impregnated alkaline earth metal exchanged zeolitic support to produce a catalyst having a surface area of at least about 165 m²/g.

Also disclosed herein are various processes for reforming hydrocarbons. One such reforming process can comprise contacting a hydrocarbon feed with a supported aromatization catalyst under reforming conditions in a reactor system to produce an aromatic product. In this reforming process, the supported aromatization catalyst can have a surface area of at least about 165 m²/g, and can comprise (i) an alkaline earth metal exchanged zeolitic support, and (ii) a Group VIII transition metal.

Both the foregoing summary and the following detailed description provide examples and are explanatory only. Accordingly, the foregoing summary and the following detailed description should not be considered to be restrictive. Further, features or variations may be provided in addition to those set forth herein. For example, certain embodiments may be directed to various feature combinations and sub-combinations described in the detailed description.

BRIEF DESCRIPTION OF THE FIGURE

FIG. 1 presents a plot of the yield adjusted temperature versus reaction time for Examples 18-19 for a first reaction cycle and a second reaction cycle (after regeneration).

DEFINITIONS

To define more clearly the terms used herein, the following definitions are provided. Unless otherwise indicated, the following definitions are applicable to this disclosure. If a term is used in this disclosure but is not specifically defined herein, the definition from the IUPAC Compendium of Chemical Terminology, 2nd Ed (1997) can be applied, as long as that definition does not conflict with any other disclosure or definition applied herein, or render indefinite or non-enabled any claim to which that definition is applied. To the extent that any definition or usage provided by any document incorporated herein by reference conflicts with the definition or usage provided herein, the definition or usage provided herein controls.

Regarding claim transitional terms or phrases, the transitional term "comprising," which is synonymous with "including," "containing," "having," or "characterized by," is inclusive or open-ended and does not exclude additional, unrecited elements or method steps. The transitional phrase "consisting of" excludes any element, step, or ingredient not specified in the claim. The transitional phrase "consisting essentially of" limits the scope of a claim to the specified materials or steps and those that do not materially affect the basic and novel

characteristic(s) of the claim. A “consisting essentially of” claim occupies a middle ground between closed claims that are written in a “consisting of” format and fully open claims that are drafted in a “comprising” format. For example, absent an indication to the contrary, describing a compound or composition as “consisting essentially of” is not to be construed as “comprising,” but is intended to describe the recited component that includes materials which do not significantly alter the composition or method to which the term is applied. For example, a feedstock consisting essentially of a material A can include impurities typically present in a commercially produced or commercially available sample of the recited compound or composition. When a claim includes different features and/or feature classes (for example, a method step, feedstock features, and/or product features, among other possibilities), the transitional terms comprising, consisting essentially of, and consisting of apply only to the feature class to which it is utilized, and it is possible to have different transitional terms or phrases utilized with different features within a claim. For example, a method can comprise several recited steps (and other non-recited steps), but utilize a catalyst system consisting of specific components; alternatively, consisting essentially of specific components; or alternatively, comprising the specific components and other non-recited components.

In this disclosure, while compositions and methods are often described in terms of “comprising” various components or steps, the compositions and methods can also “consist essentially of” or “consist of” the various components or steps, unless stated otherwise.

The terms “a,” “an,” and “the” are intended to include plural alternatives, e.g., at least one. For instance, the disclosure of “a transition metal,” “a zeolitic support,” etc., is meant to encompass one, or mixtures or combinations of more than one, transition metal, zeolitic support, etc., unless otherwise specified.

Following long term usage, a catalyst can become deactivated and have unacceptable performance in one or more of catalyst activity, hydrocarbon feed conversion, yield to a desired product(s), selectivity to a desired product(s), or an operating parameter, such as output/production rate or reforming temperature, although the determination that a catalyst is deactivated is not limited only to these features. Generally, once the catalyst performance has become unacceptable, the deactivated catalyst can be replaced with a fresh charge or it can be regenerated (e.g., in-situ regeneration, ex-situ regeneration, etc.). As used herein, a catalyst is considered “regenerable” if one or both of the following two criteria are met. The first criteria is based on the projected cycle length or useful life of the catalyst, as determined in accordance with the procedures described in Examples 18-19. If the fresh catalyst has a

cycle length or useful life of "X" hours, then a catalyst is "regenerable" if the cycle length or useful life of the regenerated catalyst is at least 0.5X (i.e., at least 50% of the useful life of the fresh catalyst in its first cycle of use). In certain embodiments disclosed herein, the useful life of a regenerable catalyst can be least 0.65X, at least 0.75X, at least 0.8X, or more. The second criteria is based on the "delta" start of run temperature (ΔT_{SOR}), as determined in accordance with the procedures described in Examples 18-19. A catalyst is "regenerable" if the difference between the start of run temperature of the catalyst after a regeneration and the start of run temperature of the fresh catalyst (ΔT_{SOR}) is less than 30 °F. In certain embodiments disclosed herein, the ΔT_{SOR} can be less than 20 °F, less than 15 °F, or less than 10 °F.

For any particular compound or group disclosed herein, any name or structure (general or specific) presented is intended to encompass all conformational isomers, regioisomers, stereoisomers, and mixtures thereof that can arise from a particular set of substituents, unless otherwise specified. The name or structure (general or specific) also encompasses all enantiomers, diastereomers, and other optical isomers (if there are any) whether in enantiomeric or racemic forms, as well as mixtures of stereoisomers, as would be recognized by a skilled artisan, unless otherwise specified. For example, a general reference to pentane, for example, includes n-pentane, 2-methyl-butane, and 2,2-dimethylpropane; and a general reference to a butyl group includes a n-butyl group, a sec-butyl group, an iso-butyl group, and a t-butyl group.

In one embodiment, a chemical "group" can be defined or described according to how that group is formally derived from a reference or "parent" compound, for example, by the number of hydrogen atoms removed from the parent compound to generate the group, even if that group is not literally synthesized in such a manner. These groups can be utilized as substituents or coordinated or bonded to metal atoms. By way of example, an "alkyl group" formally can be derived by removing one hydrogen atom from an alkane. The disclosure that a substituent, ligand, or other chemical moiety can constitute a particular "group" implies that the well-known rules of chemical structure and bonding are followed when that group is employed as described. When describing a group as being "derived by," "derived from," "formed by," or "formed from," such terms are used in a formal sense and are not intended to reflect any specific synthetic methods or procedures, unless specified otherwise or the context requires otherwise.

Various numerical ranges are disclosed herein. When Applicants disclose or claim a range of any type, Applicants' intent is to disclose or claim individually each possible

number that such a range could reasonably encompass, including end points of the range as well as any sub-ranges and combinations of sub-ranges encompassed therein, unless otherwise specified. As a representative example, Applicants disclose that catalysts provided herein can have a surface area in a range from about 165 to about 225 m²/g in certain
5 embodiments. By a disclosure that the surface area can be in a range from about 165 to about 225 m²/g, Applicants intend to recite that the surface area can be equal to about 165, about 170, about 175, about 180, about 185, about 190, about 195, about 200, about 205, about 210, about 215, about 220, or about 225 m²/g. Additionally, the surface area can be within any range from about 165 to about 225 m²/g (for example, the surface area can be in a range from
10 about 170 to about 210 m²/g), and this includes any combination of ranges between about 165 to about 225 m²/g. Likewise, all other ranges disclosed herein should be interpreted in a manner similar to this example.

Applicants reserve the right to proviso out or exclude any individual members of any such group, including any sub-ranges or combinations of sub-ranges within the group, that
15 can be claimed according to a range or in any similar manner, if for any reason Applicants choose to claim less than the full measure of the disclosure, for example, to account for a reference that Applicants can be unaware of at the time of the filing of the application. Further, Applicants reserve the right to proviso out or exclude any individual substituents, analogs, compounds, ligands, structures, or groups thereof, or any members of a claimed
20 group, if for any reason Applicants choose to claim less than the full measure of the disclosure, for example, to account for a reference that Applicants can be unaware of at the time of the filing of the application.

The term “substituted” when used to describe a group, for example, when referring to a substituted analog of a particular group, is intended to describe any non-hydrogen moiety
25 that formally replaces a hydrogen atom in that group, and is intended to be non-limiting. A group or groups can also be referred to herein as “unsubstituted” or by equivalent terms such as “non-substituted,” which refers to the original group in which a non-hydrogen moiety does not replace a hydrogen atom within that group. Unless otherwise specified, “substituted” is intended to be non-limiting and include inorganic substituents or organic substituents as
30 understood by one of ordinary skill in the art.

As used herein, the term “hydrocarbon” refers to a compound containing only carbon and hydrogen atoms. Other identifiers can be utilized to indicate the presence of particular groups, if any, in the hydrocarbon (e.g., halogenated hydrocarbon indicates that the presence

of one or more halogen atoms replacing an equivalent number of hydrogen atoms in the hydrocarbon).

An “aromatic” compound is a compound containing a cyclically conjugated double bond system that follows the Hückel ($4n+2$) rule and contains ($4n+2$) pi-electrons, where n is an integer from 1 to 5. Aromatic compounds include “arenes” (hydrocarbon aromatic compounds, e.g., benzene, toluene, xylene, etc.) and “heteroarenes” (heteroaromatic compounds formally derived from arenes by replacement of one or more methine ($-C=$) carbon atoms of the cyclically conjugated double bond system with a trivalent or divalent heteroatoms, in such a way as to maintain the continuous pi-electron system characteristic of an aromatic system and a number of out-of-plane pi-electrons corresponding to the Hückel rule ($4n+2$)). As disclosed herein, the term “substituted” can be used to describe an aromatic group, arene, or heteroarene, wherein a non-hydrogen moiety formally replaces a hydrogen atom in the compound, and is intended to be non-limiting, unless specified otherwise.

As used herein, the term “alkane” refers to a saturated hydrocarbon compound. Other identifiers can be utilized to indicate the presence of particular groups, if any, in the alkane (e.g., halogenated alkane indicates that the presence of one or more halogen atoms replacing an equivalent number of hydrogen atoms in the alkane). The term “alkyl group” is used herein in accordance with the definition specified by IUPAC: a univalent group formed by removing a hydrogen atom from an alkane. The alkane or alkyl group can be linear or branched unless otherwise specified.

A “cycloalkane” is a saturated cyclic hydrocarbon, with or without side chains, for example, cyclobutane, cyclopentane, cyclohexane, methyl cyclopentane, methyl cyclohexane, etc. Other identifiers can be utilized to indicate the presence of particular groups, if any, in the cycloalkane (e.g., halogenated cycloalkane indicates that the presence of one or more halogen atoms replacing an equivalent number of hydrogen atoms in the cycloalkane).

The term “halogen” has its usual meaning. Examples of halogens include fluorine, chlorine, bromine, and iodine.

Although any methods and materials similar or equivalent to those described herein can be used in the practice or testing of the invention, the typical methods and materials are herein described.

All publications and patents mentioned herein are incorporated herein by reference for the purpose of describing and disclosing, for example, the constructs and methodologies that are described in the publications, which might be used in connection with the presently described invention. The publications discussed throughout the text are provided solely for

their disclosure prior to the filing date of the present application. Nothing herein is to be construed as an admission that the inventors are not entitled to antedate such disclosure by virtue of prior invention.

5

DETAILED DESCRIPTION OF THE INVENTION

Disclosed herein are catalysts having high surface area and pore volume, methods for producing such catalysts, and the use of these catalysts in reforming processes.

CATALYSTS

10

Consistent with embodiments disclosed herein are catalysts comprising (or consisting essentially of, or consisting of) an alkaline earth metal exchanged zeolitic support, and a Group VIII transition metal. Generally, the features of any of the catalysts disclosed herein (e.g., the zeolitic support, the alkaline earth metal, the Group VIII transition metal, and other compositional aspects; the surface area, total pore volume, and the micropore volume of the catalyst; among others) are independently described herein, and these features can be

15

combined in any combination to further describe the disclosed catalysts.

The catalyst contains an alkaline earth metal exchanged zeolitic support, and the zeolitic support typically can comprise a crystalline inorganic oxide, examples of which can include, but are not limited to, medium and/or large pore zeolites (aluminosilicates), as well

20

as mixtures thereof. Large pore zeolites often can have average pore diameters in a range of from about 7 Å to about 12 Å, and non-limiting examples of large pore zeolites include L-zeolite, Y-zeolite, mordenite, omega zeolite, beta zeolite, and the like. Medium pore zeolites often can have average pore diameters in a range of from about 5 Å to about 7 Å.

The term “zeolite” generally refers to a particular group of hydrated, crystalline metal

25

aluminosilicates. These zeolites exhibit a network of SiO_4 and AlO_4 tetrahedra in which aluminum and silicon atoms are crosslinked in a three-dimensional framework by sharing oxygen atoms. In the framework, the ratio of oxygen atoms to the total of aluminum and silicon atoms can be equal to 2. The framework exhibits a negative electrovalence that typically can be balanced by the inclusion of cations within the crystal, such as metals, alkali

30

metals, alkaline earth metals, and/or hydrogen.

In some embodiments, the zeolitic support can comprise an L-type zeolite. L-type zeolite supports are a sub-group of zeolitic supports, which can contain mole ratios of oxides in accordance with the formula: $\text{M}_{2/n}\text{OAl}_2\text{O}_3\text{xSiO}_2\text{yH}_2\text{O}$. In this formula, “M” designates an exchangeable cation (one or more) such as barium, calcium, cerium, lithium, magnesium,

potassium, sodium, strontium, and/or zinc, as well as non-metallic cations like hydronium and ammonium ions, which may be replaced by other exchangeable cations without causing a substantial alteration of the basic crystal structure of the L-type zeolite. The “n” in the formula represents the valence of “M”; “x” is 2 or greater; and “y” is the number of water molecules contained in the channels or interconnected voids of the zeolite. In one embodiment, the zeolitic support can comprise a potassium L-type zeolite, also referred to as a KL-zeolite, in which the principal cation M incorporated in the zeolite is potassium.

Consistent with embodiments disclosed herein, the zeolite (e.g., a L-zeolite, a KL-zeolite, etc.) can be cation-exchanged with an alkaline earth metal. The resulting zeolitic support, therefore, can comprise an alkaline earth metal, such as barium, strontium, calcium, magnesium, or a combination thereof. In one embodiment, the zeolitic support can comprise barium; alternatively, strontium; alternatively, calcium; or alternatively, magnesium. In another embodiment, the zeolitic support can comprise a barium ion-exchanged L-zeolite.

While not being limited thereto, the catalyst often can comprise from about 0.1 wt. % to about 50 wt. % of the alkaline earth metal (e.g., barium). All weight percentages related to the catalyst are based on the total weight of the dried and calcined catalyst, unless indicated otherwise by the context or specified otherwise. For example, the catalyst can comprise from about 1 wt. % to about 20 wt. %, from about 2 wt. % to about 10 wt. %, or from about 4 wt. % to about 8 wt. %, alkaline earth metal (e.g., barium), based on the total weight of the catalyst.

The zeolitic support can further comprise a binder, for instance, the zeolite can be bound with a binder (or support matrix), and non-limiting examples of binders can include, but are not limited to, inorganic solids oxides, clays, and the like, as well as combinations thereof. The zeolite can be bound with the binder or support matrix as described herein below, or by using any method known in the art. In some embodiments, the binder can comprise alumina, silica, magnesia, boria, titania, zirconia, or a mixed oxide thereof (e.g., an aluminosilicate), or a mixture thereof, while in other embodiments, the binder can comprise a montmorillonite, a kaolin, a cement, or a combination thereof. In a particular embodiment contemplated herein, the binder can comprise silica, alumina, or a mixed oxide thereof; alternatively, silica; alternatively, alumina; or alternatively, silica-alumina.

While not being limited thereto, the zeolitic support often can comprise from about 3 wt. % to about 35 wt. % binder. For example, the zeolitic support can comprise from about 5 wt. % to about 30 wt. %, or from about 10 wt. % to about 30 wt. % binder. These weight percentages are based on the total weight of the zeolitic support.

The catalyst can comprise a transition metal, typically a Group VIII transition metal, and non-limiting examples of suitable transition metals can include iron, cobalt, nickel, ruthenium, rhodium, palladium, osmium, iridium, platinum, and the like, or a combination of two or more transition metals. In a particular embodiment, the transition metal can comprise platinum (Pt).

In one embodiment, the catalyst can comprise from about 0.1 wt. % to about 10 wt. % transition metal. In another embodiment, the catalyst can comprise from about 0.2 wt. % to about 5 wt. % transition metal. In yet another embodiment, the catalyst can comprise from about 0.3 wt. % to about 2 wt. % transition metal, or from about 0.5 wt. % to about 2 wt. % transition metal. These weight percentages are based on the total weight of the catalyst.

In circumstances where the transition metal is platinum or comprises platinum, the catalyst can contain from about 0.1 wt. % to about 10 wt. % platinum; alternatively, from about 0.2 wt. % to about 5 wt. % platinum; alternatively, from about 0.3 wt. % to about 2 wt. % platinum; or alternatively, from about 0.5 wt. % to about 2 wt. % platinum. In a particular embodiment contemplated herein, the catalyst can comprise platinum on a zeolitic support comprising a L-zeolite, such as a barium ion-exchanged L-zeolite.

In some embodiments, the catalyst can further comprise chlorine. When present, chlorine can be present in the catalyst in an amount of from about 0.025 wt. % to about 5 wt. %, from about 0.05 wt. % to about 5 wt. %, from about 0.1 wt. % to about 1 wt. %, from about 0.1 wt. % to about 0.8 wt. %, from about 0.1 wt. % to about 0.7 wt. %, from about 0.1 wt. % to about 0.6 wt. %, or from about 0.1 wt. % to about 0.5 wt. %. These weight percentages are based on the total weight of the catalyst.

In other embodiments, however, the catalyst can be substantially free of fluorine. In this context, "substantially free" means less than 2500 ppmw (ppm by weight) of fluorine in the catalyst. Therefore, it is contemplated that the catalyst can contain fluorine in an amount less than 2000 ppmw, less than 1000 ppmw, less than 500 ppmw, less than 100 ppmw, less than 50 ppmw, or less than 25 ppmw, in various embodiments. While not wishing to be bound by theory, Applicants believe that it can be beneficial to have substantially no fluorine present on the catalyst.

Generally, catalysts disclosed herein have a relatively high surface area, often having a surface area of at least about 165 m²/g. In one embodiment, for instance, the catalyst can have a surface area of at least about 170 m²/g, while in another embodiment, the catalyst can have a surface area of at least about 175 m²/g. In yet another embodiment, the catalyst can have a surface area of at least about 180 m²/g. Contemplated ranges for the catalyst surface

area can include, but are not limited to, the following ranges: from about 165 to about 250 m²/g, from about 165 to about 225 m²/g, from about 170 to about 220 m²/g, from about 170 to about 210 m²/g, from about 175 to about 225 m²/g, from about 175 to about 210 m²/g, from about 180 to about 220 m²/g, or from about 180 to about 200 m²/g, and the like.

5 In addition to relatively high surface areas, the catalysts disclosed and described herein can have relatively high pore volumes, often characterized by having total pore volumes of at least about 0.17 cc/g. The total pore volume encompasses pore diameters up to and including 2000 Å. In some embodiments, the catalyst can have a total pore volume of at least about 0.175 cc/g; alternatively, at least about 0.18 cc/g; alternatively, at least about
10 0.185 cc/g; alternatively, in a range from about 0.17 to about 0.25 cc/g; alternatively, in a range from about 0.17 to about 0.24 cc/g; alternatively, in a range from about 0.175 to about 0.24 cc/g; alternatively, in a range from about 0.18 to about 0.24 cc/g; or alternatively, in a range from about 0.17 to about 0.23 cc/g. Similarly, the catalyst often can have a micropore volume (encompassing pore diameters of less than 20 Å) of at least about 0.045 cc/g, such as,
15 for instance, at least about 0.05, at least about 0.055, or at least about 0.06 cc/g. Typical ranges for the micropore volumes of catalysts disclosed herein can include, but are not limited to, the following ranges: from about 0.045 to about 0.09 cc/g, from about 0.05 to about 0.09 cc/g, from about 0.055 to about 0.085 cc/g, from about 0.06 to about 0.09 cc/g, from about 0.05 to about 0.08 cc/g, or from about 0.055 to about 0.08 cc/g.

20 In an embodiment, the catalyst can be characterized by a T_{SOR} of less than about 499 °C (930 °F), or less than about 496 °C (925 °F). In another embodiment, the catalyst can be characterized by a Fouling Rate (FR) of less than about 0.28 °C/hr (0.5 °F/hr), or less than about 0.25 °C/hr (0.45 °F/hr). In yet another embodiment, the catalyst can be characterized by having a C₅+ yield of greater than about 90 wt. %, or greater than about 91 wt. %. The
25 test procedures for these parameters are discussed in greater detail in reference to Examples 1-17 that follow.

In another embodiment, and unexpectedly, the catalysts disclosed herein can be regenerated. As discussed hereinabove, a catalyst is regenerable (a) if the cycle length or useful life of the regenerated catalyst is at least 0.5X (50% of X), wherein X is the cycle
30 length or useful life (in hours) of the fresh catalyst, and/or (b) if ΔT_{SOR} is less than 30 °F, wherein ΔT_{SOR} is the difference between the start of run temperature of the catalyst after regeneration and the start of run temperature of the fresh catalyst. Both of these parameters and procedures for determining these parameters are discussed in greater detail in reference to Examples 18-19 that follow.

Consistent with some embodiments disclosed herein, the useful life of the regenerated catalyst can be least 0.65X, or at least 0.75X, while in accordance with other embodiments, the useful life of the regenerated catalyst can be at least 0.8X, or at least X. Additionally or alternatively, the ΔT_{SOR} can be less than 25 °F, or less than 20 °F, or less than 15 °F, or less than 10 °F.

METHODS FOR PRODUCING CATALYSTS

Various methods for producing catalysts comprising a Group VIII transition metal and an alkaline earth metal exchanged zeolitic support are provided herein. One such method for making a catalyst can comprise (or consist essentially of, or consist of):

(a) contacting a zeolitic base with an alkaline earth metal-containing compound to form an alkaline earth metal exchanged zeolitic support;

(b) calcining the alkaline earth metal exchanged zeolitic support at a peak calcining temperature of less than about 550 °C (1022 °F);

(c) impregnating the calcined alkaline earth metal exchanged zeolitic support with a Group VIII transition metal-containing compound; and

(d) calcining the impregnated alkaline earth metal exchanged zeolitic support to produce a catalyst having a surface area of at least about 165 m²/g.

Generally, the features of any of the methods disclosed herein (e.g., the zeolitic base, the alkaline earth metal-containing compound, the Group VIII transition metal-containing compound, various compositional aspects of the finished catalyst, the surface area, total pore volume, and micropore volume of the finished catalyst, the conditions under which any of the steps are conducted, the peak calcining temperature, among others) are independently described herein, and these features can be combined in any combination to further describe the disclosed methods. Moreover, other process steps can be conducted before, during, and/or after any of the steps listed in the disclosed methods, unless stated otherwise. Additionally, catalysts (e.g., supported aromatization catalysts) produced in accordance with the disclosed methods/processes are within the scope of this disclosure and are encompassed herein.

In step (a), the alkaline earth metal-containing compound can contain any alkaline earth metal, such as barium, strontium, calcium, magnesium, or a combination thereof. In one embodiment, the alkaline earth metal-containing compound can comprise barium; alternatively, strontium; alternatively, calcium; or alternatively, magnesium. In another embodiment, the alkaline earth metal-containing compound can comprise a salt of the

alkaline earth metal, such as an acetate, carbonate, nitrate, or halide (e.g., chloride) salt. In yet another embodiment, the alkaline earth metal-containing compound can comprise a water soluble barium salt, non-limiting examples of which can include barium nitrate, barium chloride, barium acetate, barium carbonate, and the like, as well as mixtures or combinations thereof. Generally, the alkaline earth metal-containing compound in step (a) can be in an aqueous solution, and can be contacted with the zeolitic base in an ion exchange process.

The zeolitic base in step (a) often can comprise a zeolite, such as any zeolite disclosed herein (e.g., a L-zeolite, a KL-zeolite, etc.). While not being limited thereto, the zeolitic base in step (a) can be produced by a process comprising mixing a zeolite, such as a KL-zeolite, with a binder, such as silica, then extruding the mixture, and then drying and calcining. Methods for producing a zeolitic base are described, for example, in U.S. Patent No. 6,190,539, the disclosure of which is incorporated herein by reference in its entirety. Optionally, the resultant calcined zeolitic base can be washed, dried, and calcined prior to step (a). In a particular embodiment, the zeolitic base in step (a) can comprise a silica-bound KL-zeolite.

In various embodiments contemplated herein, the methods of making a catalyst can further include one or more optional steps performed after step (a), but prior to the calcination of the zeolitic support in step (b). For example, a method of making a catalyst can further comprise an intermediate washing step prior to step (b), and/or can further comprise an intermediate drying step prior to step (b). These optional steps are discussed in greater detail herein below. In one embodiment, at least one of these optional steps can be performed in a method of making a catalyst, while in another embodiment, both of these optional steps can be performed. The optional steps can be performed in any order, however, in a particular embodiment, the intermediate washing step can be performed first, followed by the intermediate drying step.

In an embodiment, a method of making a catalyst (e.g., comprising a Group VIII transition metal and a zeolitic support) can further comprise an intermediate washing step prior to the calcination in step (b). This intermediate washing step generally can comprise contacting (e.g., mixing) the alkaline earth metal exchanged zeolitic support with a washing composition comprising (or consisting essentially of, or consisting of) water, for instance, distilled or deionized water. Catalyst washing procedures are described, for example, in U.S. Patent No. 6,190,539, the disclosure of which is incorporated herein by reference in its entirety.

While not being limited thereto, the washing step generally can be conducted at a washing temperature in a range from about 20 °C to about 95 °C; alternatively, from about 20 °C to about 90 °C; alternatively, from about 25 °C to about 75 °C; alternatively, from about 25 °C to about 65 °C; alternatively, from about 30 °C to about 90 °C; or alternatively, from about 30 °C to about 60 °C. In these and other embodiments, these temperature ranges also are meant to encompass circumstances where the washing step is conducted at a series of different temperatures, instead of at a single fixed temperature, falling within the respective ranges.

The intermediate washing step can include numerous washing cycles, often from 2 to 20, or from 2 to 10. More often, the intermediate washing step can consist of from 2 to 8, from 3 to 8, or from 3 to 5 washing cycles.

The duration of each washing cycle in the intermediate washing step is not limited to any particular period of time. Typically, each washing cycle can be conducted in a time period ranging from as little as 10 sec to as long as 2 hr (or more), but more typically, each washing cycle can be conducted in a time period that can be in a range from about 30 sec to about 1 hr, such as, for example, from about 1 min to about 45 min, from about 1 min to about 30 min, from about 5 min to about 1 hr, or from about 10 min to about 30 min.

In an embodiment, a method of making a catalyst (e.g., comprising a Group VIII transition metal and a zeolitic support) can further comprise an intermediate drying step prior to the calcination in step (b). This intermediate drying step generally can comprise contacting the alkaline earth metal exchanged zeolitic support with an intermediate drying gas stream comprising (or consisting essentially, or consisting of) an inert gas (e.g., nitrogen), oxygen, air, or any mixture or combination thereof; alternatively, nitrogen; alternatively, helium; alternatively, neon; alternatively, argon; alternatively, oxygen; or alternatively, air.

While not being limited thereto, the intermediate drying step generally can be conducted at an intermediate drying temperature in a range from about 80 °C to about 200 °C; alternatively, from about 100 °C to about 200 °C; alternatively, from about 100 °C to about 175 °C; alternatively, from about 100 °C to about 150 °C; alternatively, from about 105 °C to about 165 °C; or alternatively, from about 110 °C to about 140 °C. In these and other embodiments, these temperature ranges also are meant to encompass circumstances where the drying step is conducted at a series of different temperatures, instead of at a single fixed temperature, falling within the respective ranges.

The duration of the intermediate drying step is not limited to any particular period of time. Typically, the drying step can be conducted in a time period ranging from as little as 30

min to as long as 8 hr (or more), but more typically, the drying step can be conducted in a time period that can be in a range from about 1 hr to about 8 hr, such as, for example, from about 1 hr to about 7 hr, from about 1 hr to about 6 hr, from about 2 hr to about 7 hr, or from about 2 hr to about 6 hr.

5 The calcination of the alkaline earth metal exchanged zeolitic support in step (b) can be conducted at a variety of temperatures and time periods. However, and unexpectedly, Applicants determined that it can be beneficial for the performance of the resultant catalyst for the peak calcining temperature to be less than about 550 °C (1022 °F). In one embodiment, the peak calcining temperature in step (b) can be in a range from about 315 °C (600 °F) to about 538 °C (1000 °F). In another embodiment, the peak calcining temperature can be in a range from about 371 °C (700 °F) to about 500 °C (932 °F). In yet another embodiment, the peak calcining temperature can be in a range from about 399 °C (750 °F) to about 493 °C (920 °F). In still another embodiment, the peak calcining temperature can be in a range from about 427 °C (800 °F) to about 482 °C (900 °F). In these and other
10 embodiments, these temperature ranges also are meant to encompass circumstances where the calcination step is conducted at a series of different temperatures (e.g., an initial calcination temperature, a peak calcination temperature), instead of at a single fixed temperature, falling within the respective ranges. For instance, the calcination in step (b) can start at an initial temperature which is the same as the drying temperature in the intermediate
15 drying step. Subsequently, the temperature of the step (b) calcination can be increased to a peak calcining temperature, for example, in a range from about 315 °C (600 °F) to about 538 °C (1000 °F), or from about 371 °C (700 °F) to about 500 °C (932 °F).
20

 The duration of the calcining in step (b) is not limited to any particular period of time. Hence, the calcining can be conducted, for example, in a time period ranging from as little as
25 30-45 min to as long as 10-12 hr, or more. The appropriate calcining time can depend upon, for example, the initial/peak calcining temperature, whether an intermediate drying step is used, among other variables. Generally, however, the calcining step can be conducted in a time period that can be in a range from about 45 min to about 12 hr, such as, for example, from about 1 hr to about 12 hr, from about 1 hr to about 10 hr, from about 1 hr to about 5 hr,
30 or from about 1 hr to about 3 hr.

 The calcining in step (b) can be conducted in a calcining gas stream that comprises (or consists essentially, or consists of) an inert gas (e.g., nitrogen), oxygen, air, or any mixture or combination thereof. In some embodiments, the calcining gas stream can comprise air, while in other embodiments, the calcining gas stream can comprise a mixture of air and nitrogen.

Yet, in certain embodiments, the calcining gas stream can be an inert gas, such as nitrogen and/or argon.

In step (c), the calcined alkaline earth metal exchanged zeolitic support of step (b) can be impregnated with a Group VIII transition metal-containing compound. The Group VIII transition metal-containing compound can comprise iron, cobalt, nickel, ruthenium, rhodium, palladium, osmium, iridium, platinum, and the like, or a combination of two or more transition metals. In a particular embodiment, the Group VIII transition metal-containing compound can comprise platinum (Pt). Illustrative and non-limiting examples of Group VIII transition metal-containing compounds (e.g., which contain platinum) that are suitable for use in impregnating the zeolitic support with platinum include, but are not limited to, tetraamineplatinum(II) chloride, tetraamineplatinum(II) nitrate, platinum(II) acetylacetonate, platinum(II) chloride, ammonium tetrachloroplatinate(II), chloroplatinic acid, and the like, as well as mixtures of combinations thereof.

In an embodiment, a method of making a catalyst (e.g., comprising a Group VIII transition metal and a zeolitic support) can further comprise a final drying step prior to the calcination in step (d). This final drying step generally can comprise contacting the impregnated zeolitic support with a final drying gas stream comprising (or consisting essentially, or consisting of) an inert gas (e.g., nitrogen), oxygen, air, or any mixture or combination thereof; alternatively, nitrogen; alternatively, helium; alternatively, neon; alternatively, argon; alternatively, oxygen; or alternatively, air.

As with the intermediate drying step, the final drying step is not limited to particular final drying temperatures, but most often, the final drying temperature can be in a range from about 80 °C to about 200 °C; alternatively, from about 100 °C to about 200 °C; alternatively, from about 100 °C to about 175 °C; alternatively, from about 100 °C to about 150 °C; alternatively, from about 105 °C to about 165 °C; or alternatively, from about 110 °C to about 140 °C. In these and other embodiments, these temperature ranges also are meant to encompass circumstances where the final drying step is conducted at a series of different temperatures, instead of at a single fixed temperature, falling within the respective ranges.

The duration of the final drying step can in the same range of time periods as the intermediate drying step, e.g., from as short as 30 min to as long as 8 hr (or more), but more typically, the final drying step can be conducted in a time period that can be in a range from about 1 hr to about 8 hr, such as, for example, from about 1 hr to about 7 hr, from about 1 hr to about 6 hr, from about 2 hr to about 7 hr, or from about 2 hr to about 6 hr.

The calcination of the impregnated alkaline earth metal exchanged zeolitic support in step (d) can be conducted at a variety of temperatures and time periods. In one embodiment, the peak calcining temperature in step (d) can be in a range from about 200 °C to about 500 °C (1000 °F). In another embodiment, the peak calcining temperature in step (d) can be in a range from about 230 °C to about 400 °C. In yet another embodiment, the peak calcining temperature in step (d) can be in a range from about 230 °C to about 350 °C. In still another embodiment, the peak calcining temperature in step (d) can be in a range from about 200 °C to about 300 °C. In these and other embodiments, these temperature ranges also are meant to encompass circumstances where the step (d) is conducted at a series of different temperatures (e.g., an initial calcination temperature, a peak calcination temperature), instead of at a single fixed temperature, falling within the respective ranges. For instance, the calcination in step (d) can start at an initial temperature which is the same as the final drying temperature in the final drying step. Subsequently, the temperature of the step (d) calcination can be increased to a peak calcining temperature, for example, in a range from about 230 °C to about 500 °C, or from about 230 °C to about 350 °C.

The duration of the calcining in step (d) is not limited to any particular period of time, and generally can be in the same range of time periods as in step (b). Hence, the calcining of step (d) can be conducted, for example, in a time period ranging from as little as 30-45 min to as long as 10-12 hr, or more. The appropriate calcining time can depend upon, for example, the initial/peak calcining temperature, whether a final drying step is used, among other variables. Generally, however, the calcining of step (d) can be conducted in a time period that can be in a range from about 45 min to about 12 hr, such as, for example, from about 1 hr to about 12 hr, from about 1 hr to about 10 hr, from about 1 hr to about 5 hr, or from about 1 hr to about 3 hr.

In various embodiments contemplated herein, the methods of making a catalyst can further include one or more optional final steps performed after the calcination in step (d). For example, a method of making a catalyst can further comprise a reducing step after the step (d). This reducing step can comprise contacting the catalyst with a reducing gas stream comprising molecular hydrogen. In addition to molecular hydrogen, the reducing gas stream can comprise an inert gas, i.e., the reducing gas stream can comprise (or consist essentially of, or consist of) molecular hydrogen and an inert gas. Typical inert gasses useful in the reducing step can encompass helium, neon, argon, nitrogen, and the like, and this includes combinations of two or more of these materials. In certain embodiments, the reducing gas

stream can comprise (or consist essentially of, or consist of) molecular hydrogen and nitrogen.

The reducing step can be conducted at a variety of temperatures and time periods. For instance, the reducing step can be conducted at a peak reducing temperature in a range
5 from about 100 °C to about 600 °C; alternatively, from about 100 °C to about 550 °C; alternatively, from about 200 °C to about 500 °C; alternatively, from about 300 °C to about 550 °C; alternatively, from about 200 °C to about 400 °C; or alternatively, from about 200 °C to about 350 °C. In these and other embodiments, these temperature ranges also are meant to encompass circumstances where the reducing step is conducted at a series of different
10 temperatures (e.g., an initial reducing temperature, a peak reducing temperature), instead of at a single fixed temperature, falling within the respective ranges.

The duration of the reducing step is not limited to any particular period of time. Hence, the reducing step can be conducted, for example, in a time period ranging from as little as 30 min to as long as 24 hr, or more. For example, the reducing step can be conducted
15 in a time period that can be in a range from about 1 hr to about 24 hr, from about 2 hr to about 18 hr, from about 2 hr to about 8 hr, from about 1 hr to about 10 hr, or from about 1 hr to about 6 hr.

The method of making a catalyst, as described by steps (a) through (d) hereinabove, can be further characterized, in some embodiments, as not including a contacting step
20 between step (b) and step (c). For example, in this regard, there is no additional contacting of the calcined alkaline earth metal exchanged zeolitic support with an alkaline earth metal-containing compound prior to impregnation of the zeolitic support with a Group VIII transition metal-containing compound. In a further embodiment, step (a) can be the only step in the method which utilizes an alkaline earth metal-containing compound, for example, a
25 barium-containing compound.

In another embodiment, the method can be characterized as not including a contacting step comprising a fluorine-containing compound; additionally or alternatively, the method can be characterized as not including a contacting step comprising a chlorine-containing compound other than the Group VIII transition metal-containing compound (e.g., a platinum-
30 containing compound). Chlorine-containing compounds in these embodiments can include, but are not limited to, hydrochloric acid, chlorine gas (Cl₂), carbon tetrachloride, tetrachloroethylene, chlorobenzene, methyl chloride, methylene chloride, chloroform, allyl chloride, trichloroethylene, a chloramine, a chlorine oxide, a chlorine acid, chlorine dioxide, dichlorine monoxide, dichlorine heptoxide, chloric acid, perchloric acid, ammonium chloride,

tetramethylammonium chloride, tetraethylammonium chloride, tetrapropylammonium chloride, tetrabutylammonium chloride, methyltriethylammonium chloride, and the like, or any combination thereof. Suitable fluorine-containing compounds in these embodiments can include, but are not limited to, hydrofluoric acid, fluorine gas (F₂), 2,2,2-trifluoroethanol, tetrafluoroethylene, carbon tetrafluoride, carbon trifluoride, fluoromethane, heptafluoropropane, decafluorobutane, hexafluoroisopropanol, tetrafluoropropanol, pentafluoropropanol, hexafluorophenylpropanol, perfluorobutyl alcohol, hexafluor-2-propanol, pentafluoro-1-propanol, tetrafluoro-1-propanol, 1,1,1,3,3,3-hexafluoro-2-propanol, 2,2,3,3,3-pentafluoro-1-propanol, ammonium fluoride, tetramethylammonium fluoride, tetraethylammonium fluoride, tetrapropylammonium fluoride, tetrabutylammonium fluoride, methyltriethylammonium fluoride, and the like, or any combination thereof. Compounds which can be considered as chlorine-containing compounds and/or fluorine-containing compounds in these embodiments can include, but are not limited to, CF₃Cl, CF₂Cl₂, CFCl₃, CHFCl₂, CHF₂Cl, C₂F₂Cl₄, C₂F₄Cl₂, and the like, or any combination thereof.

REFORMING PROCESSES WITH AROMATIZATION CATALYSTS

Also encompassed herein are various processes for reforming hydrocarbons. One such reforming process can comprise (or consist essentially of, or consist of) contacting a hydrocarbon feed with a supported aromatization catalyst under reforming conditions in a reactor system to produce an aromatic product. The supported aromatization catalyst can have a surface area of at least about 165 m²/g, and can comprise (i) an alkaline earth metal exchanged zeolitic support; and (ii) a Group VIII transition metal.

Generally, the features of any of the processes disclosed herein (e.g., the hydrocarbon feed, the supported aromatization catalyst, the Group VIII transition metal, the zeolitic support, the reforming conditions, among others) are independently described herein, and these features can be combined in any combination to further describe the disclosed reforming processes. Moreover, other process steps can be conducted before, during, and/or after the step of contacting the hydrocarbon feed with the supported aromatization catalyst under reforming conditions in the reactor system to produce the aromatic product, unless stated otherwise.

The reactor systems for reforming and the respective reforming conditions are well known to those of skill in the art and are described, for example, in U.S. Patent Nos. 4,456,527, 5,389,235, 5,401,386, 5,401,365, 6,207,042, and 7,932,425, the disclosures of which are incorporated herein by reference in their entirety.

Likewise, typical hydrocarbon feeds are disclosed in these references. Often, the hydrocarbon feed can be a naptha stream or light naptha stream. In certain embodiments, the hydrocarbon feed can comprise non-aromatic hydrocarbons, for example, the hydrocarbon feed can comprise C₆-C₉ alkanes and/or cycloalkanes, or C₆-C₈ alkanes and/or cycloalkanes (e.g., hexane, cyclohexane, etc.), and the like.

EXAMPLES

The invention is further illustrated by the following examples, which are not to be construed in any way as imposing limitations to the scope of this invention. Various other aspects, embodiments, modifications, and equivalents thereof which, after reading the description herein, can suggest themselves to one of ordinary skill in the art without departing from the spirit of the present invention or the scope of the appended claims.

In Examples 1-17, the respective catalysts were evaluated for their start of run temperature (T_{SOR}, °F), fouling rate (FR, °F/hr), and C₅+ yield (wt. %) in accordance with the following procedure. Approximately 0.7 g of each catalyst were placed in a ¼-inch OD stainless steel reactor vessel in a temperature controlled furnace. Each catalyst sample was dried and reduced under flowing molecular hydrogen without recycle at a temperature increasing from room temperature to about 950 °F for 1 hr. Then, a feed stream of aliphatic hydrocarbons and molecular hydrogen was added to the reactor vessel at a feed rate of about 12 mL/min, a liquid hourly space velocity (LHSV) of about 12 hr⁻¹, a H₂:hydrocarbon molar ratio of about 1.3:1, and a pressure of about 100 psig, to obtain catalyst performance data over time. The aliphatic hydrocarbon feed contained from 22 to 26 wt. % n-hexane, 4 to 8 wt. % n-heptane, 33 to 37 wt. % C₆ iso-paraffins, 17 to 21 wt. % C₇ iso-paraffins, 6 to 10 wt. % C₈ iso-paraffins, with the balance attributable to C₆ and C₇ olefins, naphthenes, and aromatics. The reactor effluent composition was regularly analyzed by gas chromatography to determine the weight percentage of total aromatics in the C₅+ fraction (e.g., benzene, toluene). The reactor temperature was periodically adjusted to achieve a desired total 63 wt. % aromatics in the C₅+ product. Each test was conducted for 40 hr.

As would be recognized by those of skill in the art, catalysts decrease in activity during operation over time due to several reasons, for example, deposition of coke, undesirable accumulation of poisons on the catalyst surface, etc. This deactivation is generally referred to as "fouling," and the fouling rate can be determined by establishing a temperature needed to achieve a targeted conversion of the hydrocarbon feed to a selected wt. % of aromatics in the C₅+ product. As the catalyst activity decreases due to fouling, the

temperature may be increased to compensate for the loss of catalyst activity. The extent to which the temperature is adjusted over a specified time period to maintain the targeted activity is termed the fouling rate. In Examples 1-17, the temperature required to maintain 63 wt. % aromatics (the yield adjusted temperature) was plotted versus reaction time, and a linear regression fit was used to determine FR and T_{SOR} using the formula, $y = FR \cdot t + T_{SOR}$, where y is the yield adjusted temperature, FR is the fouling rate (slope), t is the reaction time, and T_{SOR} is the initial start of run temperature (y-intercept). Initial low conversion catalyst break-in conditions or initial performance, typically within the first 15 hr, were not included in the determination of T_{SOR} and fouling rate.

The C_5+ yield (wt. %) was determined by analyzing the reaction product stream using a gas chromatograph equipped with a capillary column and a flame ionization detector. Samples were taken every hour and analyzed. All measured C_5 to C_{10} components (in wt. %) and the amount of hydrogen produced (calculated from the difference between the feed and the reaction product) were used to calculate total C_5+ yield, based on the total reaction product. The values reported in **Tables I-IV** were the average C_5+ yield between 30-40 hours on stream in the 40-hr test.

Weight percentages of Pt, Ba, Cl, and F were determined using X-ray fluorescence (XRF). Surface areas were determined using the BET method, and pore volume and micropore volume were determined using the t-plot method.

EXAMPLES 1-4

Example 1 was a comparative, commercially available aromatization catalyst containing platinum on a Ba-KL zeolite with about 20 wt. % silica binder. Beneficially, this catalyst is regenerable, but often has lower catalyst activity and higher fouling rates than Example 2. Example 2 was a comparative, commercially available aromatization catalyst containing platinum and halogens (F and Cl) on a KL zeolite with about 17 wt. % silica binder. Beneficially, this catalyst generally has higher catalyst activity and lower fouling rates than Example 1, but this catalyst typically is not regenerable.

Examples 3-4 were produced as follows. An extruded base was prepared by extruding a mixture of 83 wt. % KL zeolite and 17 wt. % colloidal silica with 5 wt. % methyl cellulose (based on the zeolite) in a sufficient amount of water to make an extrudable paste, and then extruding the paste through a die to produce 1/16-inch extrudates. The wet extrudates were dried at about 250 °F for 4 hr, and then calcined at 932 °F for 1 hr in flowing air. The calcined base was washed 3 times in deionized water at 100 °F for 20 min, followed

by drying at about 250 °F for 4 hr, and then calcining at 900-950 °F for 1 hr in flowing air. Next, the calcined and washed base was ion-exchanged with a 0.3 M aqueous solution of barium nitrate at a temperature of about 180 °F for about 3 hr, followed by filtration to remove excess barium nitrate solution. The barium exchanged support was washed 3 times
 5 in deionized water at about 75 °F for 20 min, filtered, and then dried at about 250 °F for about 4 hr. Calcining was conducted at a peak temperature of 900-950 °F for 1 hr.

Approximately 20 g of the calcined barium exchanged support were impregnated with an aqueous solution of $\text{Pt}(\text{NH}_3)_4\text{Cl}_2$ (about 0.4 g of the platinum-containing compound to 9.5 mL of water) to result in the desired platinum loadings. The catalyst was dried in vacuum at
 10 100 °F for 2 hr, then at 200 °F for 30 min, and then calcined at 500 °F for 1 hr in flowing air.

Table I summarizes certain properties of the aromatization catalysts of Examples 1-4. As compared with the catalyst of Example 1, the catalysts of Examples 3-4, unexpectedly, had significantly higher surface area, total pore volume, and micropore volume, as well as increased catalyst activity as demonstrated by both a lower T_{SOR} temperature and a higher
 15 C_5+ yield. Moreover, the catalysts of Examples 3-4 had significantly lower fouling rates than that of Example 1.

As compared with the catalyst of Example 2, the catalysts of Examples 3-4 had relatively similar surface area, total pore volume, and micropore volume. Surprisingly, even with 20% less platinum than the catalyst of Example 2, the catalysts of Examples 3-4 showed
 20 relatively similar fouling rates and T_{SOR} temperatures. Interestingly, the catalysts of Examples 3-4 resulted in slightly superior C_5+ yields than the catalyst of Example 2.

Table I. Examples 1-4.

Example	1	2	3	4
Pt (wt. %)	0.57	0.98	0.79	0.72
Ba (wt. %)	6.24	0.0	6.53	6.63
Surface Area (m^2/g)	114	180	208	182
Total Pore Volume (cc/g)	0.170	0.194	0.200	0.190
Micropore Volume (cc/g)	0.043	0.063	0.069	0.058
T_{SOR} (°F)	933	914	914	916
Fouling Rate (°F/hr)	2.50	0.12	0.28	0.27
C_5+ Yield (wt. %)	83.3	90.5	91.2	91.1

EXAMPLES 5-8

The catalysts of Examples 5-6 were the same as the catalysts of Examples 1-2, respectively, but are given different example numbers due to slight variations in test results versus Examples 1-2.

Examples 7-8 were produced as follows. An extruded base was prepared by extruding a mixture of 83 wt. % KL zeolite and 17 wt. % colloidal silica with 5 wt. % methyl cellulose (based on the zeolite) in a sufficient amount of water to make an extrudable paste. The wet extrudates were dried at about 250 °F for 4 hr, and then calcined at 932 °F for 1 hr in flowing air. The calcined base was washed 3 times in deionized water at 100 °F for 20 min, followed by drying at about 250 °F for 4 hr, and then calcining at 900 °F for 1 hr in flowing air. Approximately 300 g of the calcined and washed base were ion-exchanged with 3 L of a 0.3 M aqueous solution of barium nitrate at a temperature of about 180 °F for about 3 hr with occasional stirring, followed by filtration to remove excess barium nitrate solution. The barium exchanged support was washed 3 times in 750 mL of deionized water at about 75 °F for 20 min, filtered, and then dried at about 250 °F for about 4 hr. Calcining was conducted at a peak temperature of 900 °F for 1 hr.

Approximately 120 g of the calcined barium exchanged support were impregnated with an aqueous solution of $\text{Pt}(\text{NH}_3)_4\text{Cl}_2$ (e.g., 2.88 g in 60 mL of water) to result in the desired platinum loadings. The catalyst was dried in vacuum at 100 °F for 2 hr, then at 200 °F for 30 min, and then calcined at 500 °F for 1 hr in flowing air.

Table II summarizes certain properties of the aromatization catalysts of Examples 5-8. As compared with the catalyst of Example 5, the catalysts of Examples 7-8, unexpectedly, had significantly higher surface area, total pore volume, and micropore volume, as well as increased catalyst activity as demonstrated by both a lower T_{SOR} temperature and a higher C_5+ yield. Moreover, the catalysts of Examples 7-8 had significantly lower fouling rates than that of Example 5.

As compared with the catalyst of Example 6, the catalysts of Examples 7-8 contained barium, did not contain fluorine, and contained about half of the amount of chlorine. The catalysts of Examples 7-8 had slightly higher surface areas, and comparable total pore volumes and micropore volumes to the catalyst of Example 6. Additionally, the catalysts of Examples 7-8 showed relatively similar fouling rates, T_{SOR} temperatures, and C_5+ yields as compared to the catalyst of Example 2.

Table II. Examples 5-8.

Example	5	6	7	8
Pt (wt. %)	0.57	0.98	0.80	0.94
Ba (wt. %)	6.24	0.0	6.49	6.48
F (wt. %)	0.0	0.80	0.0	0.0
Cl (wt. %)	0.27	0.83	0.34	0.42
Surface Area (m ² /g)	114	180	193	194
Total Pore Volume (cc/g)	0.170	0.194	0.192	0.228
Micropore Volume (cc/g)	0.043	0.063	0.065	0.064
T _{SOR} (°F)	933	923	926	916
Fouling Rate (°F/hr)	2.50	0.16	0.46	0.34
C ₅ + Yield (wt. %)	83.3	90.4	90.1	91.2

5

EXAMPLES 9-12

The catalysts of Examples 9-12 each contained approximately 1% platinum, and were prepared in substantially the same manner as those of Examples 7-8. The barium exchanged support was calcined at a peak temperature of either 800 °F, 900 °F, 1100 °F, or 1200 °F for 1 hr, prior to impregnating with platinum.

Table III summarizes the calcination temperature used in the preparation of each of Examples 9-12, as well as certain properties of the aromatization catalysts of Examples 9-12. The peak calcinations temperatures of 800 °F and 900 °F produced catalysts with the highest surface areas, total pore volumes, and micropore volumes, as well the lowest T_{SOR} temperature and fouling rates. The peak calcination temperature of 1200 °F produced a catalyst which had an unacceptably high fouling rate and low C₅+ yield.

15

EXAMPLES 13-17

The catalysts of Examples 13-17 each contained approximately 1.2% platinum, and were prepared in substantially the same manner as those of Examples 7-8. The barium exchanged support was calcined at a peak temperature of either 600 °F, 700 °F, 800 °F, 900 °F, or 1000 °F for 1 hr, prior to impregnating with platinum.

Table IV summarizes the calcination temperature used in the preparation of each of Examples 13-17, as well as certain properties of the aromatization catalysts of Examples 13-17. All of these catalysts, produced with peak calcinations temperatures of 600 °F to 1000 °F, had acceptable surface areas, pore volumes, micropore volumes, T_{SOR} temperatures, fouling rates, and C_5+ yields.

Table III. Examples 9-12 with 1 wt. % platinum.

Example	Peak Calcining (°F)	Surface Area (m ² /g)	Micro-Pore Volume (cc/g)	Total Pore Volume (cc/g)	T _{SOR} (°F)	Fouling Rate (°F/hr)	C ₅ + Yield (wt. %)
9	800	198	0.068	0.200	927	0.42	91.3
10	900	179	0.070	0.190	929	0.38	91.4
11	1100	161	0.056	0.170	934	0.49	91.4
12	1200	151	0.049	0.160	952	3.10	78.4

Table IV. Examples 13-17 with 1.2 wt. % platinum.

Example	Peak Calcining (°F)	Surface Area (m ² /g)	Micro-Pore Volume (cc/g)	Total Pore Volume (cc/g)	T _{SOR} (°F)	Fouling Rate (°F/hr)	C ₅ + Yield (wt. %)
13	600	190	0.063	0.22	915	0.29	87.6
14	700	182	0.055	0.21	919	0.38	90.9
15	800	189	0.054	0.18	914	0.26	89.8
16	900	201	0.064	0.23	916	0.34	91.2
17	1000	188	0.068	0.20	925	0.52	89.6

EXAMPLES 18-19

The catalyst of Example 18 contained approximately 1% platinum, and was prepared in substantially the same manner as those of Examples 7-8. The barium exchanged support was calcined at a peak temperature of 900 °F for 1 hr, prior to impregnating with platinum. Example 19 used the catalyst of Examples 2 and 6.

The first step in evaluating the regenerability of a catalyst is to determine the activity of the fresh catalyst (cycle 1). Since this test is designed to measure the longer term activity performance and fouling rates, the catalysts were tested for catalytic performance under test conditions that were designed to be more severe than described in earlier Examples 1-17. In Examples 18-19, 10 cc of catalyst ground to 20x40 mesh size were loaded in a 17.5 in x ½ in stainless steel reactor tube which was housed in a three-zone electrical furnace. The catalyst bed temperature was measured by a 5-tip thermocouple placed in an axial thermowell. Reactor operating conditions were 3 hr⁻¹ LHSV and 100 psig. The catalysts were exposed to a hydrocarbon feed (composition the same as in Examples 1-17) at a rate of 30 cc/hr, and at an initial temperature of about 800 °F. Reactor temperatures were continually adjusted to maintain 76 wt. % aromatics in the liquid C₅+ product as determined by an on-line gas chromatograph with flame ionization detection.

For an initial line-out period (~100 hr), the reactor conditions used were 3 hr⁻¹ LHSV, a 3:1 H₂/hydrocarbon molar ratio, and 100 psig. In this line-out period, after the feed introduction, the temperature was raised until the catalyst was able to produce 60 wt. % aromatics in the C₅+ product as determined by GC analysis. For Example 18, after the initial line-out period of 143 hr, the H₂:hydrocarbon molar ratios were changed to 0.5:1 until 340 hr, then 2:1 until 1174 hr, and finally to 3:1 until the EOR at 2258 hr.

After the initial line-out period, the furnace temperature required to maintain 76 wt. % aromatics was plotted versus time to determine the fouling rate (see **FIG. 1**). A line was fit to the steady state data using a simple regression. The slope of the line gives the fouling rate and the start of run temperature is the y-intercept of the line. An approximate useful catalyst life was estimated as the time (in hours) before the reactor temperature reached (or would reach) 1000 °F (i.e., the yield adjusted temperature required to maintain 76 wt. % aromatics). The first cycle was conducted for about 2250 hr.

Following this first cycle, the catalyst was regenerated in-situ as follows. A hydrogen purge of the catalyst bed was performed for 4 hr at 800 °F at a H₂ flow rate of 300 cc/min, then the reactor was cooled to about 500 °F. The flow was switched to a N₂ purge gas for 4 hr while the temperature decreased to about 400 °F. Then, a 1 vol. % O₂ (balance N₂) gas mixture was introduced to the reactor at 300 cc/min. The temperature was increased at 100 °F/hr to 425 °F, and held at that temperature until the CO₂ in the effluent gas was 100 ppmw or less. Next, the temperature was increased at 50 °F/hr to 600 °F, and held at that temperature for 12 hr. The temperature was then increased at 25 °F/hr to 700 °F, and held at that temperature until the CO₂ in the effluent gas was less than 50 ppmw, then cooled to 400 °F. The flow was switched to a N₂ purge gas at 300 cc/min for 1 hr. The catalyst was then reduced under flowing H₂ at 300 cc/min for 1 hr at 950 °F.

Following regeneration, the catalyst was subjected to a second cycle of the aromatization reaction, at operating conditions of 3 hr-1 LHSV, a 3.5:1 H₂/hydrocarbon molar ratio, and 100 psig after the initial line-out period. **FIG. 1** and **Table V** summarize the regenerability performance of the catalysts of Examples 18-19. As shown in **FIG. 1** and **Table V**, the first cycle performance of the catalysts of Examples 18-19 was very similar. Unexpectedly, however, the performance in cycle 2, after regeneration, was significantly different. The catalyst of Example 19 was not regenerable, evidenced by virtually no useful life and a ΔT_{SOR} of over 60 °F. In contrast, the ΔT_{SOR} was only 2 °F for the catalyst of Example 18, indicating a regenerable catalyst. More surprisingly, the useful life of the catalyst of Example 18 in cycle 2 far exceeded that of the catalyst of Example 18 in cycle 1.

Table V. Regeneration Experiments of Examples 18-19.

Example	18 Cycle 1	18 Cycle 2	19 Cycle 1	19 Cycle 2
T _{SOR} (°F)	945	947	938	1001
Regeneration ΔT_{SOR} (°F)	$\Delta T_{SOR} = 2$		$\Delta T_{SOR} = 63$	
Useful Life (hr)	1400	4300	1400	N/A

The invention has been described above with reference to numerous embodiments and specific examples. Many variations will suggest themselves to those skilled in the art in light of the above detailed description. All such obvious variations are within the full intended scope of the appended claims. Other embodiments of the invention can include, but are not limited to, the following:

Embodiment 1. A method of producing a catalyst, the method comprising:

- (a) contacting a zeolitic base with an alkaline earth metal-containing compound to form an alkaline earth metal exchanged zeolitic support;
- (b) calcining the alkaline earth metal exchanged zeolitic support at a peak calcining temperature of less than about 550 °C (1022 °F);
- (c) impregnating the calcined alkaline earth metal exchanged zeolitic support with a Group VIII transition metal-containing compound; and
- (d) calcining the impregnated alkaline earth metal exchanged zeolitic support to produce the catalyst having a surface area of at least about 165 m²/g.

Embodiment 2. The method defined in embodiment 1, wherein the contacting in step (a) comprises an ion exchange process.

Embodiment 3. The method defined in embodiments 1-2, wherein the alkaline earth metal-containing compound is in an aqueous solution.

Embodiment 4. The method defined in any of the preceding embodiments, wherein the alkaline earth metal-containing compound comprises barium, strontium, calcium, or a combination thereof.

Embodiment 5. The method defined in any of the preceding embodiments, wherein the alkaline earth metal-containing compound comprises barium.

Embodiment 6. The method defined in any of the preceding embodiments, wherein the alkaline earth metal-containing compound comprises a water soluble barium salt.

Embodiment 7. The method defined in any of the preceding embodiments, wherein the alkaline earth metal-containing compound comprises barium nitrate.

Embodiment 8. The method defined in any of the preceding embodiments, wherein the zeolitic base in step (a) is produced by a process comprising mixing a KL-zeolite with silica, extruding the mixture, drying, and calcining.

Embodiment 9. The method defined in embodiment 8, further comprising washing the calcined zeolitic base, drying, and calcining prior to performing step (a).

Embodiment 10. The method defined in any of the preceding embodiments, wherein the zeolitic base comprises a silica-bound KL-zeolite

Embodiment 11. The method defined in any of the preceding embodiments, wherein the method further comprises an intermediate washing step prior to step (b), the intermediate washing step comprising contacting the alkaline earth metal exchanged zeolitic support with any washing composition disclosed herein, for example, comprising deionized water.

Embodiment 12. The method defined in embodiment 11, wherein the intermediate washing step is conducted at any washing temperature disclosed herein, for example, in a range from about 20 °C to about 95 °C.

Embodiment 13. The method defined in embodiments 11-12, wherein the intermediate washing step includes any number of washing cycles (e.g., from 2 to 8) and any washing cycle time periods disclosed herein (e.g., in a range of from about 1 min to about 2 hr).

Embodiment 14. The method defined in any of the preceding embodiments, wherein the method further comprises an intermediate drying step prior to step (b), the intermediate drying step comprising contacting the alkaline earth metal exchanged zeolitic support with any intermediate drying gas stream disclosed herein, for example, comprising nitrogen, oxygen, air, or any combination thereof.

Embodiment 15. The method defined in embodiment 14, wherein the intermediate drying step is conducted at any intermediate drying temperature disclosed herein, for example, in a range from about 80 °C to about 200 °C.

Embodiment 16. The method defined in embodiments 14-15, wherein the intermediate drying step is conducted for any intermediate drying step time period disclosed herein, for example, in a range of from about 1 to about 8 hr.

Embodiment 17. The method defined in any of the preceding embodiments, wherein the peak calcining temperature in step (b) is in any range of peak calcining temperatures disclosed herein, for example, from about 315 °C (600 °F) to about 538 °C (1000 °F), from about 371 °C (700 °F) to about 500 °C (932 °F), from about 399 °C (750 °F) to about 493 °C (920 °F), or from about 427 °C (800 °F) to about 482 °C (900 °F).

Embodiment 18. The method defined in any of the preceding embodiments, wherein the calcining in step (b) is conducted for any minimum calcining time or in any range of calcining time periods disclosed herein, for example, for at least about 1 hr, for a time period in a range of from about 1 to about 10 hr, or from about 1 to about 5 hr.

Embodiment 19. The method defined in any of the preceding embodiments, wherein the calcining in step (b) is conducted in any calcining gas stream disclosed herein, for example, comprising nitrogen, oxygen, air, or any combination thereof.

Embodiment 20. The method defined in any of the preceding embodiments, wherein the Group VIII transition metal-containing compound comprises platinum.

Embodiment 21. The method defined in any of the preceding embodiments, wherein the Group VIII transition metal-containing compound comprises tetraamineplatinum(II) chloride, tetraamineplatinum(II) nitrate, platinum(II) acetylacetonate, platinum(II) chloride, ammonium tetrachloroplatinate(II), chloroplatinic acid, or a combination thereof.

Embodiment 22. The method defined in any of the preceding embodiments, wherein the method further comprises a final drying step prior to step (d), the final drying step comprising contacting the impregnated zeolitic support with any final drying gas stream disclosed herein, for example, comprising nitrogen, oxygen, air, or any combination thereof.

Embodiment 23. The method defined in embodiment 22, wherein the final drying step is conducted at any final drying temperature disclosed herein, for example, in a range from about 80 °C to about 200 °C.

Embodiment 24. The method defined in embodiments 22-23, wherein the final drying step is conducted for any final drying step time period disclosed herein, for example, in a range of from about 1 to about 8 hr.

Embodiment 25. The method defined in any of the preceding embodiments, wherein the calcining in step (d) is conducted at any final calcining temperature disclosed herein, for example, in a range from about 230 °C to about 500 °C.

Embodiment 26. The method defined in any of the preceding embodiments, wherein the method further comprises a reducing step after step (d), the reducing step comprising contacting the catalyst with any reducing gas stream disclosed herein, for example, comprising hydrogen.

Embodiment 27. The method defined in embodiment 26, wherein the reducing step is conducted at any reducing temperature disclosed herein, for example, in a range from about 100 °C to about 550 °C.

Embodiment 28. The method defined in any of the preceding embodiments, wherein the method does not include a contacting step between step (b) and step (c).

Embodiment 29. The method defined in any of the preceding embodiments, wherein step (a) is the only step in the method which utilizes an alkaline earth metal-containing compound, for example, a barium-containing compound.

Embodiment 30. The method defined in any of the preceding embodiments, wherein the method does not include a contacting step comprising a fluorine-containing compound.

Embodiment 31. The method defined in any of the preceding embodiments, wherein the method does not include a contacting step comprising a chlorine-containing compound other than the Group VIII transition metal-containing compound, for example, a platinum-containing compound.

Embodiment 32. The method defined in any of the preceding embodiments, wherein the method does not include a contacting step comprising a fluorine-containing compound or a chlorine-containing compound other than the Group VIII transition metal-containing compound, for example, a platinum-containing compound.

Embodiment 33. A catalyst obtained by the method defined in any of the preceding embodiments, for example, a supported aromatization catalyst.

Embodiment 34. A catalyst comprising:

- (i) an alkaline earth metal exchanged zeolitic support; and
- (ii) a Group VIII transition metal;

wherein the catalyst has a surface area of at least about 165 m²/g.

Embodiment 35. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst has a surface area greater than any minimum surface area or in any range of surface area disclosed herein, for example, at least about 180 m²/g, from about 170 to about 210 m²/g, or from about 180 to about 200 m²/g.

Embodiment 36. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst has a total pore volume greater than any minimum pore volume or in any

range of pore volume disclosed herein, for example, at least about 0.17 cc/g, at least about 0.18 g/cc, or from about 0.17 to about 0.24 cc/g.

Embodiment 37. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst has a micropore volume greater than any minimum micropore volume or in any range of micropore volume disclosed herein, for example, at least about 0.045 cc/g, at least about 0.055 g/cc, from about 0.05 to about 0.09 cc/g, or from about 0.055 to about 0.07 cc/g.

Embodiment 38. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst is substantially free of fluorine, for example, less than 2500 ppmw.

Embodiment 39. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst comprises less than any maximum amount of fluorine disclosed herein, for example, less than 2000 ppmw, less than 1000 ppmw, less than 500 ppmw, less than 100 ppmw, less than 50 ppmw, or less than 25 ppmw.

Embodiment 40. The catalyst or method defined in any of the preceding embodiments, wherein the Group VIII transition metal comprises platinum.

Embodiment 41. The catalyst or method defined in any of the preceding embodiments, wherein the Group VIII transition metal is platinum.

Embodiment 42. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst comprises any weight percentage range of Group VIII transition metal disclosed herein, for example, from about 0.1 wt. % to about 10 wt. %, from about 0.2 wt. % to about 5 wt. %, or from about 0.3 wt. % to about 2 wt. % Group VIII transition metal, based on the total weight of the catalyst.

Embodiment 43. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst comprises any weight percentage range of platinum disclosed herein, for example, from about 0.1 wt. % to about 10 wt. %, from about 0.2 wt. % to about 5 wt. %, or from about 0.3 wt. % to about 2 wt. % platinum, based on the total weight of the catalyst.

Embodiment 44. The catalyst or method defined in any of the preceding embodiments, wherein the zeolitic support comprises a medium pore zeolite, a large pore zeolite, or a combination thereof.

Embodiment 45. The catalyst or method defined in any of the preceding embodiments, wherein the zeolitic support comprises an L-zeolite, a Y-zeolite, a mordenite, an omega zeolite, and/or a beta zeolite.

Embodiment 46. The catalyst or method defined in any of the preceding embodiments, wherein the zeolitic support comprises a L-zeolite.

Embodiment 47. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst comprises platinum and the zeolitic support comprises a L-zeolite.

Embodiment 48. The catalyst or method defined in any of the preceding embodiments, wherein the zeolitic support comprises a potassium L-zeolite.

Embodiment 49. The catalyst or method defined in any of the preceding embodiments, wherein the zeolitic support comprises an alkaline earth metal comprising barium, strontium, calcium, or a combination thereof.

Embodiment 50. The catalyst or method defined in any of the preceding embodiments, wherein the zeolitic support comprises barium.

Embodiment 51. The catalyst or method defined in any of the preceding embodiments, wherein the zeolitic support comprises a barium ion-exchanged L-zeolite.

Embodiment 52. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst comprises any weight percentage range of alkaline earth metal disclosed herein, for example, from about 0.1 wt. % to about 50 wt. %, from about 1 wt. % to about 20 wt. %, or from about 2 wt. % to about 10 wt. % alkaline earth metal, based on the total weight of the catalyst.

Embodiment 53. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst comprises any weight percentage range of barium disclosed herein, for example, from about 0.1 wt. % to about 50 wt. %, from about 1 wt. % to about 20 wt. %, or from about 2 wt. % to about 10 wt. % barium, based on the total weight of the catalyst.

Embodiment 54. The catalyst or method defined in any of the preceding embodiments, wherein the zeolitic support further comprises a binder.

Embodiment 55. The catalyst or method defined in embodiment 54, wherein the binder comprises an inorganic solid oxide, a clay, or a combination thereof.

Embodiment 56. The catalyst or method defined in embodiment 54, wherein the binder comprises alumina, silica, magnesia, boria, titania, zirconia, a mixed oxide thereof, or a mixture thereof.

Embodiment 57. The catalyst or method defined in embodiment 54, wherein the binder comprises silica.

Embodiment 58. The catalyst or method defined in embodiment 54, wherein the binder comprises montmorillonite, kaolin, cement, or a combination thereof.

Embodiment 59. The catalyst or method defined in embodiments 54-58, wherein the zeolitic support comprises any weight percentage range of binder disclosed herein, for example, from about 3 wt. % to about 35 wt. %, or from about 5 wt. % to about 30 wt. % binder, based on the total weight of the zeolitic support.

Embodiment 60. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst further comprises chlorine.

Embodiment 61. The catalyst or method defined in embodiment 60, wherein the catalyst comprises any weight percentage range of chlorine disclosed herein, for example, from about 0.05 wt. % to about 5 wt. %, from about 0.1 wt. % to about 1 wt. %, or from about 0.1 wt. % to about 0.6 wt. % chlorine, based on the total weight of the catalyst.

Embodiment 62. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst is characterized by any maximum T_{SOR} or in any T_{SOR} range disclosed herein, for example, less than about 499 °C (930 °F), or less than about 496 °C (925 °F).

Embodiment 63. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst is characterized by any maximum Fouling Rate or in any Fouling Rate range disclosed herein, for example, less than about 0.28 °C/hr (0.5 °F/hr), or less than about 0.25 °C/hr (0.45 °F/hr).

Embodiment 64. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst is characterized by any minimum C_5+ yield or in any range of C_5+ yield disclosed herein, for example, greater than about 90 wt. %, or greater than about 91 wt.

Embodiment 65. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst is regenerable, for example, having a cycle length or useful life of the regenerated catalyst which is at least 0.5X (50% of X), wherein X is the cycle length or useful life (in hours) of the fresh catalyst.

Embodiment 66. The catalyst or method defined in embodiment 65, wherein the cycle length or useful life of the regenerated catalyst is at least 0.65X, for example, at least 0.75X, at least 0.8X, or at least X.

Embodiment 67. The catalyst or method defined in any of the preceding embodiments, wherein the catalyst is regenerable, for example, having a ΔT_{SOR} less than 30 °F, wherein ΔT_{SOR}

is the difference between the start of run temperature of the catalyst after regeneration and the start of run temperature of the fresh catalyst.

Embodiment 68. The catalyst or method defined in embodiment 67, wherein the ΔT_{SOR} is within 25 °F, for example, less than 20 °F, less than 15 °F, or less than 10 °F.

Embodiment 69. A reforming process comprising contacting a hydrocarbon feed with a supported aromatization catalyst under reforming conditions in a reactor system to produce an aromatic product, wherein the supported aromatization catalyst is the catalyst defined in any of the preceding embodiments.

Embodiment 70. The process defined in embodiment 69, wherein the hydrocarbon feed is any hydrocarbon feed disclosed herein, for example, comprising non-aromatic hydrocarbons, comprising C₆-C₉ alkanes and/or cycloalkanes, or comprising C₆-C₈ alkanes and/or cycloalkanes.

CLAIMS

That which is claimed is:

1. A catalyst comprising:

- (i) an alkaline earth metal exchanged zeolitic support; and
- (ii) a Group VIII transition metal;

wherein the catalyst has a surface area of at least about 165 m²/g; and the catalyst is substantially free of fluorine.

2. The catalyst defined in claim 1, The catalyst of claim 1, wherein the catalyst has:

- a surface area in a range from about 170 to about 210 m²/g; or
- a total pore volume of at least about 0.17 cc/g; or
- a micropore volume in a range from about 0.05 to about 0.09 cc/g; or
- any combination thereof.

3. The catalyst defined in any of the preceding claims, wherein the catalyst comprises less than 500 ppmw fluorine.

4. The catalyst defined in any of the preceding claims, wherein the Group VIII transition metal comprises platinum.

5. The catalyst defined in any of the preceding claims, wherein the zeolitic support comprises a medium pore zeolite, a large pore zeolite, or a combination thereof.

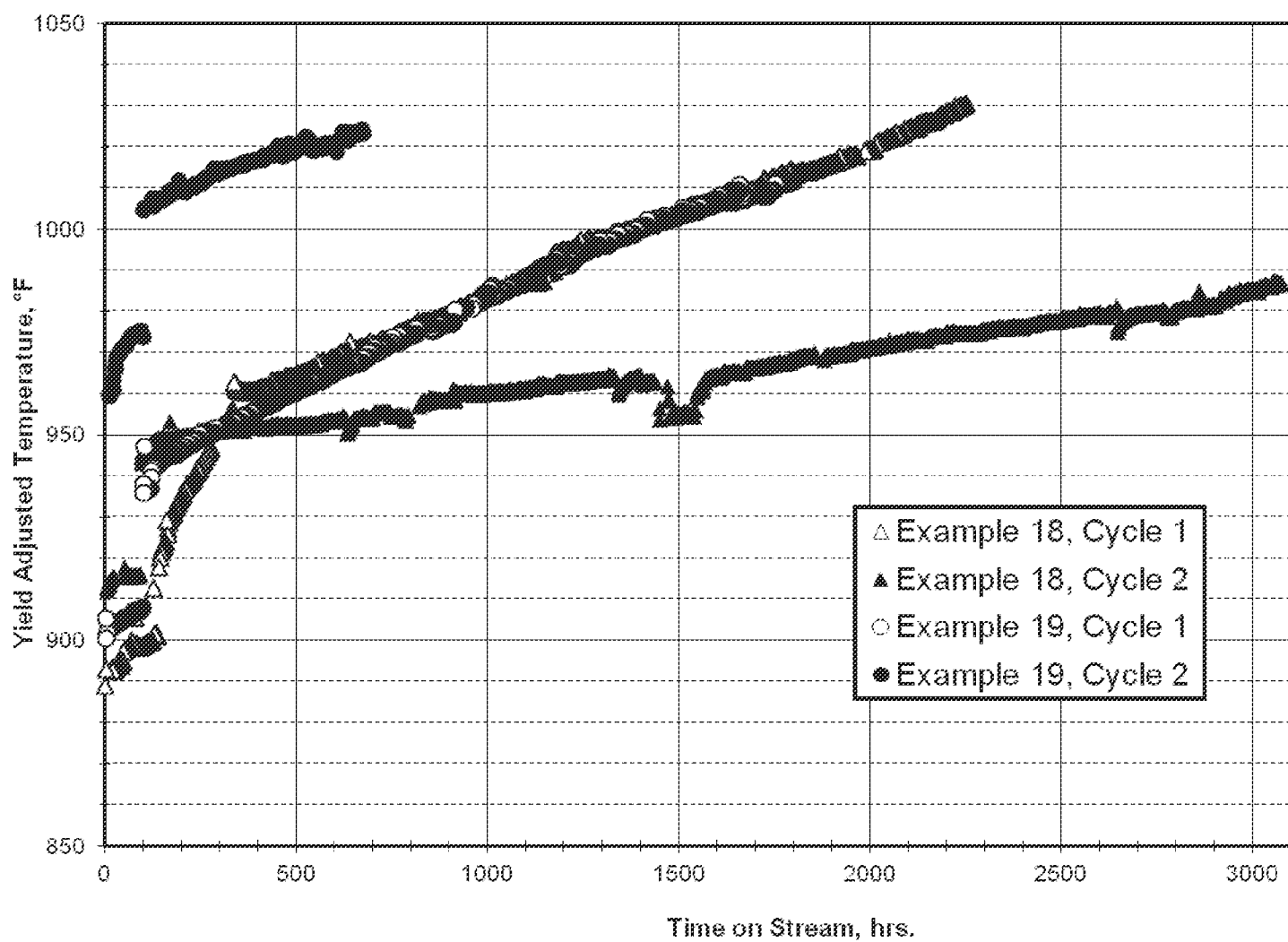
6. The catalyst defined in any of the preceding claims, wherein the zeolitic support comprises an alkaline earth metal comprising barium, strontium, calcium, or a combination thereof.

7. The catalyst defined in any of the preceding claims, wherein the catalyst further comprises chlorine.
8. The catalyst of claim 1, wherein the catalyst is regenerable.
9. A method of producing a catalyst, the method comprising:
 - (a) contacting a zeolitic base with an alkaline earth metal-containing compound to form an alkaline earth metal exchanged zeolitic support;
 - (b) calcining the alkaline earth metal exchanged zeolitic support at a peak calcining temperature of less than about 550 °C (1022 °F);
 - (c) impregnating the calcined alkaline earth metal exchanged zeolitic support with a Group VIII transition metal-containing compound; and
 - (d) calcining the impregnated alkaline earth metal exchanged zeolitic support to produce the catalyst having a surface area of at least about 165 m²/g.
10. The method of claim 9 wherein the alkaline earth metal-containing compound comprises barium, strontium, calcium, or a combination thereof.
11. The method of claims 9 or 10 wherein the zeolitic base comprises a silica-bound KL-zeolite
12. The method of claims 9 to 11 wherein the method does not include a contacting step between step (b) and step (c).
13. The method of claims 9 to 12 wherein step (a) is the only step in the method which utilizes an alkaline earth metal-containing compound, for example, a barium-containing compound.
14. The method of claims 9 to 13 wherein the method does not include a contacting step comprising a fluorine-containing compound.

15. A reforming process comprising contacting a hydrocarbon feed with a supported aromatization catalyst under reforming conditions in a reactor system to produce an aromatic product, wherein the supported aromatization catalyst is the catalyst defined in any of the preceding claims.

1/1

FIG. 1



INTERNATIONAL SEARCH REPORT

International application No

PCT/US2013/061370

A. CLASSIFICATION OF SUBJECT MATTER

INV. B01J29/62 B01J35/10 C10G35/095
ADD.

According to International Patent Classification (IPC) or to both national classification and IPC

B. FIELDS SEARCHED

Minimum documentation searched (classification system followed by classification symbols)

B01J C10G

Documentation searched other than minimum documentation to the extent that such documents are included in the fields searched

Electronic data base consulted during the international search (name of data base and, where practicable, search terms used)

EPO-Internal, WPI Data

C. DOCUMENTS CONSIDERED TO BE RELEVANT

Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	Javier M Grau ET AL: "Heptane Dehydrocyclization Over Pt/KL Catalysts Doped with Barium or Lanthanum", Catalysis Letters, 1 November 2002 (2002-11-01), pages 247-255, XP055091521, New York DOI: 10.1023/A:1021094216249 Retrieved from the Internet: URL: http://rd.springer.com/content/pdf/10.1023/A:1021094216249.pdf 2. Experimental; table 1	1-15
X	US 4 634 518 A (BUSS WALDEEN C [US] ET AL) 6 January 1987 (1987-01-06) claims; examples ----- -/-	1-15



Further documents are listed in the continuation of Box C.



See patent family annex.

* Special categories of cited documents :

"A" document defining the general state of the art which is not considered to be of particular relevance

"E" earlier application or patent but published on or after the international filing date

"L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified)

"O" document referring to an oral disclosure, use, exhibition or other means

"P" document published prior to the international filing date but later than the priority date claimed

"T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention

"X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step when the document is taken alone

"Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art

"&" document member of the same patent family

Date of the actual completion of the international search

4 December 2013

Date of mailing of the international search report

13/12/2013

Name and mailing address of the ISA/

European Patent Office, P.B. 5818 Patentlaan 2
NL - 2280 HV Rijswijk
Tel. (+31-70) 340-2040,
Fax: (+31-70) 340-3016

Authorized officer

Schoofs, Bart

INTERNATIONAL SEARCH REPORT

International application No

PCT/US2013/061370

C(Continuation). DOCUMENTS CONSIDERED TO BE RELEVANT		
Category*	Citation of document, with indication, where appropriate, of the relevant passages	Relevant to claim No.
X	US 5 028 312 A (MILLER JEFFREY T [US] ET AL) 2 July 1991 (1991-07-02) claims; examples -----	1-15
X	EP 0 145 289 A2 (EXXON RESEARCH ENGINEERING CO [US]) 19 June 1985 (1985-06-19) claims; examples -----	1-15

INTERNATIONAL SEARCH REPORT

Information on patent family members

International application No

PCT/US2013/061370

Patent document cited in search report	Publication date	Patent family member(s)	Publication date
US 4634518	A	06-01-1987	NONE
US 5028312	A	02-07-1991	NONE
EP 0145289	A2	19-06-1985	AR 243409 A1 31-08-1993
		AT 79567 T 15-09-1992	
		AU 569124 B2 21-01-1988	
		BR 8405734 A 17-09-1985	
		CA 1231699 A1 19-01-1988	
		DE 3485876 D1 24-09-1992	
		DE 3485876 T2 08-04-1993	
		EP 0145289 A2 19-06-1985	
		ES 8700961 A1 16-02-1987	
		ES 8703509 A1 01-05-1987	
		JP H0559790 B2 31-08-1993	
		JP S60175548 A 09-09-1985	
		MX 172610 B 03-01-1994	
		NO 844456 A 13-05-1985	